

OWNER'S MANUAL

FOUR-PERSON & SIX-PERSON SAUNAS



SA2418/SA1318/SA1323

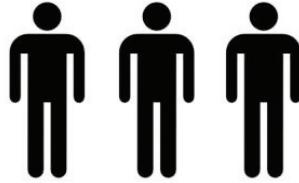
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The information contained in this manual is subject to change without notice.

ASSEMBLY TIPS & WARNINGS

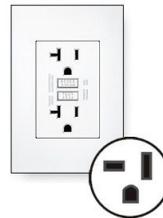
- Before you begin, read all assembly instructions and safety warnings carefully.
- This sauna requires at least 3 adults to complete assembly.



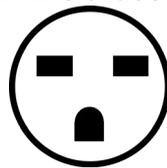
- Remove all of the contents from boxes and verify that you have all of the parts shown on the Parts Identifier before you begin assembly. *Note: Some parts may be pre-installed or pre-assembled.*
- This manual is used for the assembly of several sauna models; therefore, some figures or drawings may not look exactly like your product.
- Cover the sauna floor during assembly to avoid staining the unfinished wood surface.
- Retain this Owner's Manual for future reference.

ELECTRICAL REQUIREMENTS

- We recommend consulting a licensed electrician and checking local ordinances before installing ANY sauna.
- **Four-Person Models** require a 20 amp receptacle and a 20 amp circuit breaker. *Note: Electrical modifications may be required to accommodate 20 amp power.*



- **Six-Person Models** require a dedicated 220V line that should ONLY be installed by a licensed electrician.

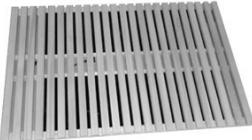


- Refer to the serial plate on the back of the sauna for complete electrical specifications.
- This sauna requires a dedicated circuit - No other appliances should share the same outlet with the sauna.

CHOOSING A LOCATION

- This sauna should only be placed INDOORS on a dry, level surface.
- There should be a minimum of 5 inches clearance between the sauna and any wall.
- Make sure the main power cord will reach the outlet and remains easy to access.
- The sauna should only be used in a dry location as moisture will damage the wood and electrical components.
- Keep the sauna away from any potential hazards including water sources, flammable objects and combustible materials.

PARTS IDENTIFIER (NOT TO SCALE)

 FRONT PANEL WITH GLASS DOOR	 LEFT PANEL	 RIGHT PANEL	 BACK PANEL	 ROOF
 ROOF COVER	 FLOOR	 FLOOR HEATER	 BENCH SEAT	 BENCH HEATER PANEL
 BACKREST	 DOOR HANDLE	 STEREO SHELF	 AM/FM CD PLAYER WITH MP3 INPUT¹	 CUP HOLDER
 MAGAZINE RACK	 DOUBLE TOWEL HOOK	 COLOR THERAPY CONTROL PANEL	 OXYGEN IONIZER	 2" (50mm) SCREW²
 1-1/2" (40mm) SCREW²	 1-1/8" (30mm) SCREW²	 3/4" (20mm) SCREW²	¹ Stereo audio cable with 3.5mm (1/8") TRS connector (mini-stereo jack) not included. ² Extra hardware is included - It is normal to have extra screws leftover when sauna assembly is complete.	
ADDITIONAL EQUIPMENT REQUIRED:  PHILLIPS HEAD SCREWDRIVER	 STEP LADDER			

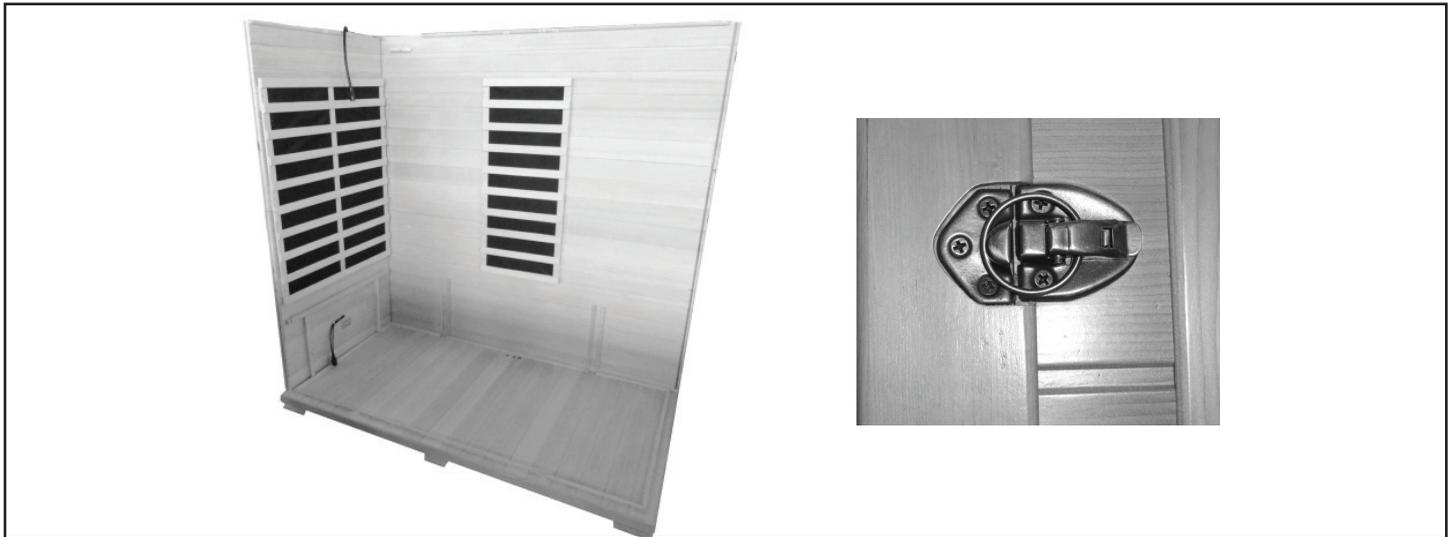
* Refer to REPLACEMENT PARTS (PAGE 15-17) to determine the correct part number when ordering replacements.

ASSEMBLY INSTRUCTIONS

1. Begin assembly by determining an appropriate location for your sauna – see ASSEMBLY TIPS & WARNINGS for details. Attach the BACK PANEL to the FLOOR by lining up the BACK PANEL with the groove in the back of the FLOOR.



2. Attach the LEFT PANEL to the FLOOR. Buckle the LEFT PANEL to the BACK PANEL.



3. Attach the RIGHT PANEL to the FLOOR. Buckle the RIGHT PANEL to the BACK PANEL.

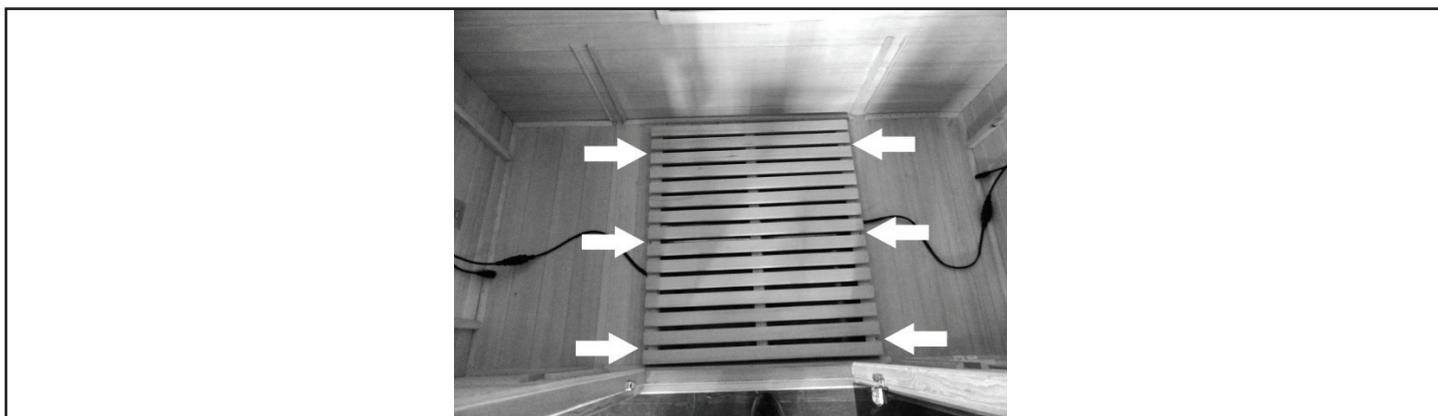


ASSEMBLY INSTRUCTIONS (CONT.)

4. Attach the FRONT PANEL to the FLOOR. Buckle the FRONT PANEL to the LEFT and RIGHT PANELS.



5. Attach the FLOOR HEATER to the FLOOR with 1-1/2" SCREWS. Connect one heater plug to each side of the sauna.

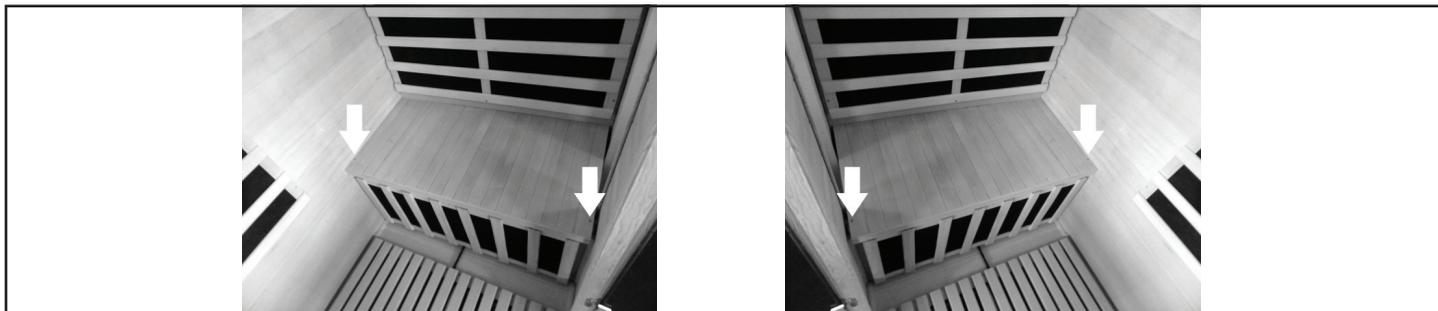


6. Slide each BENCH HEATER PANEL into place between the FRONT and BACK PANELS. Connect the heater plugs. *Note: Make sure each FLOOR HEATER cable is placed through the groove in the bottom of the corresponding BENCH HEATER PANEL.*

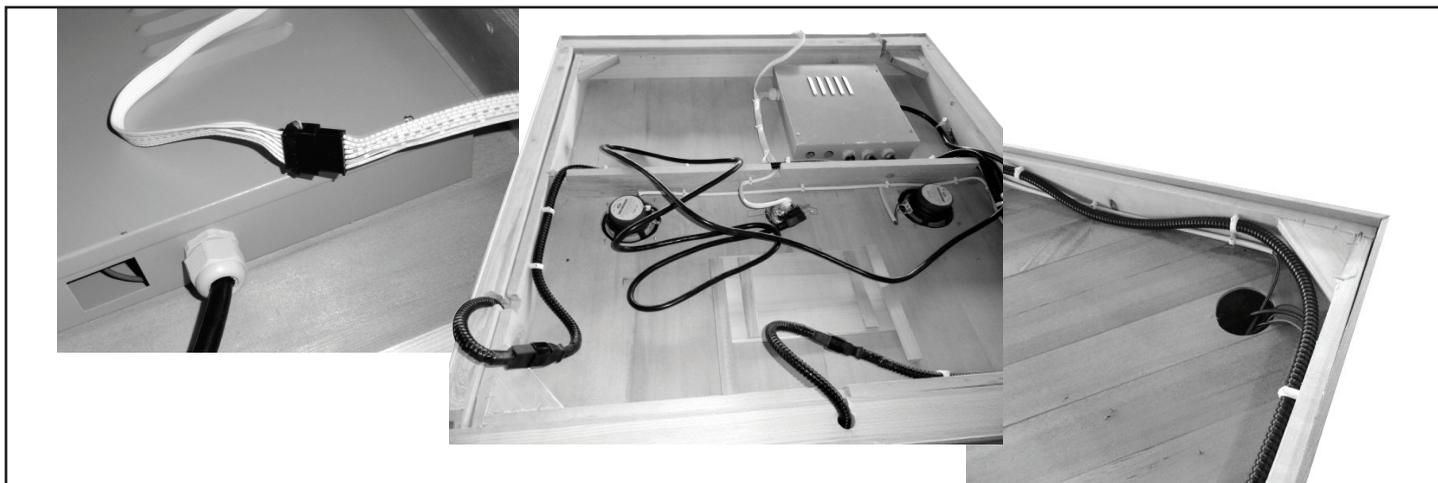


ASSEMBLY INSTRUCTIONS (CONT.)

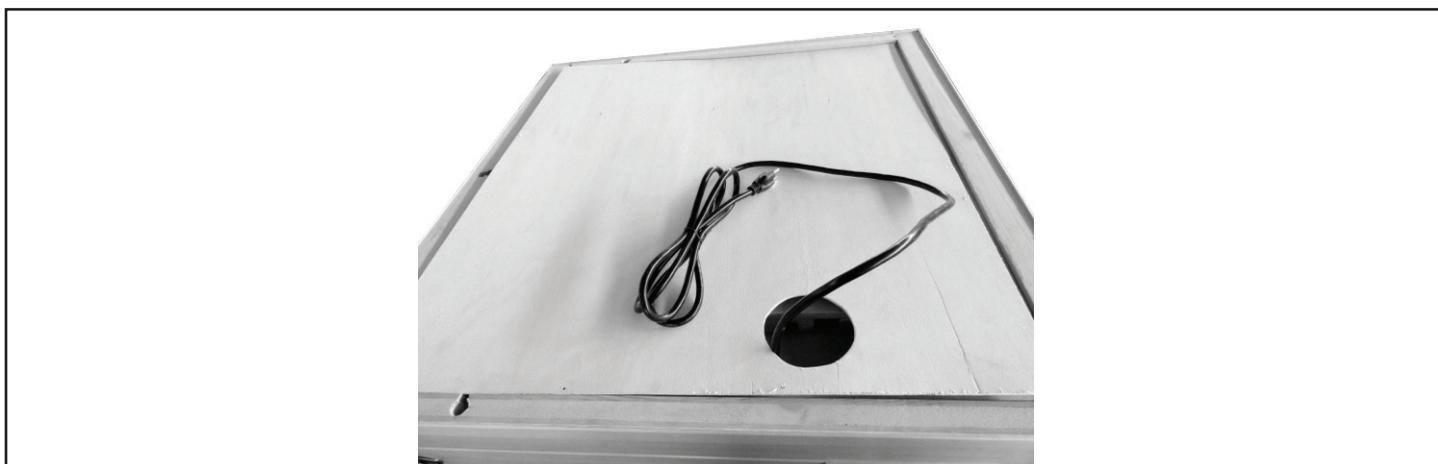
7. Attach each BENCH SEAT with 2" SCREWS.



8. Lift the ROOF above the sauna, feeding the control panel and heater cables through the corresponding holes. Feed the cables for the AM/FM CD PLAYER through the hole in the bottom of the ROOF. Secure the ROOF to the sauna with 1-1/8" SCREWS. Connect the control panel and heater plugs.



9. Feed the main power cable through hole in ROOF COVER. Secure the ROOF COVER with 3/4" SCREWS.

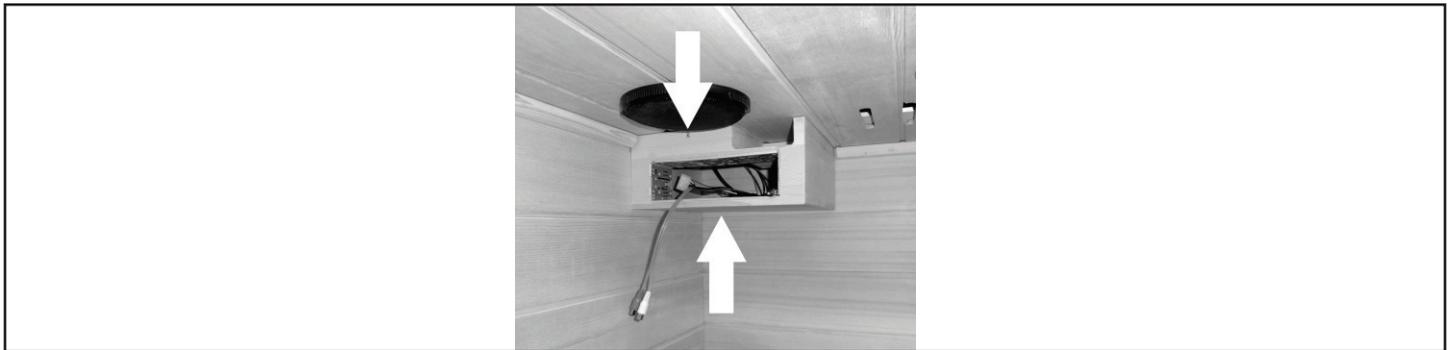


ASSEMBLY INSTRUCTIONS (CONT.)

10. Attach the DOOR HANDLE to the GLASS DOOR.



11. Gently pull the cables for the AM/FM CD PLAYER through the opening in the front of the STEREO SHELF. Attach the STEREO SHELF with 3/4" SCREWS.



12. Plug the controller and antenna into the back of the AM/FM CD PLAYER. *Note: The red and white cables are used for an optional video player and can be tucked out of the way. Slide and lock the AM/FM CD PLAYER into the STEREO SHELF. Note: Use "keys" with to remove the CD player for maintenance.*



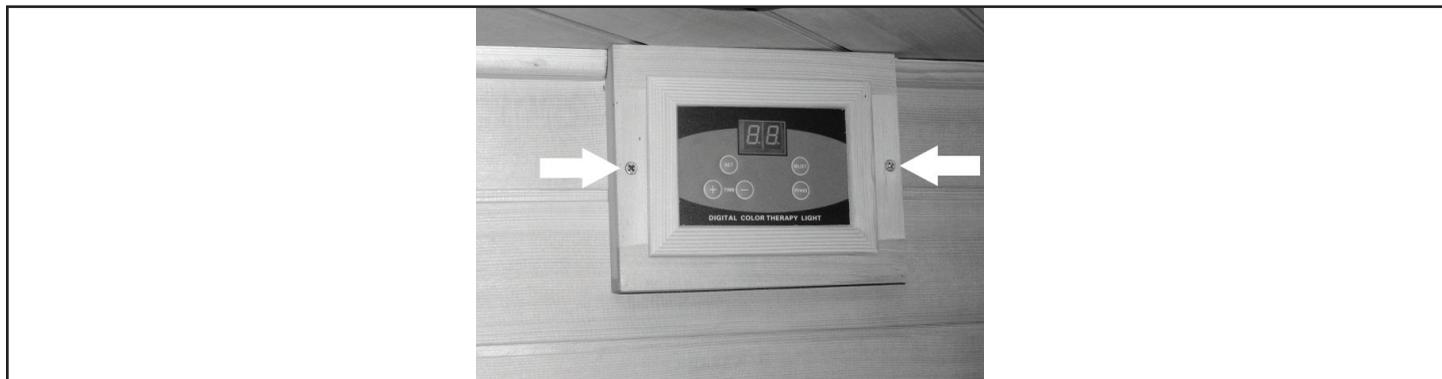
13. Attach the MAGAZINE RACK with 1-1/2" SCREWS. *Note: A sticker indicates the optimal position for this accessory, but attaching it is optional. Consider the position carefully before driving any screws into the sauna interior.*

14. Attach the CUP HOLDER(S) with 3/4" SCREWS. *Note: A sticker indicates the optimal position for this accessory, but attaching it is optional. Consider the position carefully before driving any screws into the sauna interior.*

ASSEMBLY INSTRUCTIONS (CONT.)

15. Attach the DOUBLE TOWEL HOOK with 3/4" SCREWS. *Note: A sticker indicates the optimal position for this accessory, but attaching it is optional. Consider the position carefully before driving any screws into the sauna interior.*

16. Attach the COLOR THERAPY CONTROL PANEL into the designated position with 2" SCREWS.



17. Remove the back cover of the OXYGEN IONIZER by turning it as indicated. Unwrap and install the fragrance patch, then reattach the back cover. Attach the OXYGEN IONIZER in the designated position with 3/4" SCREWS. Plug the power cable into the OXYGEN IONIZER.



18. Plug the main power cable into a dedicated outlet. *Note: No other appliances should share the same outlet with this sauna.*

CONGRATULATIONS!

The assembly of your sauna is now complete.

Please review the Operation Instructions and Health & Safety warnings before using your sauna.

To ensure years of trouble-free use, follow the Cleaning & Maintenance guidelines carefully.

OPERATION INSTRUCTIONS

SAUNA CONTROL PANEL

Note: The sauna controls are the same for both the interior and exterior Control Panels.

1. Press POWER to turn ON the sauna.
2. Set the desired TEMPERATURE with the (+) and (-) buttons.
3. Press and hold both (+) and (-) to switch between °F (Fahrenheit) and °C (Celsius).
4. Set the desired TIME with the (+) and (-) buttons.
5. Press INSIDE or OUTSIDE to turn on or off the corresponding light.
6. When the TIME reaches 00, the heaters will turn OFF automatically.
7. After your sauna session, press POWER to turn OFF the sauna.

COLOR THERAPY CONTROL PANEL

1. Press POWER to turn ON the Color Therapy Light. The Color Therapy Light will cycle through all the available colors.
2. Press SELECT to locate your preferred color or pattern, then press SET.
3. Set the desired TIME with the (+) and (-) buttons, then press SET.
4. Press POWER to turn OFF the Color Therapy Light.

OXYGEN IONIZER

1. Press ION to release negatively charged ions to purify the air.
2. Press O3 to disinfect the air with ozone.

ENJOYING YOUR SAUNA

1. Prior to initial use, wipe down all interior surfaces of the sauna with a damp cloth.
2. Turn on the sauna and set temperature to 104° F for one hour to burn off any factory dust.
3. Always drink plenty of water before, during and after your sauna session to stay properly hydrated.
4. A normal sauna session should last 30 minutes or less.
5. Allow approximately 10 to 15 minutes for the sauna to warm up before entering.
6. Perspiration will begin within 10 to 15 minutes after entering the sauna.
7. Limit the use of lotions or oils on your body while using your sauna. These products can block your pores and limit perspiration, decreasing the effectiveness of your sauna session.
8. For spot treatment of a particular area, position that body part closer to the heater, allowing for deeper heating in that area.
9. During your sauna session, place towels on the bench seats and on the floor to absorb perspiration and maintain the cleanliness of your sauna.
10. Towel off excess perspiration during your sauna session to help your body perspire more freely.
11. Open the ceiling vent or the front door to allow fresh air into your sauna.
12. Allow your body to cool down following your sauna session, then rinse the perspiration off your body in a warm shower.

HEALTH & SAFETY WARNINGS

1. Review all instructions and warnings before operating your sauna. A sauna is not a toy. Serious injury may result from negligence, intentional misuse and failure to follow safety instructions.
2. **Hyperthermia Danger:** Hyperthermia occurs when the body absorbs more heat than it can dissipate. When the elevated body temperatures are sufficiently high, hyperthermia is a medical emergency and requires immediate treatment to prevent disability or death. It is very important not to allow your body's core temperature to rise above 103° F. Symptoms of hyperthermia include dizziness, lethargy, drowsiness and fainting. The effects of hyperthermia may include failure to perceive heat, failure to recognize the need to exit the sauna, unawareness of the impending health hazard, physical inability to exit the sauna and unconsciousness.
3. If you are feeling uncomfortable, faint or dizzy, exit the sauna immediately.
4. Do not exceed recommended time and temperature guidelines.
5. Do not touch or interfere with the temperature sensor on the control panel.
6. Do not touch or spray water on the heater elements.
7. Do not use the sauna while under the influence of drugs or alcohol.
8. Do not sleep inside the sauna.
9. Do not use the sauna immediately following strenuous exercise. Allow your body to cool down for 30 minutes before entering the sauna.
10. Pets should never be placed in the sauna.
11. Pregnant women, children under the age of 6, the elderly and infirm should not use the sauna.
12. Children over the age of 6 should always be supervised by an adult.
13. People with health problems including open wounds, fever, sunburn or dehydration should not use the sauna.
14. People suffering from obesity or with a history of heart disease, low or high blood pressure, circulatory system problems or diabetes should consult a physician before using the sauna.
15. Consult a physician before using the sauna if you take any prescription medications.
16. Keep towels and combustible materials away from the heater elements.
17. Remove all towels and materials after your sauna session.
18. Never leave your sauna unattended while in use.
19. Always unplug the sauna and allow it to cool down before performing any cleaning or maintenance.
20. Always turn off and unplug the sauna when not in use.

CLEANING & MAINTENANCE

1. Always unplug the sauna and allow it to cool down before performing any cleaning or maintenance.
2. Use furniture polish or furniture oil when cleaning the sauna exterior.
3. The sauna interior surfaces should only be wiped down with a damp cloth. Do NOT use chemicals, abrasive cleaners or solvents on the unfinished interior wood.
4. As with all natural wood products, variations in the color and the grain as well as irregularities such as knots and fine cracks may be present. These characteristics are a part of the natural beauty of the wood and should not be considered defective.

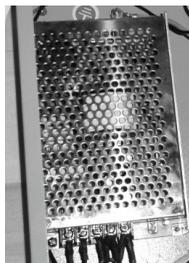
TROUBLESHOOTING GUIDE

WARNING!

- Always unplug the sauna and allow it to cool down before performing any maintenance.
- Repairs to the electrical components of the sauna should only be performed by a qualified service technician.
- Unauthorized repairs or alterations will void the manufacturer's warranty.

Problem **THERE IS NO POWER TO THE SAUNA**

- Solution**
1. Check that the Main Power Cable is plugged into the wall outlet.
 2. Check that the circuit breaker for the outlet has not tripped. If the breaker has tripped, check that the amperage of the breaker is appropriate for your sauna.
 3. Check all connections to the Power Supply Box.
 4. Check for damage to the Main Power Cable; replace, if necessary.
 5. Replace the Power Supply Box, if necessary.

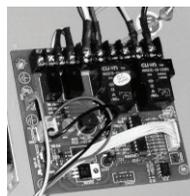


Problem **ONE HEATER DOES NOT WORK**

- Solution**
1. Check that all the connections are tight.
 2. Replace the Heater Element.

Problem **NONE OF THE HEATERS WORK**

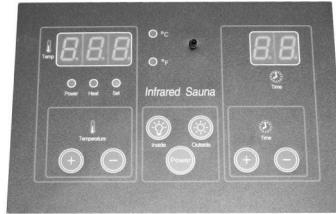
- Solution**
1. Check that all connections are tight.
 2. Replace the Heater Circuit Board, if necessary.



TROUBLESHOOTING GUIDE (CONT.)

Problem THE CONTROL PANEL DOES NOT WORK

- Solution**
1. Check that all the connections are tight.
 2. If the numbers are scrambled or the buttons are unresponsive, replace the Control Panel.
 3. If the temperature indicator does not work or reads "--" or "EP", replace the Control Panel with Temperature Sensor.



Problem THE LIGHTS ARE NOT WORKING

- Solution**
1. Check that all the connections are tight.
 2. If one light does not work, replace the bulb. *Note: Do not touch the glass part of the bulb with your fingers during installation.*
 3. If neither the lights nor the radio are working, replace the Power Supply Box.

Problem THE RADIO AND/OR CD PLAYER IS NOT WORKING

- Solution**
1. Check that all the connections are tight.
 2. Check the fuse; replace if necessary.
 3. Replace the radio.
 4. If neither the radio nor the lights are working, replace the Power Supply Box.

Problem THE SPEAKERS ARE NOT WORKING

- Solution**
1. Check that the volume is not turned all the way down and that the fader control is set correctly.
 2. If only one speaker is working, check to see that the sound balance on the stereo is not set all the way to one side.
 3. Check that all the connections are tight.
 4. Replace the speaker, if necessary.

Problem THE COLOR THERAPY LIGHTS ARE NOT WORKING

- Solution**
1. Check that all the connections are tight.
 2. Replace the Color Therapy Light or Color Therapy Control Panel, if necessary.

REPLACEMENT PARTS

In the event that you need replacement parts, locate your sauna model in the guide below to reference the correct part numbers. It is important to use only the replacement parts specified by the manufacturer. The use of unauthorized substitutes may damage your sauna or cause electrical hazards resulting in injury or fire.

SA2418 FOUR-PERSON HEMLOCK SAUNA

<u>DESCRIPTION</u>	<u>PART NUMBER</u>	<u>QTY</u>
FRONT PANEL with GLASS DOOR	SAP2652	1
LEFT PANEL	SAP2653	1
RIGHT PANEL	SAP2654	1
BACK PANEL	SAP2655	1
ROOF	SAP2656	1
ROOF COVER	SAP2614	1
FLOOR	SAP2657	1
FLOOR HEATER	SAP2658	1
BENCH SEAT	SAP2480	2
BENCH HEATER PANEL	SAP2479	2
BACKREST	SAP2412	4
DOOR HANDLE	SAP2413	1 SET
STEREO SHELF	SAP2402	1
AM/FM CD PLAYER with MP3 INPUT	SAP2408	1
CUP HOLDER	SAP2444	2
MAGAZINE RACK	SAP2414	1
DOUBLE TOWEL HOOK	SAP2460	1
COLOR THERAPY CONTROL PANEL	SAP2427	1
OXYGEN IONIZER	SAP2409	1
2" (50mm) SCREW	SAP2411	6
1-1/2" (40mm) SCREW	SAP2411	10
1-1/8" (30mm) SCREW	SAP2411	6
3/4" (20mm) SCREW	SAP2411	28
300W HEATER ELEMENT – BACK PANEL	SAP2422	1
300W HEATER ELEMENT – LEFT PANEL	SAP2422	2
300W HEATER ELEMENT – RIGHT PANEL	SAP2422	2
180W HEATER ELEMENT – FLOOR HEATER	SAP2419	2
180W HEATER ELEMENT – BENCH HEATER	SAP2419	2
CONTROL PANEL	SAP2406	1
CONTROL PANEL with TEMPERATURE SENSOR	SAP2603	1
CONTROL PANEL FRAME	SAP2417	1
MAIN POWER CABLE	SAP2613	1
POWER SUPPLY BOX	SAP2407	1
HEATER CIRCUIT BOARD	SAP2428	1
25 AMP OVERCURRENT PROTECTOR	SAP2530	1
INTERIOR LIGHT BULB	SAP2403	4
EXTERIOR LIGHT BULB	SAP2404	3
LIGHT HOUSING	SAP2405	7
LIGHT SOCKET	SAP2606	7
COLOR THERAPY LIGHT	SAP2410	1
SPEAKER	SAP2416	2
GLASS DOOR	SAP2457	1
DOOR HINGE	SAP2415	2
BUCKLE	SAP2607	12

REPLACEMENT PARTS

SA1318 FOUR-PERSON CEDAR SAUNA

<u>DESCRIPTION</u>	<u>PART NUMBER</u>	<u>QTY</u>
FRONT PANEL with GLASS DOOR	SAP3033	1
LEFT PANEL	SAP3034	1
RIGHT PANEL	SAP3035	1
BACK PANEL	SAP3036	1
ROOF	SAP3037	1
ROOF COVER	SAP3038	1
FLOOR	SAP3039	1
FLOOR HEATER	SAP3040	1
BENCH SEAT	SAP3041	2
BENCH HEATER PANEL	SAP3042	2
BACKREST	SAP3010	4
DOOR HANDLE	SAP3011	1 SET
STEREO SHELF	SAP3012	1
AM/FM CD PLAYER with MP3 INPUT	SAP2408	1
CUP HOLDER	SAP3013	2
MAGAZINE RACK	SAP3014	1
DOUBLE TOWEL HOOK	SAP3015	1
COLOR THERAPY CONTROL PANEL	SAP3016	1
OXYGEN IONIZER	SAP2409	1
2" (50mm) SCREW	SAP2411	6
1-1/2" (40mm) SCREW	SAP2411	10
1-1/8" (30mm) SCREW	SAP2411	6
3/4" (20mm) SCREW	SAP2411	28
300W HEATER ELEMENT – BACK PANEL	SAP2422	1
300W HEATER ELEMENT – LEFT PANEL	SAP2422	2
300W HEATER ELEMENT – RIGHT PANEL	SAP2422	2
180W HEATER ELEMENT – FLOOR HEATER	SAP2419	2
180W HEATER ELEMENT – BENCH HEATER	SAP2419	2
CONTROL PANEL	SAP3017	1
CONTROL PANEL with TEMPERATURE SENSOR	SAP3018	1
CONTROL PANEL FRAME	SAP3019	1
MAIN POWER CABLE	SAP2613	1
POWER SUPPLY BOX	SAP2407	1
HEATER CIRCUIT BOARD	SAP2428	1
25 AMP OVERCURRENT PROTECTOR	SAP2530	1
INTERIOR LIGHT BULB	SAP2403	4
EXTERIOR LIGHT BULB	SAP2404	3
LIGHT HOUSING	SAP2405	7
COLOR THERAPY LIGHT	SAP2410	1
SPEAKER	SAP2416	2
GLASS DOOR	SAP2457	1
DOOR HINGE	SAP2415	2
BUCKLE	SAP2607	12

REPLACEMENT PARTS

SA1323 SIX-PERSON CEDAR SAUNA

<u>DESCRIPTION</u>	<u>PART NUMBER</u>	<u>QTY</u>
FRONT PANEL with GLASS DOOR	SAP3056	1
LEFT PANEL	SAP3057	1
RIGHT PANEL	SAP3058	1
BACK PANEL	SAP3059	1
ROOF	SAP3060	1
ROOF COVER	SAP3061	2
FLOOR	SAP3062	1
FLOOR HEATER	SAP3063	1
BENCH SEAT	SAP3064	2
BENCH HEATER PANEL	SAP3065	2
BACKREST	SAP3010	4
DOOR HANDLE	SAP3011	1 SET
STEREO SHELF	SAP3012	1
AM/FM CD PLAYER with MP3 INPUT	SAP2408	1
CUP HOLDER	SAP3013	2
MAGAZINE RACK	SAP3014	1
DOUBLE TOWEL HOOK	SAP3015	1
COLOR THERAPY CONTROL PANEL	SAP3016	1
OXYGEN IONIZER	SAP2409	1
2" (50mm) SCREW	SAP2411	6
1-1/2" (40mm) SCREW	SAP2411	10
1-1/8" (30mm) SCREW	SAP2411	6
3/4" (20mm) SCREW	SAP2411	44
300W HEATER ELEMENT – LEFT PANEL	SAP2422	3
300W HEATER ELEMENT – RIGHT PANEL	SAP2422	3
225W HEATER ELEMENT – FLOOR HEATER	SAP2421	2
180W HEATER ELEMENT – BENCH HEATER	SAP2419	2
CONTROL PANEL	SAP3017	1
CONTROL PANEL with TEMPERATURE SENSOR	SAP3018	1
CONTROL PANEL FRAME	SAP3019	1
MAIN POWER CABLE	SAP3066	1
POWER SUPPLY BOX	SAP2407	1
HEATER CIRCUIT BOARD	SAP2428	1
25 AMP OVERCURRENT PROTECTOR	SAP2530	1
INTERIOR LIGHT BULB	SAP2403	4
EXTERIOR LIGHT BULB	SAP2404	3
LIGHT HOUSING	SAP2405	7
LIGHT SOCKET	SAP2606	7
COLOR THERAPY LIGHT	SAP2410	1
SPEAKER	SAP2416	2
GLASS DOOR	SAP2457	1
DOOR HINGE	SAP2415	2
BUCKLE	SAP2607	12

SAUNA WARRANTY REGISTRATION CARD

1. This sauna has a 5-Year Warranty against defects in materials and workmanship. To receive the warranty, the card must be filled out completely and returned. This 5-Year Warranty covers the sauna. The radio in your sauna is covered by a limited 1-Year Warranty.
2. Please notify Blue Wave Products in advance of any sauna warranty claim prior to shipping the sauna back. Contact our warranty claim department at warranty@splashnetxpress.com.
3. If the warranty claim department determines that the item must be returned, it must be returned with a receipt showing date of purchase, purchase price, and the dealer from which the sauna was purchased. **No warranty claim will be honored without a receipt.**
4. The freight on the item when returned must be prepaid.
5. Warranty claims will only be resolved with the repair of the current product or shipment of a replacement product. NO REFUNDS will be given.
6. Improper installation, misuse or damages resulting from acts of nature will render this warranty null and void.
7. This warranty is in lieu of all other warranties expressed or implied and no responsibility is assumed for future damage due to misuse. This sauna is intended for INDOOR USE ONLY – outdoor installation of the sauna WILL VOID THE WARRANTY. We are not responsible for damage to the sauna due to improper installation or misuse. Additional actions that will void the warranty are: Use of lacquer or paints, placing sauna on non-approved surface, and outdoor applications.

Surface cracks are not considered defects in material or workmanship, as they are normal characteristics of all wood.

To send in this warranty card: Fill out below, detach and mail to the following address:

**BLUE WAVE PRODUCTS
1745 Wallace Ave. Suite B
St. Charles, IL 60174**

Detach Here

Detach Here

SAUNA WARRANTY REGISTRATION FORM

Date Purchased: ____/____/____

Name: _____

Address: _____

City/State/Zip: _____

Phone: () _____ Email: _____

Purchased from: _____

Item Number: _____ Purchase Price: _____

Serial Number: _____