



# TheraSpa

## Installation Assembly Manual

860745 Rev A 1/12/2021

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860010-1, 860020-1, 860030-1, 860010-1SB  
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## Introduction

These instructions are for the installation of a TheraSpa in various configurations as shown below in figure 1. Follow the instructions for your particular installation configuration.

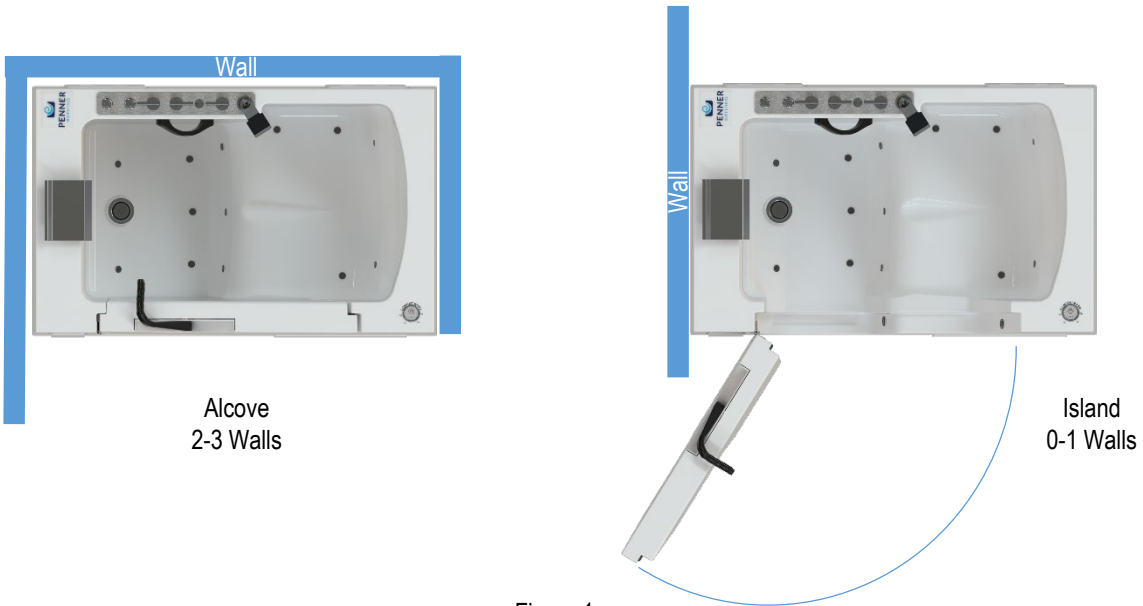


Figure 1

## Terminology and Symbols Meanings

When the terms “left” or “right” are used with reference to the spa, this means left or right as you look when seated in the spa.



Meaning: Safety warning. Failure to understand and obey this warning may result in injury to you or to others.

### CAUTION

Meaning: Failure to follow these instructions may cause damage to parts or systems.

Note: Refer to the “Spa Controls” section of this manual for the location of any of the controls referenced.



The hot and cold temperature controls adjust the spa fill overall temperature. Hot temp is limited to 110°F from the factory but can easily be adjusted.

Aqua-Aire system has a three speed blower motor. First push of the air transmitter provides full speed and aeration of spa. Second push is a medium level while a third push is the lowest setting for blower speed. A fourth push will turn the blower motor off. There is a time limit from the last push of the Aqua-aire transmitter where it will automatically turn off after 20 minutes.

The Diverter Valve will select between spa fill and the Shower wand. Both can be used at the same time, Ex. Filling the spa while starting a rinse.

Aqua Aire High/Med/Low/Off    Hot Temp Control    Cold Temp Control    Diverter Valve Fill and Shower    Shower Wand

Spa Fill Spout



Comfort Warm Operation Control

Figure 2



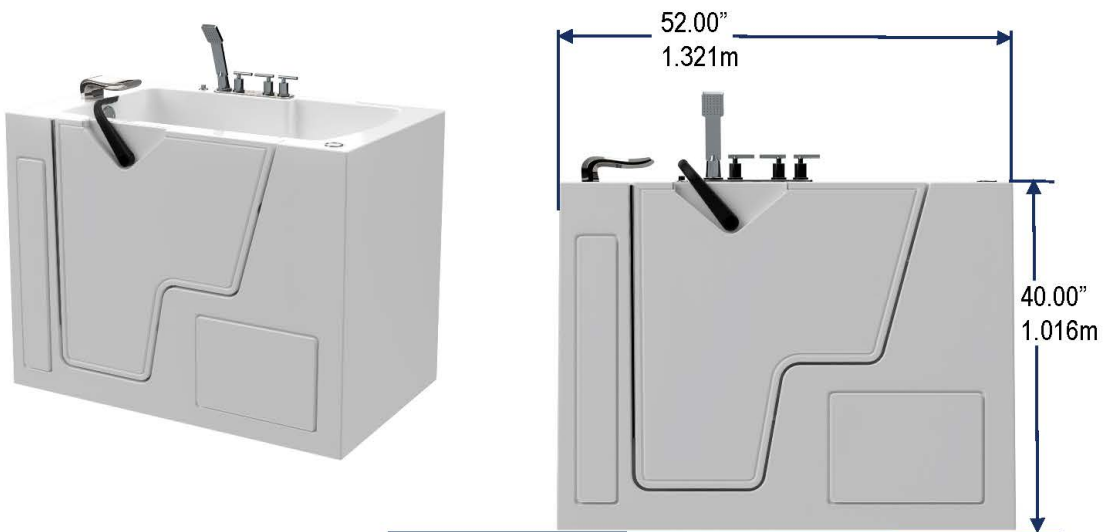
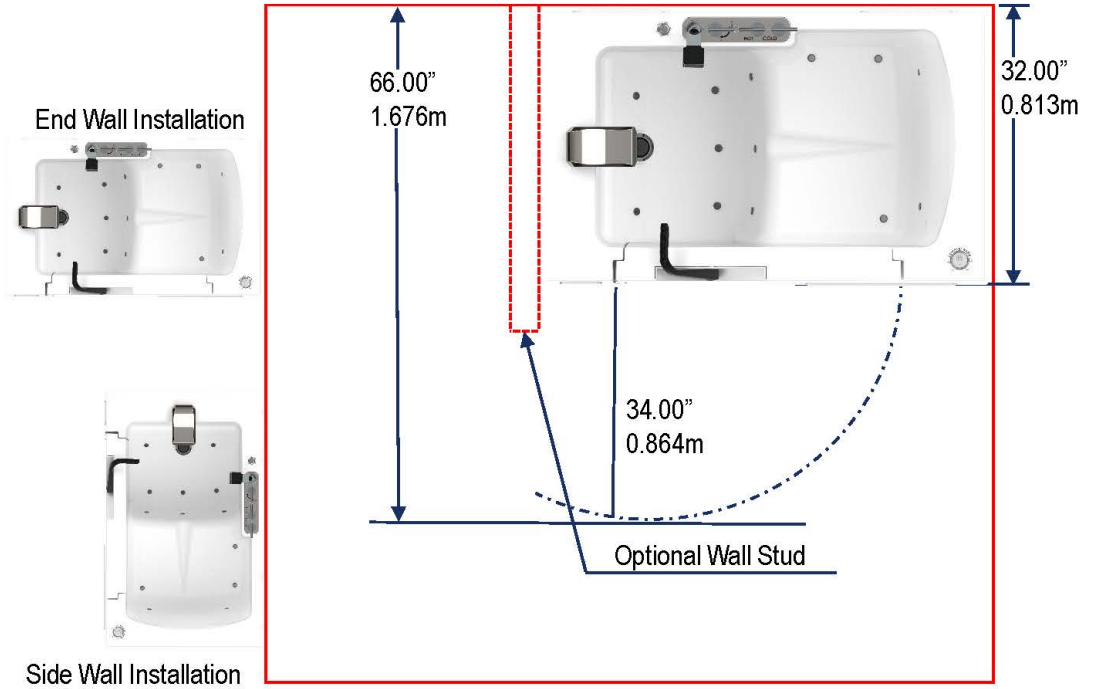
# TheraSpa Dimensions

TheraSpa Standard and Metric Measurements  
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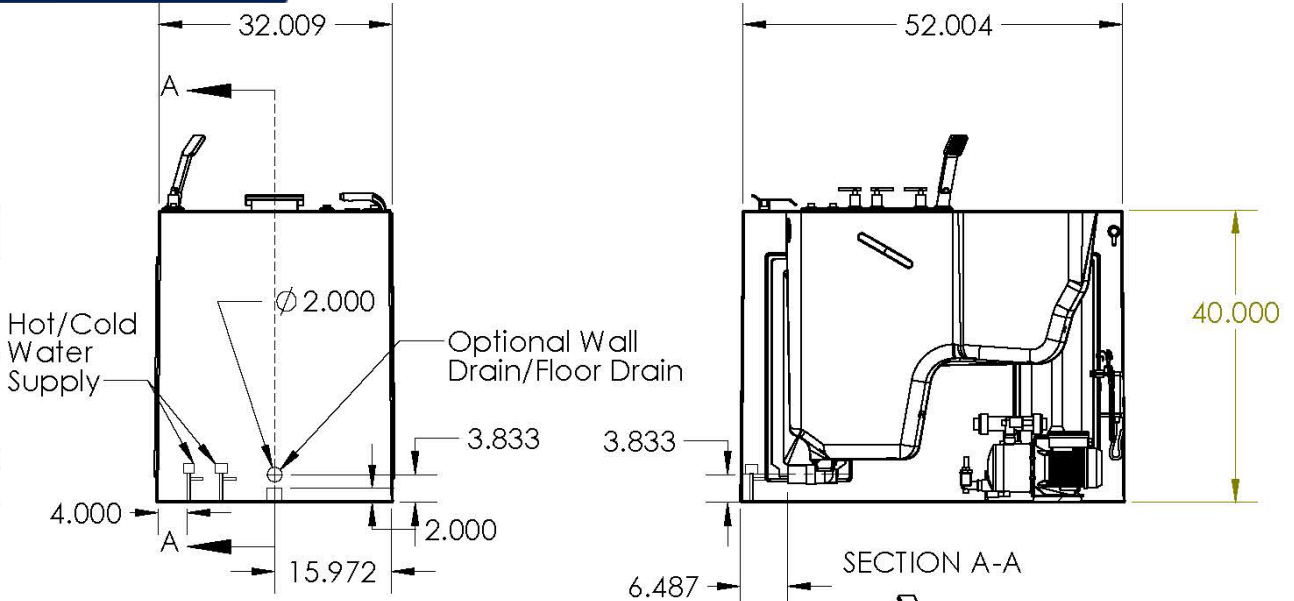
# TheraSpa Rough In

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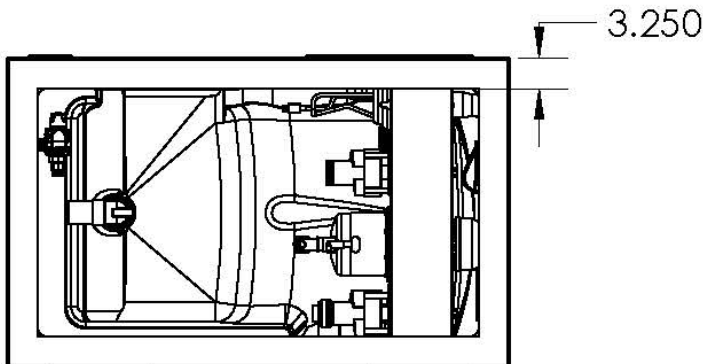
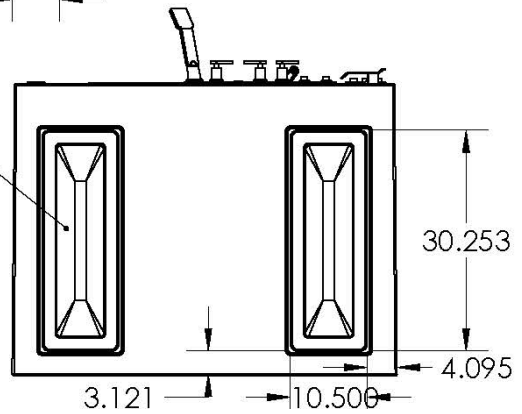
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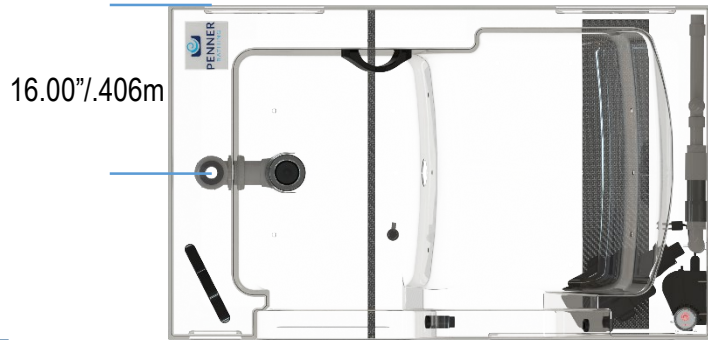
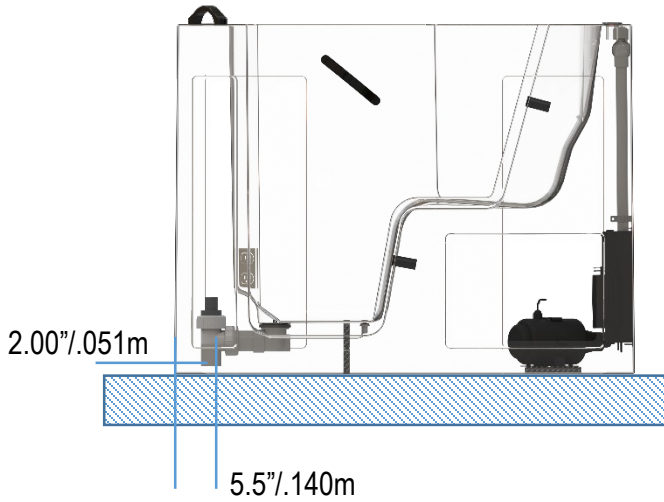
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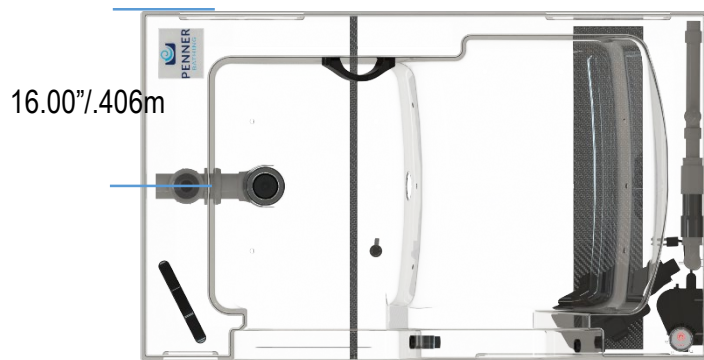
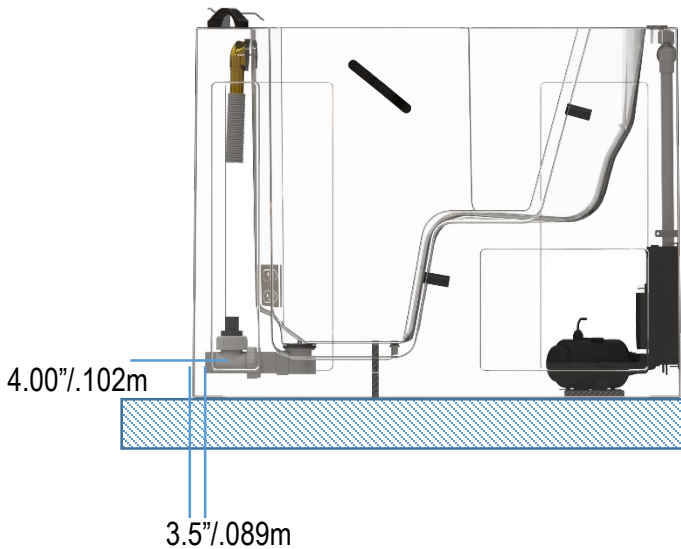


Open rear access doors for electrical outlet location. Fiber glass can also be cut as long as it is 15 inches under deck height.





Drain tee can be rotated to face towards the front of the spa or down towards the ground depending on resident drain location. P-trap is not included. 2" drain diameter. A rubber coupler and clamps can be used.





## Hot and Cold water supply requirements

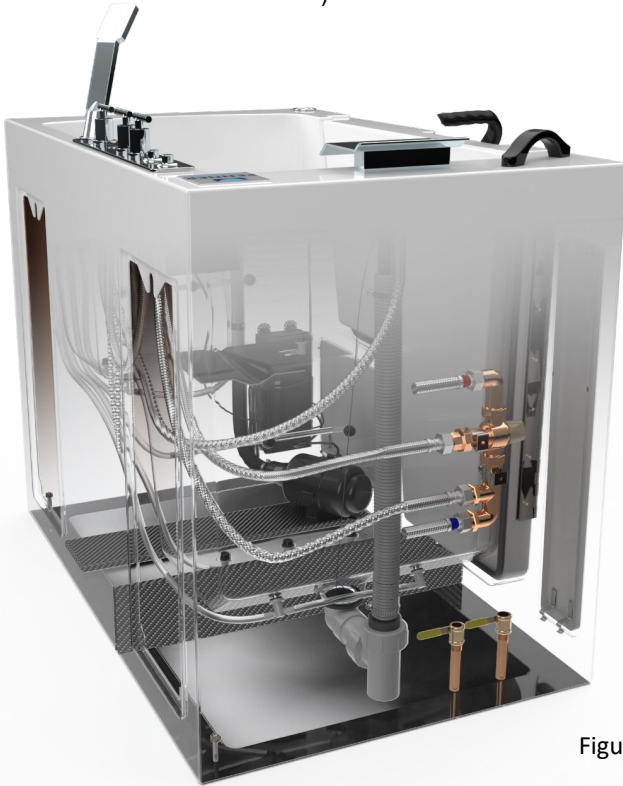
$\frac{3}{4}$ " supply lines with on/off valves NPT male threads. We recommend a  $\frac{3}{4}$ " ball valve with  $\frac{3}{4}$ " NPT male ports. (Valves supplied by others.) See figure 14-15

For optimum performance, dynamic pressures should be nominally equal between hot and cold supplies.

Maximum static supply pressure: 145 PSI.

Maximum dynamic/maintained supply pressure: 81 PSI.

Maximum supply Hot water temperature: Consult local requirements for maximum allowed supply temperatures. (Not recommended over 120°F).



Figures 14-15

## Electrical requirements

The TheraSpa is rated 10.5 Amps at 120 Volts AC.

A 15 amp GFCI circuit is required.

The Load Center is located on the back inside wall of the TheraSpa. It is supplied with a 3 foot electrical cord for a 120 V outlet. Please contact Penner Manufacturing, INC. for further options. Best location for power supply is through the rear skirt access door. Small cutouts through tub skirt as needed can allow for various electrical supply options. See figure 14-15.



It is recommended that the power wires be installed by an electrician. Then connect the Dream spa electrical cord.



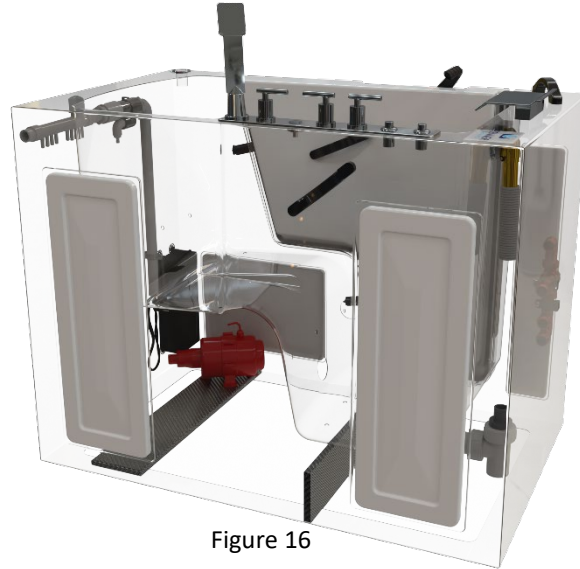


Figure 16

The blower motor sits on composite board. If drain, water supply, or electrical hook up are in this area, the board can be moved. Use a ½" wrench or socket and ratchet to remove the hold down nuts. Lift the board up and move to desired location while making sure the blower motor delivery hose doesn't kink.

## Unpacking the TheraSpa

1. Remove cardboard around spa. Remove spa from pallet by unscrewing hold-down boards from pallet. (Blower motor in red and composite board do not need to be removed. Reference Figure 16)
2. Remove plastic cover and wrapping around spa.
3. Locate and save installation components. (Ex. anchor pins)
4. Remove all access doors (if applicable) and place them where they will not be damaged during the installation process.

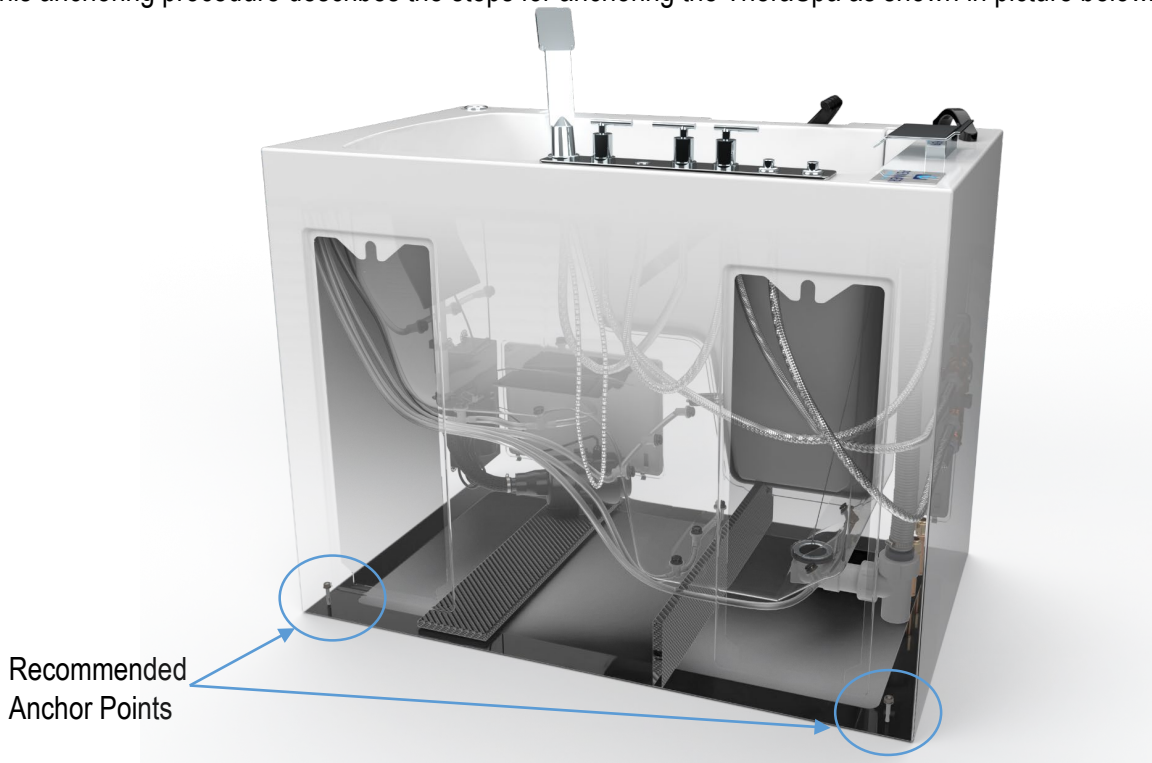
## Water Supply Hose Connections

With an installation where the left side of the spa will be against a wall and the water supply lines come from that wall, connect the hot and cold water lines to the supply valves prior to moving the spa into place. The water lines use a gasket to make the seal. No thread tape or sealant is needed. The hose lines are female ¾" NPT swivel ends.



## Anchoring the tub

This anchoring procedure describes the steps for anchoring the TheraSpa as shown in picture below.



1. Ensure that the electrical supply box has been wired properly. Also ensure that the provided supply lines have been connected to the supply valves.
2. If the drain connection is to be made with a rubber coupler, it may need to be in place (loosely on the drain pipe) prior to moving the spa into place.
3. Carefully slide the spa into the desired position.
4. There are two 5/16 x 2" anchor pins provided with the spa on commercial models. Residential models come with two additional 1/4"x2" lag screws and washers. Drill a 5/16" hole through the base flange just inside the access door openings on either side of the spa towards the front. If the floor is something other than concrete, consult the building engineer for anchor selection. Residential models can use lag screws instead or anchor and lag screws if desired. Another alternative is to place a sturdy board across both base flanges and bolt it to the leveled floor, pinning the spa down.



## Electrical Connections

It is highly recommended that the electrical outlet be installed by a professional electrician. A minimum of a 15 amp 120 volt service is required with a ground fault circuit interrupter.



**Warning: Ensure that the power supply is turned off before attempting to wire in the power supply to the spa. Failure to do this could result in injury or death to the installer.**

When the power supply is installed and wired, take the plug-in from the Load Center and plug it into the outlet.

The Comfort Warm control button will cycle through multiple colored lights and go off.

If the Comfort Warm or Blower motor is on when electrical supply is first hooked up to the spa, push the related air button until system turns off. There are three heat levels for the Comfort Warm and then an off. Also, there are three speed settings for the blower motor, and then an off.

Comfort warm system will automatically turn off after 30 minutes.

Aqua-Aire blower motor will automatically turn off after 20 minutes.

## Water Supply and Drain Connections

**Note: It is highly recommended that a licensed plumber makes the final connections of the hot and cold water supply and the connection to the drain.**

1. Connect the supply hoses (hot and cold water supply) to the respective ports on the spa. Ensure that there are sealing gaskets within the swivel fittings on the hoses.
2. Connect the drain (waste) of the spa to the facility's drain system.
3. Close the water door of the spa, place the drain plug into the drain, and open the facility's supply valves to the spa and check for leaks.
4. Check each system (Spa fill, Hand shower, Aqua-Aire, and Comfort Warm) one at a time. Look for leaks as it is flowing water. If no leak is found, turn off the water with your hot and cold control valves on the Spa.
5. If any leaks are found, tighten the connection to stop the leak.
6. Open the spa drain and check the drain system for any leaks, and fix if needed.



If removal of the water door or access doors was necessary during installation, reinstall those components. Apply a white silicon caulking between door cover and door. Wipe off excess amount with damp towel or clothe. Fascia screws need to be tightened enough to hold fascia in place, but DO NOT over tighten, as this may cause the fiberglass to crack.

Proper care and maintenance of the TheraSpa will significantly increase the life and usage of the spa.



**Do Not** attempt to operate this equipment before reviewing all the manuals and having proper professionals install electrical and plumbing services. The use of this equipment before proper review and installation could result in equipment damage or injury to the spa user.

For your nearest distributor, contact:

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**Box 523 / 101 Grant St.**  
**Aurora, NE 68818**

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