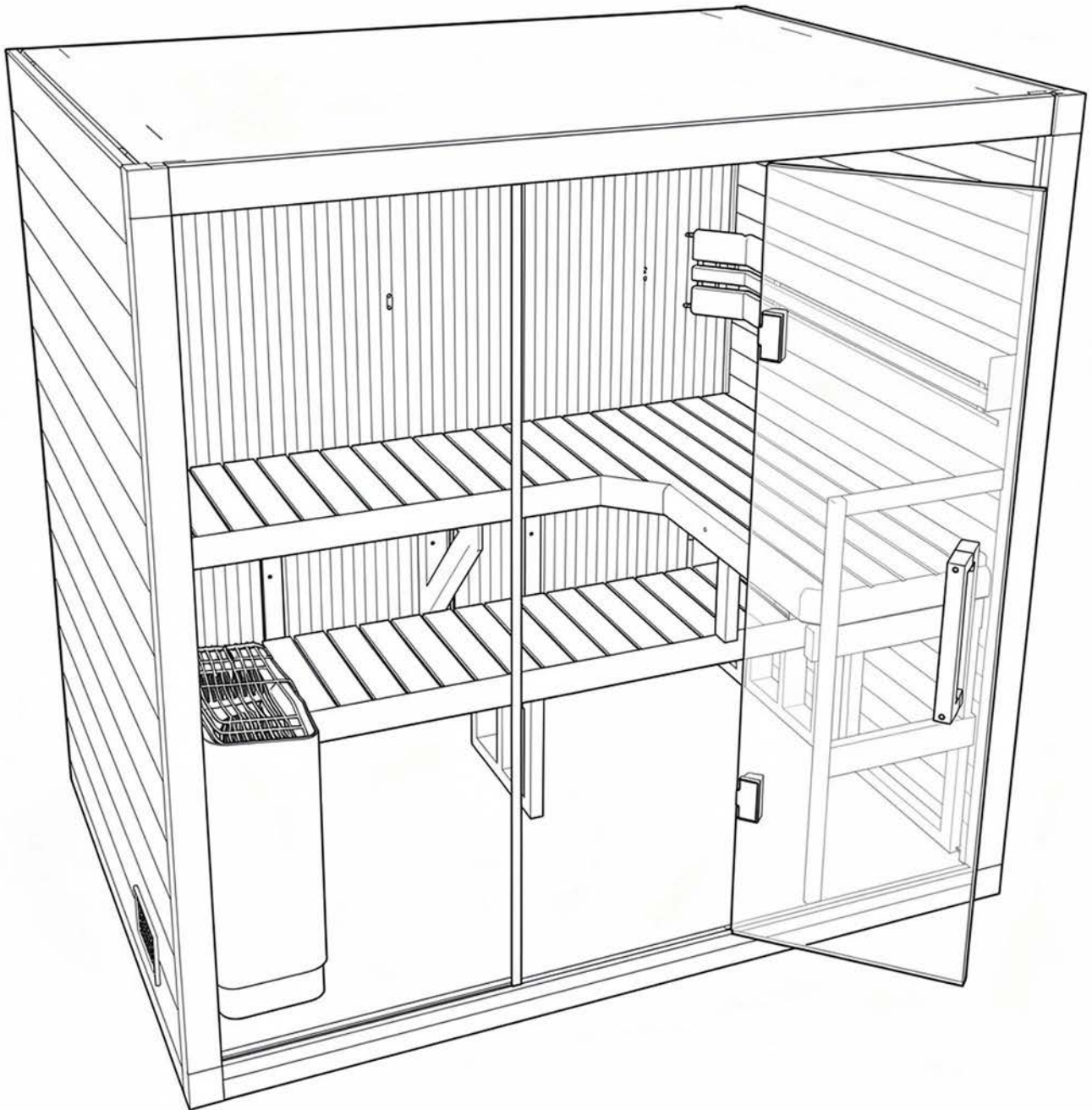


HALMSTAD 4

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 4 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 4 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.

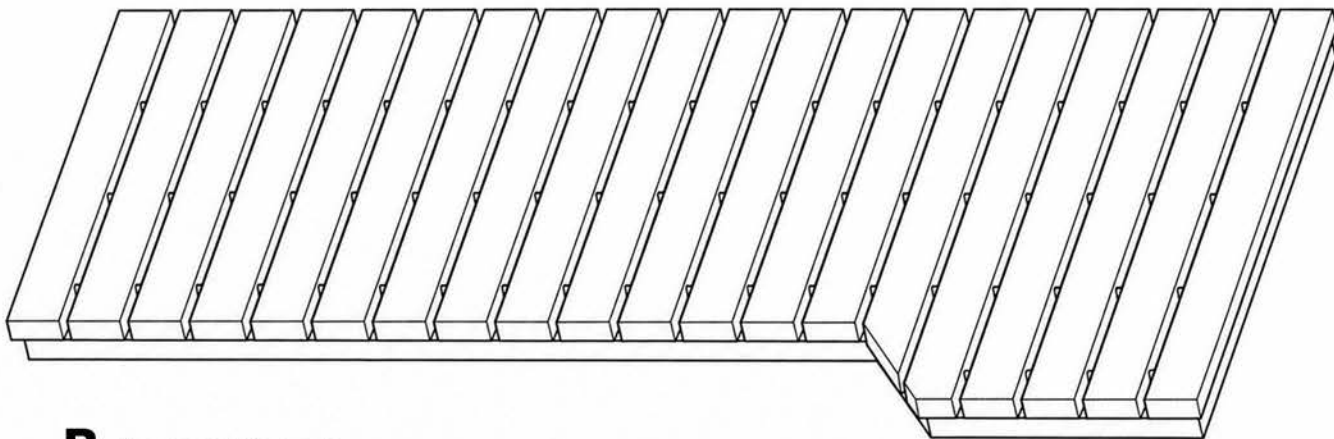
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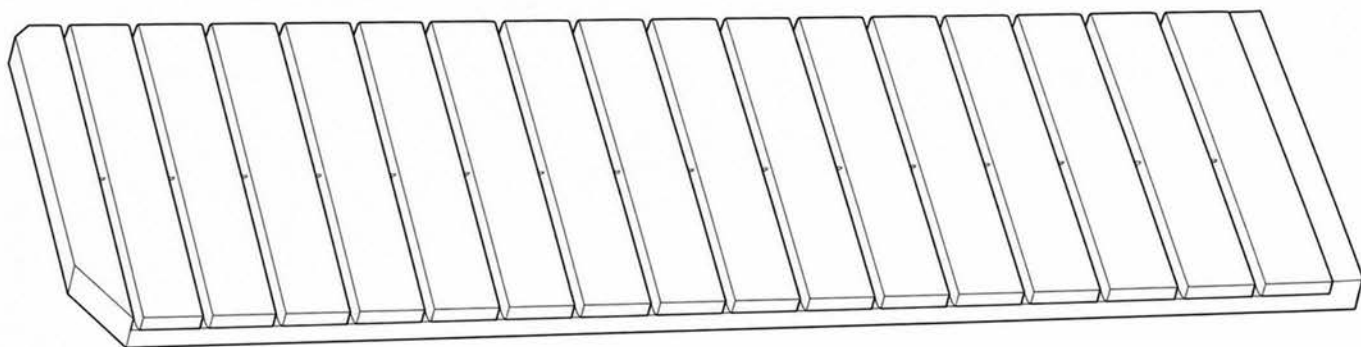
ORIGINAL SAUNA PARTS LIST

*that are involved in the installation

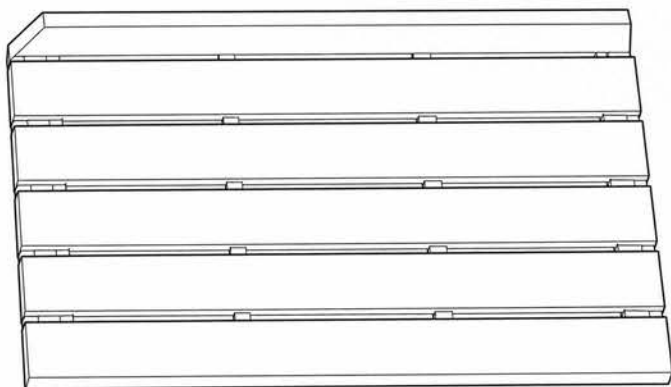
A Top Bench



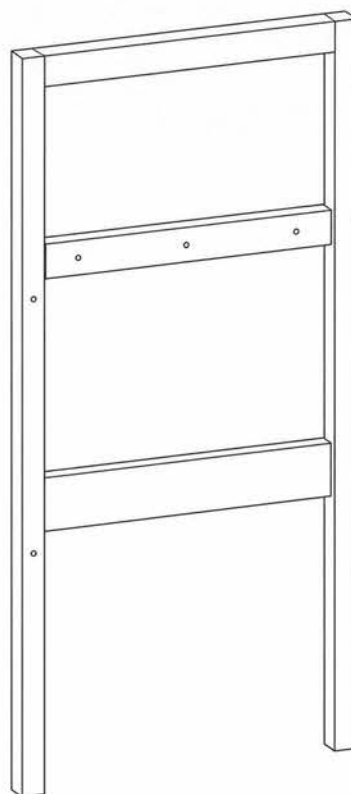
B Lower Bench



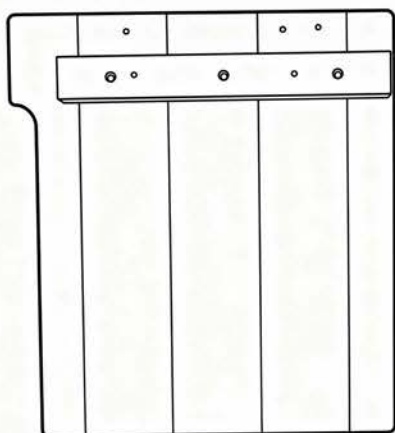
C Return Bench



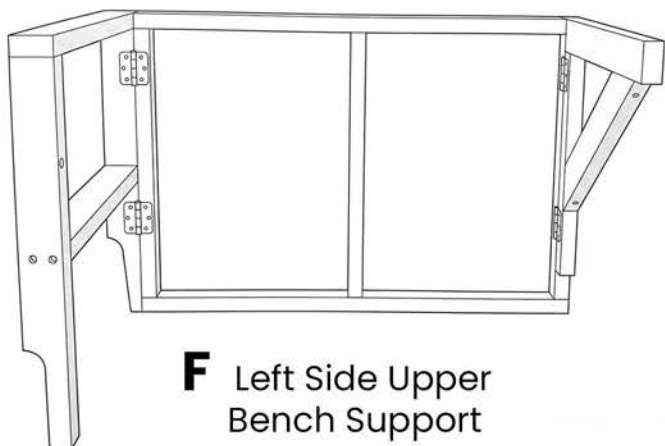
D H Leg



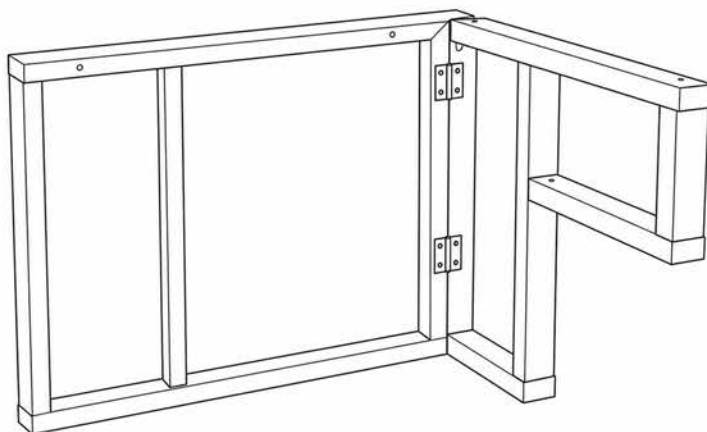
E Lower Bench Support



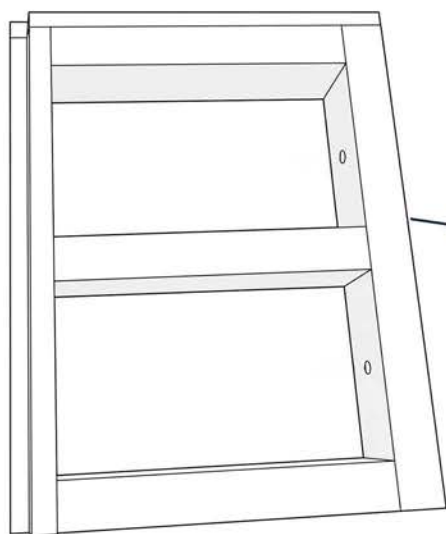
SUPPORT KIT PARTS



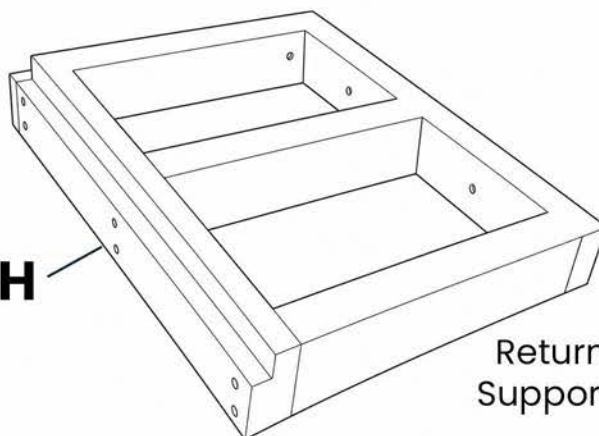
F Left Side Upper Bench Support



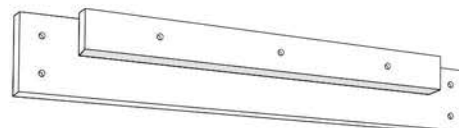
G Right Side Upper Bench Support



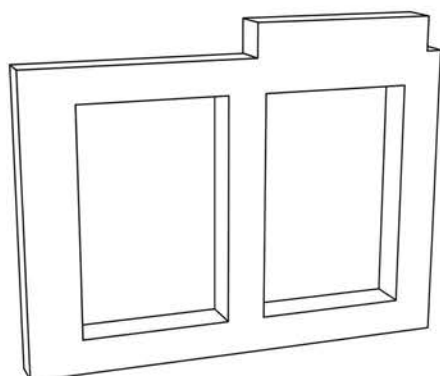
Return Lower Bench Support



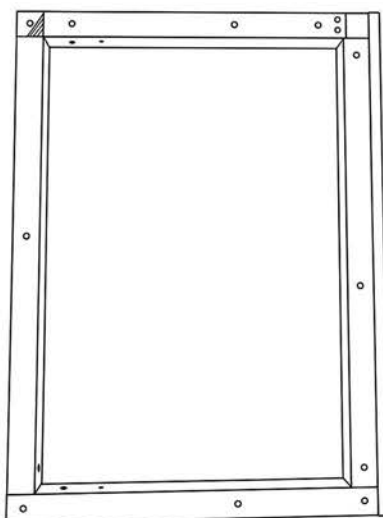
Return Lower Bench Support (side angle)



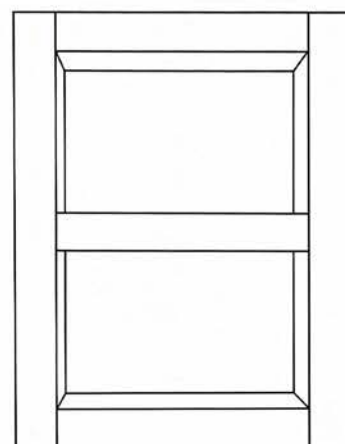
K H Leg Brace



I & J
Lower Bench
Midspan Support (2)



L Return Cleat Support



M Return Support

MITIGATION KIT HARDWARE

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

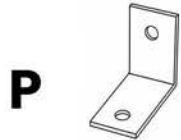
Note: kit may contain extra hardware



#9 x 2 1/2" Torx Flat-Head Screws (49)

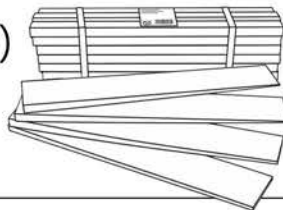


#8 Button Head Screws (2)



Metal bracket (3)

Shims (12)



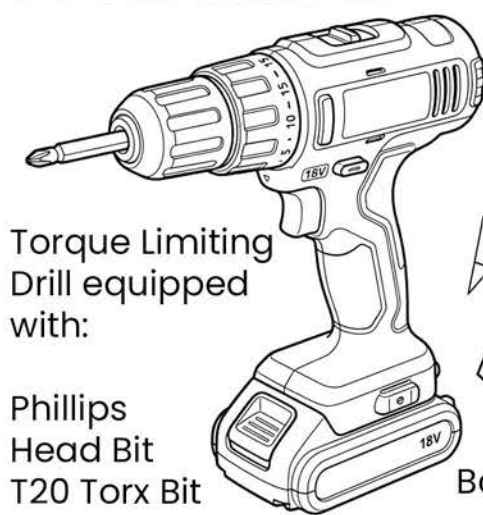
#6 x 3/4" Screws (18)

R { **RA** 5/16" x 3" Hex Head Bolts (2)
RB 5/16" Hex Nuts (2)
RC 5/16" Flat Washers (4)
RD Split-Lock Washer (2)



9 x2" Torx Flat-Head Screw (12)

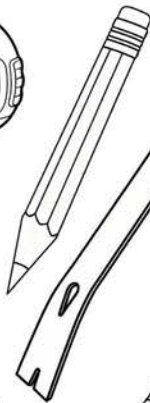
TOOLS NEEDED



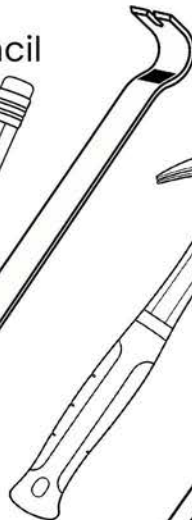
Torque Limiting Drill equipped with:

Phillips Head Bit
 T20 Torx Bit
 T25 Torx Bit
 3/32 Drill Bit
 9/64 Countersink Taper Drill Bit

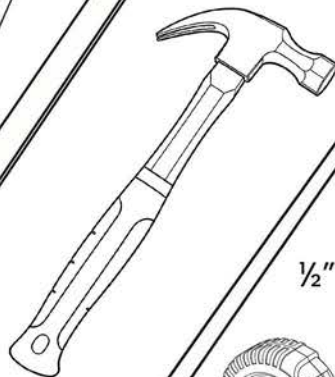
Pencil



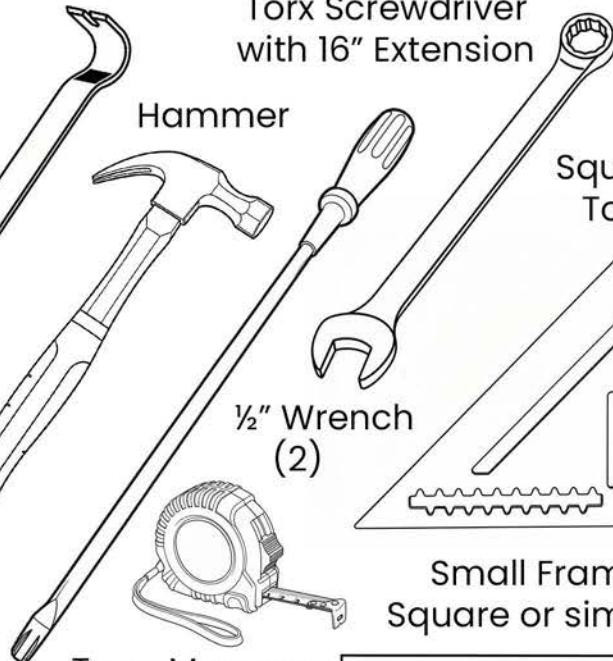
Pry Bars (2)



Hammer



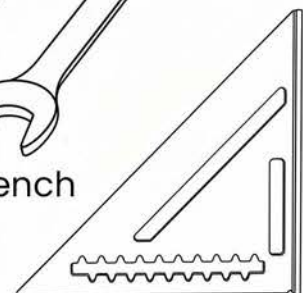
Torx Screwdriver with 16" Extension



1/2" Wrench (2)



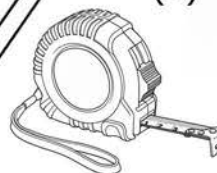
Square Tool



Small Framing Square or similar

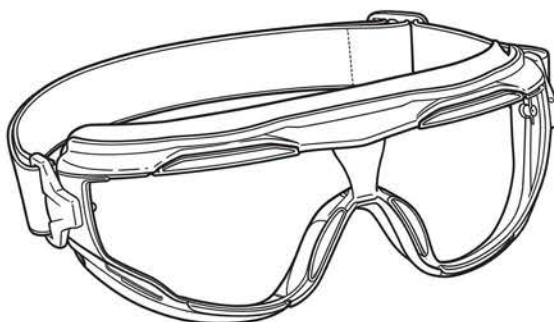


Tape Measure

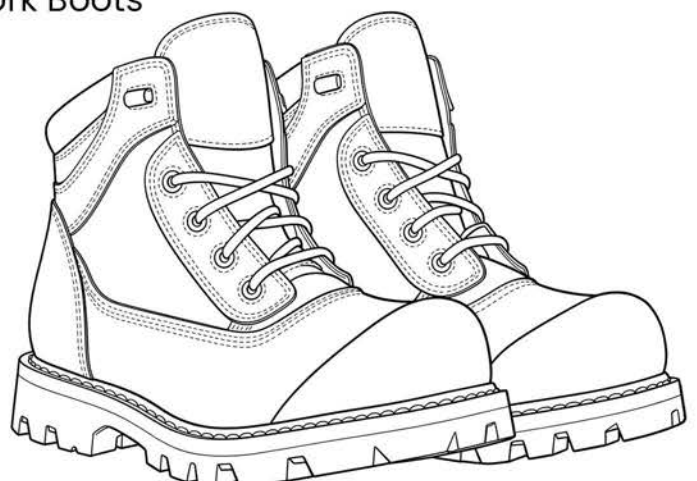


PPE

Safety Glasses



Work Boots



NOTICE

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

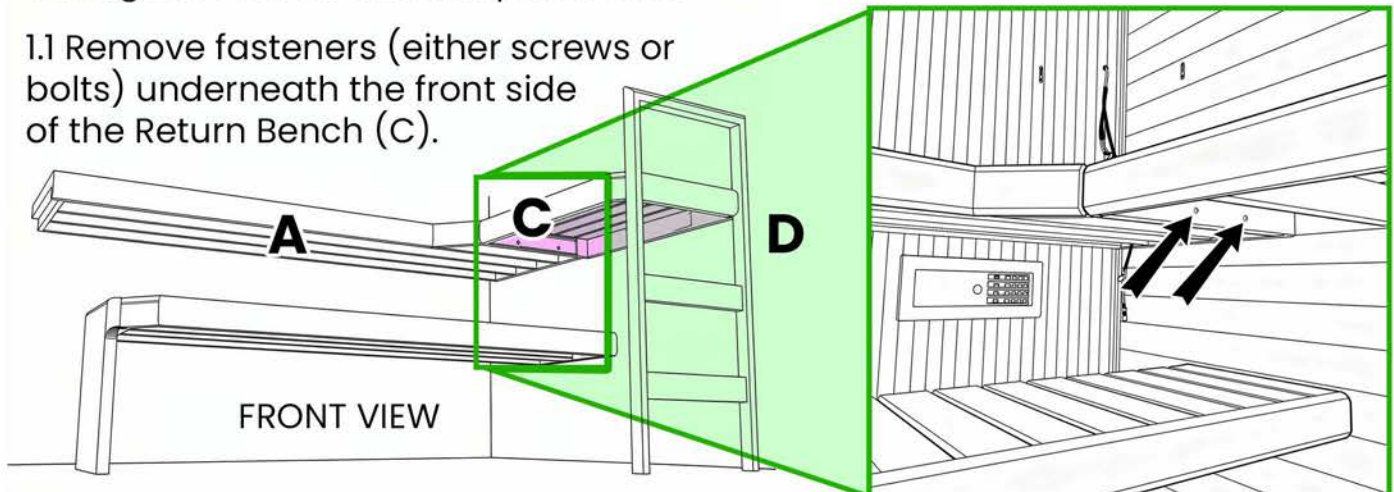
⚠ WARNING

- 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.

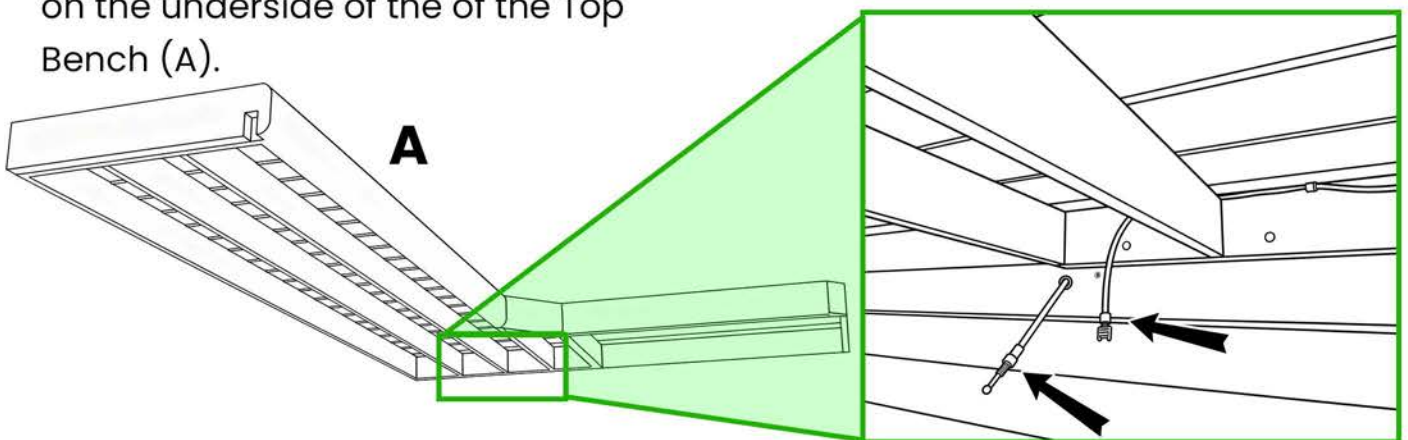
STEP 1. REMOVE RETURN BENCH (C)

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

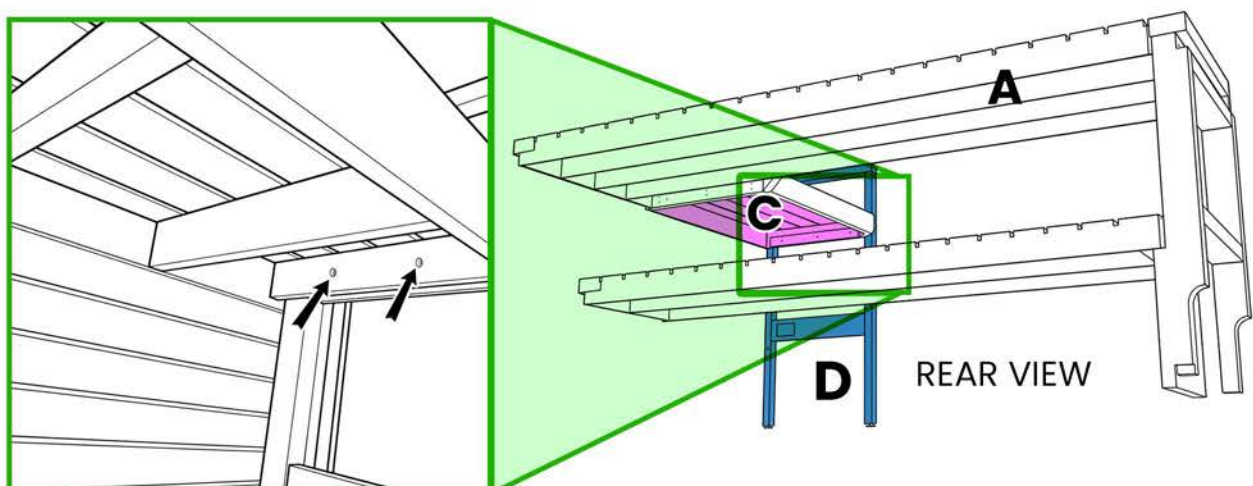
1.1 Remove fasteners (either screws or bolts) underneath the front side of the Return Bench (C).



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

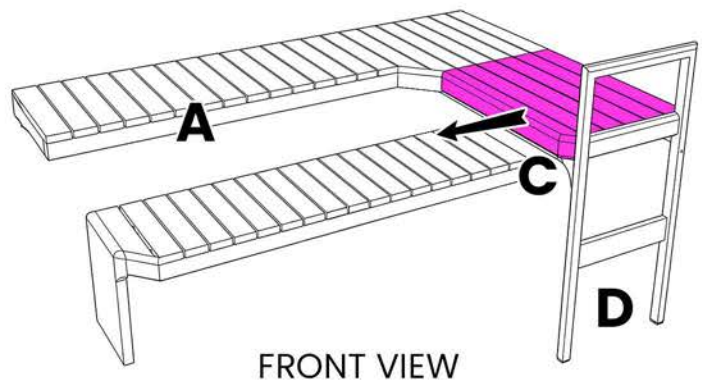


1.3 Remove two screws from underneath the Return Bench (C) using a torque limiting drill.



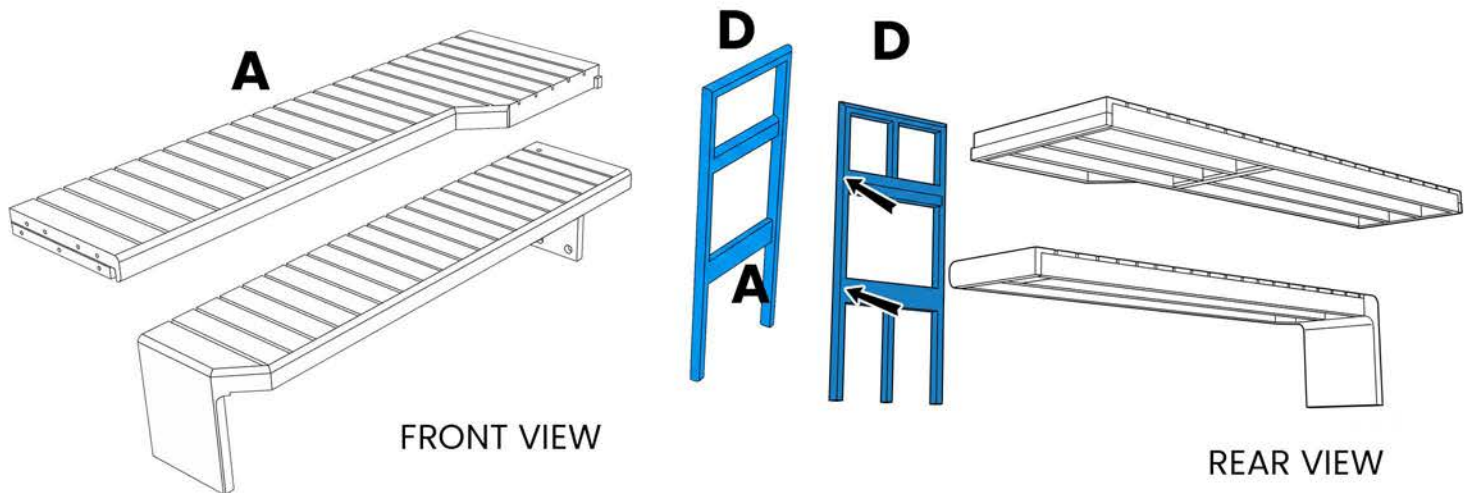
STEP 1. REMOVE RETURN BENCH (C)

1.4 Lift the Return Bench (C) out and place in a clear area outside the sauna.



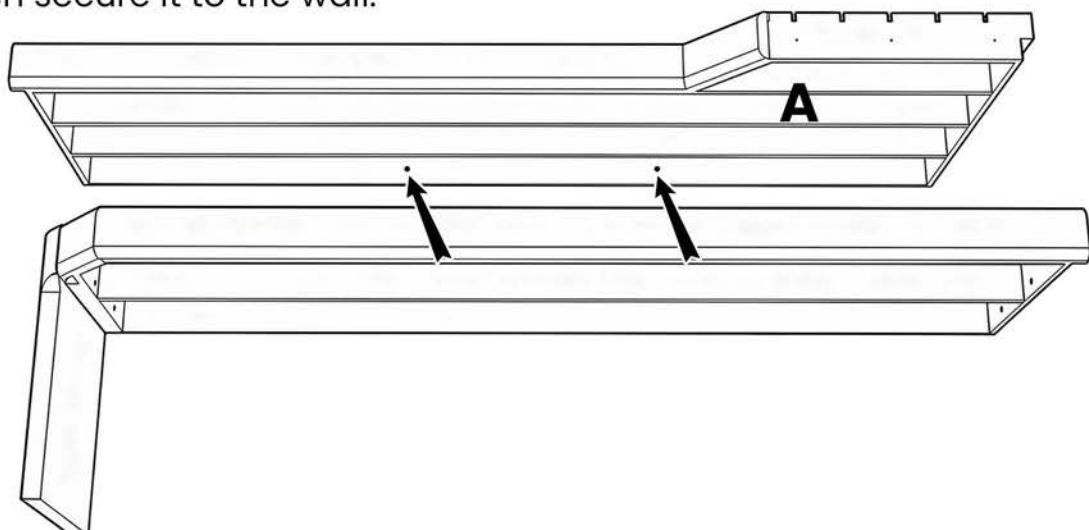
STEP 2. REMOVE H LEG (D)

Remove the two screws on the left side of the H Leg (D) using a torque limiting drill, and remove the H Leg (D) from the sauna.



STEP 3. REMOVE BENCHES (A)

3.1 If present, remove two screws underneath the back side of the Top Bench (A) which secure it to the wall.

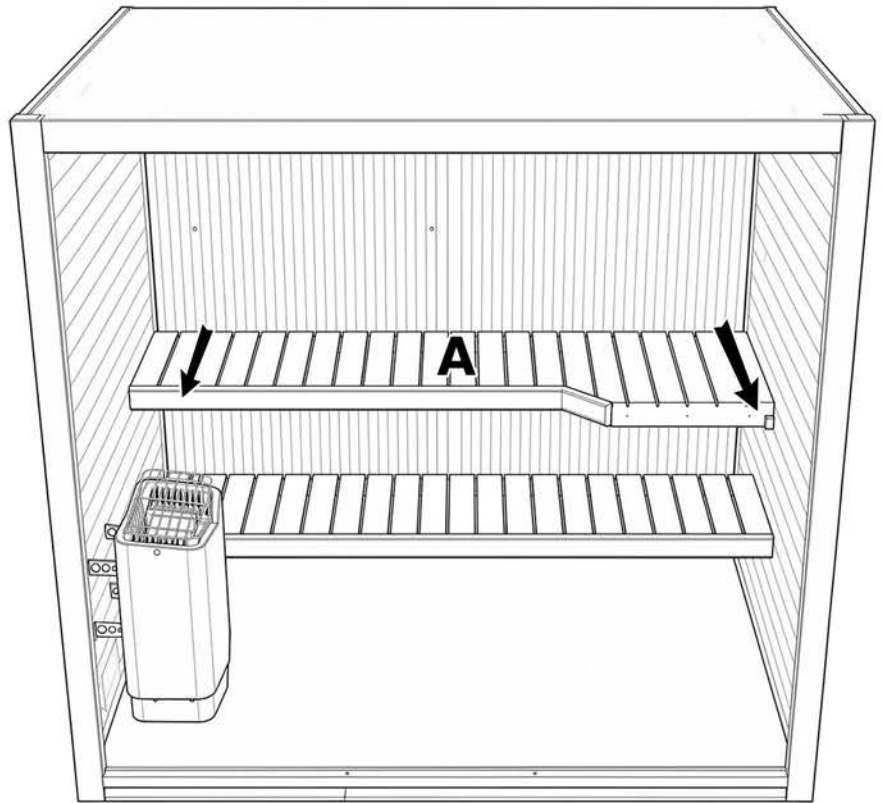


STEP 3. REMOVE BENCHES (A)

3.2 Slide the Top Bench (A) forward and lift it out. Carefully rotate the bench, angling it vertically for easier removal from the sauna.

CAUTION

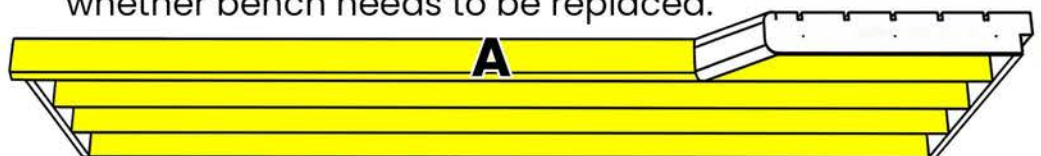
Do not strike glass door, walls, ceiling, or heater with the bench in order to avoid potential damage.



CHECK THE TOP BENCH FOR DAMAGE

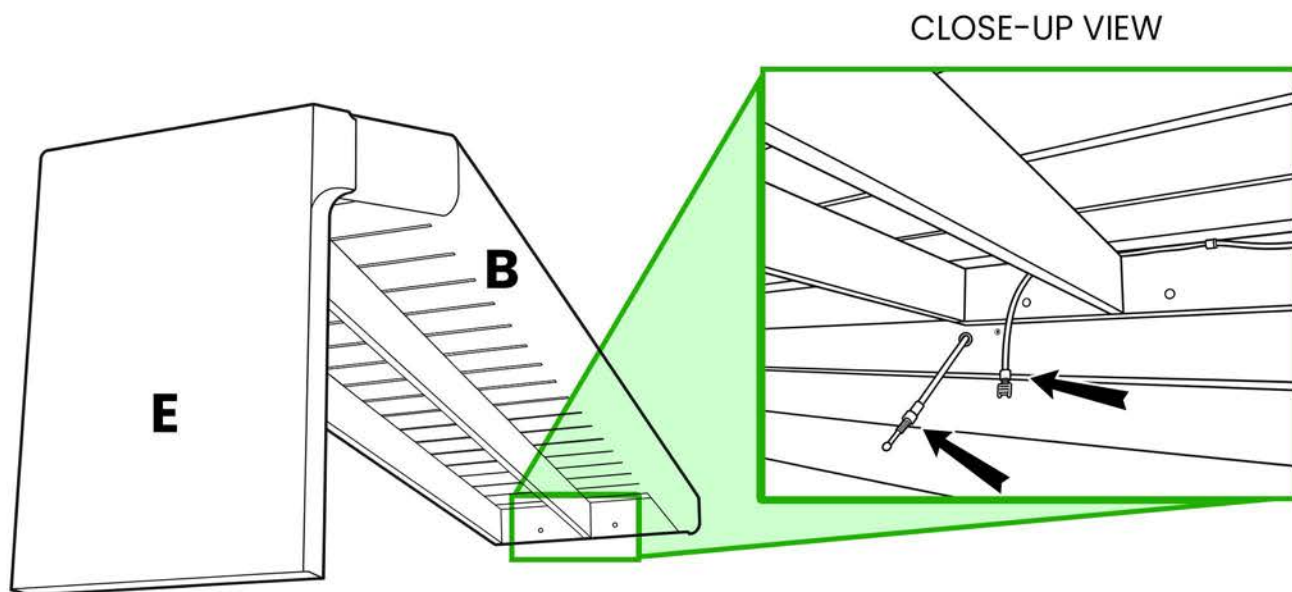
WARNING

- 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 (highlighted in yellow) the bench should be replaced. Contact 888-780-4427 (Menu Option - 2) if you are unsure whether bench needs to be replaced.



STEP 3. REMOVE BENCHES (B, E)

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



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

3.5 Lift the lower bench up and rotate one end of it down to move it out of the sauna.

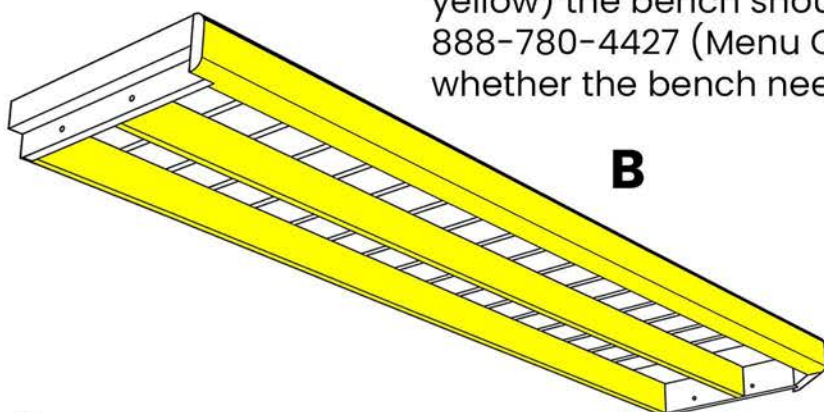
⚠ CAUTION

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

CHECK THE LOWER BENCH FOR DAMAGE

⚠ WARNING

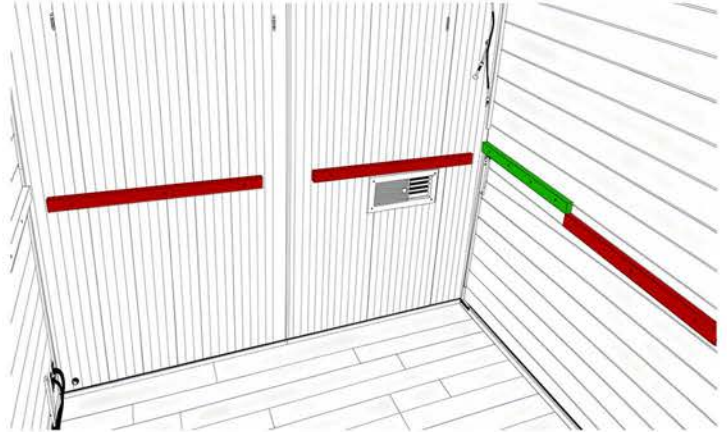
- Damaged stringers (highlighted in yellow) can weaken the bench structure and may result in bench failure, causing injury
- If there are cracks through the stringers (highlighted in yellow) the bench should be replaced. Contact 888-780-4427 (Menu Option - 2) if you are unsure whether the bench needs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



STEP 4. REMOVE BACK AND SIDE WALL CLEATS

4.1 Remove Back Wall Cleats and Side Wall Cleat

- If the back wall of the sauna has cleats installed, remove them before proceeding before proceeding (shown in red).
- If there are no back wall cleats, proceed to Step 5.
- If the right side wall of the sauna has a cleat (shown in red), remove it before proceeding.
- **DO NOT** remove the side wall cleat that is closest to the back wall of the sauna (shown in green).



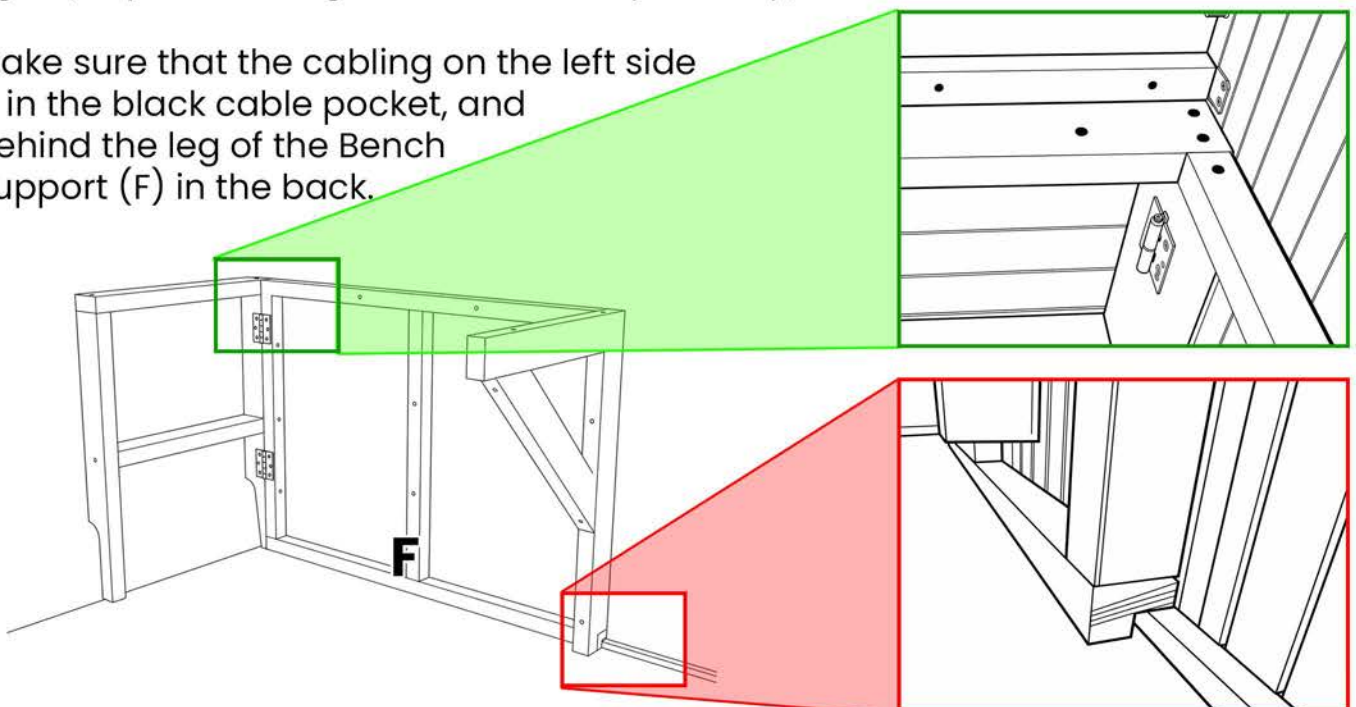
TO REMOVE BACK WALL CLEATS AND THE SIDE WALL CLEATS:

- 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.

STEP 5. INSTALL BENCH SUPPORTS (F)

5.1 Place the Left Side Upper Bench Support (F) 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).

Make sure that the cabling on the left side is in the black cable pocket, and behind the leg of the Bench Support (F) in the back.



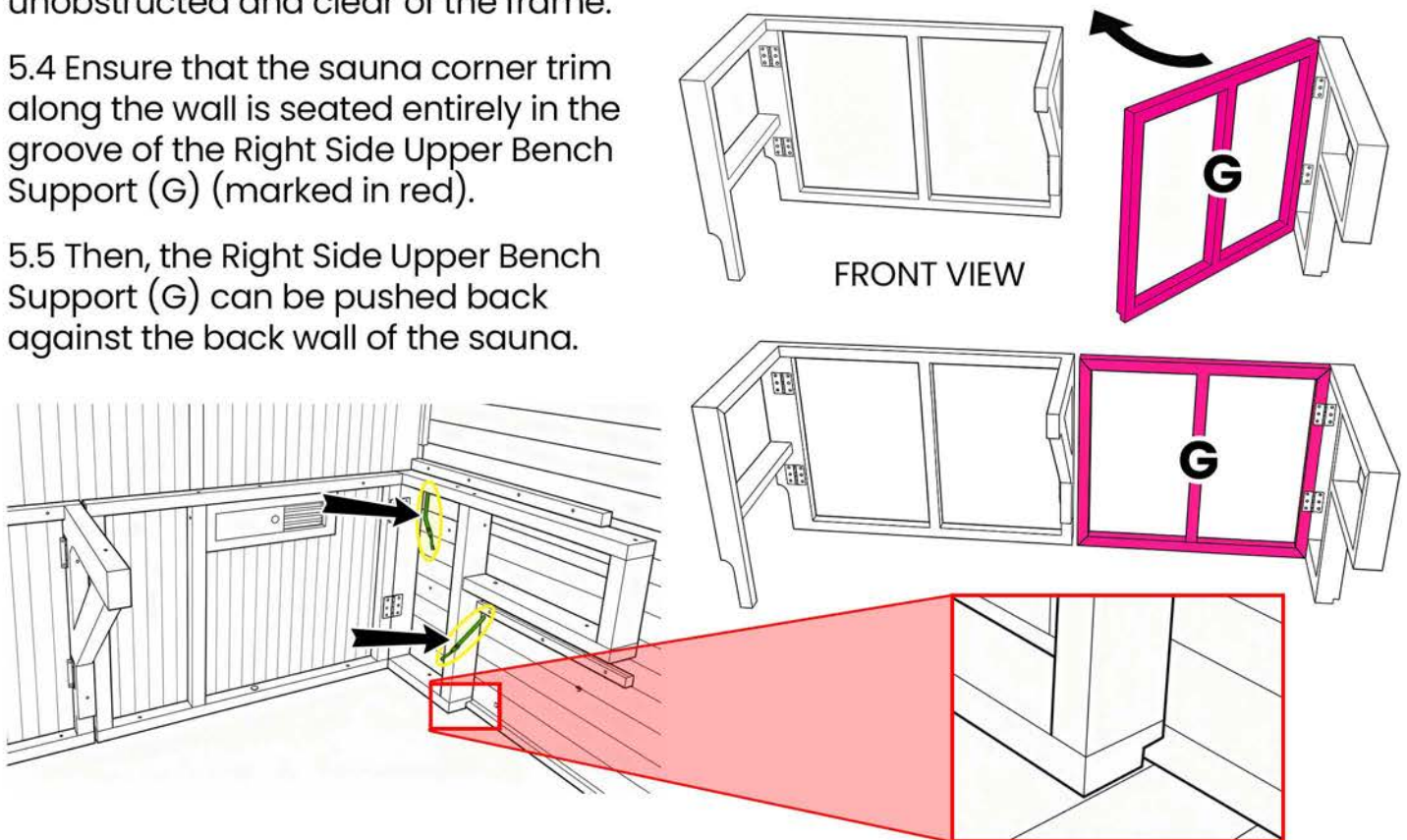
STEP 5. INSTALL BENCH SUPPORTS (G)

5.2 Place the Right Side Upper Bench Support (G) into the right corner of the sauna by placing it in the back right corner of the wall.

5.3 Route the upper and lower wires (circled in yellow) so they remain unobstructed and clear of the frame.

5.4 Ensure that the sauna corner trim along the wall is seated entirely in the groove of the Right Side Upper Bench Support (G) (marked in red).

5.5 Then, the Right Side Upper Bench Support (G) can be pushed back against the back wall of the sauna.

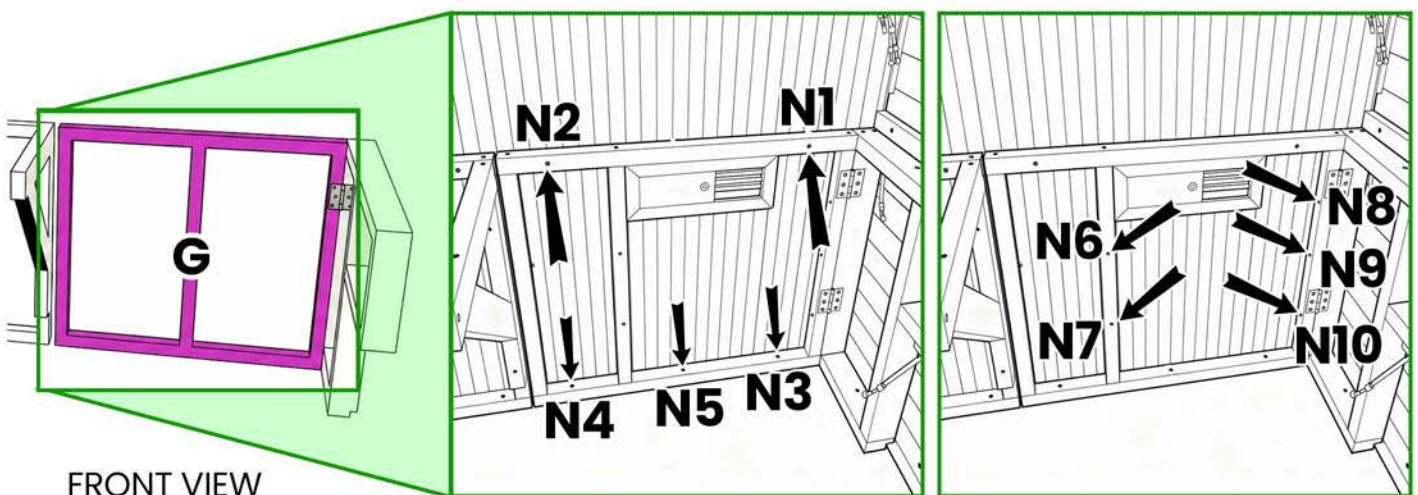


STEP 6: SECURE THE BENCH SUPPORTS (G)

6.1 Drive #9 x 2-1/2 inch screws (N) into the Right Side Upper Bench Support (G) at pre-drilled holes. Install the screws in numerical order (N1 - N10) as shown.

NOTICE

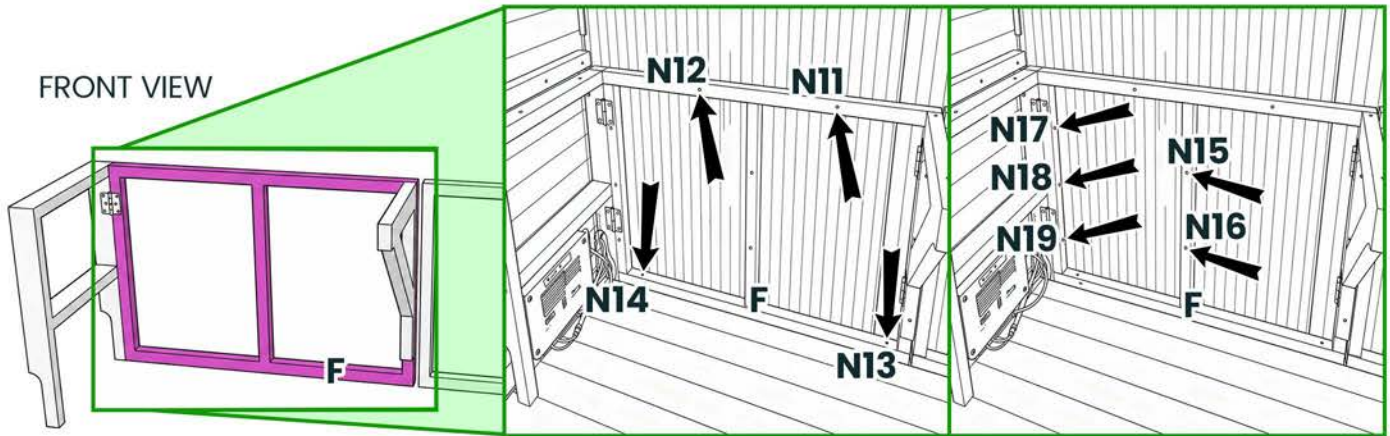
- Follow the order defined here, starting with affixing the top screws to the back wall.



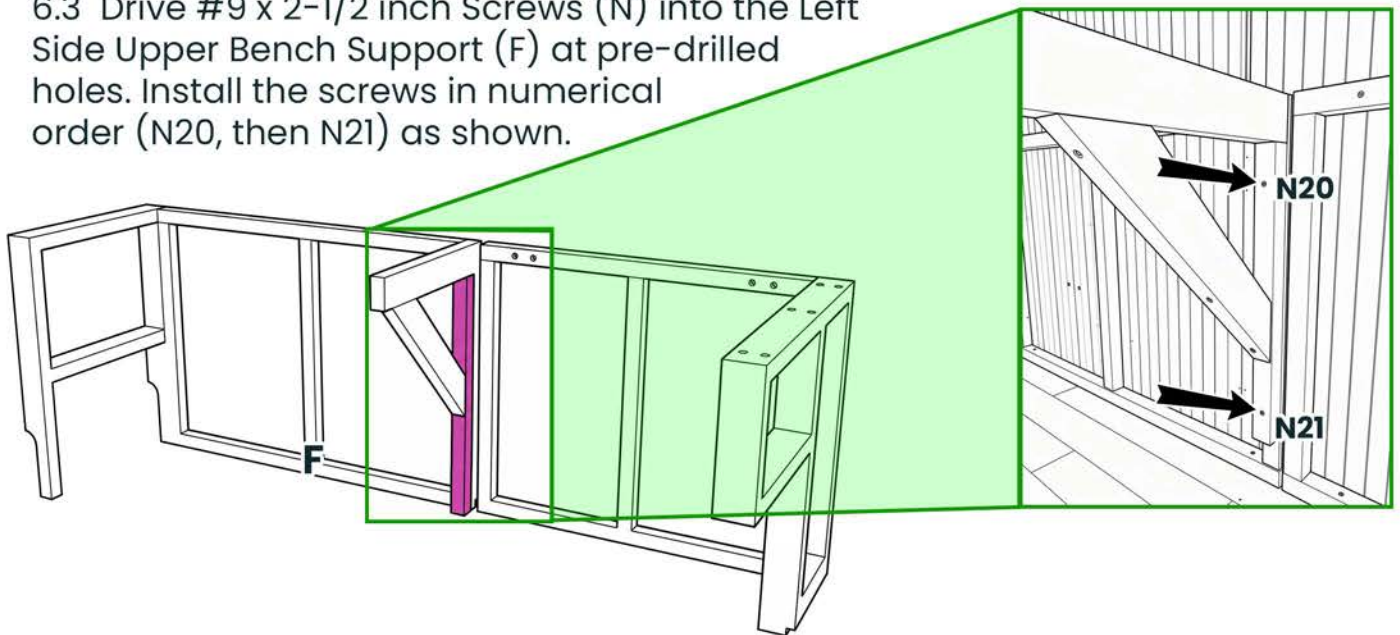
STEP 6. SECURE THE BENCH SUPPORTS (F)

6.2 Drive #9 x 2-1/2 inch Screws (N) into the Left Side Upper Bench Support (F) at pre-drilled holes. Install the screws in numerical order (N11 - N19) as shown.

Ensure all screws are flush and do not strip screw.



6.3 Drive #9 x 2-1/2 inch Screws (N) into the Left Side Upper Bench Support (F) at pre-drilled holes. Install the screws in numerical order (N20, then N21) as shown.

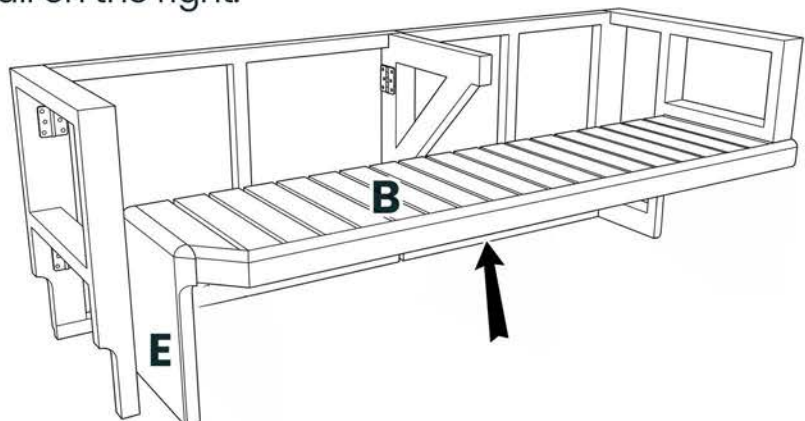


STEP 7. RE-INSTALL THE LOWER BENCH STRUCTURES (B,E)

7.1 Bring the assembled Lower Bench (B + E) into the sauna and slide it onto the right cleat, flush against the wall on the right.

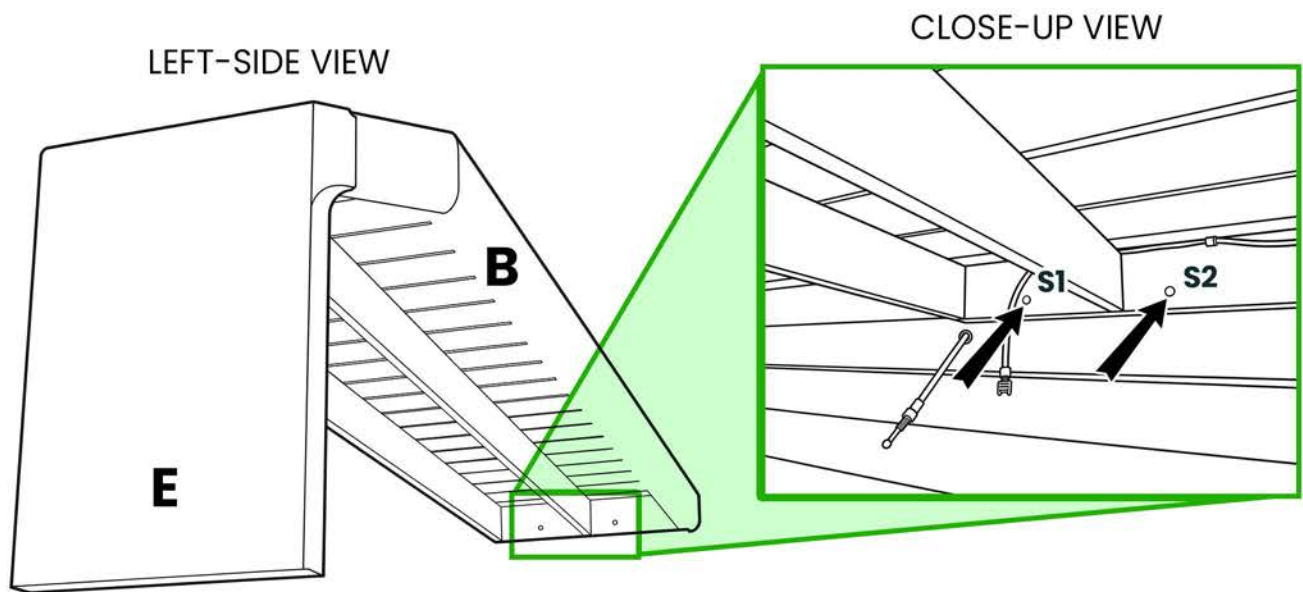
CAUTION

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

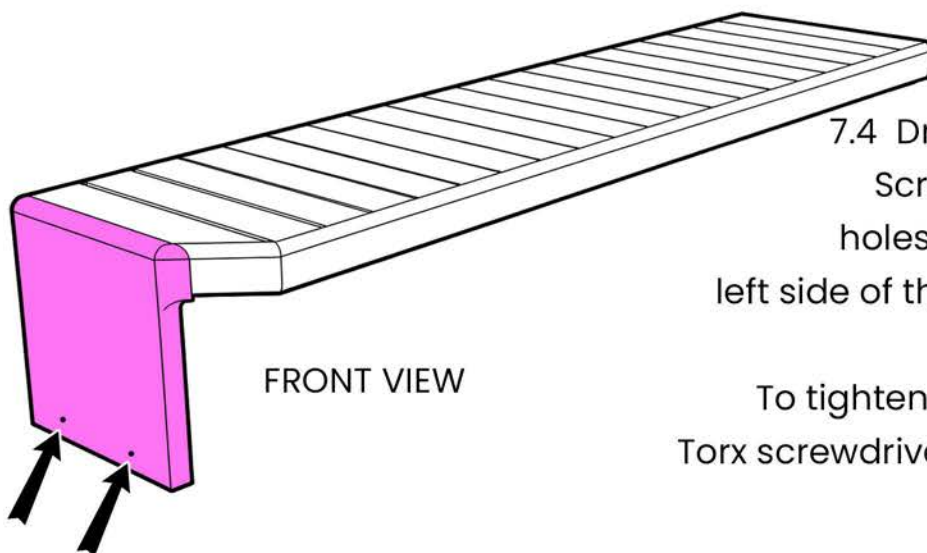
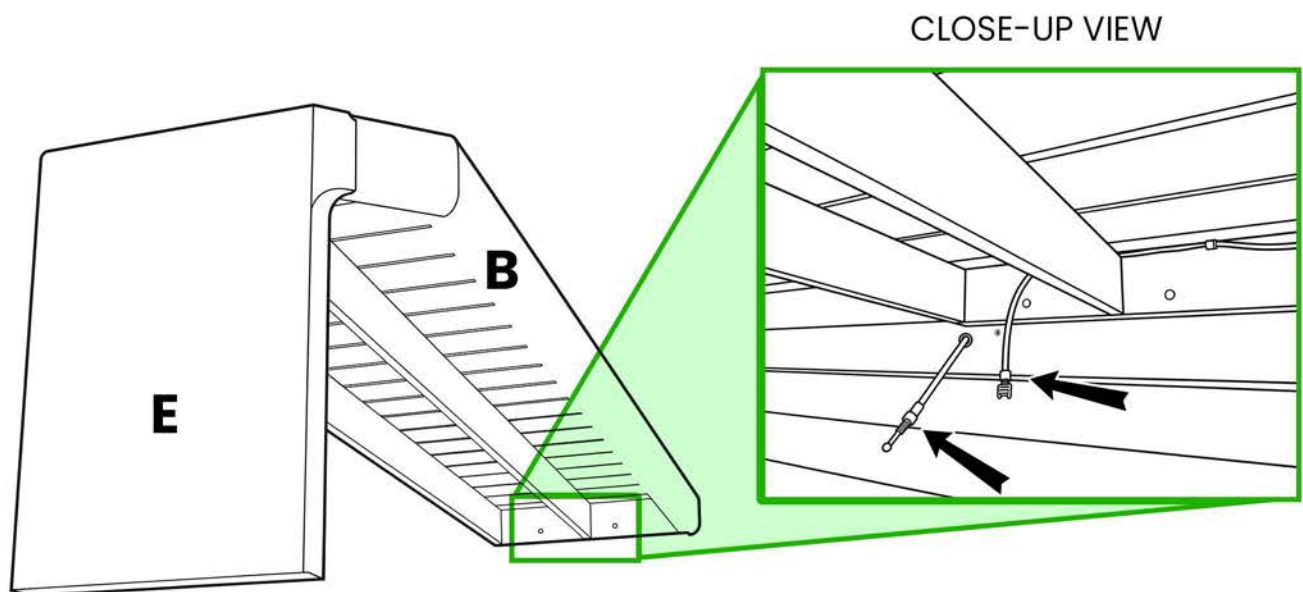


STEP 7. RE-INSTALL THE LOWER BENCH STRUCTURES (B, E)

6.2 Drive two # 9 x2" Torx Flat-Head Screw (S) into the inner right side of the lower bench (B), against the right wall of the sauna at pre-drilled holes.



7.3 Reconnect the lower lighting wires located underneath the lower bench.

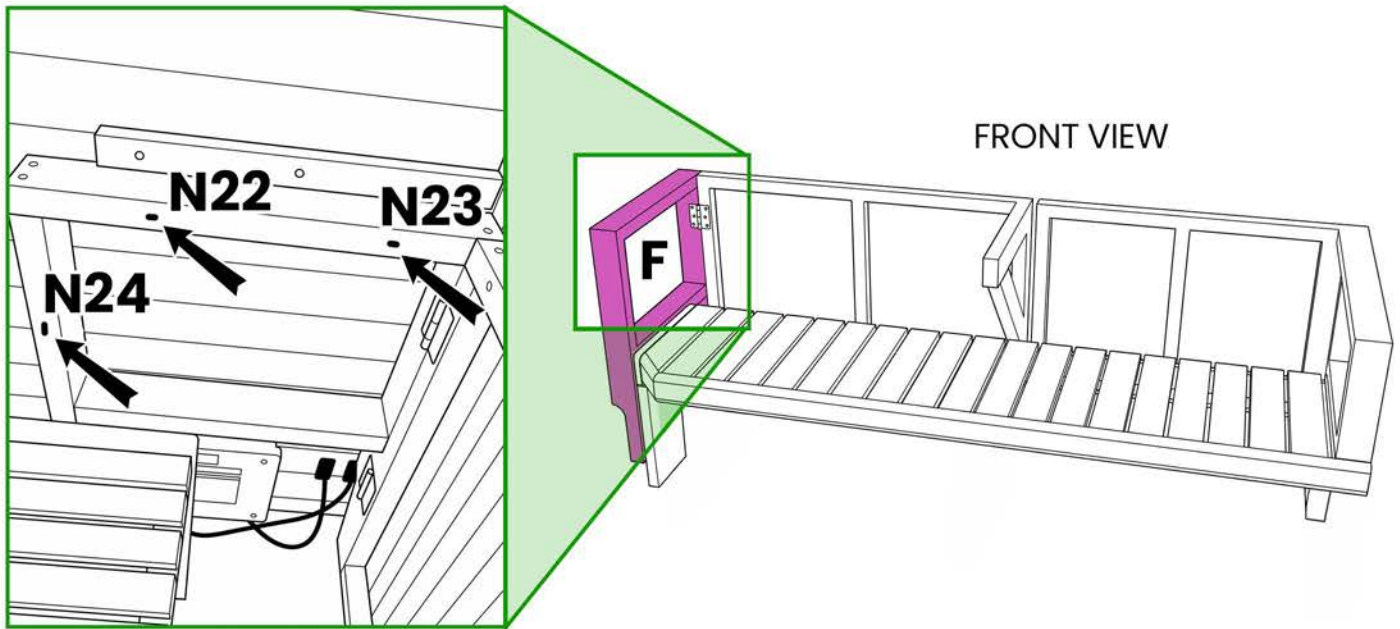


7.4 Drive in two #8 Button Heads Screws (O) into the pre-drilled holes on the bottom of the outer left side of the Lower Bench Support (E).

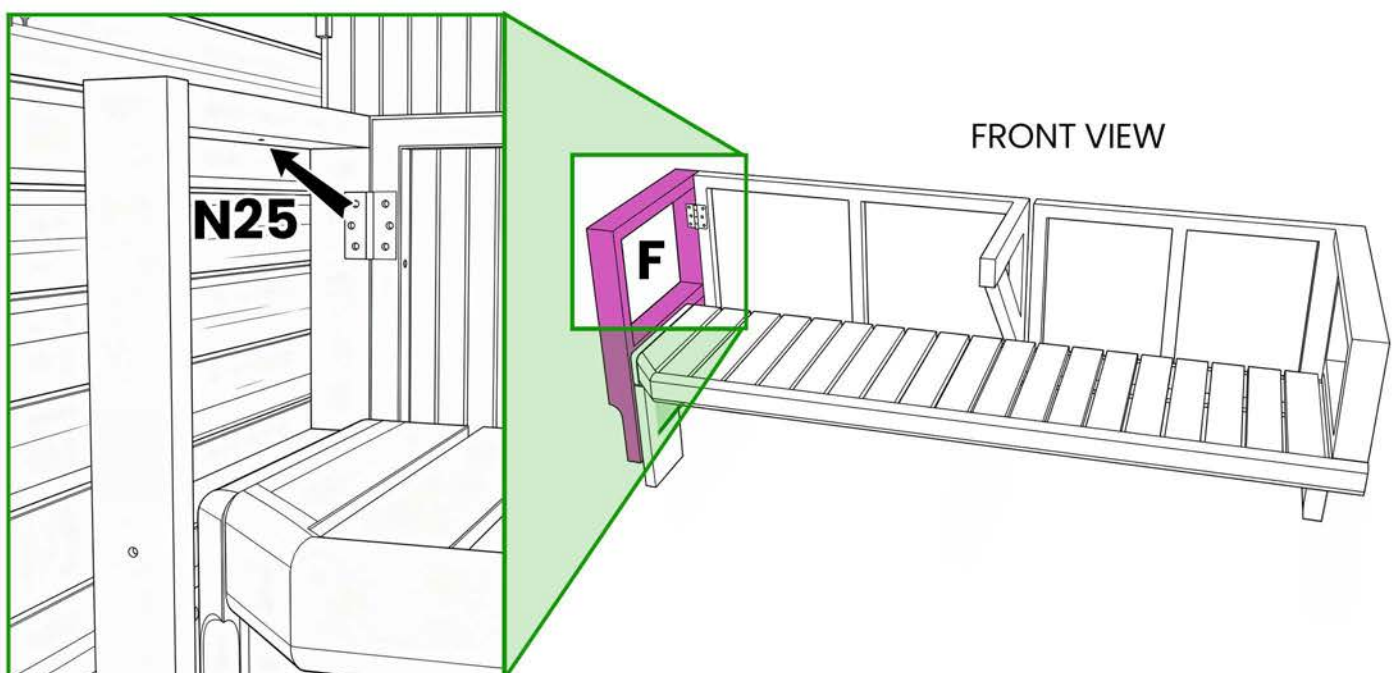
To tighten the screws, you will need a Torx screwdriver with a 16-inch extension.

STEP 8. SECURE THE BENCH SUPPORT TO SIDE WALL (F, G)

8.1 Push the Left Side Upper Bench Support (F) against the wall into place, and drive in three #9 x 2-1/2-inch Screws (N) into pre-drilled holes in the side of the Left Side Upper Bench Support (F) that sits against the left wall of the sauna in the noted order.



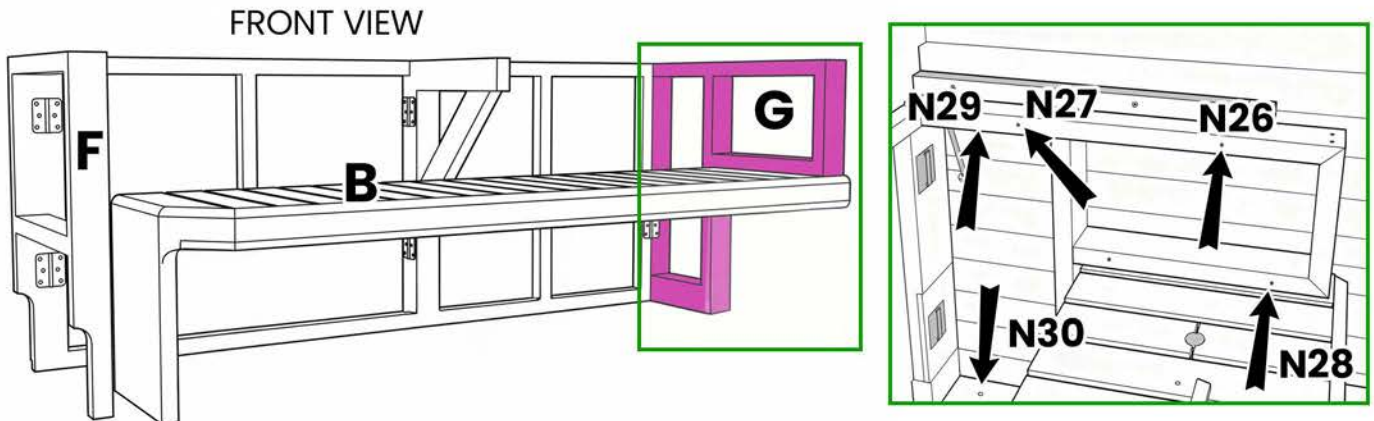
8.2 Drive in one #9 x 2-1/2-inch Screw (N) into the underside of the Left Side Upper Bench Support (F) that goes through the bench into the cleat.



STEP 8. SECURE THE BENCH SUPPORT TO SIDE WALL (F, G)

8.3 Push the Lower Bench (B) and Right Side Upper Bench Support (G) against the wall into place, and drive in #9 x 2-1/2 inch Screws (N) into the side of the Right Side Upper Bench Support (G) that sits against the right side of the sauna at pre-drilled holes. Install the screws in numerical order (N26, N27, N28, N29, then N30) as shown.

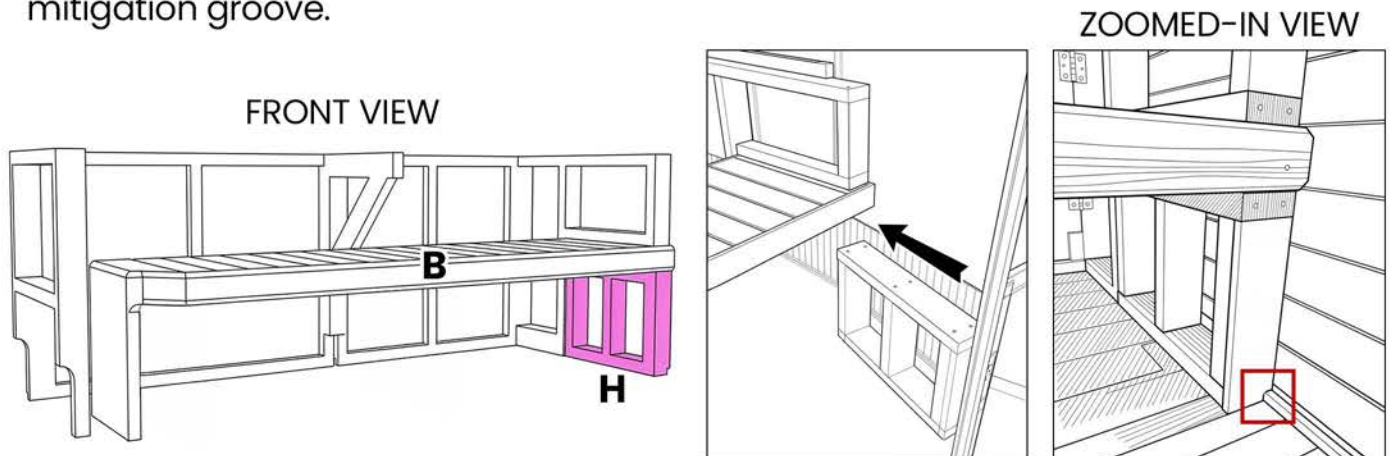
Note that the N29 screw goes from the underside of the Right Side Upper Bench Support (G) up into the cleat (red arrow).



STEP 9. INSTALL THE RETURN LOWER BENCH SUPPORT (H)

9.1 Slide the Return Lower Bench Support (H) under the Right Side of the Lower Bench (B).

Make sure that the Return Lower Bench Support (H) is behind the dark brown front edge of the Lower Bench (B) and beneath the stringer. Make sure that the Return Lower Bench Support (H) is flush with the wall, with the sauna corner trim in the mitigation groove.



STEP 9. INSTALL THE RETURN LOWER BENCH SUPPORT(H)

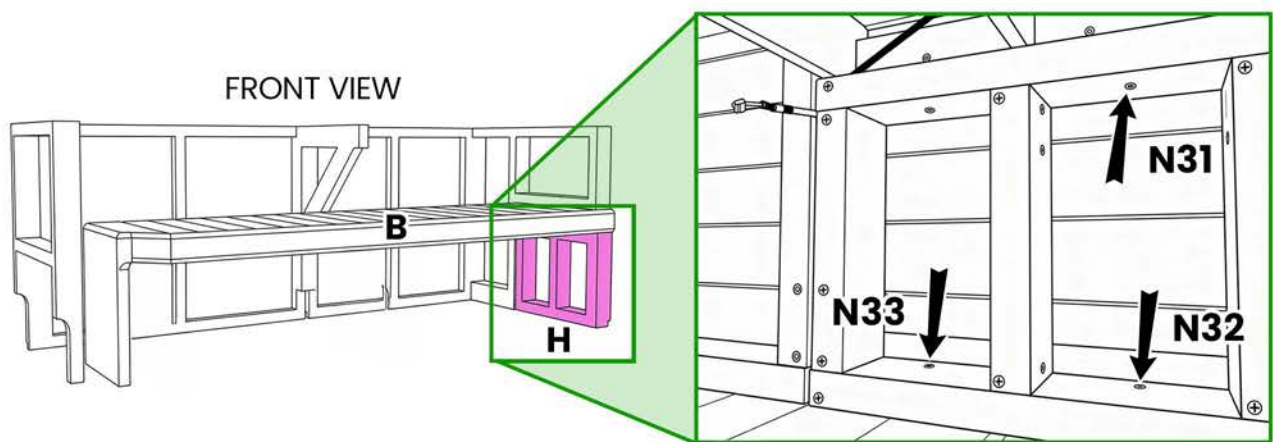
If there is a gap between the Return Lower Bench Support (H) and the Lower Bench (B) slide in the supplied shims to eliminate the gaps.

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 (Q) into the pilot hole through the shim and support. Once the shims are secure, re-install the Lower Bench (B)

9.2 Make sure the Return Lower Bench Support (H) is flush against the wall and confirm that it is underneath the Lower Bench(B). Then drive #9 x 2-1/2 inch screws into pre-drilled holes. Install the screws in numerical order (N31, N32, then N33) as shown.

⚠ WARNING

Gap between Lower Bench (B) and Bench Support (H) can result in bench collapse and serious injury.

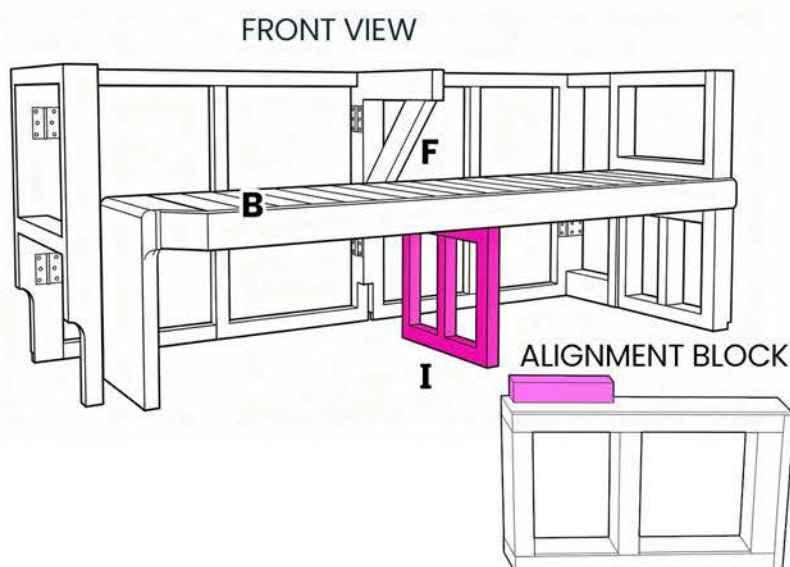


STEP 10. INSTALL THE LOWER BENCH MIDSPAN SUPPORT (I)

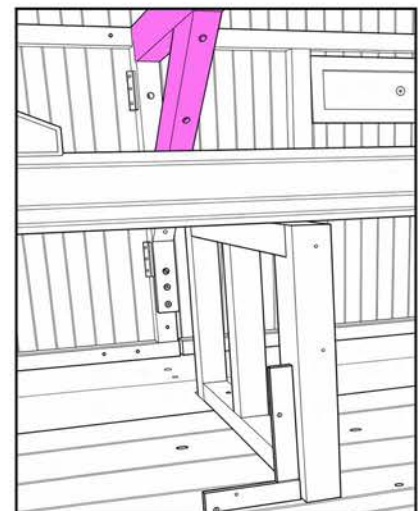
10.1 Place the Lower Bench Midspan (I) support underneath the Lower Bench (B) in line with the cantilever on the Left Side Upper Bench Support (F).

Align the Lower Bench Midspan Support (I) such that the Top Alignment Block (highlighted) sits between the back two stringers.

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



CANTILEVER (Part of F)



STEP 11. SECURE THE LOWER BENCH MIDSPAN SUPPORT(I)

If there is a gap between the Lower Bench Midspan Support (I) 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 (Q) into the pilot hole through the shim and support. Once the shims are secure, re-install the Lower Bench.

WARNING

Gap between Top Bench (B) and Bench Support (I) can result in bench collapse and serious injury.

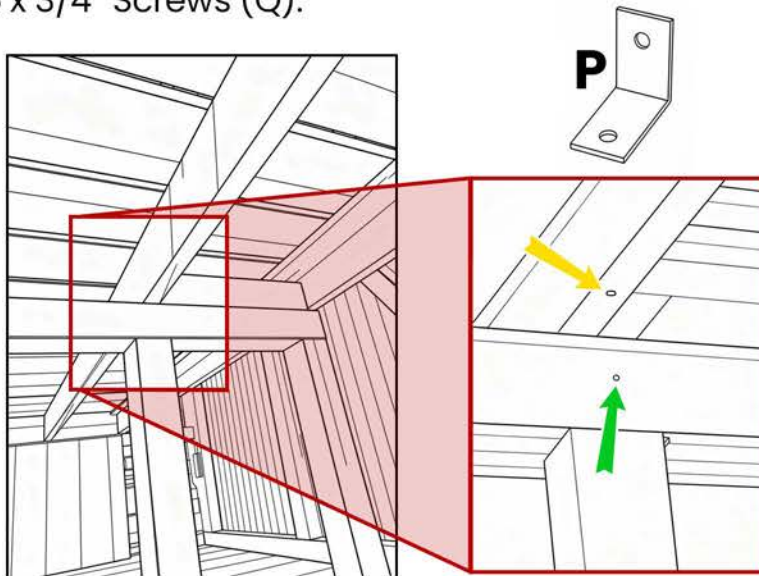
11.1 Install the Metal Bracket (P) in the Lower Bench Midspan Support (I).

11.2 Position the metal bracket over the pre-drilled hole (green arrow).

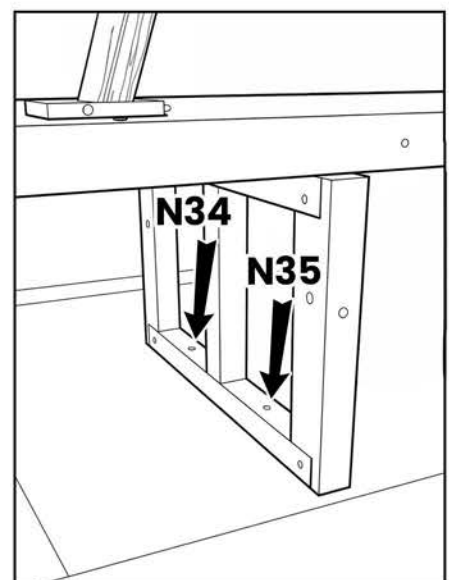
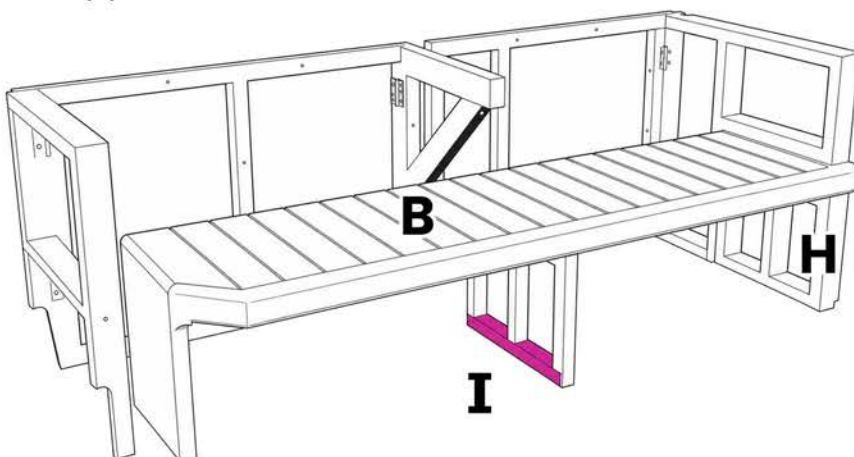
11.3 Mark the location of the upper hole (yellow arrow) through the metal bracket using a pencil.

11.4 Drill a pilot hole into the lower bench stringer approximately 1" deep (yellow arrow) using a 3/32 drill bit.

11.5 With the metal bracket aligned over the pilot holes, drive the screws in using #6 x 3/4" Screws (Q).



11.6 Drive two #9 2-1/2 inch Screws (N) through the bottom of the Lower Bench Midspan Support (I) into the Sauna floor.



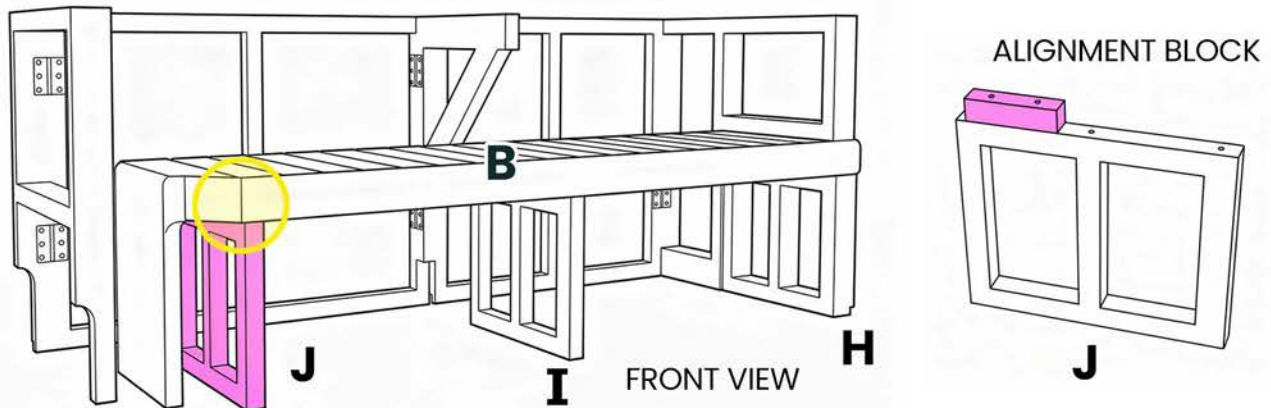
STEP 12.

INSTALL THE LEFT LOWER BENCH MIDSPAN SUPPORT (J)

12.1 Place the Left Lower Bench Midspan Support (J) underneath the Lower Bench (B) underneath the front left corner (circled in yellow).

Align the Left Lower Bench Midspan Support (J) such that the top alignment block (highlighted) sits between the back two stringers.

Use a small framing square or similar to ensure the support is perpendicular to the floor and Lower Bench (B).



STEP 13.

SECURE THE LEFT LOWER BENCH MIDSPAN SUPPORT (J)

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

⚠ WARNING

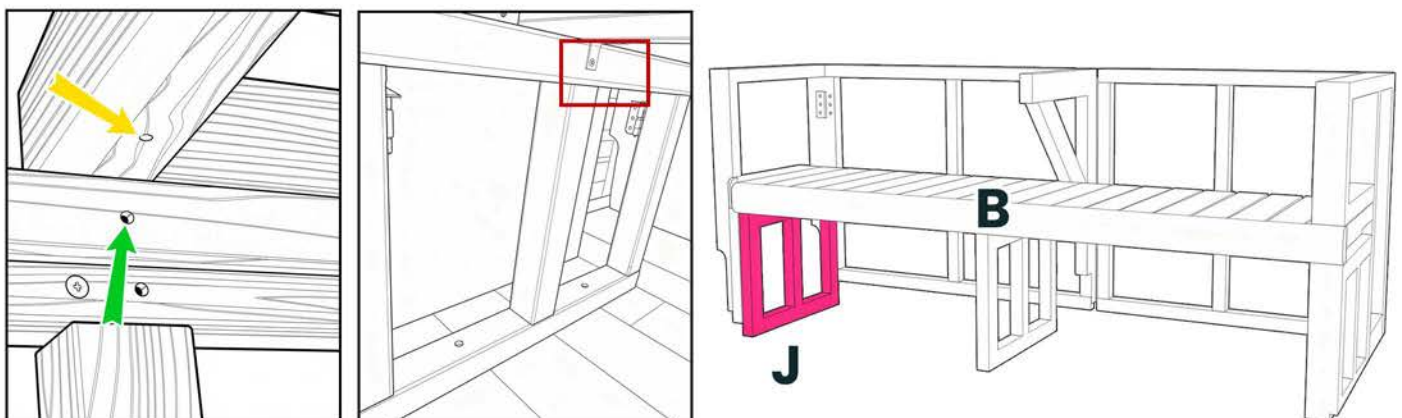
Gap between Top Bench (B) and Bench Support (J) can result in bench collapse and serious injury.

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 (Q) into the pilot hole through the shim and support. Once the shims are secure, re-install the Lower Bench (B).

13.1 Install the Metal Bracket (P) in the Lower Bench Midspan Support (J).

13.2 Position the metal bracket over the pilot hole (green arrow).

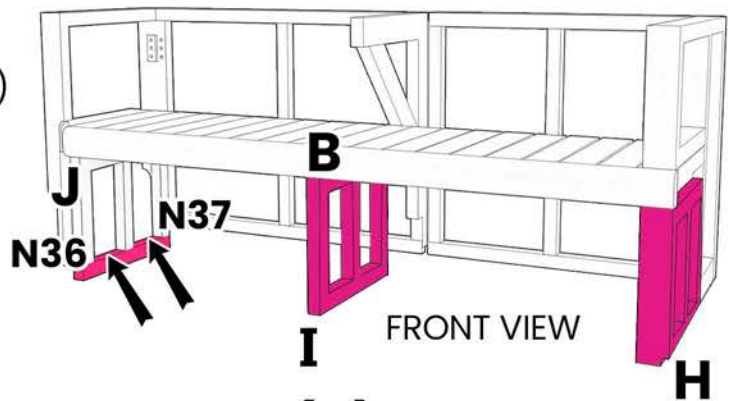
13.3 Drill a pilot hole into the lower bench stringer approximately 1" deep (yellow arrow) using a 3/32 drill bit.



STEP 13.

SECURE THE LEFT LOWER BENCH MIDSPAN SUPPORT (J)

13.5 Drive two #9 2-1/2 inch Screws (N) through pre-drilled holes on the bottom of the Lower Bench Midspan Support (J) into the sauna floor (N36, N37).



STEP 14. RE-INSTALL THE TOP BENCH (A)

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

CAUTION

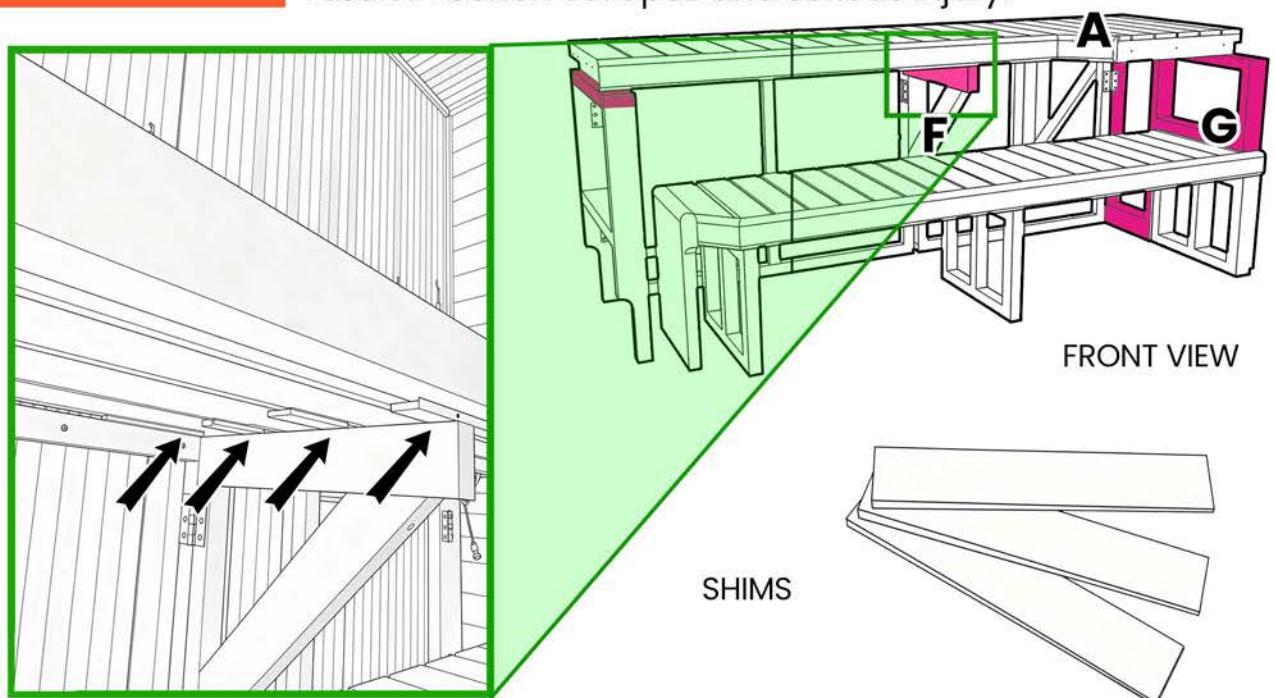
Do not strike glass door, walls, ceiling, or heater with the bench in order to avoid potential damage.



14.2 Check for gaps between the Top Bench (A) and the Left and Right Upper Bench Supports (G, F), 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 (Q) into the pilot hole through the shim and support. Once the shims are secure, re-install the Top Bench (A).

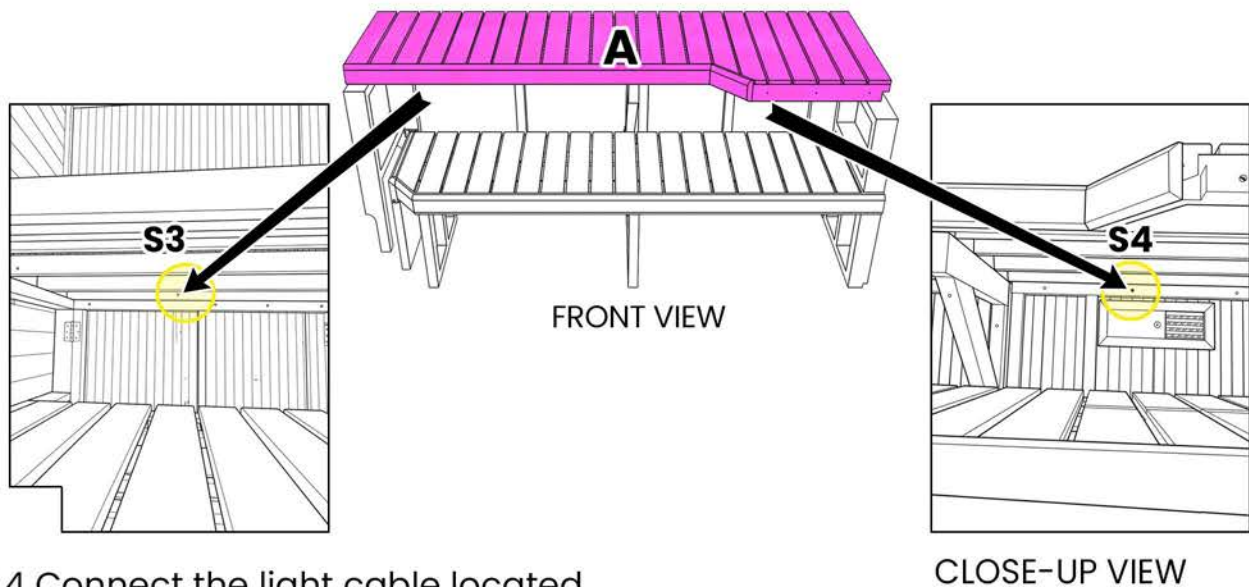
WARNING

Gap between Top Bench (A) and Bench Supports (G, F) can result in bench collapse and serious injury.

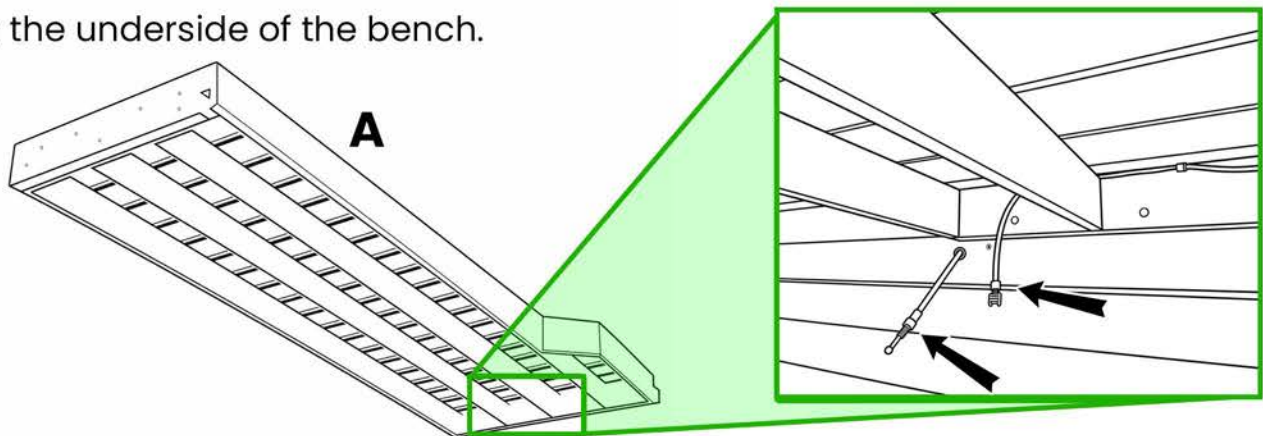


STEP 14. RE-INSTALL THE TOP BENCH (A)

14.3 Drive in two # 9 x2" Torx Flat-Head Screw (S) through pre-drilled holes at the rear of the Top Bench (A) into the back wall (yellow circles).



14.4 Connect the light cable located on the underside of the bench.



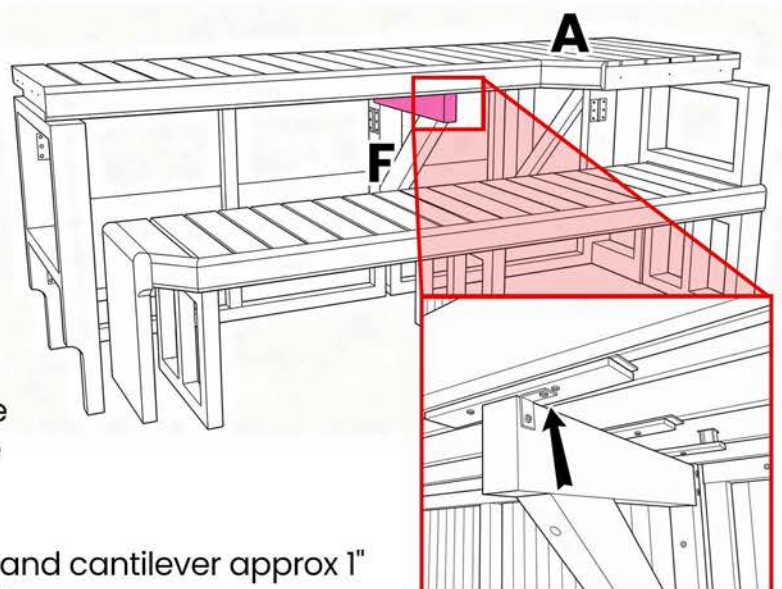
STEP 15. SECURE THE TOP BENCH (A)

15.1 Install the Metal Bracket (P) on the right side of the cantilever of the Upper Bench Mitigation (F).

Position the Metal Bracket (P) at the front right side of the cantilever and mark the location of the upper and lower hole through the Metal Bracket (P) 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 the Upper Bench.

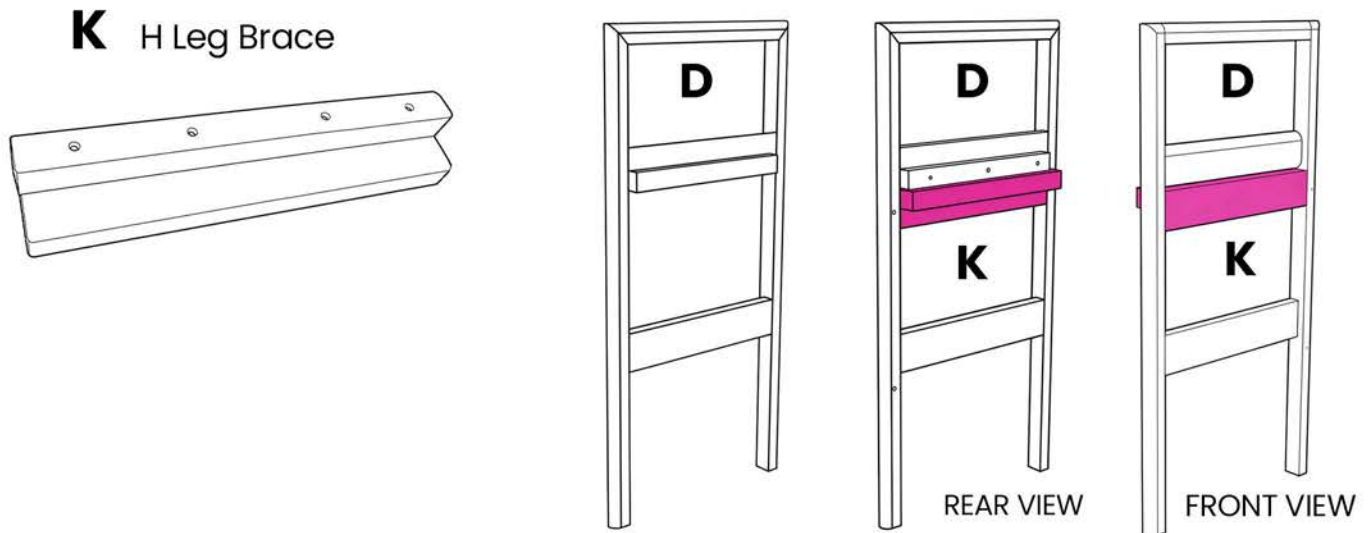
Drill a pilot hole into the Top Bench (A) and cantilever approx 1" deep (black arrow) using a 3/32 drill bit

With the metal bracket aligned over the pilot holes, drive the screws in using #6 x 3/4" Screws (Q).



STEP 16. INSTALL THE H LEG BRACE (D, K)

16.1 Place the H Leg Brace (K) underneath the cleat of the H Leg (D). Ensure that the H Leg Brace (K) is lined up with the surface of the H Leg (see red shading)



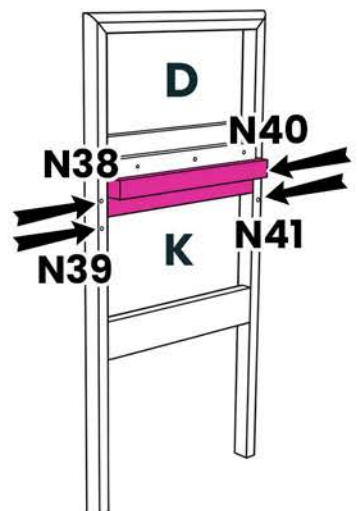
16.2 Measure 14 inches down from the top edge of the left side of the H Leg Brace (K). Mark the first pilot hole at this location.

16.3 Measure 15.5 inches down from the top edge of the left side of the H Leg Brace, under the first pilot hole. Mark the second pilot hole at this location.

16.4 Repeat for the right side of the H Leg Brace (K).

16.5 Drill pilot holes $\frac{9}{64}$ " countersink taper drill bit.

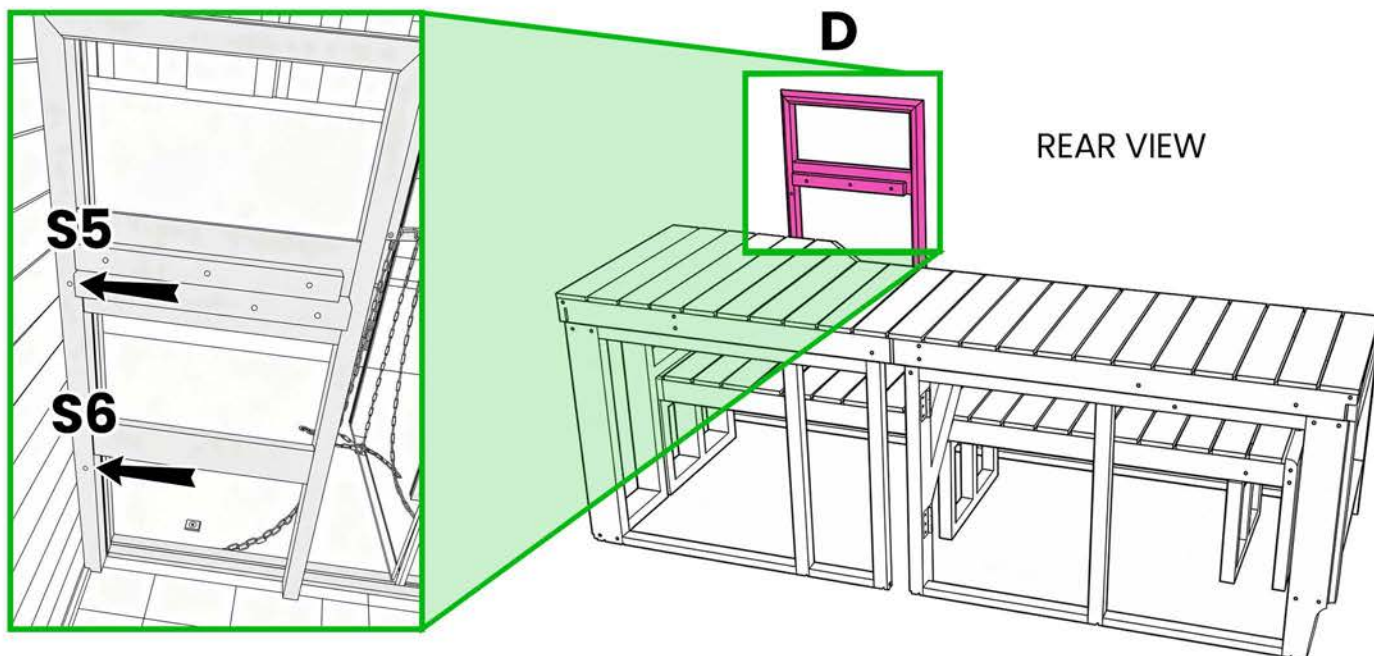
16.6 Secure the H Leg Brace (K) using two #9 2-1/2 inch Torx Flat Head Screws (N) on each side of the H Leg Brace into the H Leg (N38, N39, N40, N41).



STEP 17. INSTALL THE H LEG (D)

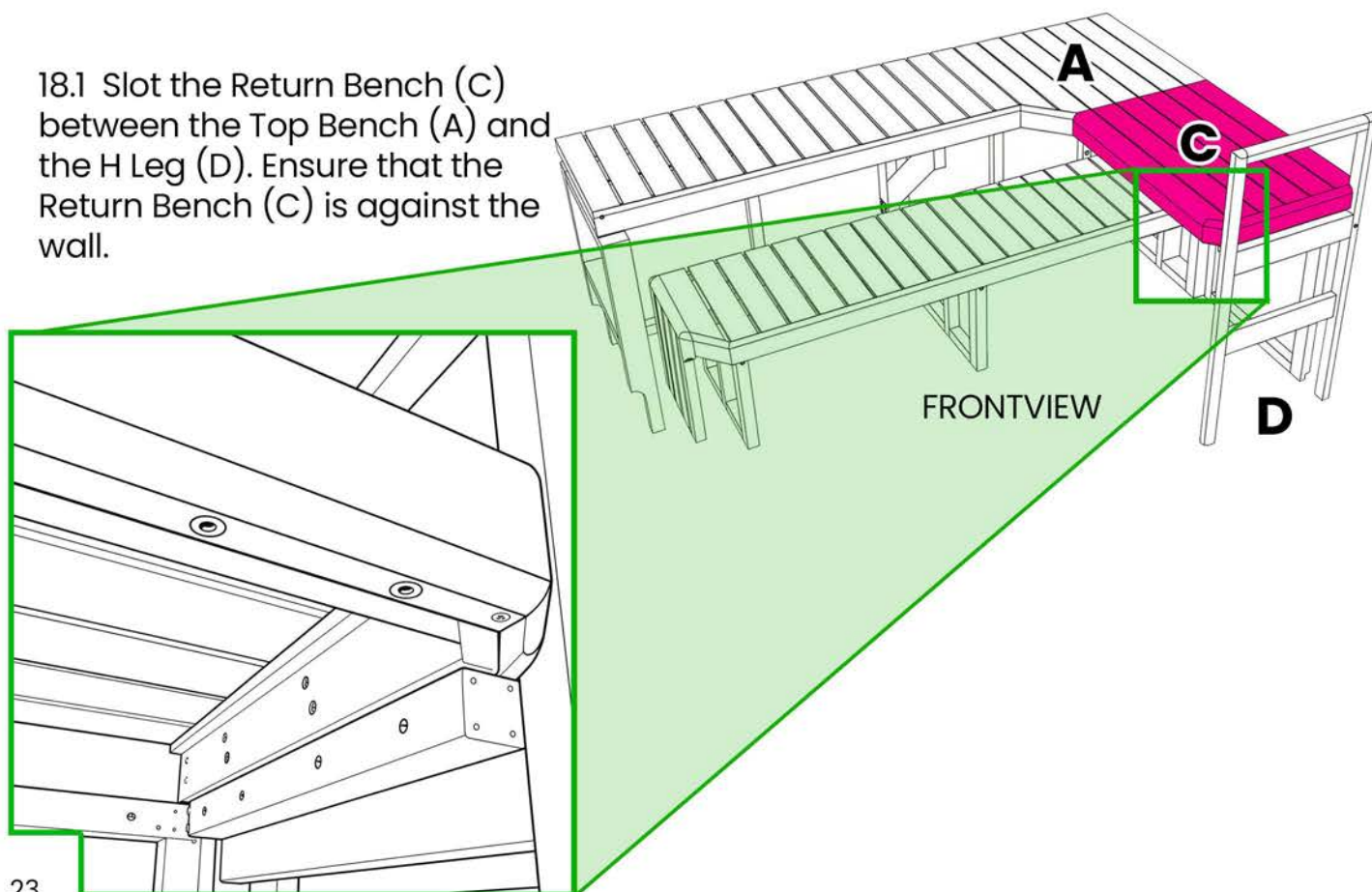
17.1 Place the assembled H Leg (D + K) inside the sauna against the glass door opposite the side with the heater.

17.2 Drive two #9 x 2" Torx Flat-Head Screws (S) into pre-drilled holes in the H Leg (D) in the order specified. Install the screws in numerical order (S5, then S6) as shown.



STEP 18. RE-INSTALL THE RETURN BENCH (C)

18.1 Slot the Return Bench (C) between the Top Bench (A) and the H Leg (D). Ensure that the Return Bench (C) is against the wall.



STEP 19. SECURE THE RETURN BENCH (C)

19.1 When initially removing the Return Bench (C) in step 1.2, if screws were removed, reinsert new # 9 x2" Torx Flat-Head Screw (S). If bolts were removed, follow steps 19.2-19.7.

IF BOLTS:

19.2 Gather two of each of the following: (2) 5/16 x 3" Hex Bead Bolts, (2) 5/16" Hex-Nuts, (2) flat washers, and (2) Split-Lock Washers (RA-RD).

19.3 Slide one Flat Washer (RC) onto each Hex Bolt (RA).

19.4 Insert the bolts through the drilled holes in the rear edge of the Return Bench (C) to the front right edge of the Top Bench (A).

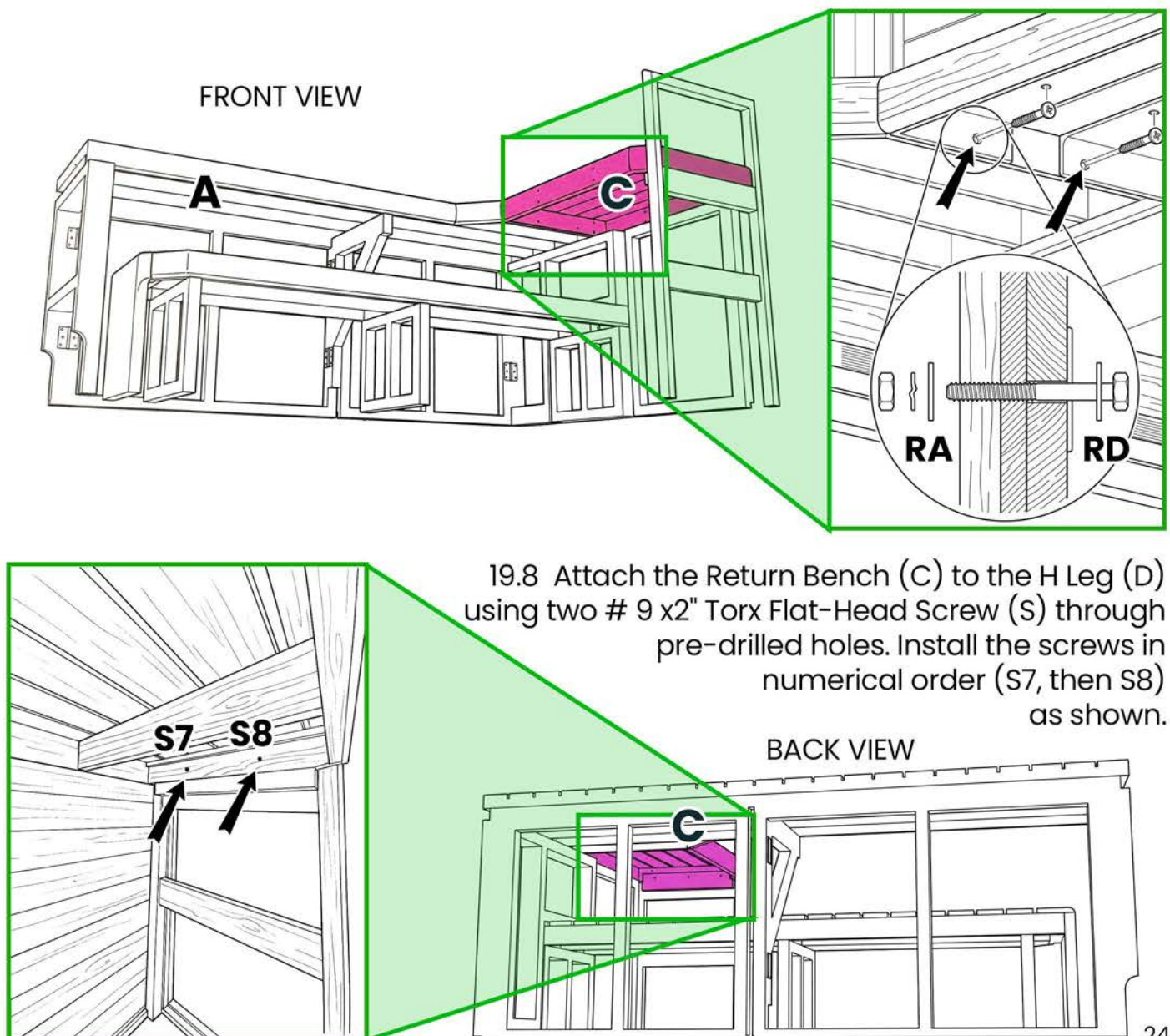
19.5 Slide on one Flat Washer (RC) and one Split-Lock Washer (RD) onto the ends of each bolt.

19.6 Install a hex nut onto the end of each bolt.

19.7 Tighten the hex nut until the Split-Lock Washer (RD) is compressed flat, using a wrench.

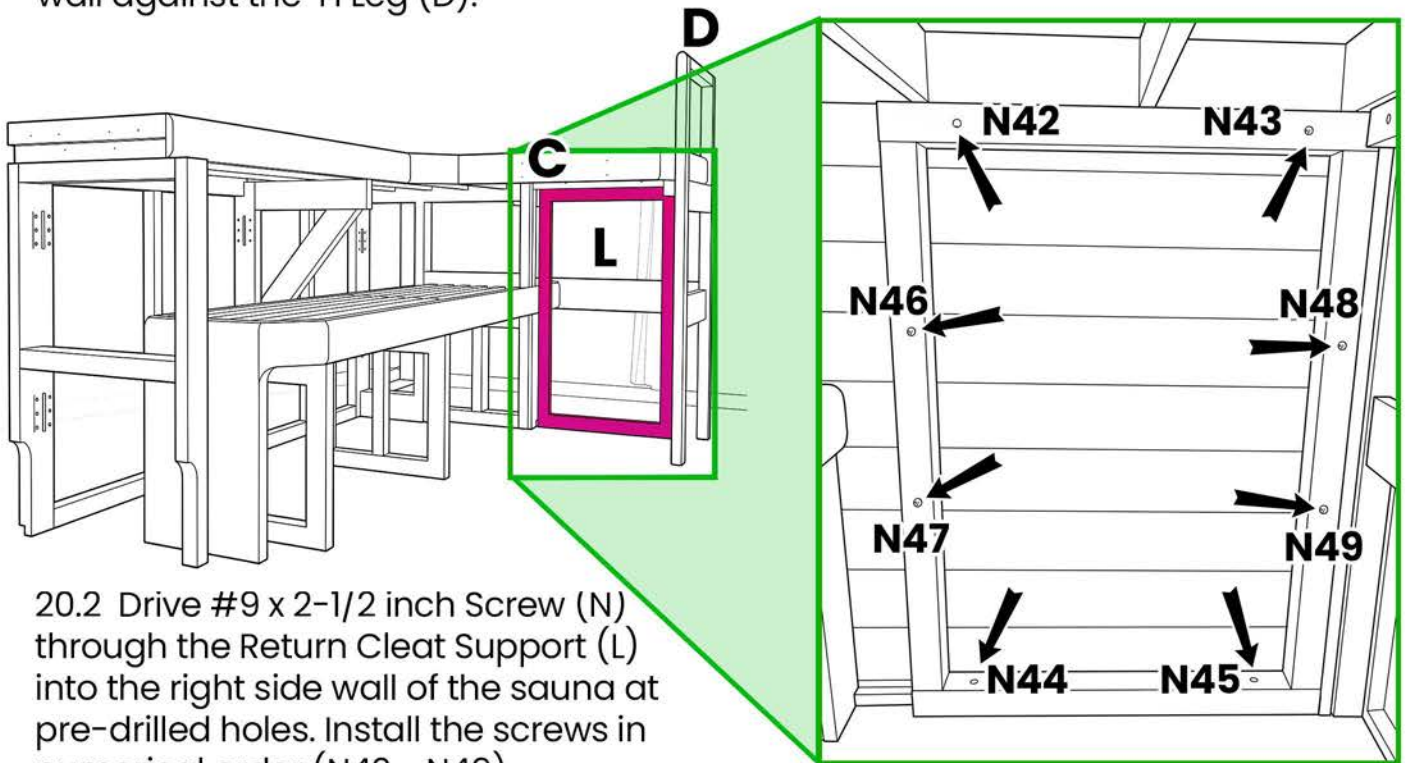
CAUTION

Do not overtighten, as compression will affect the integrity of wood fibers in the bench support.



STEP 20. INSTALL RETURN CLEAT SUPPORT (L)

20.1 Place the Return Cleat Support (L) against the right side of the sauna underneath the Return Bench (C). Push the Return Cleat Support (L) against the wall against the H Leg (D).



20.2 Drive #9 x 2-1/2 inch Screw (N) through the Return Cleat Support (L) into the right side wall of the sauna at pre-drilled holes. Install the screws in numerical order (N42 - N49).

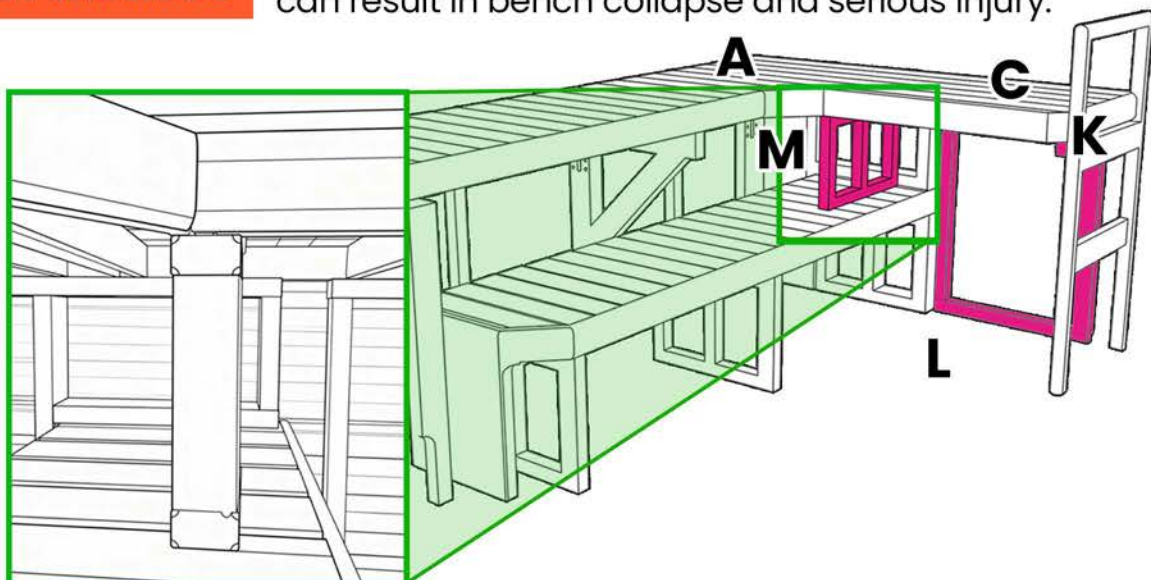
STEP 21. INSTALL RETURN SUPPORT (M)

21.1 Slide the Return Support (M) underneath the Top Bench (A) and Return Bench (C) where they meet, as depicted.

21.2 Check for gaps between the Return Bench (C), and the Return Bench Support Components (K, L, M). Slide in and secure the supplied shims to eliminate the gaps. To secure shim, remove the Return Bench (C) and drill a pilot hole through the middle of the shim 1 inch deep into support. Drive a #6 x 3/4" Screw (Q) into the pilot holes through the shim and support. Once the shims are secure, re-install the Return Bench (C).



WARNING Gap between Return Bench (C) and Bench Supports (K, L, M) can result in bench collapse and serious injury.

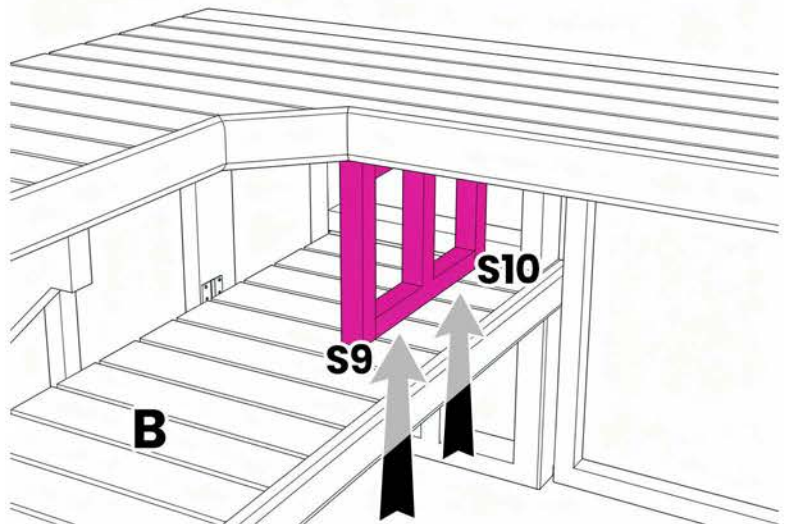


STEP 22. SECURE RETURN SUPPORT (M)

22.1 Position yourself underneath the Lower Bench (B) such that you are looking up at the underside of the bench slats.

Starting from the left side identify the third and fifth slats (note that the first slat will have a black wire attached to it).

On the third and fifth slat, locate the point at the center of the slat and center of the upper bench support. Mark these two points with a pencil. Drill a pilot hole into these slats at the marked location



Hold the support firmly to prevent movement, and drive two # 9 x2" Torx Flat-Head Screw (S) into pilot holes through the Lower Bench (B) into the Return Support (M). Drill a pilot hole into the lower bench stringer approximately 1" deep using a 3/32 drill bit. Install the screws in numerical order (S9, S10)

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.
- ☐ A final visual inspection has been completed and the installation meets all requirements in this manual.
- ☐ All wiring is secure

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

Confirm that the sauna is working properly.

