

AUKI
Installation, operation & maintenance manual



Dear Customer, Thank you for purchasing an ORANS sauna. We hope you will be fully satisfied with your purchase. Please remember that this manual is an important document of reference and should be provided by the seller with the sauna. ORANS forbids the reproduction of any part of this manual. Each sauna is checked and tested thoroughly at our premises prior to delivery to ensure its correct working order and the absolute reliability of its safety devices. Should you require any further information or clarification, please contact your local dealer or contact our company directly.

Excluding models specifically designed to be placed directly in the outdoor weather elements, your sauna can be placed either indoors or outdoors. Sauna models without a specific outdoor roofing cannot be placed directly in the weather elements. These models, if placed outdoors, can be placed under a covered structure such as a patio. The barrel sauna models can be placed in the outdoors. Before assembling, make sure the surface in which the sauna will be placed on is level/dry and can support the weight of the sauna and its occupants. We recommend a concrete base or wood deck to support the sauna. If you will be placing the sauna directly on the ground, you must use such materials as concrete cinder blocks or other similar supporting structure to prevent the sauna from settling into the ground over time.

Once you have removed the parts from the boxes, you will want to take a look at the parts for identification. For the barrel saunas, you will want to carefully inspect the staves for placement. We do use a higher grade of wood, but wood is still a natural resource and you may find blemishes or knots. You will want to use less attractive staves on the floor instead of higher up on the walls.

For sauna models specifically designed to be outdoors, the wood can withstand the weather elements with proper maintenance. The outdoor model saunas were designed to be placed in the rain and sun. Please note that the natural weathering elements will change the color of the wood over time. For barrel saunas and other sauna models placed directly in the weather elements, you will have some water seepage, especially at the top and sides due to the porous characteristics of the wood and how the staves and wood planks fit together. The water seepage will not damage the sauna and usually dries quickly when the sauna is in operation.



TWO PEOPLE ARE NECESSARY!

It indicates a procedure for which two people are required. Otherwise, the product or other objects in the surroundings may be damaged.



INSTALLER FOR ELECTRICAL SUPPLIES

Technician specialised in installing the product in ordinary work conditions. He is competent for all the interventions concerning the electrical supplies such as registrations, maintenance and repairs. He is skilled for interventions in electrical boards or electrical outlets which are under power.

Electrical Sauna System compliance with:

CSA Std. C22.2 No. 164-18 - Electric sauna heating equipment

UL Std. No. 875 (14th edition) – Electric Dry-Bath Heaters

Some information or pictures in this manual may show details and spare parts which may be slightly different from the ones of your Sauna room: however, the primary information remains unchanged. Following our constant search for improvements, the Sauna room may show some changes which are not included in this manual.



ORANS refuses all responsibility for damages caused by an inappropriate use of the sauna. ORANS reserves the right to institute legal proceedings against those who make any changes to its Sauna room without previous written authorisation.

PROCEDURE:

The installation must be done by qualified people based on the information given in this manual and in accordance with national regulations and standards. Upstream of the electrical power system, you must install a CLASS "A" GROUND FAULT CIRCUIT INTERRUPTER. Check that the flooring is flat and even.

SAFETY WARNINGS



The equipment must not be used by children under the age of 8 and by people with reduced physical, sensorial or mental capabilities or those lacking the necessary experience or knowledge, other than under supervision, or if they have been given instructions for the safe use of the equipment and therefore understand the risks involved in its use. Children must not play with the appliance. Cleaning and maintenance intended to be carried out by the user must not be carried out by children without supervision. Care should be taken when using the appliance due to the hot temperature.



The sauna must not be used by children under the age of three, anyone with heart disorders, internal inflammation, epilepsy or people with a pacemaker.



Sauna heaters must not be subjected to water spray and shower heads must not be installed above the sauna heaters.



CAUTION: AVOID A FIRE, DO NOT PLACE COMBUSTIBLE MATERIAL ON THE SAUNA HEATER.



CAUTION: USE ONLY A CONTACTOR APPROVED FOR 250,000 ENDURANCE CYCLES.



The door of the heated room should not include any locking or latching system. Its malfunction could cause entrapment inside the room.



It is always advisable to consult your own doctor before using the sauna. "Hyperthermia" occurs when the internal temperature of the body reaches a level several degrees above the normal body temperature of 37 °C. The symptoms of hyperthermia include an increase in the internal temperature of the body, dizziness, lethargy, drowsiness, and fainting. The effects of hyperthermia include:

- a) Failure to perceive heat;
- b) Failure to recognize the need to exit the room;
- c) Unawareness of impending hazard;
- d) Fetal damage in pregnant women;
- e) Physical inability to exit the room;
- f) Unconsciousness.

WARNING– The use of alcohol, drugs, or medication may greatly increase the risk of fatal hyperthermia.



Children over the age of three may use the sauna only under the supervision of an adult and after seeking medical advice.



Any use of the home spa for purposes other than those expressly prescribed is strictly prohibited.



Do not remove the adhesive labels affixed to the internal surfaces of the units, for any reason. If they deteriorate, request replacements.



Users must be fully informed about how to use it.



Read this manual carefully before using the sauna.



Pay careful attention to the hazard warnings and safety standards issued by the authorities in each country.



When this heater is not installed for use with an attendant or is controlled by remote with APP, a timed-cutoff switch must be connected in the input circuit to disconnect all ungrounded conductors of the heater circuit from the supply source at the end of 1 hour of operation. The timed-cutoff switch must be located outside the heater room, or mounted on a wall or door inside the heater room. The time feature of the switch must not lend itself to being overridden.

All measurements are in mm.

UNPACKING

IMPORTANT. After removing the packaging, check that all the items and materials are complete and undamaged. If damage has been caused during transport, the carrier must be notified within the legal period so as not to forfeit the insurance cover.

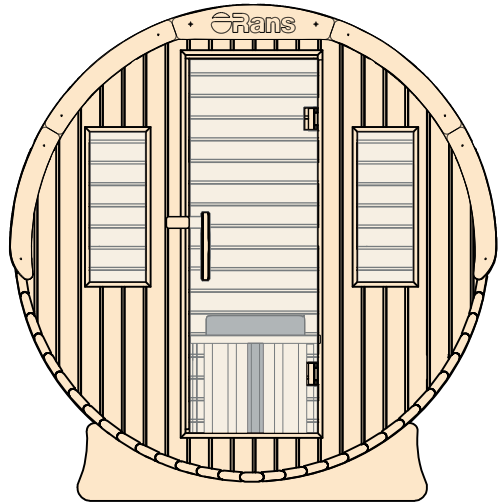
Sauna Room Hygiene

Each time the sauna is used, we recommend cleaning both the slatted floor boards and the benches that have been used so as to guarantee, among other things, correct hygiene of the product.

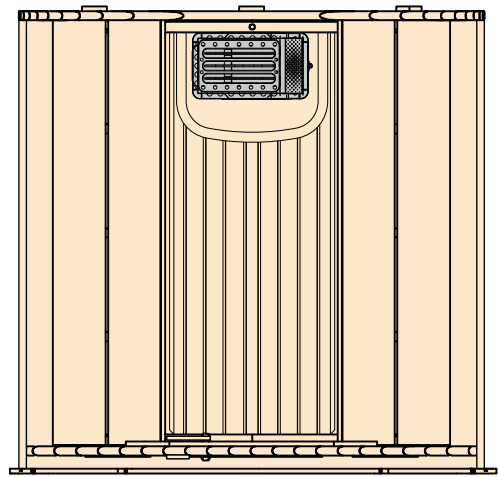
The wooden surfaces of the sauna must never be chemically treated, not even with common varnish or paint, since it would negatively affect the natural characteristics of the wood and on the one hand would make the sauna totally ineffective and on the other would give rise to risk of severe burns to the body.

Clean the sauna cabin with a wet cotton cloth and dry it with a clean, dry cloth regular cleaning ensures the long life of the sauna NO complaints are accepted in respect of certain natural imperfection in the wood such as slight colour tone variations or small cracks or splits.

1800x1800x1900(mm)

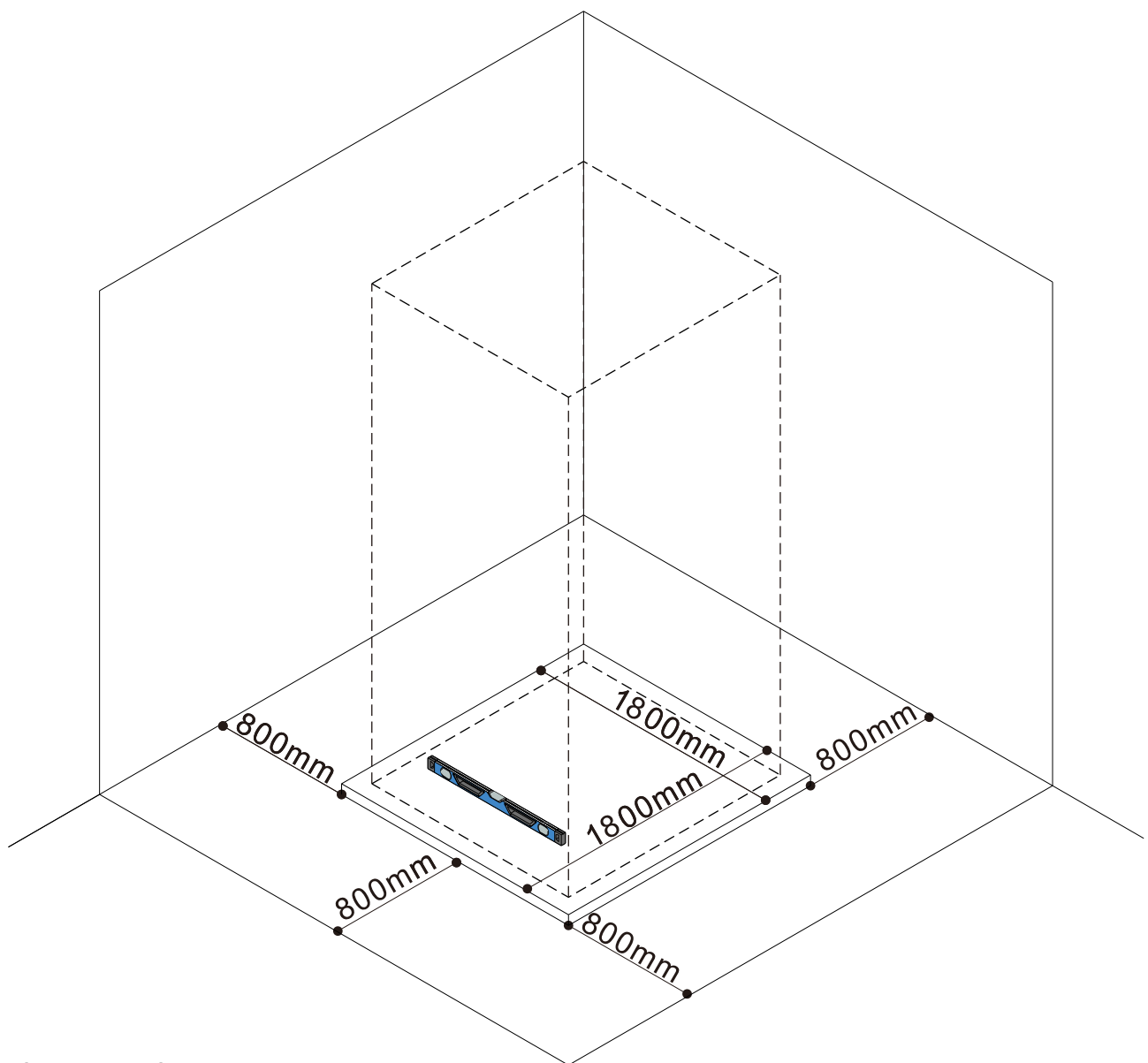


1900mm



1800mm

1800mm



FOUNDATION:

An outdoor sauna can weigh up to 600kg once assembled, therefore requires a sturdy foundation. This needs to be a flat, level surface that supports the entire weight of the sauna and users. We recommend using either a concrete slab or a pile foundation. The base of the sauna must not rest upon anything that will degrade the quality of the timber (soil, grass etc.)

Your foundation should have some form of drainage or contour, allowing storm water to drain away from the base of the sauna. If you find after creating the foundation that your sauna base does not sit level, use packing shims or similar to correct to level positioning.

Once your outdoor sauna has been assembled, it becomes near impossible to move great distances. Therefore assembling the sauna in its desired location, or very close to, is strongly advised. Moving your assembled sauna can potentially cause damage or alter its performance, which may void the warranty. The figure shows the minimum ground foundation requirements for outdoor sauna rooms, and the ground reinforcement thickness is at least 10 cm.

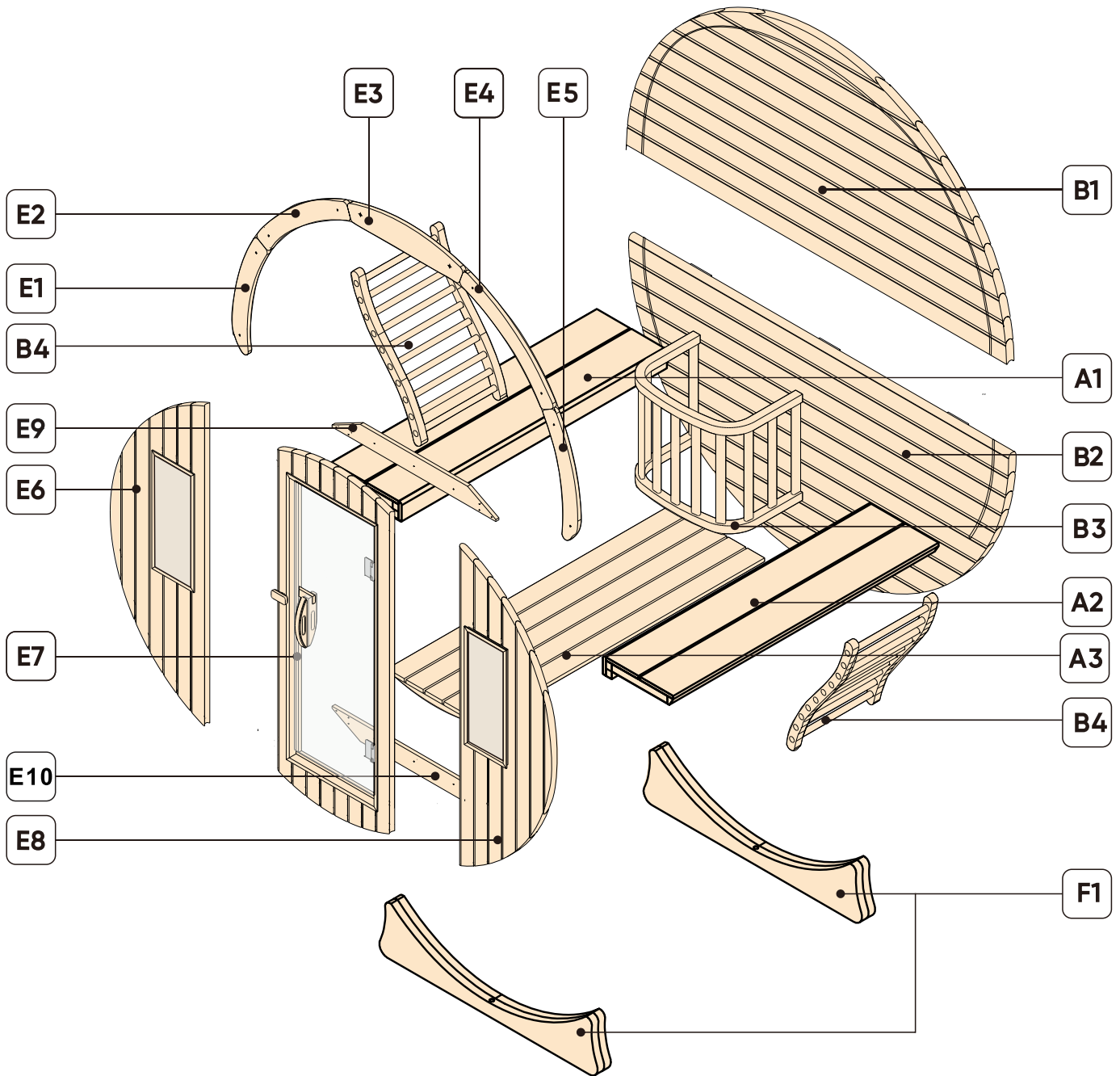
GENERAL INSTALLATION:

Assembling an outdoor sauna should be left in the hands of a qualified builder. Expect the assembly process to take you and a buddy a good chunk of your weekend if you intend to take on the challenge. Once the sauna has been assembled, it is near impossible to move it without a HIAB or forklift.

ELECTRICAL SETUP:

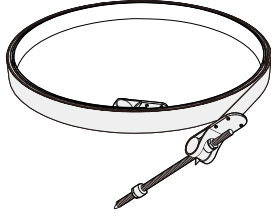
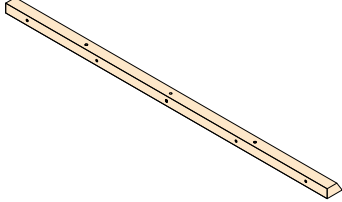
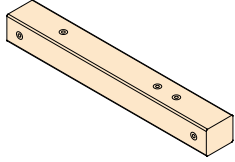
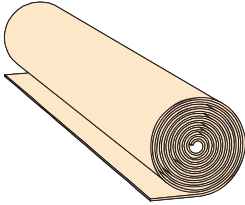
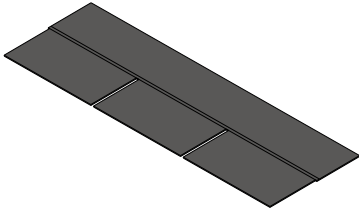
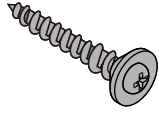
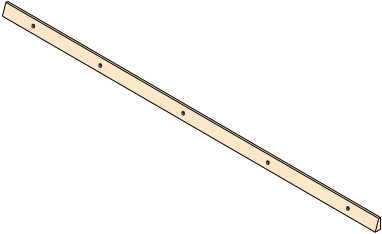
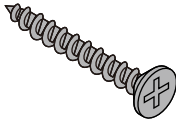
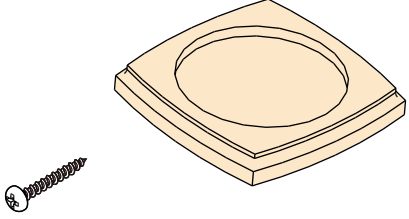
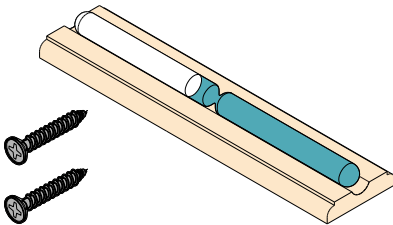
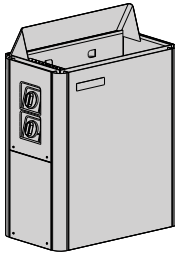
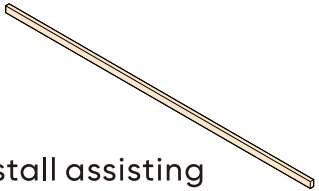
Your outdoor sauna will not come with a cable or plug and requires an electrician to install the appropriate required components to get it powered safely. All outdoor models require cable, hardwiring and an appropriately rated RCD. We cannot provide this service as we are not licensed electricians but we may have recommendations in your area. Please discuss your electrical requirements with your sales consultant.

Technical specifications				
Model	Power (kW)	Min.cross-section of elec.conductors (mm ²)	Electric intensity (A)	Voltage (V)
AUKI	4.5	2.5	20	220–240 Vac 1N 50–60 Hz



Parts List

The parts below are numbered with the letter corresponding to their elements (wood panels)

C1	2 Pcs.	C2	2 Pcs.	C3	4 Pcs.
 <p>L=5725mm</p>		 <p>L=1500mm</p>		 <p>L=300mm</p>	
C4	2 Pcs.	C5	44 Pcs.	C6	167 Pcs.
 <p>L=2900mm</p>				 <p>ST4*20 SUS304</p>	
C7	2 Pcs.	C8	20 Pcs.	C9	1 Pcs.
		 <p>ST4*30 SUS304</p>		 <p>ST4*25 SUS304</p>	
C10	1 Pcs.	D1	1 Pcs.	D2	2 Pcs.
 <p>ST4*25 SUS304</p>				 <p>Install assisting securing bar</p>	

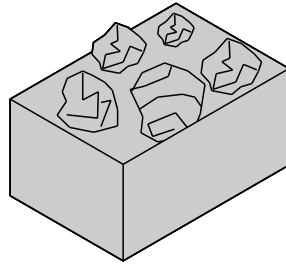
D3

1 Pcs.



D4

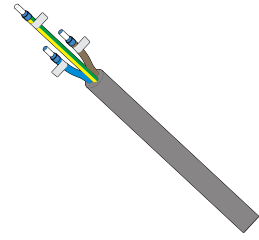
1 Pcs.



20 KG

D5

2 Pcs.



L=3900mm

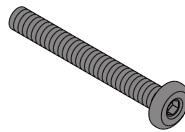
D6

1 Pcs.



D7

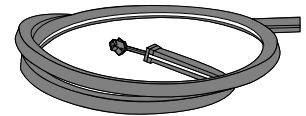
12 Pcs.



M6x50 SUS304

D8

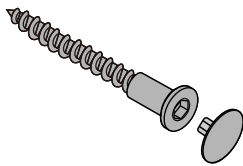
1 Pcs.



L=3495mm

D9

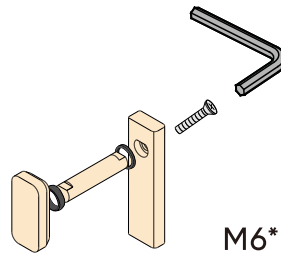
18 Pcs.



ST 4.5x40

D10

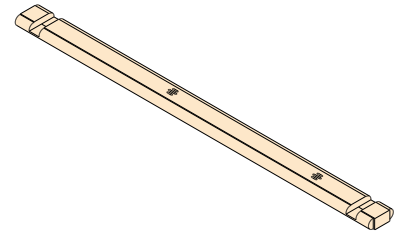
1 Pcs.



M6*25
SUS304

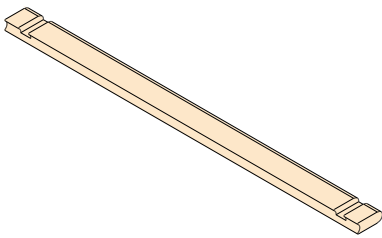
F2

1 Pcs.



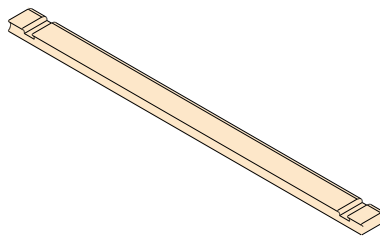
F3

64 Pcs.



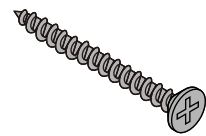
F4

2 Pcs.



F5

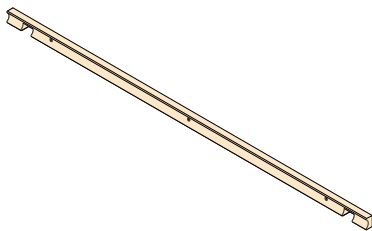
178 Pcs.



ST4*40
SUS304

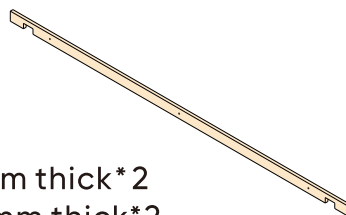
F6

1 Pcs.



F7

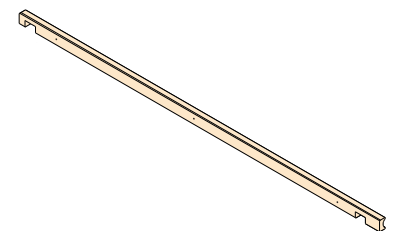
1 Pcs.



5mm thick*2
10mm thick*2

F8

1 Pcs.

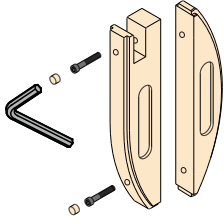


F9

1 Pcs.

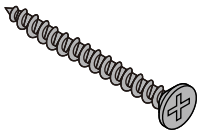
F10

10 Pcs.



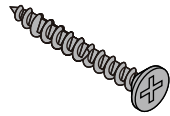
M6*35 SUS304

Spare parts



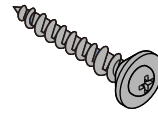
ST4*40 SUS304

10 Pcs



ST4*30 SUS304

2 Pcs



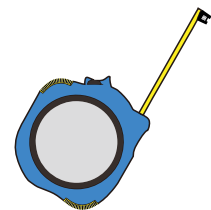
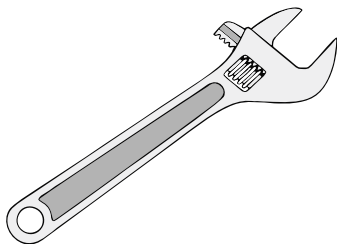
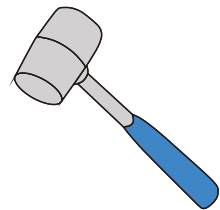
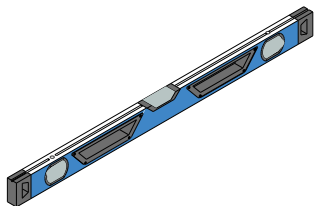
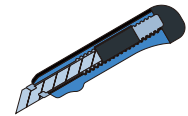
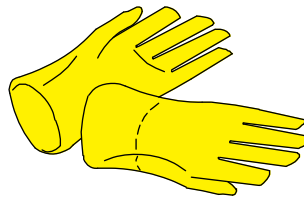
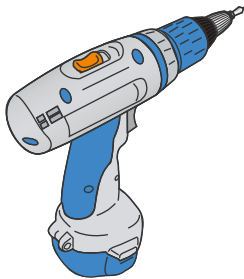
ST4*20 SUS304

10 Pcs



2 Pcs

Tools required for installation(not supplied)



Fill the heater with the stones provided.

ATTENTION:

The stones are supplied already washed, nevertheless we suggest you wash them again before putting them on the heater. The smaller stones must be put on the lower part, because this will ensure perfect air circulation. They should be positioned one on the other, ensuring that they do not cover the whole surface of the heating elements. We suggest you move and position the stones at least twice a year. When you do this, you have to throw away the smaller stones and the broken ones. In this way, you can have correct air circulation inside the heater and avoid the overheating of the heating elements and, consequently, their breaking. The size of the stones should be 3-5cm.

N.B.: THE WARRANTY DOES NOT COVER ANY DAMAGE CAUSED BY USING STONES THAT ARE TOO SMALL OR UNSUITABLE.

ATTENTION: no air circulation between the stones inside the heater may cause damage to the heating elements.

Connect the ORANS sauna to the mains using a H07NR-F power cable with a suitable cross-connection (see nameplates).

Install a Class "A" ground fault circuit interrupter upstream on the power supply line to the sauna. Refer to the rating plate of the sauna to be installed for the sizing of the power supply components (voltage, current, maximum power consumption, line protection fuse).

IMPORTANT:

If you need to replace the power supply cable, Contact an approved service centre.

IMPORTANT:

If you need to replace the power supply cable, be sure to make the connection (fixed) between the power supply cable itself (type H07NR-F) and the feeding line respecting, the polarities indicated by the respective symbols placed on the terminal board of the heater: L=phase, N=neutral connected to the light blue coloured wire, = the main ground terminal connected to the yellow-green wire. At the end of the new power supply cable installation, you have to seal the upper opening in order to prevent dust and liquid from entering through the passage of the power supply cable.

It is compulsory to fix the connection of the sauna ground wire to an efficient safety ground terminal.

The sauna should be installed in a dry, ventilated room that is not exposed to adverse weather conditions, rain, splashes or jets of water.

Installation and positioning in the bathroom area is permitted, provided that the local regulations in force are complied with, away from splashes or jets of water.

Always observe all the hazard warnings and safety regulations issued by the relevant authorities in each country.

Using the Heater

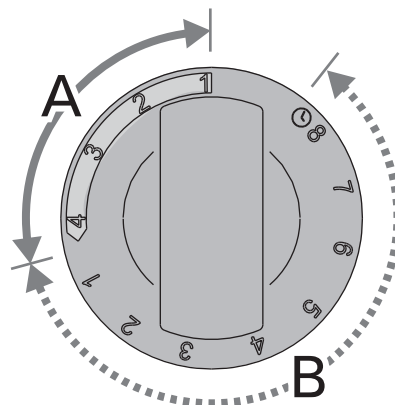
Before switching the heater on always check that there isn't anything on top of the heater or inside the given safety distance.

Heater On

Turn the timer switch to the "on" section (section A, 0–4 hours). The heater starts heating immediately.

Pre-setting Time (timed switch-on)

Turn the timer switch to the "pre-setting" section (section B, 0–8 hours). The heater starts heating when the timer has turned the switch back to the "on" section. After this, the heater will be on for about four hours.



Example: You want to go walking for three hours and have a sauna bath after that. Turn the timer switch to the "pre-setting" section at number 2. The timer starts. After two hours, the heater starts heating. Because it takes about one hour for the sauna to be heated, it will be ready for bathing after about three hours, that is, when you come back from your walk.

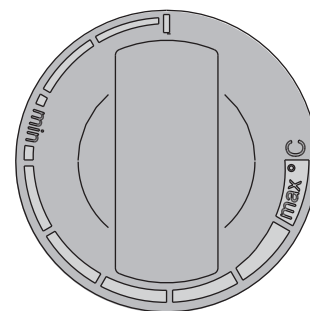
Heater Off

The heater switches off, when the timer turns the switch back to zero. You can switch the heater off at any time by turning the timer switch to zero yourself. Switch the heater off after bathing. Sometimes it may be advisable to leave the heater on for a while to let the wooden parts of the sauna dry properly. **NOTE!** Always check that the heater has switched off and stopped heating after the timer has turned the switch to zero.

Setting the Temperature

The purpose of the thermostat is to keep the temperature in the sauna room on a desired level. By experimenting, you can find the setting that suits you best.

Begin experimenting at the maximum position. If, during bathing, the temperature rises too high, turn the switch counter-clockwise a little. Note that even a small difference within the maximum section will change the temperature of the sauna considerably.



Resetting the Overheat Protector

If the temperature of the sauna room becomes dangerously high, the overheat protector will permanently cut off the supply of the heater. The overheat protector can be reset after the heater has cooled down.

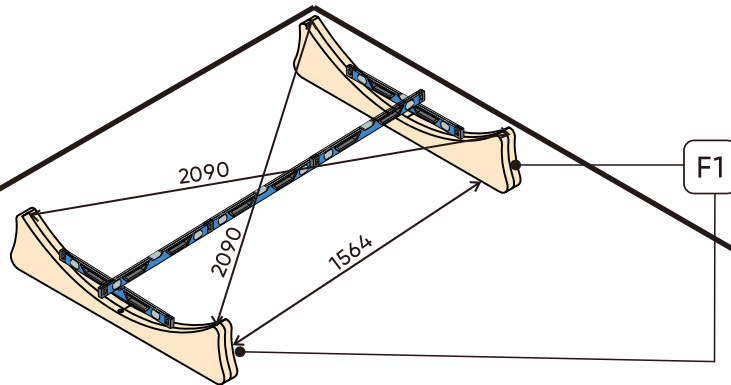
The reset button is located in located inside the heater's connection box .

Only persons authorised to carry out electrical installations can reset the overheat protector.

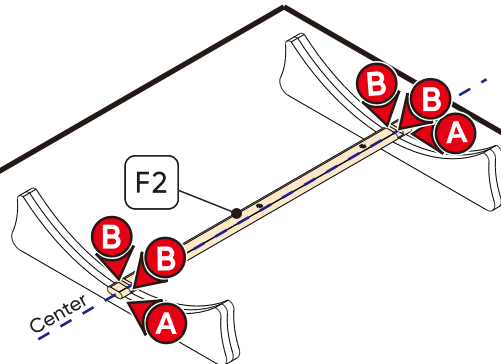
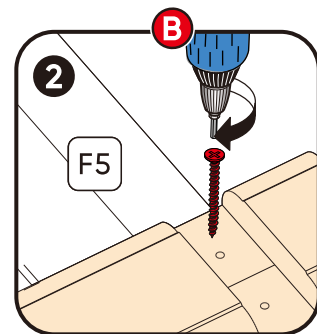
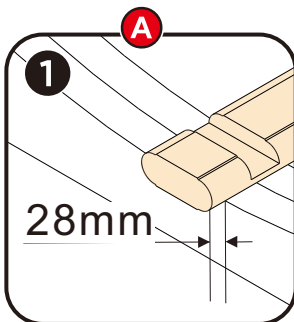
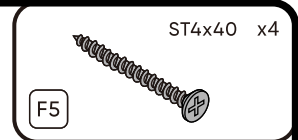
1



The base of the sauna must be level!



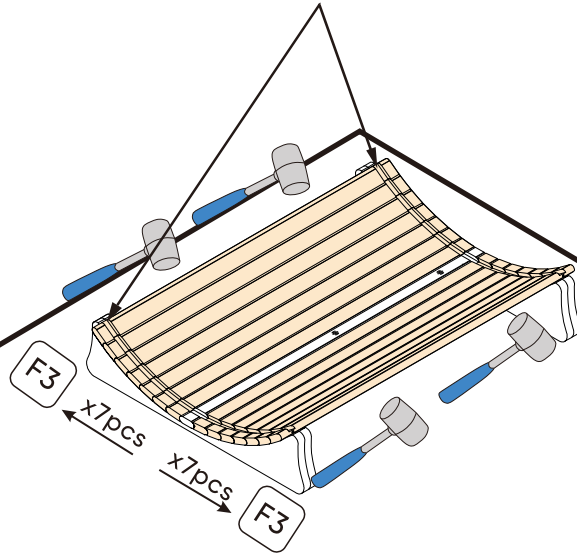
2



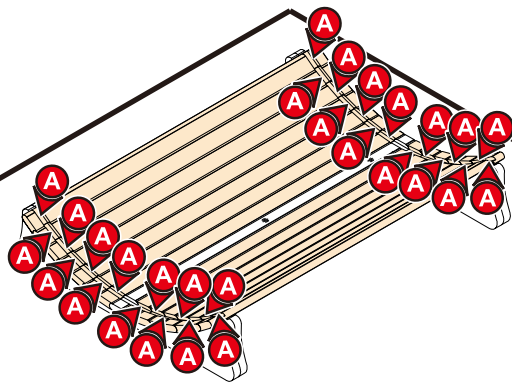
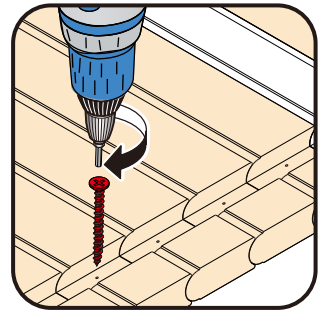
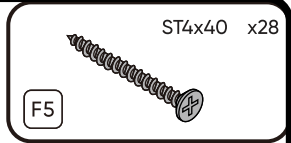
3



Align grooves on same line.



4

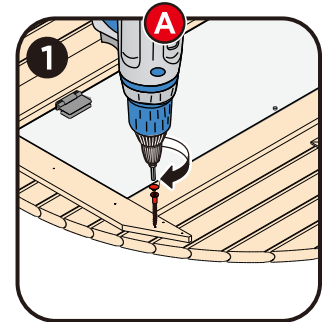
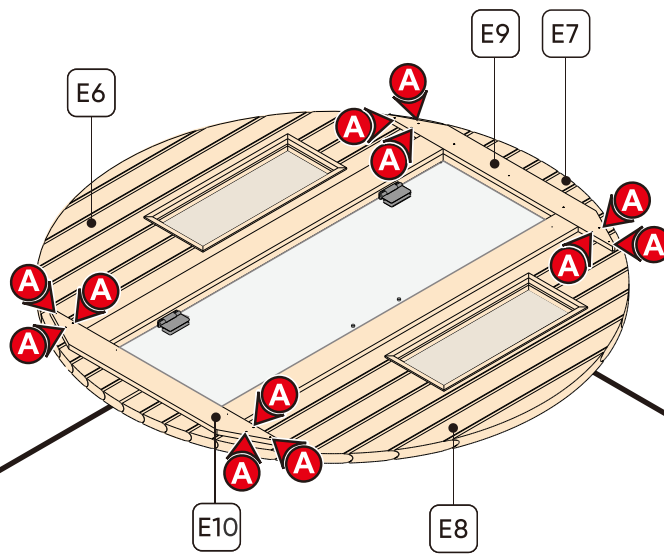
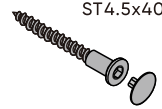


5



ST4.5x40 x12

D9



6

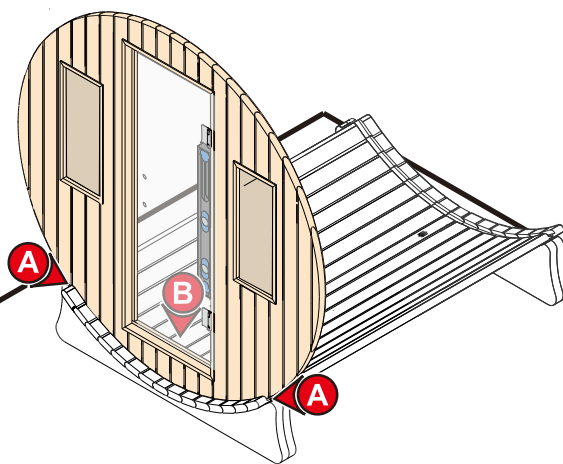
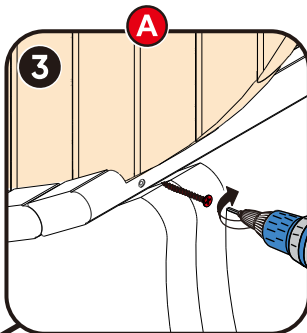
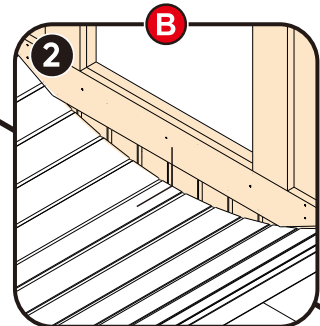
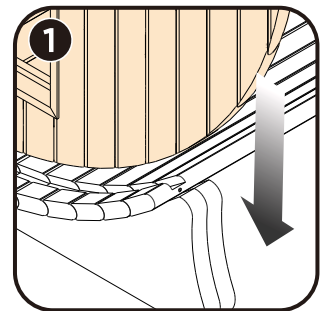


ST4x40 x2

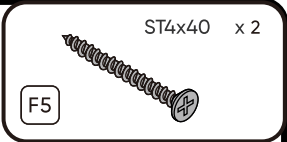
F5



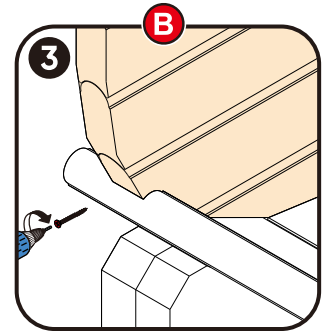
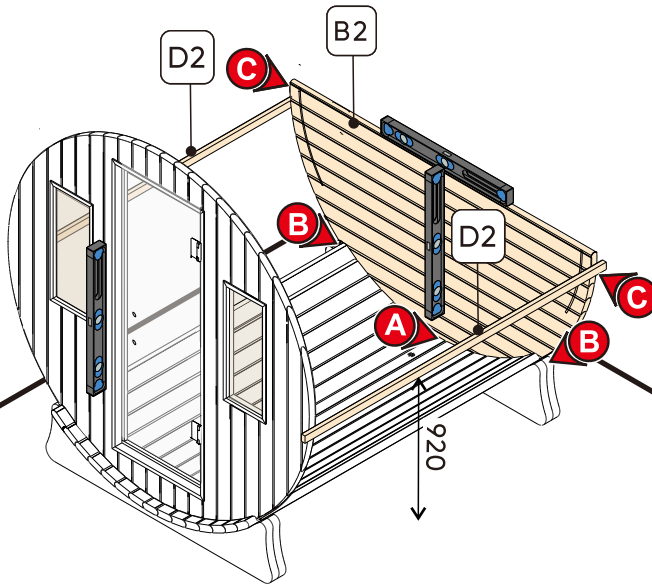
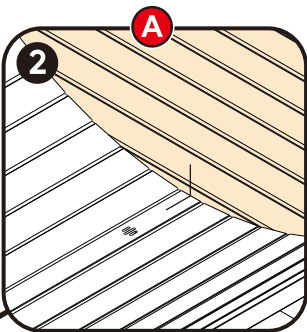
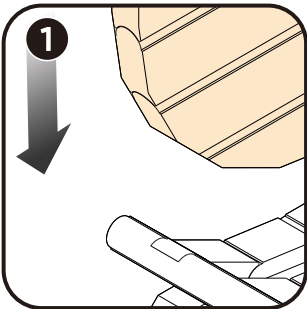
Ensure the wall is vertical during installation.



7

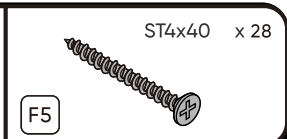
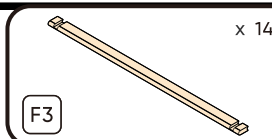


Ensure the wall is vertical during installation.

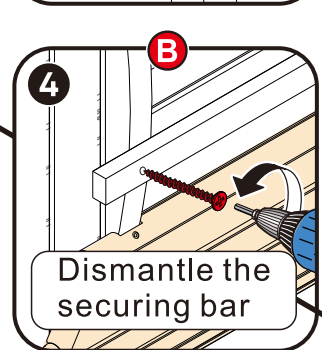
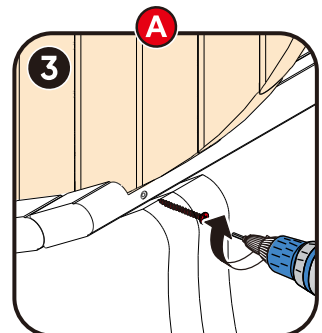
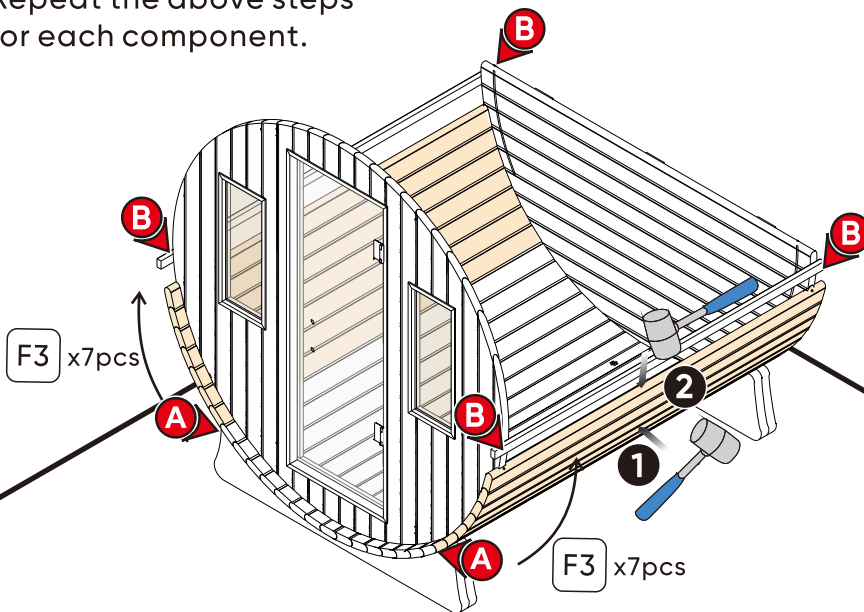


Install assisting securing bar

8




Repeat the above steps for each component.



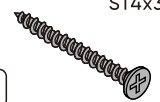
Dismantle the securing bar

9



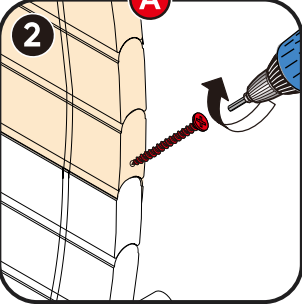
ST4x30 x 2

F5

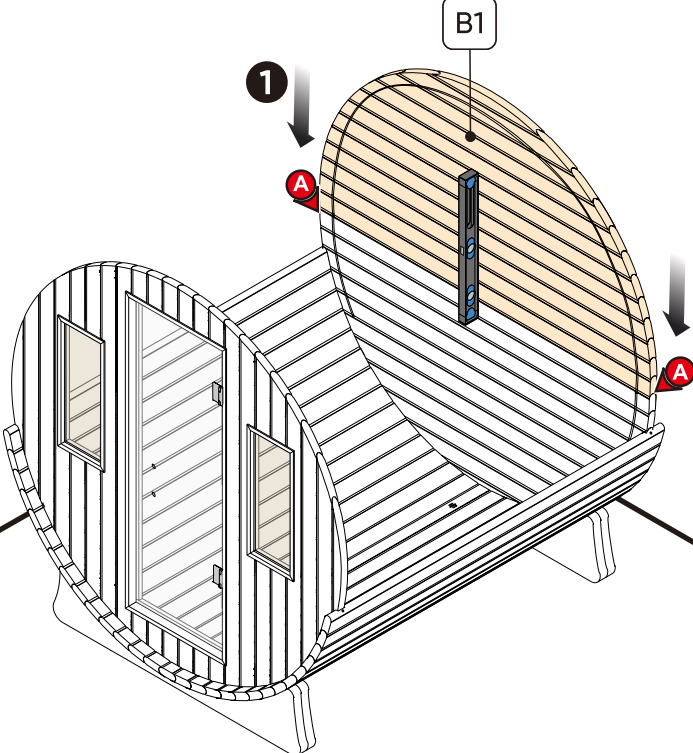


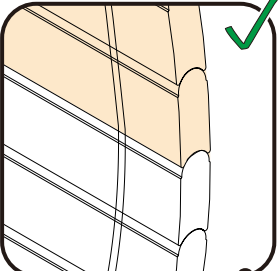
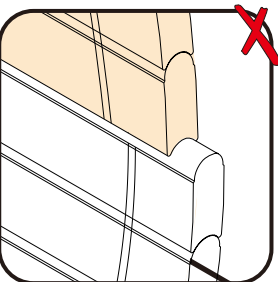
2

A




1



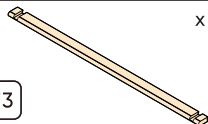



10




x 36

F3



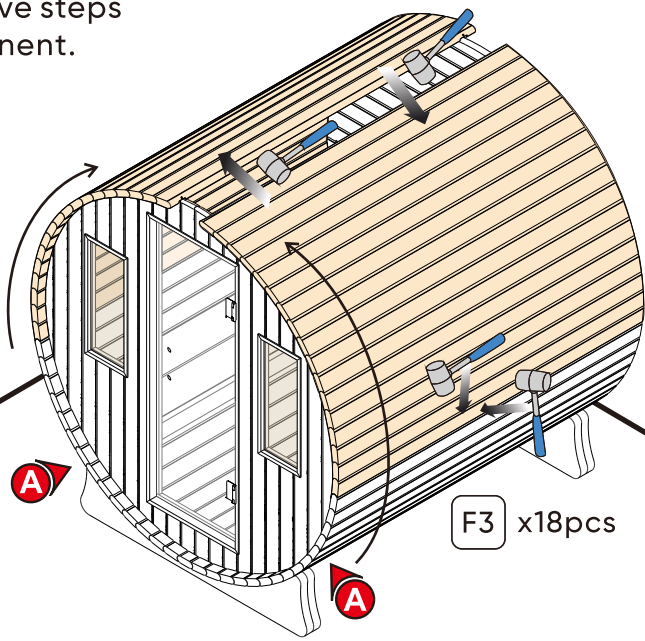
ST4x40 x 72

F5

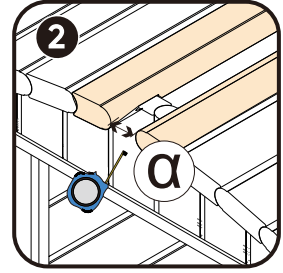
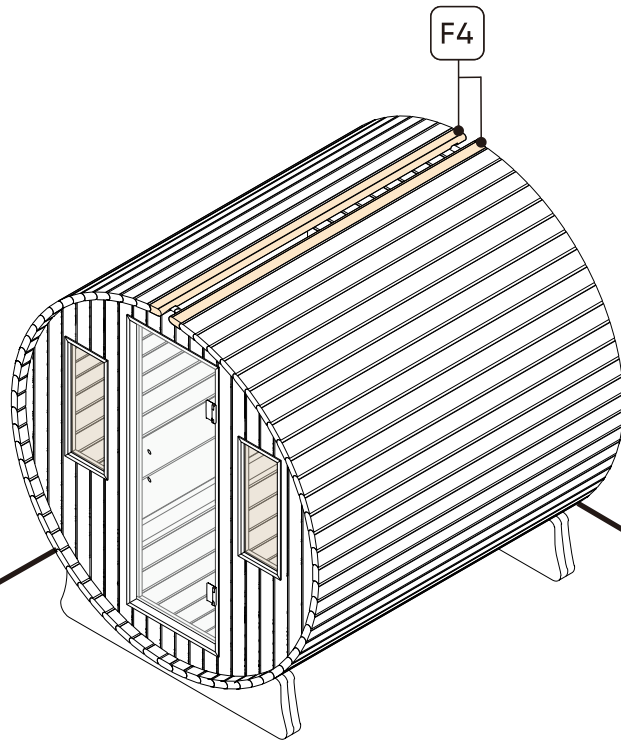
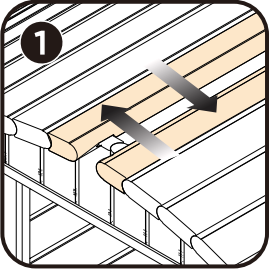


Repeat the above steps for each component.

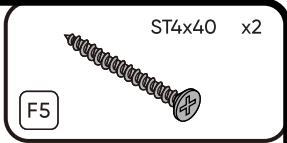
F3 x18pcs



11

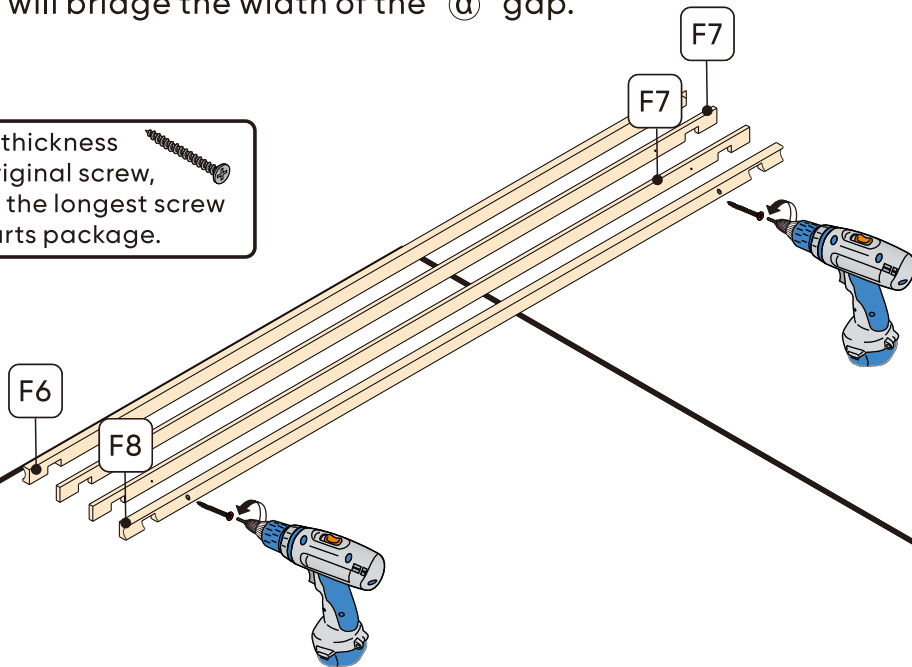


12



Join boards together (as shown in diagram) that will bridge the width of the "α" gap.

If the stacking thickness exceeds the original screw, please replace the longest screw in the spare parts package.

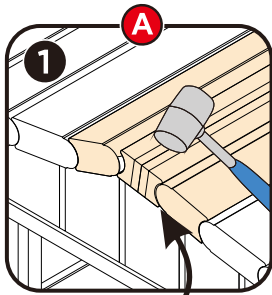


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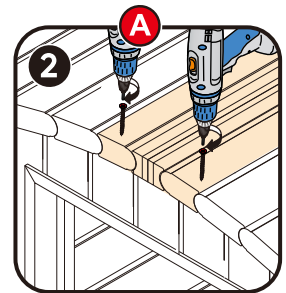
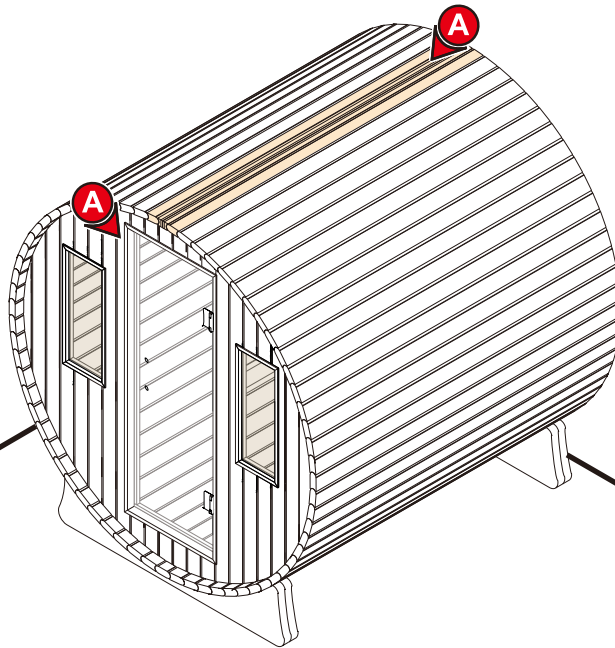


ST4x40 x4

F5



Raise slightly before installing the combined board

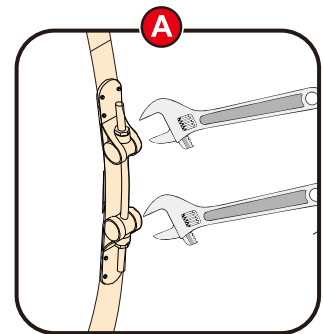
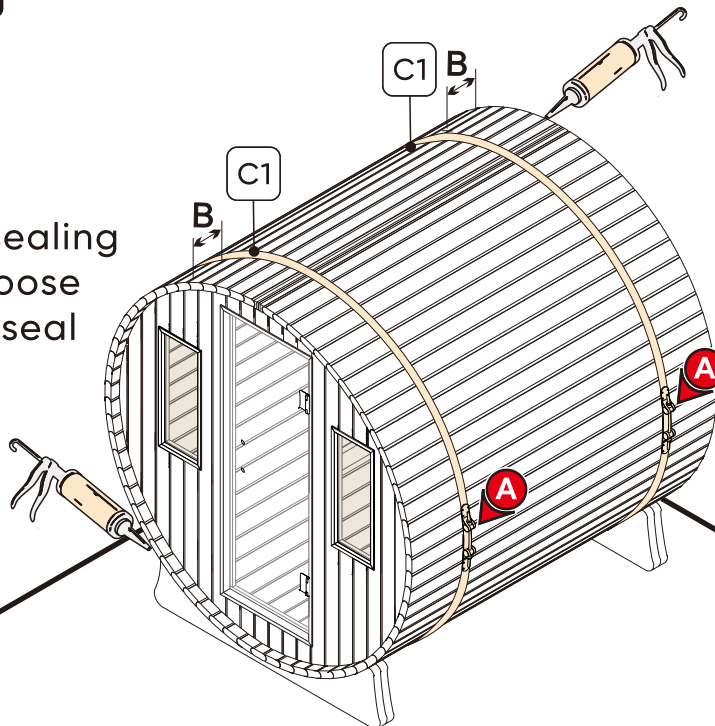


14



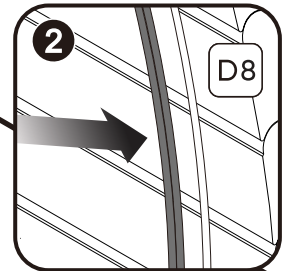
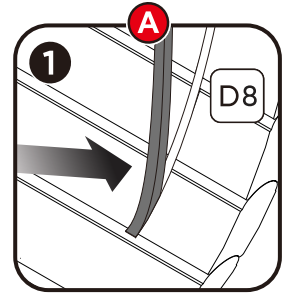
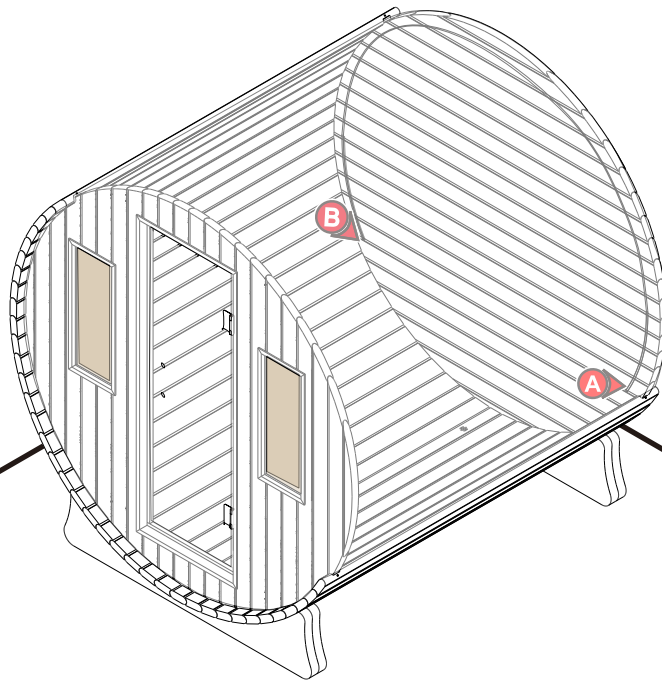
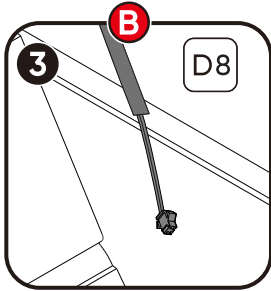
B=150mm

For better sealing you can choose whether to seal with glue.



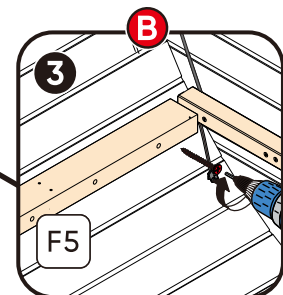
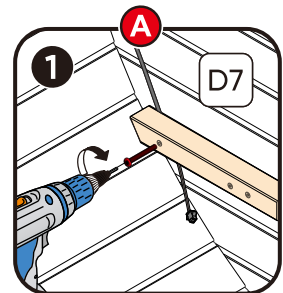
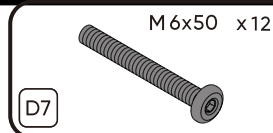
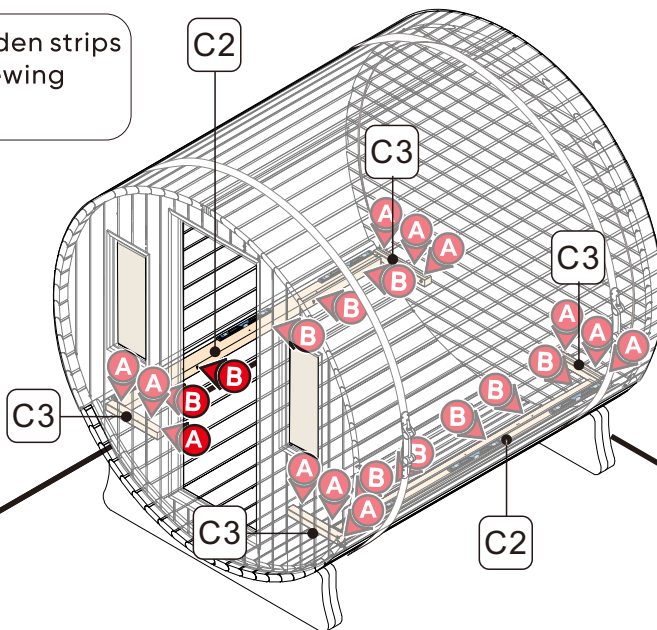
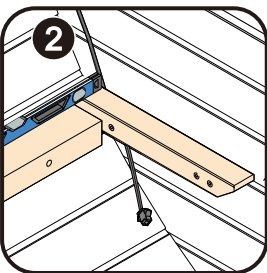
Tighten all nuts securely!

15 



16 

Ensure the two wooden strips are flush before screwing them together.

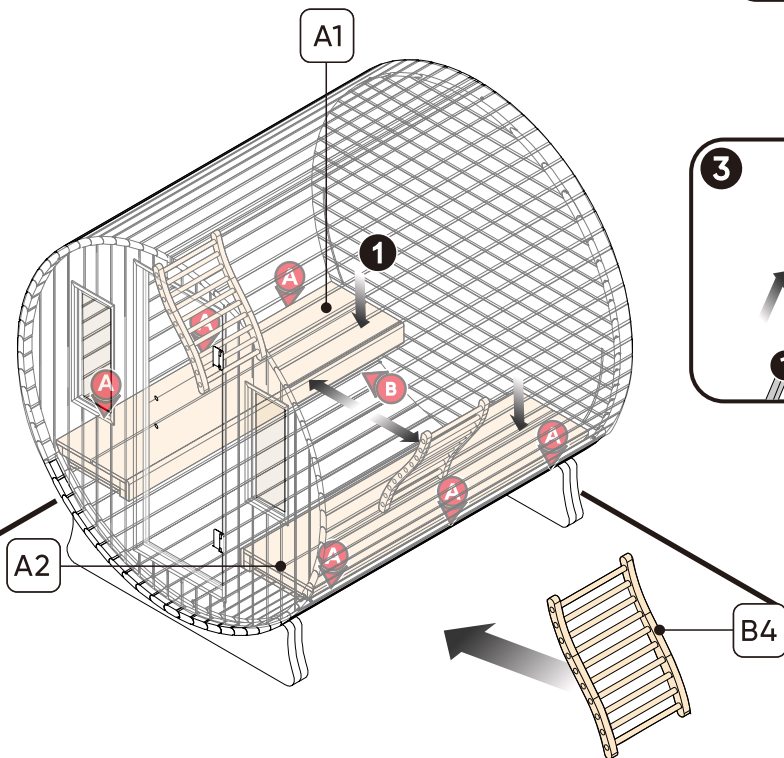
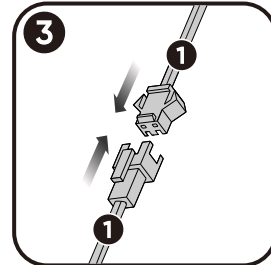
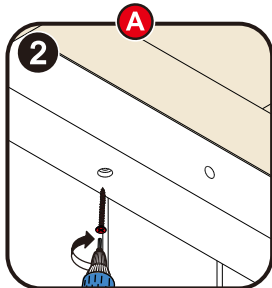


17



ST4x40 x6

F5

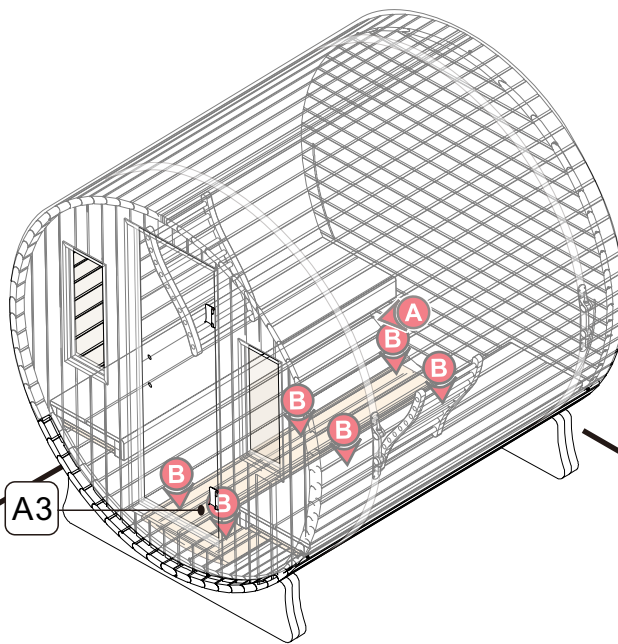
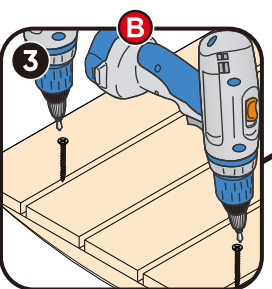
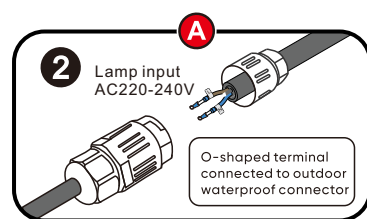
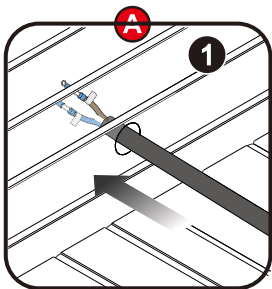


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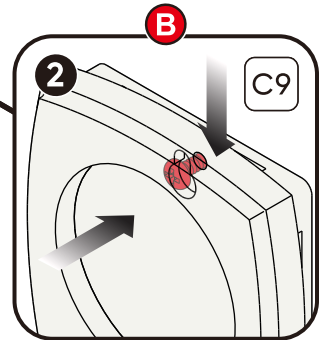
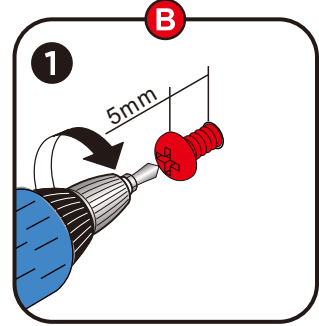
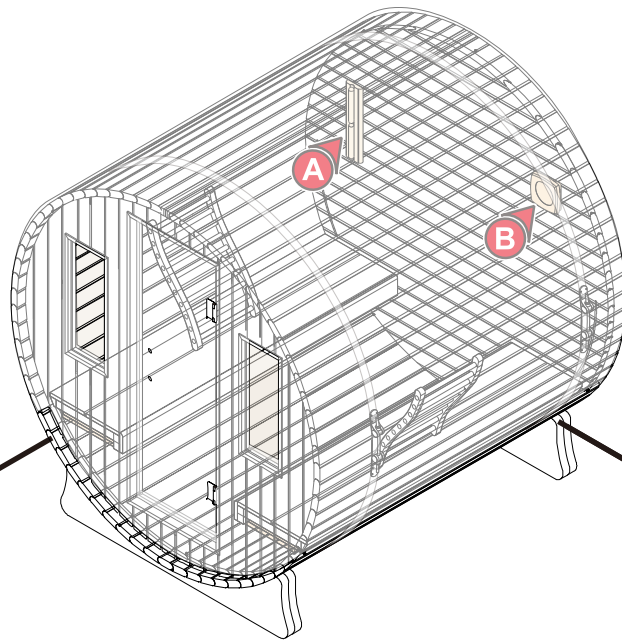
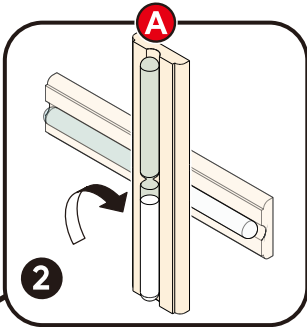
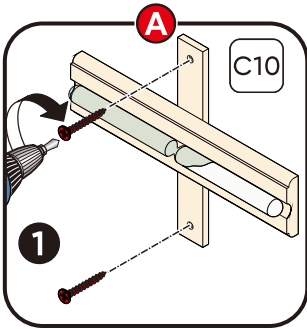
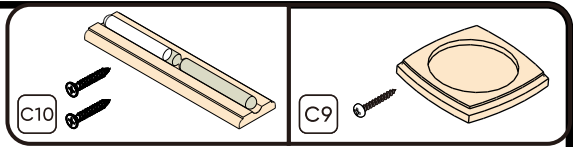


ST4x40 x6

F5



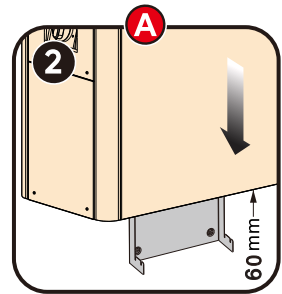
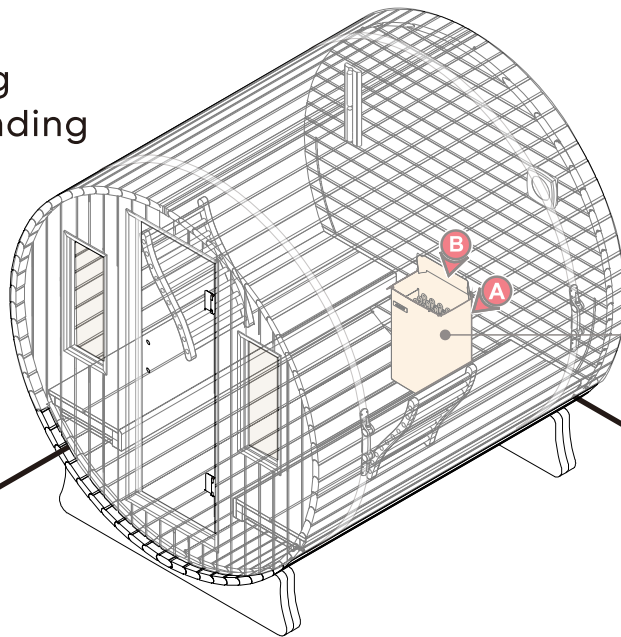
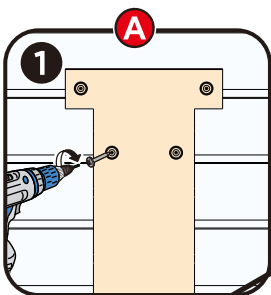
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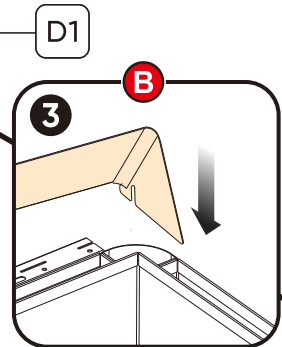
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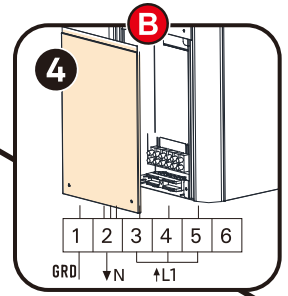
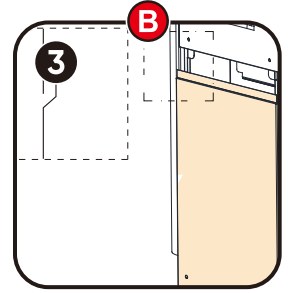
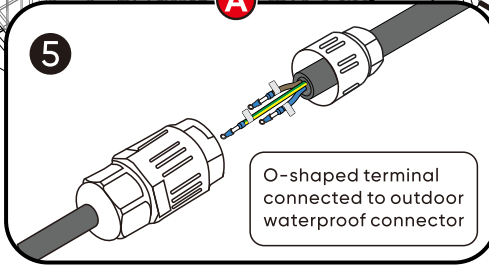
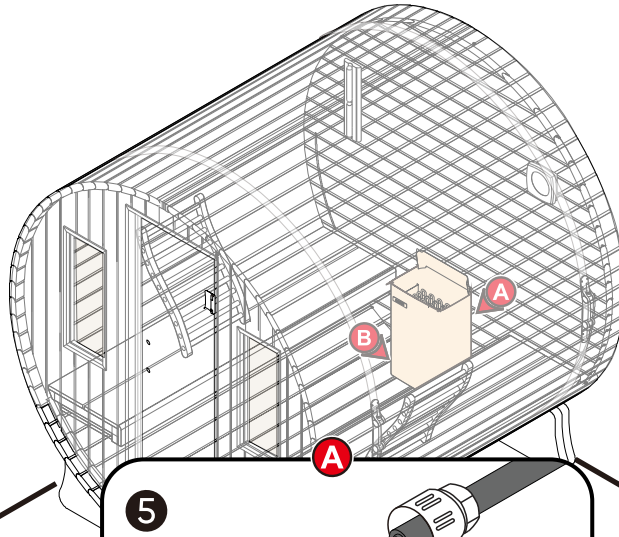
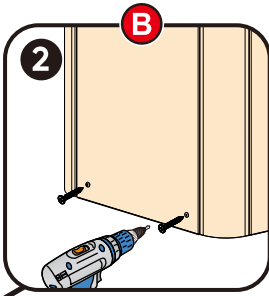
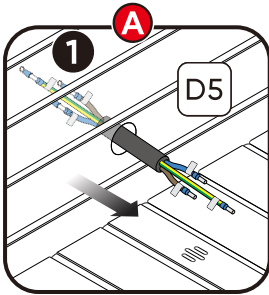
Install according to the corresponding hole positions.



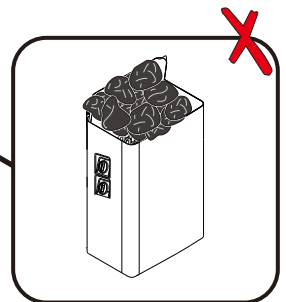
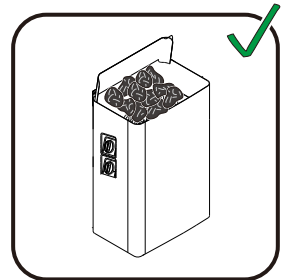
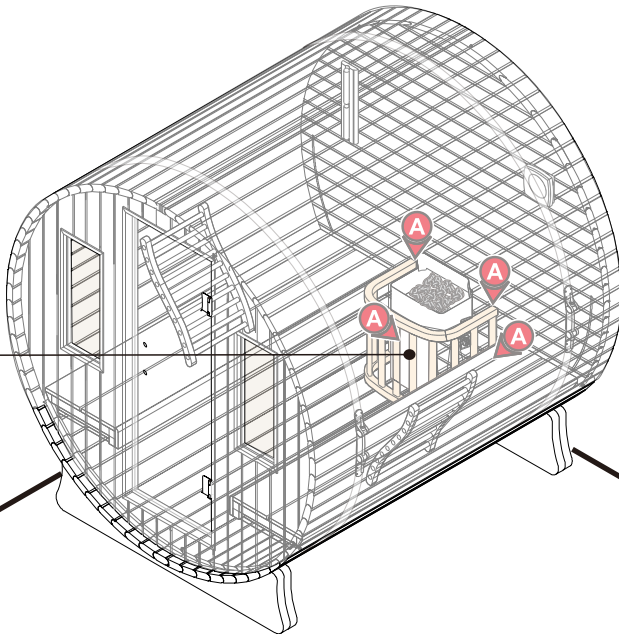
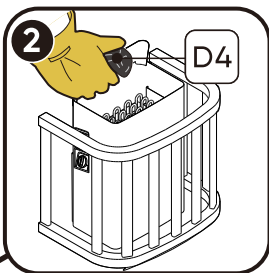
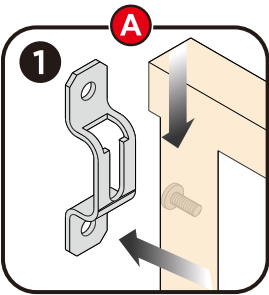
Height from ground



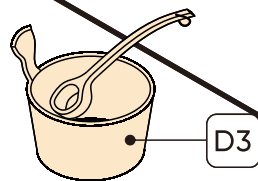
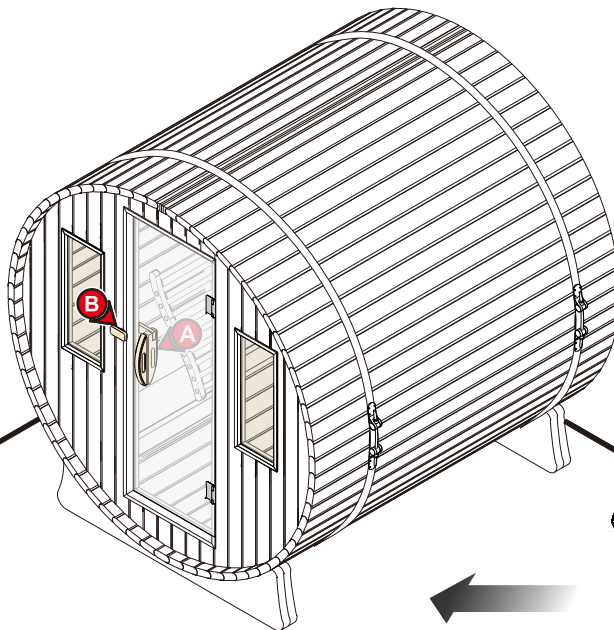
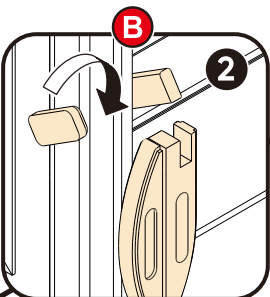
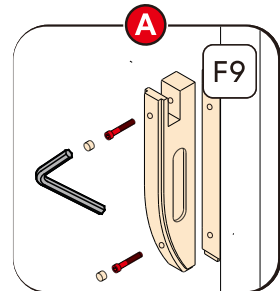
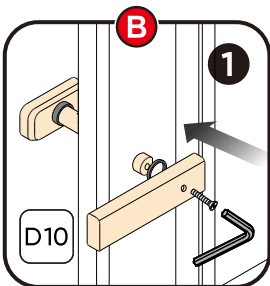
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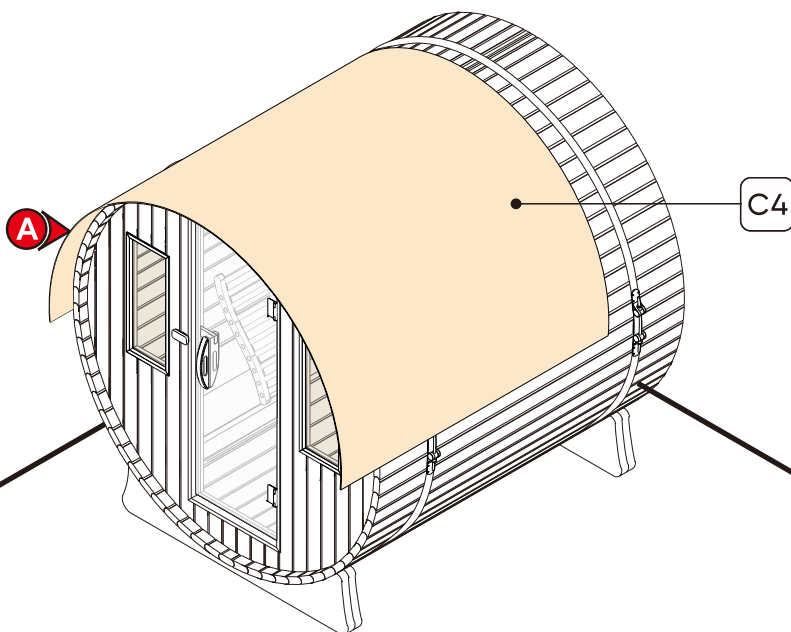
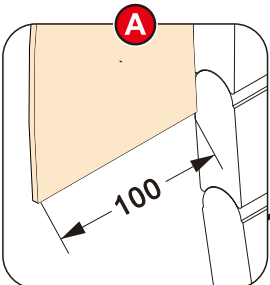
22



23



24

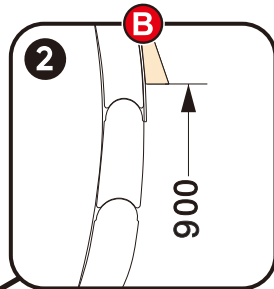
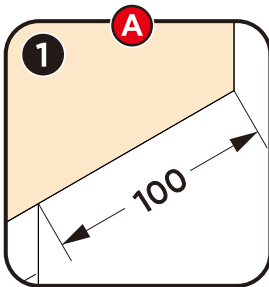


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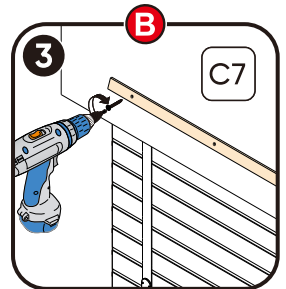
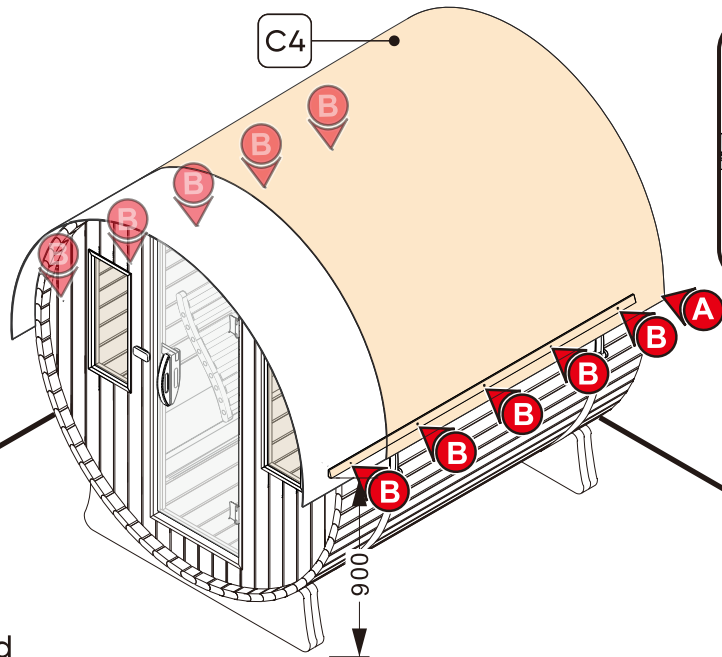


ST4x40 x10

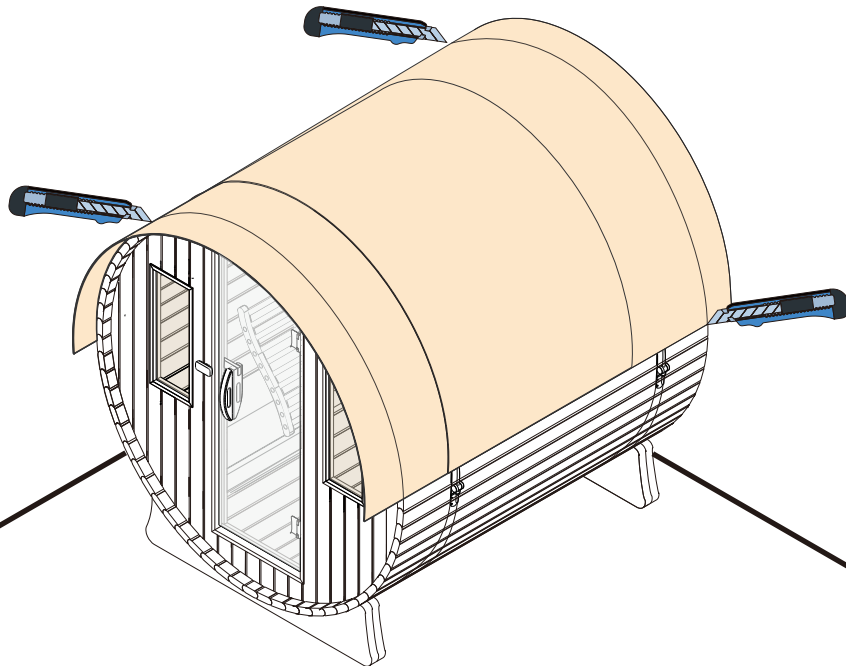
F5



Height from ground



26

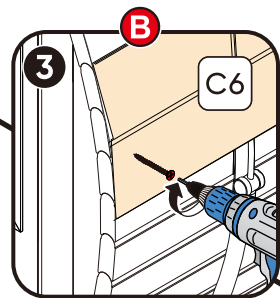
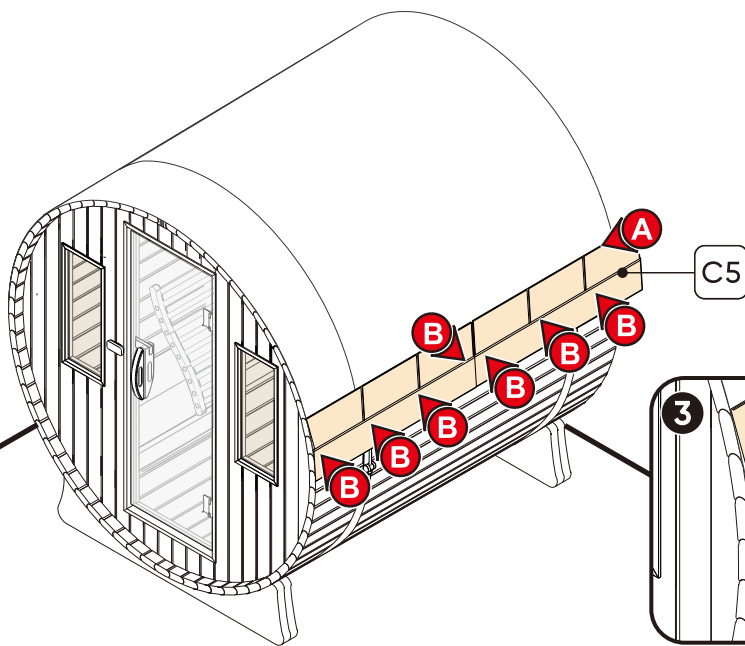
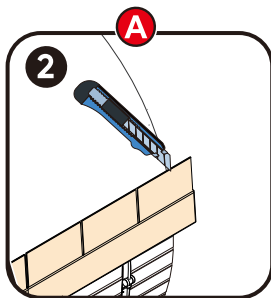
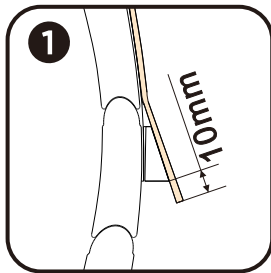
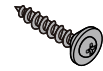


27



ST4x20 x7

C6

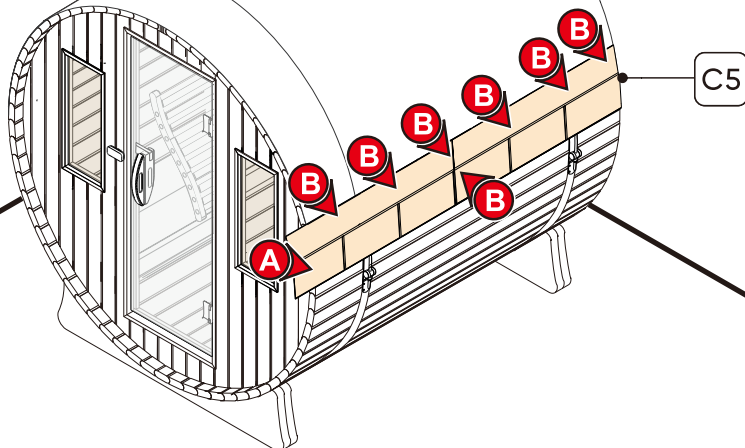
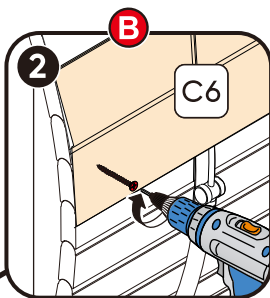
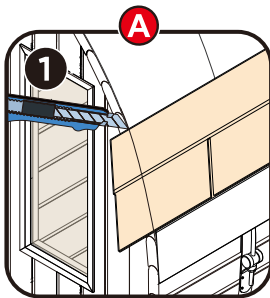


28



ST4x20 x7

C6

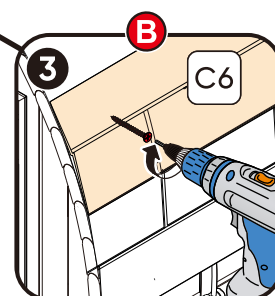
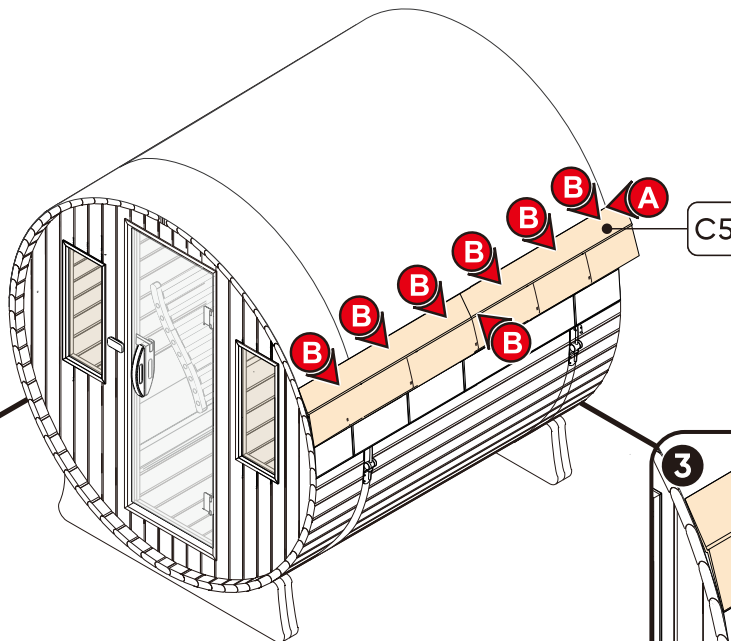
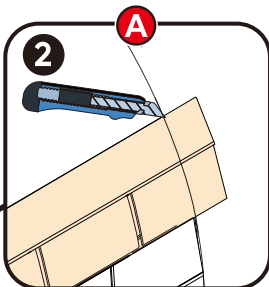
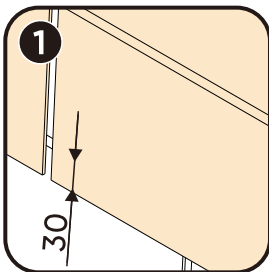


29



ST4x20 x7

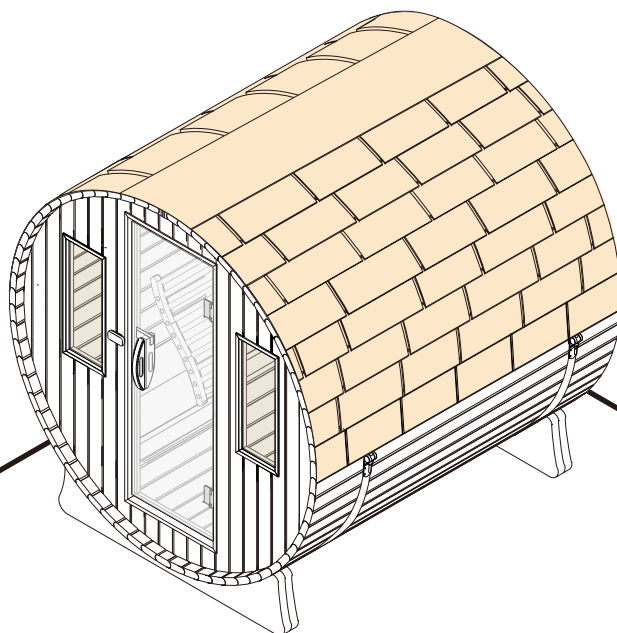
C6



30



Keep placing shingles till last layers goes over the middle of the roof

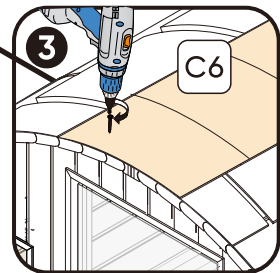
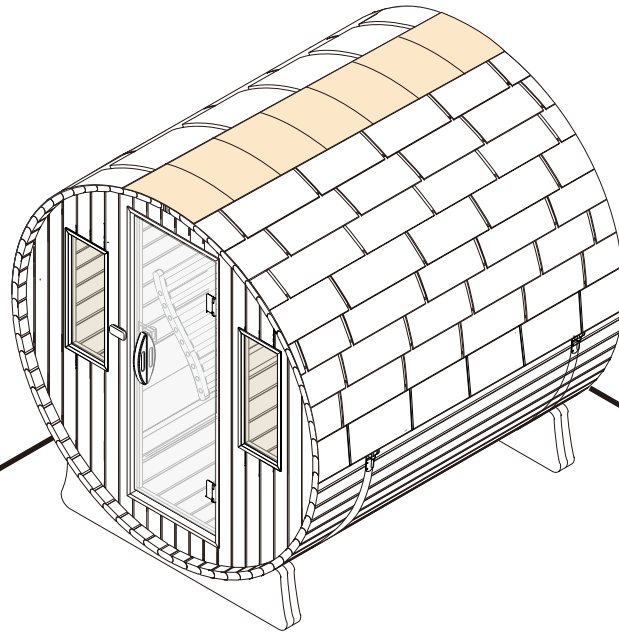
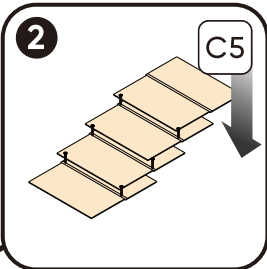
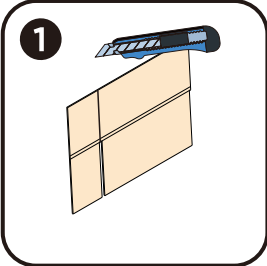


31



ST4x20 x20

C6



32



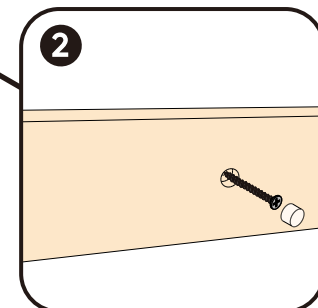
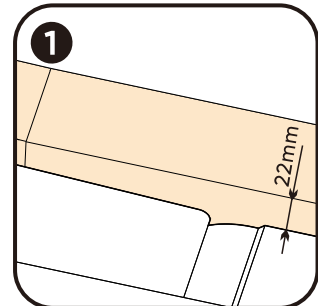
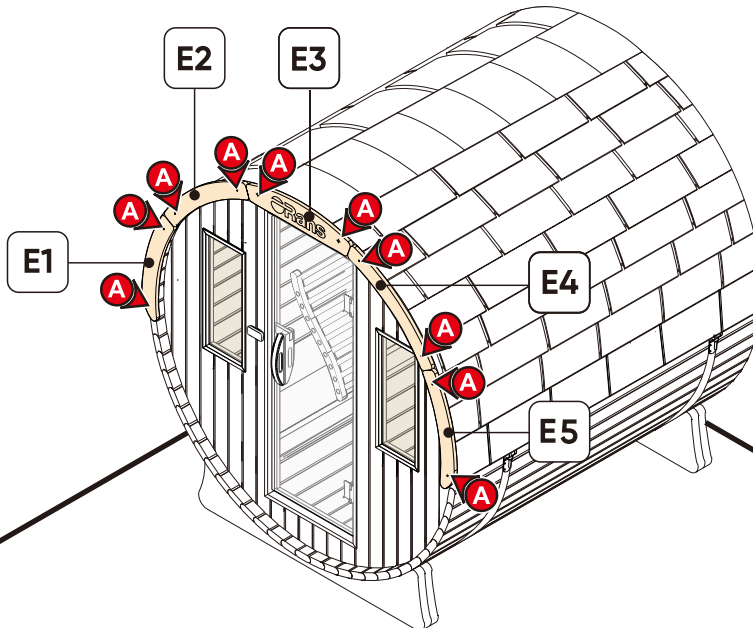
x10

ST4x40 x10

F10



F5



WOOD PROTECTION AND MAINTENANCE:

Protective coating : Apply a wood preservative at least once a year (or more often) to improve resistance to dirt and moisture, make cleaning easier, and extend the life span of the product.

SAUNA HEATER :

Heater installation : Follow the manufacturer's instructions for heater installation.

Cleaning heater stones : Wash new stones before placement to remove dust and chemicals.

First heating : The first heating must take place under supervision for two hours to a temperature of about 210°F. The sauna must be well ventilated both during and after heating. This allows the wood to absorb finishing materials and form a protective layer.

SAUNA MAINTENANCE-YEARLY:

Wood treatment : Re-treat wooden surfaces with a suitable product, especially for frequently used saunas.

Cleaning surfaces : Clean all surfaces with a soft brush/cloth and a designated cleaning agent according to the product's instructions.

Heavy stains : For stubborn stains, lightly sand the area before re-treating with wood Preservative.

Avoid unsuitable products : Avoid paints, varnishes, harsh disinfectants, or pressure washers, as these can damage the wood.

Hardware checks: Inspect bench and support mountings. Tighten loose screws if necessary, as wood can loosen due to heat and moisture fluctuations.

WOOD CHARACTERISTICS IN SAUNA:

Natural changes : Wood is a natural material that may crack or warp slightly due to temperature fluctuations. This is normal in saunas with extreme temperature and humidity changes.

Deformation factors : The risk of wood deformation depends on the material, usage intensity, and is more noticeable with wider boards.

Darkening wood : Wood in areas exposed to hot steam may darken over time.

Wood smell : Thermally treated wood has a characteristic smell that diminishes

over time but does not completely disappear. In a sauna, the smell weakens faster if it is heated for a long time and aired at the same time. Do not wash untreated thermal wood with water, as this will make the smell stronger.

TIGHTENING THE BANDS:

Tightening the bands on a wooden sauna is important for maintaining the structural integrity of the sauna and ensuring its longevity. The stainless bands wrap around the sauna to hold the wooden panels together tightly. Over time, due to changes in temperature and humidity, these bands may loosen, causing the wooden panels to separate or warp. Tightening them periodically helps prevent such issues and keeps the sauna in good condition.

Here's how you can tighten the bands on a wooden sauna:

1. Assess the situation: Before tightening the bands, inspect the sauna to identify any areas where the bands have loosened or where the wood appears to be separating.
2. Gather the necessary tools: You'll need a standard spanner to tighten the bands.
3. Tighten the fasteners: Use the appropriate spanner to tighten the bolts securing the bands.
4. Gradually tighten both bands to ensure an even distribution of pressure as opposed to doing one and then the other. Ensuring that each fastener is tightened securely. This helps prevent warping or uneven pressure on the wooden panels.
5. Monitor for any signs of loosening: After tightening the bands, keep an eye on the sauna for any signs of loosening or warping. If you notice any issues, address them promptly to prevent further damage.

By following these steps and regularly tightening the bands on your wooden sauna, you can help ensure its stability and prolong its life span.

 **Rans**