

Additional assembly instructions for HT150 Prestige (0908)

Thank you for choosing a product from SpaDealers. HT150 Prestige is a unique wooden spabath with a plastic inner lining. This makes cleaning easy and protects the wood. When assembling it is very important to follow the instructions in order to avoid leakages. Please read our guarantee conditions and what they include.

These additional assembly instructions contain important descriptions, which refer to the picture numbers shown in the graphic instructions. **If you have any queries, please contact us at +358-(0)10-239 5600 or info@spadealers.fi**

Taping the joint before applying sealant

IMPORTANT! Before starting to fill the joints, masking tape should be applied according to recommendations. See pictures 1, 2, 3 and 4. Masking tape needs to be placed outside the pre-marked line. **Note** where the masking tape starts and ends according to the letters in the pictures. This is important, because it will be easier to remove the tape when the sealing procedure has finished. Otherwise, there is a risk of not getting a good final finish and might cause problems later. **NOTE!** Study the details in the pictures, for example the folding of the first masking tape, picture 1 /**e/B**. The reason for this is the fact that you need something to grip when removing the tape. Check additional instruction “Mask properly”.

Sealing groove and nozzles for sealant

Grooves have been made in the benches and side parts in order to guarantee the best possible fit. There are also grooves made for the sealant. Pictures 5 and 7. The assembly tools contain a nozzle for the black sealing compound which is used to fill the cut outs and grooves.

VERY IMPORTANT! Fill the grooves with a bit more sealing compound than necessary, just that it comes into contact with the other surface by pressing it down, see picture 5 /**D**. However, be careful that you **do not use too much** of it, because it can get quite difficult to press the surfaces against each other.

Assembly of seating area

The seating area is assembled so that 3 benches are assembled first, picture 7. Then assemble the other 3 benches and put both sets of benches facing each other, picture 8. Assemble on a clean smooth cardboard surface or similar to avoid scratching the benches. Use the included textile hoop in order to tighten the seating area. Place the seating area on the level shown in picture 10 /**F** and tighten carefully. Carefully tap the vertical sides and the benches with a rubber mallet. The arrows in picture 9 show the recommended places. Tighten a bit more and repeat tapping gently with the rubber mallet. Go all the way round and try to tighten the seating area as well as possible. The theoretical opening between the benches is 1.5 mm divided equally between all the benches. If too much sealant has been used, it is possible that the seating area won't become tight enough. In such a situation it can help to tap the

benches and let the tightening pressure press the sealant together. Tighten the angle bar to each seat, picture 9/8.

Afterwards please assemble the air valves of the bubble system. It is important to apply silicone beneath the air valves and on top of the threads. Smear the silicone down on the threads using your finger. The rubber sealing ring should be placed on the backside and not beneath the air valves, picture 11.

Now you can start with the caulking of the seating area's inside in alphabetical order according to pictures 9 and 10. The sealant should be evened out until it covers the surfaces to the masking tape. Repeat a few times. It is recommended to use your finger for this. Remember to rinse your finger with turpentine afterwards. It's important that the sealant is smoothed out thin towards the edge of the masking tape, in order to make it easier to remove the tape.

Adjusting the seating area to the base

When the base has been assembled the connection pipes for the pressure and suction side should be mounted now (picture 15), the two horizontal grooves are filled with sealing compound and smoothed out, picture 16. Now fill the sealing agent in the base's joints, picture 17. After having done this it is time to lift the seating area into position. The T-connection for the bubble system air hose connection must be mounted in the same direction and place as shown in picture 17!

If the seating area is correctly assembled, it will now fit into the groove at the base. Otherwise, adjustments might be necessary. Do these by gently tapping the vertical sides with a rubber mallet to make them fit into the grooves. Then gently tap on top of the benches to make the assembly fall down into the grooves and come in contact with the sealant.

Attending to the sealing joint for the seating area and base

Then turn the base upwards in order to be able to screw it to the seating area, picture 18. Use the included screw 4.5x50 mm (3), picture 18/3. In order to get the right distance between the base and the bench, use the included 6 pre-cut pieces, picture 18/10. The adjustment of side modules is then easy. After this procedure, the sealing joint between the base and the seating area must be fixed and smoothed out, picture 19/a. Then do the same with the upper joint between the benches, picture 19/b.

Remove the masking tape now. Start at the point where the masking tape is folded and then pull outwards, picture 20. Let the joints dry. Check additional instruction "Mask properly".

Bubble system assembly (accessory)

After the sealing is completed, the bubble system can be assembled. It is important to apply silicone beneath the air valves and on top of the threads. Smear the silicone down on the threads using your finger. The rubber sealant should be placed on the backside and not beneath the air valves. The T-connection 20x32x20 (marked with a

!) should be placed in the same direction as the arrow. (Separate assembly instruction)

Preparing the side modules

While the joints are drying, start masking the joints of the side modules (unless it hasn't already been done). It is important to do this according to the instructions. See picture 22 and tape in the right order **a-c**. Check additional instruction "Mask properly". Also check for possible small cracks and holes due to knots in the side module where the plastic does not cover. They are unlikely, but not impossible. *If you find cracks or holes, mend them by putting a bit of sealant on top of them. Press down the sealant and smooth out. Wipe extra sealant off with turpentine. This gives a result that is virtually invisible.*

IMPORTANT!!! Leakage test

One important part of the assembly process is the leakage test. This is first made with the seating area. Check additional instruction "Mask properly" for drying times. The test must be made in stages according to the graphic instructions. Lock the pipe system with the rubber pipes which belong to the chimney and which have been sent as well. Those ones should be turned and taped that no water can run out. If there is a lamp (accessory), it should also be mounted according to the instructions. This can be done while the joints are drying.

Mending leakages

If a leakage is detected, it should be fixed before the next test is made. Mark the leakage, empty the water, wipe clean, mask the spot where the leakage has been detected (and at least 10 cm to each side), put on some sealant, press it down and smooth it out with your finger. Then remove the tape. You can now do the next test without waiting till it dries. Continue until the entire seating area has been tested. Empty the water and then continue with the assembly of the side modules.

ATTENTION! A leakage which has not been resolved correctly can lead quite likely to other leakages due to its material movements. A leakage should be always resolved from "inside" and without any delay.

Side module assembly

Before starting the side module assembly, apply masking tape to the top of the benches around the entire seating area. Follow the marked line, picture 23. Start by mounting the side module with the hole, and place it opposite the suction connection at the base. When doing the assembly, the masked line of the side module (left and right side) must fit in so it meets the line of the joints on the seating module, picture 24/L. When the side modules are assembled so that horizontal and vertical joints follow each other, the result will look good. The side modules should follow the outer line where the masking tape is, picture 24/K, 25/M. NOTE! The side should not be tapped so hard that they move towards the masking tape. At the base, there is also a line showing approximately how far the staves should be tapped inwards, picture 24/J.

Tightening the hot tub

After the side modules have been assembled, they must be tightened and “locked” with 2 included stainless hoops. Follow the measurements and placing shown in picture **26**. The tightening must be made in stages. First tighten the lower part, but only until it feels a bit tight. Walk around the tub and tap with the rubber mallet at the height where the side modules and benches are fastened to each other. Try to get an even distance between side modules and the line where the masking tape is. At this stage it is still possible to make the vertical groove on the side to follow the joint between the benches. NOTE! Be careful and don't break the side modules. This could cause cracks along the joint that is already plasticized. If cracks occur they must be dealt with later according to the method that has been described earlier in the chapter “**Preparing the side modules**”. Tighten the upper hoop every time the lower hoop has been fixed. The opening between the hoops should be approx. 40 mm when they are tightened enough, picture **26/N**.

Sealing benches and sides

First fill the vertical grooves between the side modules, 6 pcs, with sealant. Then apply sealant to the joint between benches and sides, picture **27**. Smooth everything out and remove masking tape, picture **28**. Let the joints dry. Check additional instruction “Mask properly”.

Leakage test above benches

When everything else has been assembled a leakage test can be made above the benches. First, fill water over the joint where the benches and the sides are mounted, picture **29/1**. Check for any leakages. Then make the leakage test above, picture **29/2**. Normally there is no reason why there should be a leakage above the benches. If not enough care has been taken when assembling the side modules, there is a risk that a crack could occur in the thin part of the inner tongue. In such cases, the risk of leakage above the joint between the benches and side module is high, and almost always there is then a leakage in the side stave tongue, which makes water drip in the lower end. Find the crack and resolve it promptly according to chapter “**Preparing the side modules**”.

>> Regarding the rim, please read separate assembly instruction.

>> Regarding the assembly of the heater or similar please read separate instructions.

The hot tub is now ready and you can start using it.

Remember that water hygiene is important and follow separate instructions concerning this. We hope you thoroughly enjoy your spa bath!