

SECTION 13 24 26 / 13054
STEAM ROOMS

PART 1 GENERAL

1.1 SECTION INCLUDES

- A. Steam generators and control.
- B. Prefabricated modular steam rooms.

1.2 RELATED SECTIONS

- A. Cold Formed Metal Framing: Framing for steam room enclosures.
- B. Rough Carpentry: Framing for steam room enclosures.
- C. Board and Batt Insulation: Thermal insulation and vapor barrier at steam room enclosures.
- D. Joint Sealers: Sealant at exterior periphery of steam enclosures.
- E. Tile: Interior finish for steam room enclosures.
- F. Cut Natural Stone Tile: Interior finish for steam room enclosures.
- G. Plumbing Piping: Domestic water supply to steam generator and faucet.
- H. Plumbing Specialties: Floor drain in steam room.
- I. Equipment Wiring.

1.3 SUBMITTALS

- A. Submit under provisions of specifications.
- B. Product Data: Manufacturer's data sheets on each product to be used, including:
 - 1. Preparation instructions and recommendations.
 - 2. Storage and handling requirements and recommendations.
 - 3. Installation methods.
- C. Shop Drawings: Complete details of modular steam room enclosures, including required clearances and locations of service connections.

1.4 QUALITY ASSURANCE

- A. Manufacturer Qualifications: A company with not less than 20 years of experience in manufacturing components of the type required for this project.
- B. Regulatory Requirements: Provide only ASME certified low-pressure vessels and UL listed equipment and controls.

1.5 DELIVERY, STORAGE, AND HANDLING

- A. Store products in manufacturer's unopened packaging until ready for installation.

PART 2 PRODUCTS

2.1 MANUFACTURERS

- A. Acceptable Manufacturer: Helo Commercial, 575 E Cokato St, Cokato, MN 55321. Tel: (800) 225-7519 Fax: (320) 286-6100. E-mail: sales@helocommercial.com
www.helocommercial.com
- B. Substitutions: Not permitted.

- C. Requests for substitutions will be considered in accordance with provisions of specifications.

2.2 STEAM GENERATORS AND CONTROLS

- A. Steam Boiler: Helo Commercial by Amerec Steam Boiler (All steel construction with powder coat finish and stainless steel feet to prevent corrosion), of size as recommended by manufacturer based on volume of room and type of construction materials employed.
1. Provide T100B touch screen control package with external control system including programmable temperature and time displays, light switch, and temperature read out in Celsius or Fahrenheit.
 2. Provide Cool Flush Auto Drain System that ensures the unit is flushed and drained daily, eliminating the need to rely on maintenance personnel to perform the procedure.
 3. Provide 24-hour, 7-day timer, to turn the generator on and off at a specific time each day of the week.
 4. Provide high temperature alert alarm, to set off audible alarm at a specific temperature and interrupt power to the unit when that temperature setting is exceeded.
 5. Room "over-temperature shut down" turns boiler elements off and blinks indicators to show alarm
 6. Indicator lights with integral diagnostics
 7. Digital Timers for on/off operation and Auto-drain programming. (Optional)
 8. Low Water Cut-Off, where required by code. (Optional)
- B. Provide all other items needed to provide complete functional installation.

2.3 MODULAR STEAM ROOM ENCLOSURES

- A. Acrylic Modular Steam Rooms: Prefabricated, packaged unit, complete with fittings.
1. Construction: Formed acrylic sheet
 2. Thickness: 5/32 inch (4 mm) walls and ceiling;
 - a. 9/32 inch (7 mm) seating areas with block reinforcement from behind for Elysee Rooms.
 - b. Excellent rooms use white lacquered, aluminum benches, 7/8 inch (22 mm) thick tops.
 3. Finish: High glazed, white color.
- B. Capacity and Dimensions: Our 5 standard sizes are listed; other sizes available. Elysee Steam Rooms are constructed with acrylic seats formed in the molded wall panels. Excellent Steam Rooms are constructed with flat acrylic wall panels and two tiered stand-alone, white lacquered aluminum benches (similar to standard commercial construction)
1. Elysee 4F – 52.75" x 83.5" x 81.5" – 4 person capacity
 2. Elysee 6F – 76" x 83.5" x 81.5" – 6 person capacity
 3. Elysee 8F – 99.25" x 83.5" x 81.5" – 8 person capacity
 4. Excellent 8FL – 76" x 83.5" x 81.5" – 8 person capacity
 5. Excellent 12FL – 99.25" x 83.5" x 81.5" – 12 person capacity
- C. Door: All glass door mounted on aluminum frame.
1. Glass: 5/16 inch (8 mm), tempered and tinted. Standard width is 35-1/2" (1010 mm)
- D. Light: Manufacturer's standard
1. Elysee – One LED downlight above each seat module
 2. Excellent – Ceiling mounted lights, as appropriate for size of room.
- E. Thermal Insulation: No insulation is required or recommended.
- F. Exterior Finish: As specified in Division 9.

PART 3 EXECUTION

3.1 EXAMINATION

- A. Verify that rough-ins for all utilities are properly sized and in correct locations.
- B. Do not begin installation until substrates have been properly prepared.
- C. If substrate preparation is the responsibility of another installer, notify Architect of unsatisfactory preparation before proceeding.

3.2 INSTALLATION

- A. Install steam room components in strict accordance with manufacturer's instructions and approved shop drawings.
- B. Modular Steam Room Enclosures: Install prefabricated panels to final room dimensions in accordance with manufacturer's assembly instructions; lock panels into place.
- C. Install insulation and vapor barrier in accordance with requirements of specifications.
- D. Steam Generators and Accessories: Install and connect steam generators, steam outlets, controls, and temperature sensors. Coordinate with work of mechanical and electrical sections, and connect to utilities.

3.3 PROTECTION

- A. Protect installed products until completion of project.
- B. Touch-up, repair or replace damaged products after Substantial Completion.

END OF SECTION





The Helo Sauna and Steam Experience

The benefits of saunas and steam baths are well documented — making these amenities essential for health clubs and other commercial installations. They have also become “must have” home amenities.

To ensure maximum enjoyment and performance from your sauna and steam bath, choose Helo Sauna and Steam — the world’s oldest and largest sauna company.

Design: Helo’s reputation as the “commercial experts” begins with well thought out design assistance. Our in-house experts will provide design assistance and architectural drawings. This ensures you get exactly what you want — a sauna and/or steam bath to fit your requirements.

Large or Small: Residences, hotels, corporate wellness centers and apartment complexes... individual needs require an individual approach. Whether for two or 22 persons, it doesn’t matter — Helo will work with you to design the perfect sauna or steam bath.

Quality Saunas Since 1919: Together we will find the best solutions for your sauna and steam bath project.

Your design (or ours), your ideas and your wishes, in partnership with our 90 years experience will ensure you unmatched form, function and quality. From the first sketch to the final installation, our technical support and product knowledge will be at your disposal.

Helo works with you every step of the way to make the sauna and steam bath portion of your project hassle free. A high quality product is what you get, and our project management makes your sauna and steam projects pleasurable — not stressful.

What does project management include?

Helo provides:

- *Free design assistance, including CAD drawings*
- *More than 90 years of experience to design and build the perfect sauna for your project.*
- *Necessary documents/submittals at each phase of the construction project; management of contractual matters*
- *Nationwide network of factory certified installers*
- *Service after the sale (we’ve been here for more than 90 years, and we’ll be here to take care of your future needs)*

HELO TRADITION, QUALITY AND DESIGN

The decision to reward yourself with a sauna goes hand in hand with choosing Helo. Helo is the oldest name in sauna — beginning in Finland more than 90 years ago. Since arriving in the US more than 40 years ago, more American architects have specified Helo than any other brand. Helo has manufactured more than two million sauna heaters — making it the sauna of choice in homes and clubs around the world.

Helo has become the world's largest sauna and steam manufacturer through innovation, product development and an uncompromising commitment to quality. Helo saunas, at first glance, are very impressive; they become even more so upon careful examination.

Helo quality is immediately evident by our styling and design — with innovative use of glass, curves and lighting. It continues with our use of hand-selected woods — clear and graded to the lightest colors. Select Western Red Cedar is standard. For those wanting wood that is lighter and more consistent color, or wood specific for hypo-allergenic purposes, consider Helo's vertical grain Canadian Hemlock.

To maximize form and function, all Helo saunas are matched with sleek, contemporary heaters and user-friendly controls. Helo means superior value and years of satisfaction delivered in the name of relaxation and good health.

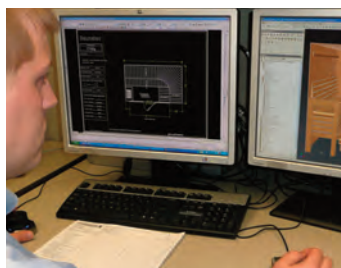
Now is the perfect time to enjoy the finest saunas available. Whichever package you choose, you'll enjoy the quality only found in Helo.



Western Red Cedar



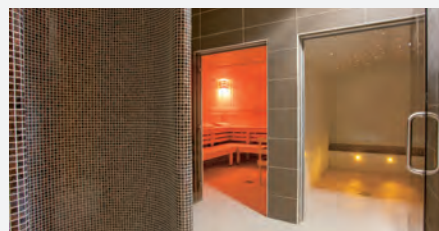
Canadian Hemlock



From the first sauna ever designed by Helo to the most recent projects, we have been a leader in setting commercial-sauna industry standards. The Helo ideals — client satisfaction, quality, professionalism and value — have guided the way we've done business for generations. They are the way we want to do business with you. The following is a partial list of Helo clients.



Detroit Pistons - Palace of Auburn Hills
Disney Resorts, Vero Beach, FL
Jewish Community Centers, Nationwide
YMCAs, Nationwide
Joe Louis Arena, Detroit, MI
Detroit Lions Training Center, Allen Park, MI
Coors Field, Denver, CO
Core State Arena, Philadelphia 76'ers / Flyers
Gillette Stadium - New England Patriots
Royal Pacific Resort - Universal Studios
GM World Headquarters, Detroit, MI



Hilton Hotels, Nationwide
Westin Hotels, Nationwide
Hampton Inn Hotels, Bronx, NY
Hyatt Hotels, Nationwide
Duke Athletic Center, Durham, NC
Paul Brown Stadium - Cincinnati Bengals
American Airlines Arena - Miami Heat, Miami, FL
Powerhouse Gyms, Nationwide
Five Seasons Country Clubs, Nationwide
Ritz Carlton Hotels, Nationwide
Mercedes-Benz - U.S. International Inc.

Golds Gyms, Nationwide
Embassy Suites, Nationwide
Marriott Hotels, Nationwide
Fort Bragg, Fort Bragg, NC
Urban Actives - Nationwide
St. Regis Hotel, Atlanta, GA
Vandenberg AFB, CA
U of Michigan Hockey & Wrestling
U of Indiana Basketball
U of Kansas Football

The Helo Difference

The Helo Difference is notable — beginning with the design, but continuing to the less obvious details.

Finest Lumber

Our premium Western Red Cedar is the most select. To ensure that no distortion of the wood takes place after construction, the kiln-dried lumber is shipped from the mill to our climate controlled warehouse. A moisture content of sauna lumber of 12% or less is critically important; if moisture has accumulated the wood may shrink and split at high temperatures. All Helo saunas include as standard a foil vapor barrier.

Western Red Cedar is a superior sauna wood because it is least hot to the touch, it has the most beautiful color variation, and it has a pleasant aroma. It has very high resistance to discoloration, splintering, warping and decay.

Broad Sauna Heater Line

Helo heaters range from 1.7 kW to 14.4 kW (all UL or ETL listed).

Factory Direct Sales and Support

Helo specializes in factory-direct support. That means you work directly with our expert team to efficiently get everything you need to take care of your project.

Custom Designed to your Specifications

From your design or ours, we will provide a sauna virtually any size or shape. Ask for our Sauna Design Manual, including in depth information on sauna guidelines, specifications, CAD drawings, bench and wall construction details, window alternatives, wiring diagrams and installation instruction.

A complete line of heat-bathing products — Saunas, Steam baths and Infrared Rooms

Helo's product line is second to none, and includes a virtually infinite range of saunas (custom-cut material packages and panel-built packages); a broad range of acrylic modular steam rooms; a wide range of steam bath generators from the small plug-in 120-volt version up to our hard-working commercial boilers. Additionally, Helo's product range includes Infrared Sauna Rooms.





Going Green Has Never Felt So Good

While all of Helo's wood packages are manufactured with materials from carefully selected suppliers and forests, a Helo sauna package constructed of FSC® certified materials shows accountability to these standards by creating a chain of custody through which the wood can be traced back to its origins.

Helo FSC certified sauna wood packages provide the following benefits:

- *Contributes towards LEED credit MR 7, which requires certified lumber*
- *Contributes towards credits for most residential green building programs*
- *Ensures the forests from which the sauna wood is harvested will be around for future generation to enjoy a sauna*
- *Shows a commitment to responsible management of forests and ethical business practices*

Features of these rooms include:

- *FSC certified tongue and groove boards for the walls and ceiling*
- *Benches constructed using FSC certified S4S wood for bench tops and internal framing*
- *Heater guard rail and Sauna trim/moulding manufactured of FSC materials*
- *Dri-Dek vinyl interlocking flooring. Dri-dek is very durable and features anti-microbial properties to maintain a more sanitary environment*
- *All-glass door hung on FSC certified door jamb*
- *The sauna heater and control matched for the sauna room size and features selected by the customer*

For more information or pricing on our FSC packages, contact your local dealer or call us directly at 1-800-225-7519. For more information on our full product line, visit us on our website at www.helocommercial.com



Helö Custom-Cut Saunas

FOR THE DO-IT-YOURSELFER AND THE CONTRACTOR

The custom-cut interior sauna package contains everything you need to finish and equip the sauna interior after the room has been framed, wired and insulated. Many elements are uniquely included or improved. This package is flexible to any dimensions and custom modifications.





Custom-Cut Sauna Packages Include Wall and Ceiling Paneling

- 1x4, V-joint, T&G, kiln-dried Western Red Cedar.
- Wall boards are mounted vertically if any wall is longer than 8'.
- Ceiling at 7' to keep the heat downward.

Foil Vapor Barrier

- To improve heat and humidity efficiency.

Base, Corner and Ceiling Trim

Benches

- Bench Tops: 1 x 4 W. R. Cedar, standard bench is 24"
- Bench Face: 1 x 4 W. R. Cedar
- Bench Framing: 2 x 4 W. R. Cedar (2 x 6 on commercial benches longer than 6') with 1 x 4 clear cedar cross framing.
- Bench comes pre-assembled.

Heater and Controls

- Heater selected by square and cubic footage. Controls with thermostat, heat indicator light, light switch, and timer.

Heater Guard Rail

- 1 x 4 Western Red Cedar

Sauna Door

- Pre-hung door with 16"x67" window (27"x67" on 3'0" door), handles and hinges.

Standard Accessories Package

- Bucket, dipper, thermometer, and wall light fixture. See pg. 18.

Duckboard Flooring

- Western Red Cedar duckboard in walk area. Alternative Dri-Dek vinyl flooring.

Installation Instructions

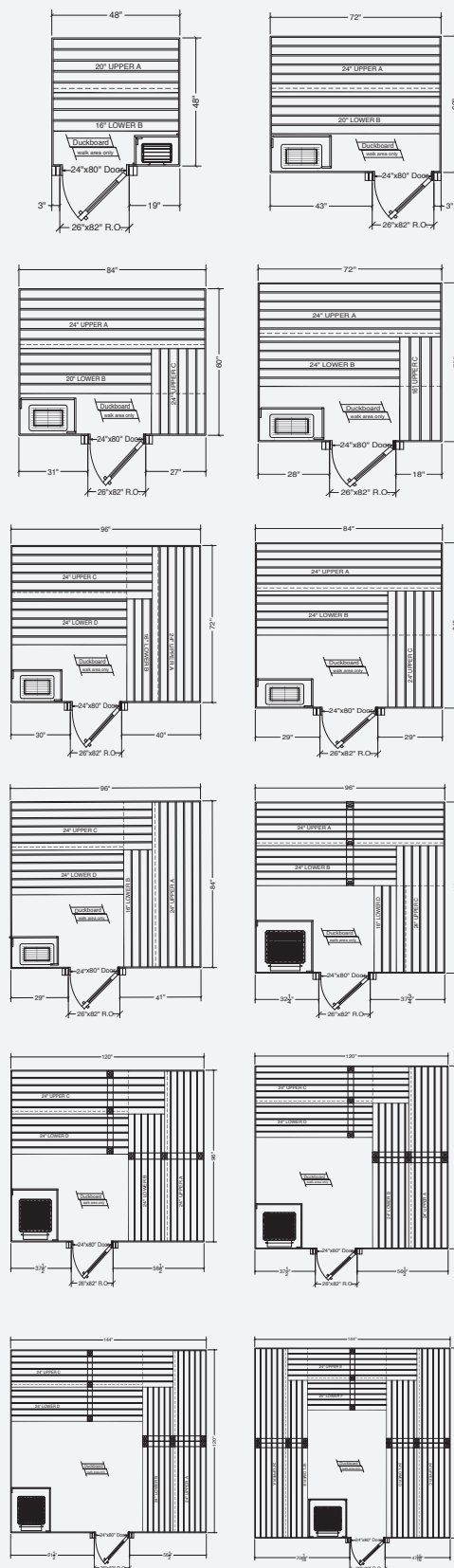
- Clear and explicit. For any level of experience.

Computer-Aided Shop Drawings

- Top and elevation views.



In addition to the examples of sauna layouts and sizes shown, Helo offers a limitless variety of standard and custom-made sauna rooms. Call 1-800-225-7519 for free CAD design assistance and alternative layouts.



Helo Panel Built Saunas



THE REMODELER'S DREAM

Your room will look almost identical to one built from a custom-cut interior package, but it will require far less labor. You can erect your free standing panel-built sauna in an afternoon —without special skills. Wall and ceiling panels, benches, guard rail, and duckboards are all pre-assembled and pre-drilled to fit perfectly. Interior and exterior trim is precisely cut to length. Because it is easily assembled in sections, it is also mobile. Clear, explicit instructions and job-specific drawings remove all the confusion and risk. The assembly is so easy, it's fun!

Enhance any part of your home with a Helo sauna. Meticulously designed for beauty, they are of exceptional quality and offer efficient assembly in as little as 60 minutes.





Arctic Lights, 7'x7'



Serenity, 6'x7'



PB 57 w/Sidelights

For Heavy-use Commercial Installations Upgrade to the Helo Pro Series Panel-Built Sauna

The most heavy-duty panel-built sauna in the sauna industry. Walls constructed with 2" x 3" framing, a full seven feet of interior height, 4 1/2" framing on the benches, and a handicap accessible door makes this the ideal sauna for heavy-use commercial saunas. The Pro Series is another example of why Helo is "The Professional's Choice." See complete specifications on page 27.

Panel-Built Kits are all Inclusive:

- All wall and ceiling pre-fabricated panels
- Panels are finished inside and out, with clear, tongue and groove, Western Red Cedar, fully insulated, and include a foil vapor barrier
- All interior and exterior trim
- Plywood paneling is available as an option for exterior walls to be hidden, painted, papered or tiled
- Genuine Helo heater, rocks, and heater guard
- Pre-hung door with glass window or all-glass door
- Pre-assembled benches, head-rests and duckboard flooring
- Room light, thermometer, wooden bucket, dipper, and all hardware

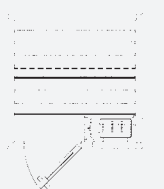


Panel-Built Sauna Components

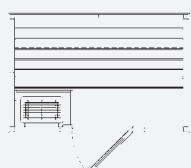


Onyx, 6'x7'

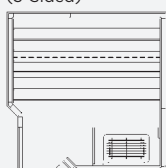
PB 44 / 4' x 4'



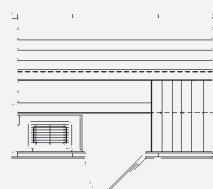
PB 46 / 4' x 6'



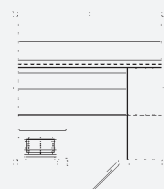
PB 55-5 / 5' x 5'
(5-Sided)



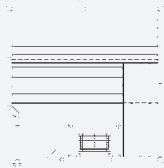
PB 57 / 5' x 7'



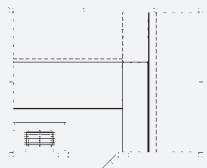
PB 66 / 6' x 6'



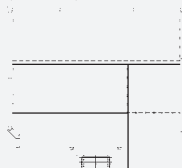
PB 66-5 / 6' x 6'
(5-Sided)



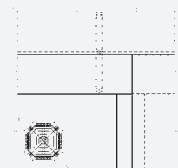
PB 68 / 6' x 8'



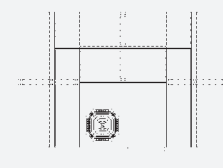
PB 77-5 / 7' x 7'
(5-Sided)



PB 88 / 8' x 8'



PB 812 / 12' x 12'





Helo Sauna Heaters

Wall Mounted and Floor Standing

Junior Heater - wall mounted

For small saunas and tight spaces, the Junior heater combines great European design with easy-to-use digital technology. Stainless steel construction.



JUNIOR	Junior 21	Junior 21	Junior 30	Junior 30
Sauna size (Cu. Ft.)	45 - 100	45 - 100	70 - 150	70 - 150
Heating power (kW)	2.1	2.1	3.0	3.0
Vulcanite rocks (lbs)	25	25	25	25
Amps/Voltage/Phase	17.5 / 120 / 1	8.75 / 240 / 1	25 / 120 / 1	12.5 / 240 / 1
Control unit	SaunaLogic	SaunaLogic	SaunaLogic	SaunaLogic
Shipping weight	19	19	19	19
Dim. (inch) (WxHxD)	11 ¹ / ₂ x 26 x 8	11 ¹ / ₂ x 26 x 8	11 ¹ / ₂ x 26 x 8	11 ¹ / ₂ x 26 x 8
Extra features	Optional Spectra Light Kit Add-on			

Designer S - wall mounted

Designer S offers external control of your sauna. Pair with SC-9, SC-60 or SC-Club control.



DESIGNER S	DSNR-45-S	DSNR-60-S	DSNR-80-S	DSNR-80-S/3
Sauna size (Cu. Ft.)	100 - 210	175 - 310	250 - 425	250 - 425
Heating power (kW)	4.5	6.0	8.0	8.0
Vulcanite rocks (lbs)	33	50	50	50
Amps/Voltage/Phase	18.8 / 240 / 1	25.0 / 240 / 1	33.3 / 240 / 1	22.2 / 208 / 3
Shipping weight	35	36	37	37
Dim. (inch) (WxHxD)	16 ¹ / ₂ x 23 x 11	16 ¹ / ₂ x 23 x 11	16 ¹ / ₂ x 23 x 11	16 ¹ / ₂ x 23 x 11
Control unit	SC	SC	SC	SC
Extra features	-			

Designer T - wall mounted with T1 touch screen control

The Designer T is matched with Helo's exclusive T1 Touch Screen Control.



DESIGNER T	DSNR-45-T	DSNR-60-T	DSNR-80-T	DSNR-80-T/3
Sauna size (Cu. Ft.)	100 - 210	175 - 310	250 - 425	250 - 425
Heating power (kW)	4.5	6.0	8.0	8.0
Vulcanite rocks (lbs)	33	50	50	50
Amps/Voltage/Phase	18.8 / 240 / 1	25.0 / 240 / 1	33.3 / 240 / 1	22.2 / 208 / 3
Shipping weight	35	36	37	37
Dim. (inch) (WxHxD)	16 ¹ / ₂ x 23 x 11	16 ¹ / ₂ x 23 x 11	16 ¹ / ₂ x 23 x 11	16 ¹ / ₂ x 23 x 11
Control unit	T1	T1	T1	T1
Extra features	-			

Soft Heat Maxi - wall mounted

The Maxi Soft Heat series offers double rock capacity and separate control panels, standard or digital controls. Use with separate controls. Symmetrical construction for a finished look on all four sides (ideal for saunas with windows). No Separate contactor box required. SO-D match with Digi I, II or VII control.



SOFT HEAT MAXI	SO-45-SC, or D	SO-60-SC, or D	SO-80-SC, or D	SO-80-SC/3, or D
Sauna size (Cu. Ft.)	100 - 210	175 - 310	250 - 425	250 - 425
Heating power (kW)	4.5	6.0	8.0	8.0
Vulcanite rocks (lbs)	66	66	66	66
Amps/Voltage/Phase	18.8 / 240 / 1	25.0 / 240 / 1	33.3 / 240 / 1	22.2 / 208 / 3
Shipping weight	35	36	37	37
Dim. (inch) (WxHxD)	18 ³ / ₄ x 22 x 11	18 ³ / ₄ x 22 x 11	18 ³ / ₄ x 22 x 11	18 ³ / ₄ x 22 x 11
Control unit	SC or Digi	SC or Digi	SC or Digi	SC or Digi
Extra features	Optional floor stand			

Viki Heater - wall mounted

For saunas up to 425 cubic feet, the Viki digital heater with the SaunaLogic Control is easy to use and is a terrific value. Stainless steel construction.



VIKI HEATER	Viki 45	Viki 60	Viki 80
Sauna size (Cu. Ft.)	100 - 210	175 - 310	250 - 425
Heating power (kW)	4.5	6.0	8.0
Vulcanite rocks (lbs)	50	50	50
Amps/Voltage/Phase	18.8 / 240 / 1	25.0 / 240 / 1	33.3 / 240 / 1
Shipping weight	35	36	37
Dim. (inch) (WxHxD)	17 x 26 x 12 ¹ / ₂	17 x 26 x 12 ¹ / ₂	17 x 26 x 12 ¹ / ₂
Control unit	SaunaLogic	SaunaLogic	SaunaLogic
Extra features	Optional Spectra Light Kit Add-on		

Octa Heater - floor standing

Helo's eight sided, floor-standing heater brings outstanding design and superb performance to larger saunas. Finished on all sides, the heater can be placed in the middle of a sauna, in a corner, or mid-wall. Its rock capacity provides soft heat, soft steam and extremely uniform temperatures. Standard stainless steel construction. Separate contactor box required.



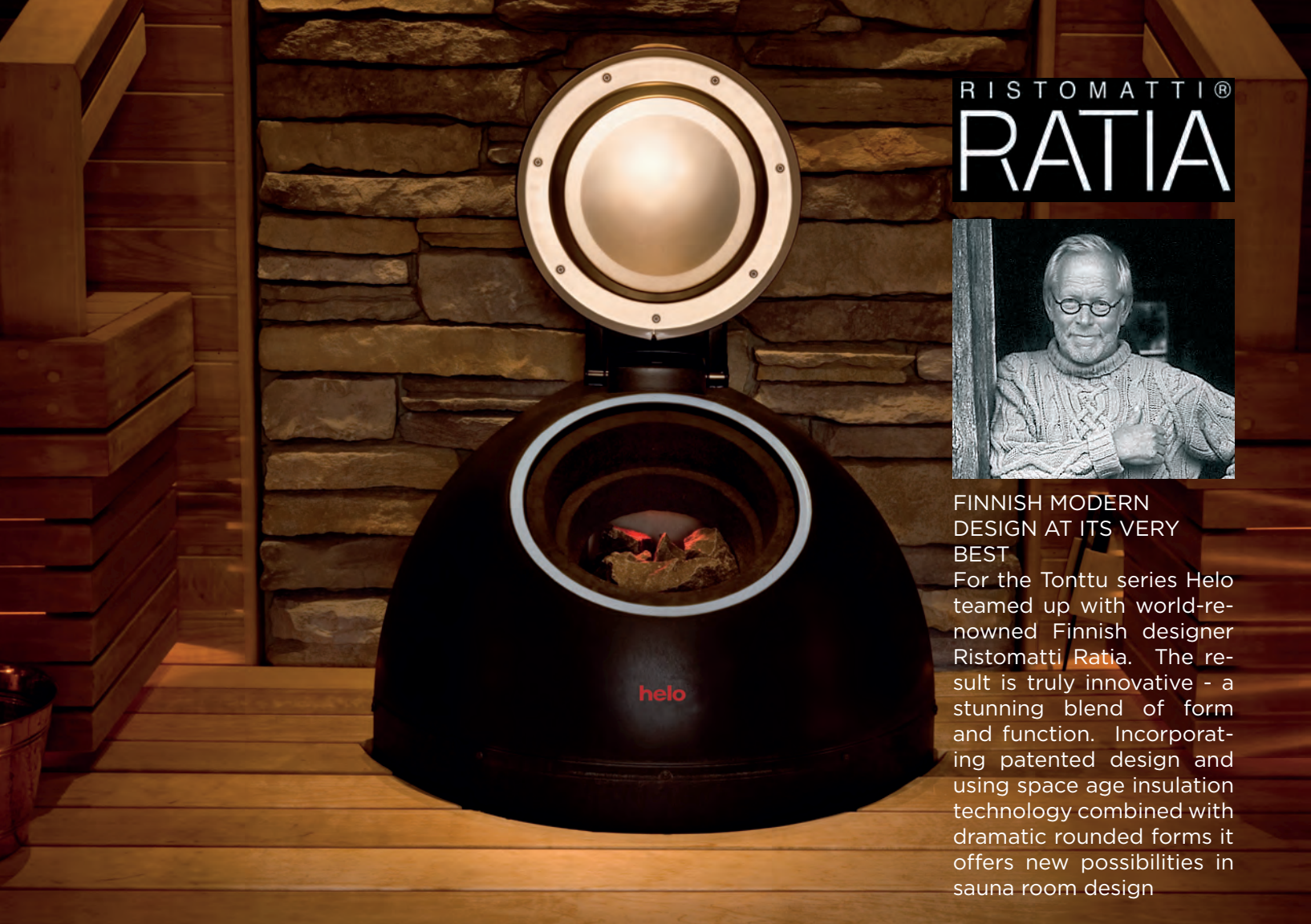
OCTA HEATER	Octa 105	Octa 120	Octa 140	Octa 105/3	Octa 120/3	Octa 140/3
Sauna size (Cu. Ft.)	390 - 600	510 - 740	630 - 950	390 - 600	510 - 740	630 - 950
Heating power (kW)	10.5	12.0	14.4	10.5	12.0	14.4
Vulcanite rocks (lbs)	132	132	132	132	132	132
Amps/Voltage/Phase	43.8 / 240 / 1	50.0 / 240 / 1	60.0 / 240 / 1	29.2 / 208 / 3	33.3 / 208 / 3	40.1 / 208 / 3
Control unit	SC or Digi	SC or Digi	SC or Digi	SC or Digi	SC or Digi	SC or Digi
Shipping weight	75	75	75	75	75	75
Dim. (inch) (WxHxD)	22 x 35 x 22	22 x 35 x 22	22 x 35 x 22	22 x 35 x 22	22 x 35 x 22	22 x 35 x 22
Extra features						

Pro - floor standing

Freestanding Pro heaters have been the standard of the industry for more than 20 years. Designed for large, commercial-sized sauna rooms, use with separate control panels. Remote control panel. Stainless steel exterior and junction box. Separate contactor box required.



PRO	Pro 105	Pro 120	Pro 140	Pro 105/3	Pro 120/3	Pro 140/3
Sauna size (Cu. Ft.)	390 - 600	510 - 740	630 - 950	390 - 600	510 - 740	630 - 950
Heating power (kW)	10.5	12.0	14.4	10.5	12.0	14.4
Vulcanite rocks (lbs)	132	132	132	132	132	132
Amps/Voltage/Phase	43.8 / 240 / 1	50.0 / 240 / 1	60.0 / 240 / 1	29.2 / 208 / 3	33.3 / 208 / 3	40.1 / 208 / 3
Shipping weight	68	70	75	68	70	75
Dim. (inch) (WxHxD)	20 x 29 x 19	20 x 29 x 19	20 x 29 x 19	20 x 29 x 19	20 x 29 x 19	20 x 29 x 19
Control unit	SC or Digi	SC or Digi	SC or Digi	SC or Digi	SC or Digi	SC or Digi
Extra features	-					



RISTOMATTI®
RATIA



FINNISH MODERN
DESIGN AT ITS VERY
BEST

For the Tonttu series Helo teamed up with world-renowned Finnish designer Ristomatti Ratia. The result is truly innovative - a stunning blend of form and function. Incorporating patented design and using space age insulation technology combined with dramatic rounded forms it offers new possibilities in sauna room design

Helo Heat Storing Heaters

Designed and patented by Helo to provide saunas for today's fast paced lifestyles...saunas always ready when you are, saunas providing the environment desired by sauna users worldwide—lower temperature and higher humidity.

Helo's "Saunatonnttu" (sauna elf) heaters are a combination of a thousand years tradition and the best of modern technology.

These magnificent heat-storing heaters allow the sauna bather to enjoy sauna at any time without preheating. Simply open the lid, sit or lie down, sprinkle water on the preheated rocks...and enjoy.

The secret of the Helo heat-storing heaters is in the constant heat retained by the large quantity of rocks (220 lbs.) within the super-insulated heater. Space age insulation technology made this innovation possible—super heated rocks inside, cool surface temperatures outside. The temperature of the rocks is maintained with low wattage elements that can be switched to 100 watts, 200 watts or 300 watts depending on the amount of heat and steam desired by the user. If more heat is desired, or if multiple users will use the sauna, the booster element can be turned on for extra heating power.

SAUNATONTTU

Taking the SaunaTime to new heights, Helo and world-renowned designer, Ristomatti Ratia, created the ultimate sauna heater—the Saunatonttu (Sauna Elf). Incorporating several patented features, and superb European design, the Saunatonttu is truly the “Best sauna heater in the world”, bar none.

- Super insulated to keep rocks “always hot, always ready”
- Very low surface temperatures
- Includes child safety lock on lid
- Small safety clearances gives flexibility in sauna design
- Patented lid-switch, allowing the booster element to come on when the lid is opened and to go off when the lid is closed
- Diminutive, hand-held control panel for easy in-sauna use, great looks and safety
- Fiber-optic light inside the rock compartment creates an atmosphere similar to glowing embers.
- Contemporary design with curved front, circular top and optional metal or wooden rail—the Saunatonttu will enhance the looks of any sauna
- Backside is square to allow installation into a sauna corner
- Can also be installed in front of windows, or even in the center of a sauna. In these installations, optional T&G backside panels are available
- Dimensions: 19³/₄"W x 19³/₄"D x 43"H
- Low wattage range (“always on” mode): 100W, 200W or 300W
- Booster element power range: 4.6 kW or 6.0 kW
- For saunas from 175 cu. ft. to 425 cu. ft.



SAUNATONTTU	Saunatonttu 4	Saunatonttu 6
Sauna size (Cu. Ft.)	175 -310	250 - 425
Heating power (kW)	4.6	6.0
Vulcanite rocks (lbs)	200	200
Amps / Voltage / Phase	19.2 / 240 / 1	25 / 240 / 1
Shipping weight	120 lbs.	120 lbs.
Dim. (inch) (WxHxD)	19 3/4 x 43 x 19 3/4	19 3/4 x 43 x 19 3/4
Control unit	Built-in, Hand held	Built-in, Hand held
Extra features	Low wattage range 100w, 200w or 300w	

PIKKUTONTTU

The Tonttu series, designed by renowned European designer, Ristomatti Ratia, harmoniously combines form and function. Helo's goal was to create a sauna heater series with stunning design and with technological features that provide luxurious soft heat and soft steam.

Users of the Saunatonttu heater agree it provides the ultimate sauna environment. Now, for those sauna bathers who do not need their heater “always on”, the Pikkutonttu (little elf) has been added to the Tonttu Series. Instead of being always on, the Pikkutonttu is controlled with the Helo Digi-I, Digi-II or Digi-VII control and turns on only when activated by the control.

Even though the heater has a huge rock mass (154#--for soft heat and soft steam) its super-insulated shell keeps sauna heat-up time similar to a traditional sauna heater. With the 24-hour programmability of the Digi controls, users can easily program the control to have the heater hot and ready at a prescribed time.



- Tonttu design with Digi Control on/off/ temp/time
- 154 lbs. Vulcanite rocks for soft and gentle bathing environment
- Very low surface temperature
- Small safety clearance
- Digi-I, Digi-II or Digi-VII control
- Contemporary curved front and circular top
- 4.5kW, 6.5kW and 9kW



PIKKUTONTTU	Pikku 4.5	Pikku 6.5	Pikku 9.0
Sauna size (Cu. Ft.)	100 - 210	175 - 350	310 - 500
Heating power (kW)	4.5	6.5	9.0
Vulcanite rocks (lbs)	154	154	154
Amps / Voltage / Phase	18.8 / 240 / 1	27.1 / 240 / 1	37.5 / 240 / 1
Amps / Voltage / Phase	12.5 / 208 / 3	18.0 / 208 / 3	25.0 / 208 / 3
Shipping weight	73	73	73
Dim. (inch) (HxWxD)	18 x 39 x 18	18 x 39 x 18	18 x 39 x 18
Control unit	Digi	Digi	Digi
Extra features	-		



Helo Sauna Controls

Offering both mechanical and programmable/digital technology, Helo controls are state-of-the-art, reliable and very friendly to the user. Whether built into the heater or wall-mounted, Helo controls are compact and attractive.



T1

- Touch screen operation for easy control of temperature and time settings
- Large screen displays sauna temperature and time settings
- Display temperature in Fahrenheit or Celsius
- Sleep mode with integral sensor to activate screen when approached
- Delayed start feature to pre-heat sauna at selected time
- Multiple language settings including English and Spanish
- Flush-mount, low profile installation



SaunaLogic

- Surface mount control
- 8.75" w x 5.75" h x 1" d
- 24-hour programmability
- Adjustable time and temperature
- On/off buttons for interior, exterior and color light
- For use with Junior and Viki heater series



Digi I

- Surface or flush mount control
- 24 hour programmability, delayed startup
- Adjustable time and temperature
- Ventilation fan and light buttons
- Sleek European graphics



Digi II

Similar to Digi-I, but with four user memory buttons and Saunasmart™ function

- Surface or flush mount control
- 24 hour programmability
- Delayed start up with Saunasmart feature
- Saunasmart automatically determines length of time needed to reach desired temperature
- Ventilation fan and light buttons
- Adjustable time and temperature
- Sleek European graphics



Digi VII

Similar to the Digi-II, but with 7-day programmability

- Perfect for Health Clubs with predetermined start and stop times each day
- Full 7-day, 24 hour programmability Saunasmart function applies for start up time each day
- Adjustable time and temperature
- Ventilation fan and light buttons
- Sleek European graphics
- Integral audible alarm for additional safety



SC-60

Sleek, flush mounted design with satin stainless steel face plate

- 60 minute timer
- Adjustable thermostat control
- Light switch
- Heat indicator light
- Flush mount control
- Sleek satin stainless steel face
- For use with SO, Designer S, Pro and Octa heaters
- Floor heaters require separate contactor box



SC-9 Control

Similar to SC-60 but with 9-hour time delay start up.

- 60 minute timer with 9-hour time delay for start up



SC-Club

Similar to SC-60 but with on/off switch

- On/off switch for club use with attendant on duty (no timer)

SAUNA CONTROL SPECIFICATION		
Type	Use with heater series	Use with contactor
T1	Designer T	None
SC	SO-SC/Designer S	None
Digi I & II	SO D	None
Digi VII	SO D	None
SC	Octa/Pro	Yes
Digi VII	Octa/Pro	Yes
SaunaLogic	Junior	Yes
SaunaLogic	Viki	Yes

240 V / 1 phase	Max power (kW)
Yes	8
Yes	8
Yes	8
Yes	8
Yes	14.4
Yes	14.4
Yes	3
Yes	8

208 V / 3 phase	Max power (kW)
Yes	8
Yes	8
Yes	8
Yes	8
Yes	14.4
Yes	14.4
No	-
No	-

Helo Custom Infrared Saunas



CUSTOM AND FLEXIBLE

The Helo Custom IR sauna has combined its CarbonFlex far-infrared technology into virtually any sauna room design—available with other sauna upgrades such as special bench designs, special lighting, etc.

Let your imagination go. For the first time in the worldwide sauna industry, there are now IR options to give you exactly what you want.

Custom Infrared on Your Framed Walls

- *New construction, remodeling*
- *Convert existing sauna into an infrared sauna*

NEW CONSTRUCTION—TRULY “CUSTOM” INFRARED

The options with our Custom IR are endless...with innovative use of glass windows and all-glass doors, angles, curves, special lighting and sound systems. Your design (or with our free design service incorporating your ideas), in partnership with Helo experience and quality, assures unmatched form and function.

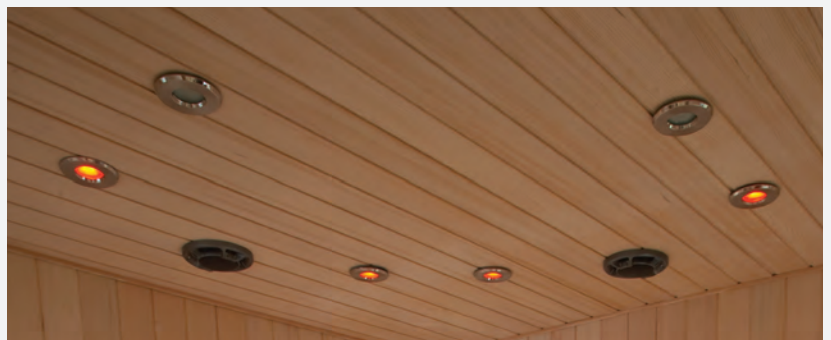
Handcrafted to your plan, we'll precut the finest hand-selected wood for your walls and ceiling, we'll pre-build the benches and door, and include a CarbonFlex IR Panel Kit sized for your room—all for installation on your framed walls. Simply provide the inside dimensions of the framed walls, the door location and your preference for bench configuration—and we'll do the rest. Need design assistance to overcome potential challenges? Call or email us.

Custom Infrared Saunas are perfect for new construction or remodeling: residential, hotels, health clubs, condos and apartments.



FAR-INFRARED COLOR LIGHT THERAPY

All Helo Commercial Infrared sauna rooms may include a Color Light Therapy System. Color light has a range of psychological and therapeutic effects. You can easily select the color of your choice or have the colors change automatically.





Helø Infrasauna

You like traditional sauna but your spouse prefers infrared sauna? No problem. On weekends you like a traditional sauna with lots of steam but during the work week you like mild/soothing infrared sauna heat therapy? No problem. The Helø InfraSauna may be the ultimate sauna--a blending of Helø Traditional Finnish Sauna with Helø Infrared Sauna.

This wonderful combination room provides pleasure beyond what a traditional or infrared sauna can do individually. Taking the best of both worlds, Helø has combined its traditional sauna technology with its CarbonFlex far-infrared technology into virtually any sauna room design.

The combination InfraSauna is designed for use in Helø Modular saunas and Helø Custom Cut saunas up to 420 cu. ft.--from personal size saunas up to six to eight person saunas with plenty of room to lie down in.

The InfraSauna can include many of the interior designs and upgrades as shown within this catalog. The difference is--you can now add CarbonFlex far infrared heating technology to create the ultimate sauna.

THE INFRA Sauna COMBINATION ROOM INCLUDES:

- *Stainless Steel Junior or Viki Heater with SaunaLogic digital control*
- *Pre-manufactured wood-framed CarbonFlex heating panels for walls and behind legs; quantity of panels depends upon room size*
- *All-glass door; many window options available*
- *Interior of sauna includes Cedar or Hemlock T&G for walls and ceiling, prebuilt benches, prebuilt bench skirts, backrests, heater guard, floor boards and low-voltage lighting system with color therapy (or alternative lighting system of your choice)*
- *Bucket, ladle, thermometer, rocks and installation hardware.*





Helo Sauna Accessories

Add extra pleasure to your sauna with these Helo sauna accessories. Crafted of the finest materials, they'll add years of enjoyment to your sauna.

1. Wooden bucket with plastic insert, 1 gallon
2. Wooden bucket with stainless steel insert, 2.5 gallons
3. Copper bucket, 1 gallon
4. Wooden ladle, long
5. Wooden ladle, short
6. Stainless steel bucket and ladle
7. Long handled bath brush
8. Bath brushes, set of two
9. Vapor proof sauna wall light
10. Headrest, deluxe
11. Linen towel with "sauna" text
12. Linen scrub mitt
13. Deluxe sand timer, beech and aluminum frame
14. Linen seat cover (available in light or dark)
15. Eucalyptus fragrances, 2oz, 8oz, 16oz
16. Thermometer, beech and aluminum frame
17. Hygrometer, beech and aluminum frame
18. Thermometer/Hygrometer, beech and aluminum frame
19. 5" chrome thermometer
20. 5" chrome thermometer/hygrometer
21. 7" brass thermometer/hygrometer
22. Curved backrest with birch dowels
23. Clothes hanger 3-peg; 2-peg and 4-peg also available
24. Cedar sauna sign (laser etched)

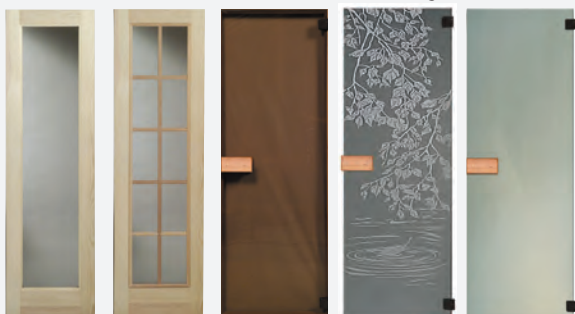


Many more accessories available; visit www.helocommercial.com for more selection.

Helo Sauna Door Options

A quality Helo sauna door is shipped with every sauna room package and is also available as a separate component.

Douglas Fir Douglas Fir with Grids Standard All-Glass All-glass with Etched "Birch Leaf" Design All-Glass, "Satin" Door



STANDARD DOOR — F24P

- 2'0" x 6'8" x 1³/₄" door with a 4⁵/₈" or 5³/₈" jamb. Provide a 26" x 82" rough opening. (A 24" door is generally recommended to maximize bench space and to minimize air movement during passage.)
- Vertical grain Douglas Fir rails for resistance to damage and warping.
- 16"x67" clear, insulated (double sealed), tempered safety glass. Takes away the "closed-in" feeling of ordinary saunas.
- Pre-hung door includes hinge and wooden handles.

OPTIONAL DOORS

- Douglas Fir doors available in 2'0", 2'6", and 3'0". Custom Cedar doors are also available.
- All-glass doors: ⁵/₁₆" bronze tinted glass (no wood on the door itself), mounted on 2" thick jamb. Available 2'0" x 6'0", 2'0" x 6'8" and 3'0" x 6'8"
- Douglas Fir doors with fir grid. Same specs as F24P, but with attractive grid insert.

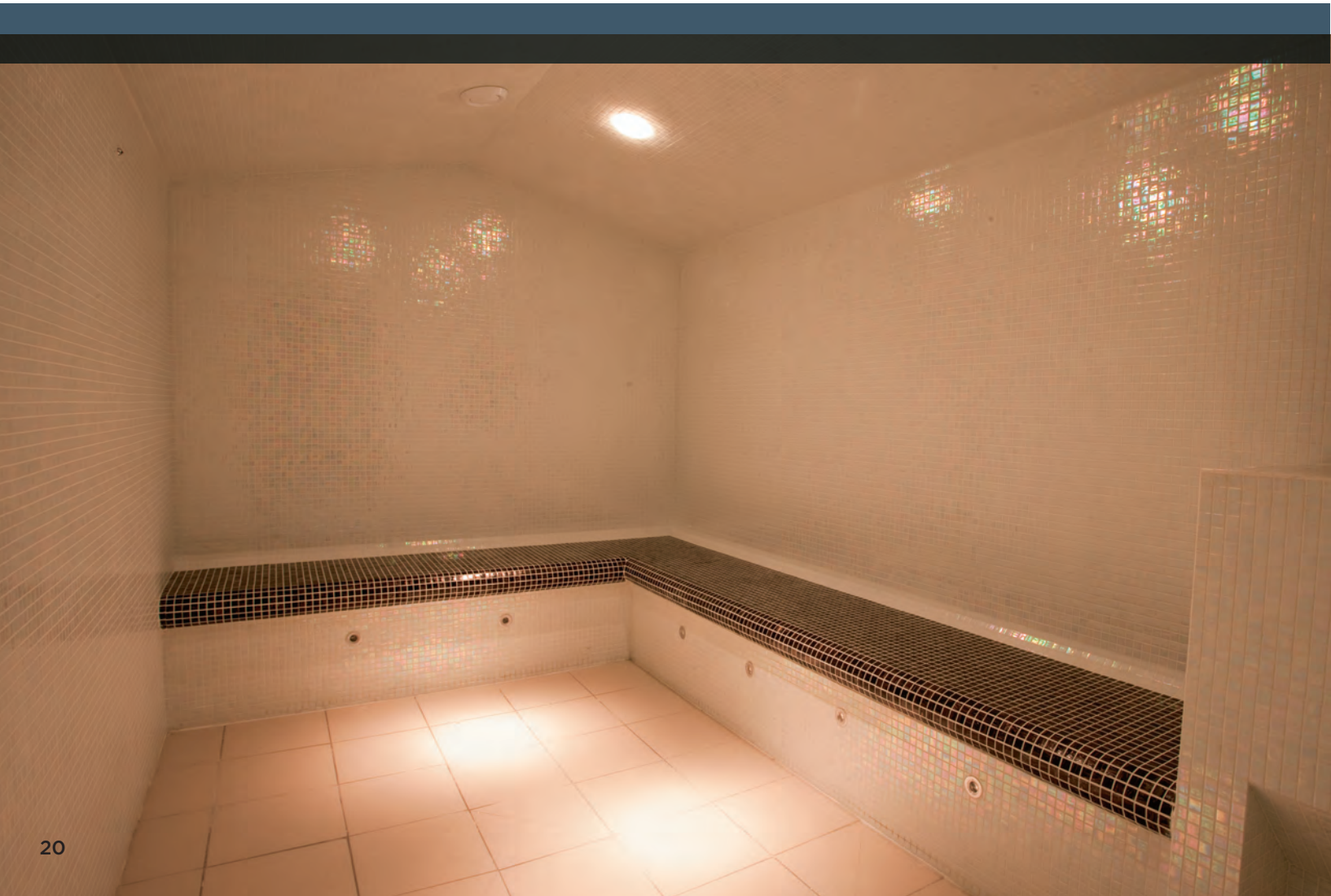


HELO
COMMERCIAL
STEAM BY

amerec[®]
your moment

AMEREC 3K & 3T SERIES COMMERCIAL STEAM GENERATOR

Whatever the size of your facility, these days it is more important than ever to ensure customer comfort and satisfaction. Amerrec's 3K and 3T Series steam generators help you create added value for guests cost effectively. Easy to maintain and service, the 3K and 3T Series steam generators are designed for use in smaller commercial steam baths that are operated for short, intermittent periods of time. Their relatively compact size means they can be fitted even when space is at a premium, allowing you to turn underused space into a wellness center that will be appreciated. At the same time, they are powerful enough to provide a steady flow of soft, gentle steam at even temperature, ensuring maximum guest comfort.





POWERFULLY SMALL

All boilers feature all-steel construction with powder coat. Don't let the size of the 3K/T Series steam generators fool you. Each provides more than enough power to heat and steam the room dimensions it was designed for. Yet their relatively compact size gives you storage options, letting you plan for more effective use of space at your facility.

TEAM WORK

3K/T Series generators are purpose-designed for easy coupling — multiple units can be connected together to effectively heat large steam rooms up to 1,500 cu. ft.. The 3K/T Series makes maintenance and access very easy, and included power-saving features that help keep electricity bills low.

- Compact yet powerful generators provide soft, even steam and dependable ongoing performance
- Easily coupled for large room application, easy to control and service
- Effective power and water consumption lets you provide a cost-effective guest amenity that will be appreciated
- We are happy to help advise you free of charge on the generator configuration that make most sense for your facility — simply call 1-800-225-7519.

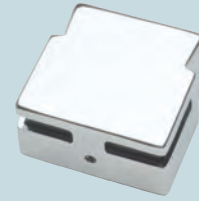
3K SERIES GENERATOR					
Type	Power (kW)	Volts	Phase	Max Cu. Ft.	Size (WxHxL - inch)
3K8/3T8	8.0	208	3	300	6 ¹ / ₄ x 13 x 16 ¹ / ₂
3K10/3T10	10.0	208	3	400	6 ¹ / ₄ x 13 x 16 ¹ / ₂
3K12/3T12*	12.0	208	3	500	6 ¹ / ₄ x 13 x 16 ¹ / ₂
3K14/3T14*	14.0	208	3	600	6 ¹ / ₄ x 13 x 16 ¹ / ₂
3K20/3T20**	20.0	208	3	800	—
3K24/3T24**	24.0	208	3	1,000	—
3K28/3T28**	28.0	208	3	1,200	—
3K36/3T36***	36.0	208	3	1,500	—

* 2 steam heads are recommended for 3K12 and 3K14 generators.

** 3K20, 3K24 & 3K28 include 2 generators connected to function as 1 system with 1 control.

***3K26 includes 3 generators connected to function as 1 system with 1 control.

Multiple unit ganged systems require 1 steam head for each generator. Heads must be ordered separately. Multiple unit ganged systems require 1 drain valve kit for each generator. Please call 1-800-225-7519 or look at www.amerec.com for detailed electrical specifications.



COMFORT FLO STEAM HEAD

The Amerec Comfort Flo steam heads add comfort and safety to your steam bath. Steam passed through a plastic insulator, preventing the exterior metal surface from getting too hot. The Comfort Flo steam head also features a fragrance reservoir that lets you enjoy the proven benefits of aromatherapy — simply add a few drops of your favorite scent to personalize an even more enriching steam bath experience.



K60 / K30 CONTROLS

K60/K30 controls make it easy to control the most important features of your steam baths. Both versions can be mounted inside the steam room or out, and offer intuitive, easy to understand controls for features such as temperature control, on/off and timer settings.

T100 TOUCH CONTROL FEATURES:

- Touch screen operation for easy control of temperature and time settings
- Large screen displays steam bath temperature and time of day
- Displays temperature in Fahrenheit or Celsius
- Sleep mode with integral sensor to activate screen when approached
- Delayed start feature to pre-heat steam room at selected time up to 24 hours in advance
- Multiple language settings include English and Spanish
- Remote mounted sensor allows the Touch control to be mounted inside or outside the steam shower or steam room
- Flush-mount, low-profile installation
- Installed dimensions 6³/₈"H x 4"W





AMEREC AI SERIES

COMMERCIAL STEAM BOILER

AI boilers are the steam generators of choice for large commercial steam rooms, and can help you create an inviting, relaxing environment that adds real value and generates positive word of mouth and returns for your business. The AI Series is specially designed for easy on-site maintenance and hands-off, automated operation. From their corrosion-resistant exteriors to their multiple safety features, AI boilers provide a welcome, genuine steam bath experience at less cost and with less hassle.





BUILT TO LAST

AI boilers feature all-steel construction with powder coat exterior, brass fittings and stainless steel feet to prevent corrosion. Designed to minimize downtime, AI boilers are easy to access and service, with integrated diagnostic systems alert you to any problems using LED indicator lights.

- Powerful dependable steam boiler for large commercial spaces
- One or two room operation, each controlled individually by low voltage on/off switches for maximum ease of use
- Low service and maintenance requirements, saving time and other costs
- ASME H-stamped Low-Pressure Vessel, National Board Registered
- UL Listed

AI SERIES BOILER					
Type	Power (kw)	Volts	Phase	Max. Cu. Ft.	Size (WxHxL - inch)
AI 12*	12	*	1/3	500	22"x20"x24-1/2"
AI 18*	18	*	1/3	750	22"x20"x24-1/2"
AI 24*	24	*	1/3	100	22"x20"x24-1/2"
AI 30**	30	**	3	1250	28"x20"x24-1/2"
AI 36**	36	**	3	1500	28"x20"x24-1/2"
AI 42**	42	**	3	1750	28"x20"x24-1/2"
AI 48***	48	***	3	2000	28"x20"x24-1/2"

* Available in 208 V and 240 V in 1 phase and 208, 240, 415 and 480 V in 3 phase.

** Available in 208, 240, 415 and 480 V in 3 phase.

***Available in 240, 415 and 480 V in 3 phase.

It is recommended that one steam head is installed for every 12kW.



PROTECTING YOUR INVESTMENT

AI boilers come with multiple safety features to minimize service costs and downtime. An automatic switch turns boiler elements off if they reach a critical temperature point, preventing them from burning out. Additional standard features include water level sight glass, 3-level water sensing system with optional low water cut off and high pressure cut off.



ITI/IT2 CONTROLS

IT thermostats (I for one room installations, 2 for two room installations) are boiler-mounted time and temperature controls designed to be easy-to-under-

stand and use. A separate thermostat is required for each steam room.



UPGRADE YOUR BOILER WITH T100 TOUCH SCREEN CONTROL

T100 TOUCH CONTROL FEATURES:

- Touch screen operation for easy control of temperature and time settings
- Large screen displays steam bath temperature and time of day
- Displays temperature in Fahrenheit or Celsius
- Sleep mode with integral sensor to activate screen when approached
- Delayed start feature to pre-heat steam room at selected time up to 24 hours in advance
- Multiple language settings include English and Spanish
- Remote mounted sensor allows the Touch control to be mounted inside or outside the steam shower or steam room
- Flush-mount, low-profile installation
- Installed dimensions 6-3/8"H x 4"W

Amerec Controls and Accessories

COMMERCIAL STEAM BOILER

Being able to consistently offer your customers the highest quality steam bath experience is always a good investment. With additional controls and time and cost-savings accessories, you can enhance quality even further while minimizing maintenance time, effort and expenses.



T100

- Touch screen operation
- Set operating time and temperature
- Delayed start
- Up to 24-hours operating time
- Flush mount



IT1

- Thermostat for 1 room installation.
- Remote or boiler mounted.
- Required with each boiler.



IT2

- Thermostat for 2 room installation.
- Remote or boiler mounted.



IDS

- In-Room "refresh" control for a quick burst of steam delivered on demand.



I60

- 60 Minute Timer to control steam flow in steam rooms with intermittent use.



124/7

- 7-Day Time Clock with 2 hour on/off segments.



124/1

- 24-Hour Time Clock with 30 minute on/off segments.



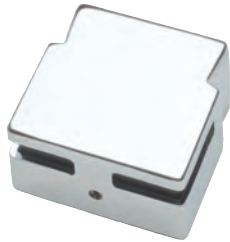
D24/7

- 24-Hour 7-Day Digital Time Clock with battery backup.



ADI CoolFlush™

A drain and flush system that automatically performs recommended daily draining and flushing of the boiler tank to reduce build-up of solids such as scale and sludge. Uses a computer controlled drain cycle to add and drain water in steps, rinsing the tank and draining water at or below 140° F. Available with optional Digital Run Clock.



AI Outlet 3/4"

Polished Chrome steam head for use with AI series boilers.



ASX200 Dual Sump/Cartridge System

With replaceable cartridges featuring a ScaleX2 filter to reduce scale build-up common in boilers. The ASX200 will also reduce chlorine and sediment from water by trapping particulates in a second filter as water passes through.

Amerec Commercial Steam Doors

Club 190 Steam Door

The steam door features 1/4" tempered glass with a sturdy aluminum frame, excellent for high volume use commercial applications. Optional 1" insulated glass panel provides increased thermal efficiency. Push-pull handles and hydraulic closer included.

- Door is 36" x 84"; frame size is 39 1/2" x 85 3/4"
- Custom sizes available. Please call for quote.
- Vinyl sweep.
- Hydraulic closer included. Closer to be mounted on exterior side of door.
- Push - Pull handles included.
- 31 3/8" x 70 7/8" clear 1/4" tempered glass.
- Optional 1" insulated glass provides increased thermal efficiency.



Modular Steam Rooms

COMMERCIAL OR RESIDENTIAL INSTALLATIONS

Elysee and Excellent modular acrylic steam rooms are made of high-tech, vacuum-formed special-grade white acrylic material for a rigid, steam-tight construction. Supplied in ready-to-assemble wall and roof sections and comfortable seating. The door is made from tinted, tempered safety glass in a sturdy frame with handles of anodized aluminum. These luxurious steam rooms are a perfect complement to public bathing facilities in hotels, spas, fitness centers and gyms.



Elysee Modular Acrylic Steam Rooms

- Constructed of white, high-gloss, easy to clean panels that provide a bright bathing environment
- Extra wide 35½" tinted safety glass door with flat sill (no raised threshold) and anodized aluminum handles
- Integral recessed LED light installs above each seat section to provide subdued lighting
- Smoked, tempered safety glass front wall in a frame of anodized aluminum (optional)
- Exterior surface and floor not provided

ELYSEE MODULAR ACRYLIC STEAM ROOMS			
Type	Steam room	Cubic feet	Size (WxHxL - inch)
EL-4F-GF Elysee	4-Person	220	83.5 x 52.75 x 81.5
EL-6F-GF Elysee	6-Person	320	83.5 x 76 x 81.5
EL-8F-GF Elysee	8-Person	490	83.5 x 99.25 x 81.5

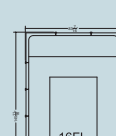
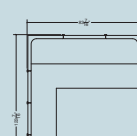
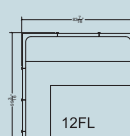
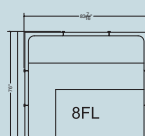
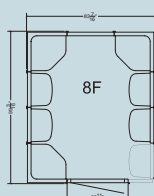
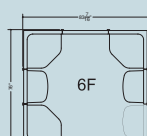
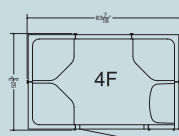
Please select an appropriate sizes AK, 3K or AI generator and controls based upon Elysee room cubic footage.

Excellent Modular Acrylic Steam Rooms

- Constructed of white, high-gloss, easy to clean panels that provide a bright bathing environment
- Extra wide 35½" tinted safety glass door with flat sill (no raised threshold) and anodized aluminum handles
- Wide, comfortable benches in white lacquered aluminum
- Exterior surface and floor not provided

EXCELLENT MODULAR ACRYLIC STEAM ROOMS			
Type	Steam room	Cubic feet	Size (WxHxL - inch)
EX-8FL Excellent	8-Person	320	83.5 x 76 x 81.5
EX-12FL Excellent	12-Person	490	83.5 x 99.25 x 81.5

Please select an appropriate sizes AK, 3K or AI generator and controls based upon Excellent room cubic footage.



Steam Specifications

GENERAL: Acrylic modular steam rooms shall be manufactured by Helo Commercial, 575 East Cokato St., Cokato, MN 55321. The following specifications include design parameters for Helo modular steam rooms, as well as for Helo Custom Style steam rooms.

WORK TO BE DONE BY OTHERS: All work set forth below will be included under other sections for specifications.

For all Helo Modular Steam Room types:

1. Frame, install and finish exterior surface of steam room.
2. Foundation, sub-floor, and final floor work
3. All electrical and plumbing from supply, including connections to generator, control and light

For all Helo custom tile steam enclosures:

4. Installation of stud walls and ceiling joists.
5. Installation of insulation and vapor barrier.
6. Installation of ceramic or stone tile, or some other interior surface.

FOR MODULAR ACRYLIC STEAM ROOMS:

WALLS AND CEILING FOR HELO MODULAR STEAM ROOM: No framed walls are required for Helo modular steam rooms (steam room is free standing). However, exterior of the steam room is unfinished, and requires furring strips on walls to be covered. Steam room modules are vacuum-formed acrylic sheet. High glazed, white color. Insulation is not supplied; we recommend at least R11 for walls and ceiling. Wall modules include integral seating, rigid strips for joining wall and ceiling panels, gasket tape and silicone sealant.

STEAM ROOM DOOR: All-glass door, mounted on aluminum frame, includes handles. Glass is 6 mm, tempered and tinted. Wheel chair accessible door.

LIGHT: Steam room includes vapor proof lighting.

FOR CUSTOM TILED STEAM ROOMS:

DOOR: For commercial, handicap accessible steam door, specify Helo Commercial Steam Door with vapor proof, 1/4" tempered glass; clear anodized aluminum frame and jamb, or architectural bronze finish. See door specs on p. 25.

STEAM GENERATOR: Shall be Amerec Model _____, sized according to the size of the steam room as shown below. Generator shall be UL listed, includes insulated steam head with fragrance reservoir, and matching escutcheon.

CONTROLS: Shall be Amerec Model _____, UL listed, and matched with generator according to the specifications.

SIZING THE STEAM GENERATOR: Steam generator kW size is based on the cubic volume of the steam room and the construction materials used. Use the following "guidelines" to select the recommended steam generator:

Step 1: Calculate the cubic footage of the steam room enclosure. Length x Width x Height = Cubic Feet. (Do not deduct for benches or other intrusions as they represent surface area to heat.) L x W x H = _____

Step 2: Calculate the cubic footage of the steam room enclosure. Length x Width x Height = Cubic Feet. (Do not deduct for benches or other intrusions as they represent surface area to heat.)

A. Acrylic or Cultured Marble	Cubic Footage x 0% _____
B. Ceramic Tile	Cubic Footage x 20% _____
C. For each glass or glass block wall, or exterior wall exposed to freezing.	Cubic Footage x 15% _____
D. Natural Stones (Marble, Granite, Travertine, Slate or Porcelain Tile)	Cubic Footage x 100% _____
	Total (1 + 2A + 2B + 2C + 2D) _____

IMPORTANT: The maximum cubic footage on the steam generator charts is for reference only. Complex room construction and material variables may substantially alter the model required for your installation. For further information see "Amerec Steam bath Architectural Guidelines".

Helo Custom-Cut and Panel-Built Sauna Specifications

GENERAL: Sauna room(s) shall be manufactured by Helo Commercial, 575 East Cokato St., Cokato, MN 55321. The following specifications include design parameters for the Helo pre-fab/modular saunas, as well as for Helo Custom-Cut material packages. Work to be done by others: All work set forth below will be included under other sections for the specifications.

For all sauna types:

1. Finish painting and/or staining of exterior surfaces.
 2. Subfloor and/or foundation work.
 3. All electrical work from supply, including connections to control, heater, and light
- For Helo Custom-Cut Saunas:**
4. Installation of stud walls (or furring strips) and ceiling joists.
 5. Installation of insulation between wall studs and ceiling joists.

CODE REQUIREMENTS: All materials, components, and work shall conform to all applicable local, state, and federal building and safety codes, ordinances and regulations.

TYPE CONSTRUCTION:

HELO CUSTOM-CUT MATERIAL PACKAGES (for installation on previously framed walls).

Wall framing shall be on 16" centers. Standard framed wall shall have 2" x 4" studs, bottom base plate treated, and ceiling lowered to 84" I.D. from floor to framing. Existing masonry walls shall have furrings strips on 16" centers; metal studs shall have furring strips—for nailing of T&G wall boards.

Walls and Ceiling shall be insulated with R11 rated fiberglass insulation, with foil vapor barrier (foil provided by Helo).

Walls and ceiling interior materials shall be 1" x 4" (nominal) V-joint, kiln dried to 12% or less, T&G clear Western Red Cedar. Boards to be blind nailed using 5p galvanized nails, or comparable galvanized staples. Wallboards applied horizontally unless specified otherwise.

WHEN ORDERING: SAUNA MATERIAL PACKAGE, shall be Helo model CC_____. Provide interior dimensions of the framed space, indicate direction of ceiling joists, and swing of door.

TYPE CONSTRUCTION: HELO PANEL-BUILT SAUNA PACKAGES (free-standing, modular units).

No framed walls are required for Helo Panel-Built packages. Install on any level, water proof floor.

Wall and ceiling panels shall be framed of 2" x 2" framing (standard), 2" x 3" commercial, insulated with fiberglass batts, vapor barrier of Type C Reynolds Building Foil. Panel interior and exterior shall be lined with 1" x 4" (nominal), V-joint, kiln dried, clear Western Red Cedar. Optional: panel exterior can be 1/4" smooth Luan Plywood on walls to be hidden or walls to be covered with drywall, tile, or wallpaper.

TYPE CONSTRUCTION: ALL TYPES—CUSTOM CUT AND PANEL BUILT.

BENCHES: Shall be preassembled by Helo. Standard top bench width equals 24" in saunas 5' deep or greater. Bench tops of kiln-dried, clear, all-vertical-grain Western Red Cedar. Internal framing of 2" x 4" (standard), 2" x 6" commercial. Bench tops fastened from bottom with stainless steel screws. Bench supports of 5/4" x 4" European Alder or 2" x 4" Western Red Cedar. Commercial Sauna Benches: Internal framing 2" x 6" Western Red Cedar on benches over 6', and H-leg bench supports on benches 8' and longer.

BACKRESTS: Made with clear, Western Red Cedar S4S.

INTERIOR AND EXTERIOR TRIM: Corner and cove molding of clear, kiln-dried Western Red Cedar. Panel-Built saunas also include fascia of same material.

HEATER GUARD RAIL: Shall be constructed of clear Western Red Cedar to surround heater. Dimensions shall match UL requirements for proper spacing between heater and guard rail.

DOOR: Shall be Helo Model DF (clear, all-vertical grain Douglas Fir rails with sealed, double pane, tempered glass 16" x 67" window, pre-hung on mahogany jamb — available in 24" x 80", 30" x 80", and 36" x 80". Alternative doors are all-glass door with 1/4" bronze tinted tempered glass, mounted on 1 1/2" thick jamb. Available 24"x80", 30"x80" or 36"x80".

HANDICAP ACCESSIBLE COMMERCIAL SAUNA DOORS AVAILABLE: All-glass doors (AG) or Douglas Fir doors (DF) are available in 36" widths. For Helo Custom-Cut saunas handicap door size is 36" x 80"; for Helo Panel-built saunas handicap door size is 36" x 72".

SAUNA HEATER: Shall be Helo Model _____, sized according to the size room as shown on pages 10-11. Heater shall be UL or ETL listed. Shall include olivine igneous rocks.

CONTROLS: Shall be Helo model _____, UL or ETL listed, and matched with heater according to chart on p. 15.

FLOOR: Floor shall be of cement, ceramic tile, or similar waterproof type (no carpeting). Removable dri-dek flooring or duckboard of Cedar is provided for walk area in front of benches.

LIGHT: Shall be wall-mounted, UL listed, vapor-proof Progress P5511 or Hubbell B2s-Var. Frosted white globe with satin finish, neoprene gasket, brushed aluminum base. Ceiling mounted and low voltage lighting available.

ACCESSORIES: All sauna packages include standard accessories of thermometer, bucket, ladle. A wide range of additional accessories are available. See page 18. All saunas also include headrest, backrest and duckboards.

WARRANTY: All Helo sauna rooms, heaters and controls are fully warranted for five years for residential use; one year for commercial use against defects in material and workmanship. For further information regarding the Helo warranty, please contact Helo.

DESIGN ASSISTANCE: Helo's design staff will gladly offer any assistance you may require when designing or specifying sauna rooms and heaters. Free CAD design service available.

HANDICAP ACCESSIBILITY: Most of Helo's panel-built and custom-cut saunas can be made handicap accessible. Contact Helo Commercial for assistance.

Helo reserves the right to change specifications and design without notice.



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