

**INSTALLATION INSTRUCTIONS  
OPERATION AND MAINTENANCE  
WARRANTY**



<b>TETSU</b>	<b>5-1/2' x 32"</b>	<b>MODEL 60525</b>
<b>TETSU</b>	<b>5-1/2' x 36"</b>	<b>MODEL 60545</b>
<b>LUTEZIA</b>	<b>5-1/2' x 36"</b>	<b>MODEL 60645</b>
<b>ARCHIVE</b>	<b>5-1/2' x 36" OVAL</b>	<b>MODEL 60745</b>

***THANK YOU...***

for selecting an Porcher bath. Your new bath is shipped to you after careful inspection. The Air Massage System is completely assembled with air pump, motor and system piping. All you need to finish the installation are your selected fittings and electrical connections for an Air Massage System.

To ensure maximum performance and pleasure from this product, please follow the instructions and cautions.

**ATTENTION INSTALLER:  
Please deliver this manual to homeowner.**

FOR AFTER-SALES SERVICE CALL 1 (800) 359-3261 WEEKDAYS.


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# IMPORTANT SAFETY INSTRUCTIONS


## READ AND FOLLOW ALL INSTRUCTIONS!


 **WARNING: Risk of personal injury.** Do not permit children to use this bathtub without adult supervision. Never drop or insert any object into any opening. Do not operate this unit without the guard over the suction fitting.

 **WARNING: Risk of electric shock.** Do not permit electrical appliances near any bathtub when bathtub contains water.

 **WARNING: Risk of hyperthermia and possible drowning.** People using medications and/or having adverse medical history should consult a physician before using this product.

 **WARNING: Risk of personal injury.** Do not overfill bathtub before entering. Entering tub when filled more than 2/3 can cause overflow and slippery conditions. Exercise caution when entering and exiting.

 **WARNING: No Food or Alcoholic Beverages.** Use of your bathtub immediately after meals is not recommended. Avoid alcohol consumption before or during bathing. Alcoholic beverages can cause drowsiness or hyperthermia resulting in loss of consciousness or even drowning.

 **WARNING: Pregnancy.** If you are or think you may be pregnant, consult your physician before using the bathtub.

Use this unit only for its intended use as described in this manual.  
Do not use any attachments not recommended by Porcher.

The unit must be connected only to a supply circuit that is properly protected by a ground-fault circuit-interrupter (GFCI). Such a GFCI should be provided by the installer and should be tested on a routine basis. To test the GFCI, push the test button. The GFCI should interrupt power. Push the reset button. Power should be restored. If the GFCI fails to operate in this manner, the GFCI is defective. If the GFCI interrupts power to the bathtub without the test button being pushed, a ground current is flowing, indicating the possibility of an electric shock. Do not use this air bath. Disconnect the air bath and have the problem corrected by a licensed electrician before using.

## SAVE THESE INSTRUCTIONS

## General Installation Information

Carefully uncrate and inspect your new bath for any shipping damage. If such damage is found, report it to your vendor immediately. After inspection and during installation, protect the bath from construction damage. Before installation, and before enclosing with wallboard, tile, etc., the bath must be filled with water to check for leaks that may have resulted from shipping damage or mishandling! Fittings (bath filler, shower arm, etc.) are not provided with the bath and must be ordered separately. Framing and enclosing materials are provided by others. Follow test procedures carefully.

## ATTENTION INSTALLER!

**THIS TUB MUST BE TESTED FOR OPERATION AND LEAKS PRIOR TO ENCLOSURE OF SURROUNDING AREAS. FAILURE TO DO SO WILL VOID WARRANTY. THIS TUB WAS WATER TESTED AT THE FACTORY AND FOUND TO BE FULLY OPERATIONAL AND LEAK FREE PRIOR TO SHIPPING. FREIGHT HANDLING AND JOB SITE EXPOSURE MAY HAVE DETERIORATED THE TUB'S CONDITION. IT IS THE RESPONSIBILITY OF THE INSTALLER TO THOROUGHLY TEST THE UNIT PRIOR TO INSTALLATION. TUBS ARE INTENDED FOR INDOOR USE ONLY.**

### TEST PROCEDURES:

1. Place the tub on a flat surface such as a driveway.
2. Seal the drain with tape.
3. Fill tub and allow tub to stand for five minutes **without the blower running**. Examine all fittings carefully for leaks. **NOTE:** The overflow is a plumbing device designed to prevent water from reaching a certain level in your tub. **DO NOT**, under any circumstances, tape off or block the overflow in any way. Any controls located above the normal water line are designed to be water resistant, not waterproof. The controls will not leak under normal usage, however, they are not warranted against leaks when improperly used or subjected to conditions for which they are not designed.
4. Plug the blower into a 110V GFCI outlet. Start the blower and check all fittings for leaks.
5. Check that all optional equipment is functioning properly and that the features on the tub match exactly what was ordered.
6. **If any leaks or operating problems are discovered, do not complete installation until problems are resolved. Porcher will not be responsible for any costs involved with removing or reinstalling the tub, or for the costs of any surrounding materials or labor.**

If you have installation or warranty questions please do not return the unit to the place of purchase. Call 800-359-3261

Always protect tub from construction damage by using a protective cover. Damage, including chips and scratches incurred at the jobsite is excluded from warranty but may be repaired by qualified technician at the owner's expense. Do not stand in the tub or store materials in the tub during construction. Do not store tub in temperatures below 32 degrees Fahrenheit. Proper waste and overflow installation is the responsibility of the installer. Porcher does not warrant leaks associated with improper waste and overflow installation.

Access must be provided to air blower and/or electrical component on your tub.

The access panel(s) must have a minimum size of 16" x 14" (406 x 356mm) for installation and future servicing of the equipment. Porcher, Inc. will not authorize any service unless clear access is available. Access from a crawl space or incomplete access to all equipment may result in warranty claims being denied.

Check for availability of optional Porcher wall tiling bead (required for recess installation).

Protect all finished surfaces of the bathtub during construction and installation using a drop cloth.

**For Air Baths:**

1. Never handle the bath by the blower, piping or other equipment.
2. Make sure the manifold and airlines are protected when moving the tub into the house.
3. An access panel measuring 16" x 14" (406 x 356mm) must be provided for the blower for any future servicing.
4. The blower must not be insulated and must have sufficient air space to permit proper operation. Surrounding ambient air temperature should be between 72°F and 86°F.
5. The heating element on your blower heats the air blown into the tub to prevent the water from cooling too quickly. It will not, under any circumstances, reheat or maintain the temperature of bath water.
6. The area underneath and around the tub must be cleaned thoroughly before finalizing installation to prevent any particles from entering the blower or being blown into the air jets.
7. Before filling the tub, clean installation debris and dirt from the interior of the tub. If necessary, use the soft brush attachment of a vacuum cleaner.
8. Fill tub and test for proper operation and leaks. Note: The blower must be plugged into a GFCI protected outlet.
9. The drain supplied must be used. It is part of the Air Bath and the system will not function correctly without it.

**List of Required Tools and Supplies**

**Tools**

- Level
- Tape Measure
- Pipe Wrench
- Slip Joint Pliers
- Screw Driver
- Standard Woodworking Tools
- Personal Safety Equipment
- Caulking Gun

**Supplies**

- Nails
- Putty
- Caulking (waterproof)
- 1 X 4 Stringers
- Drop Cloth
- Cement, Plaster, Grout
- Liquid Nails (Freestanding Modes Only)

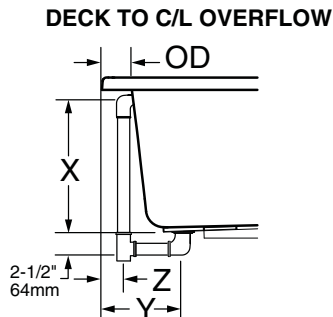
**Optional Components (not included):**

- Tile Bead Kits (P/N 751755-100)

**Required Components:**

- Drain (included)
- Bath Filler (not included)

**SPECIFICATIONS**



**GENERAL SPECIFICATIONS AIR BATHS - DROP IN AND RECESS MODELS**

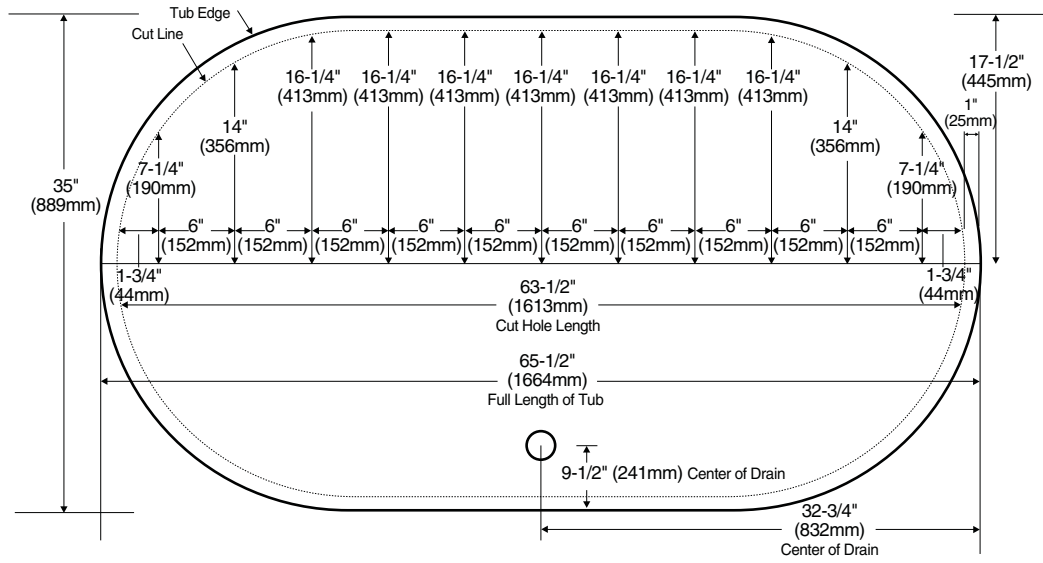
Description	Drain / Overflow	Cut Out Pier G x F	Rough-In Recess A x C	Weight with Water / Floor Loading	Product Weight	Gallon to Overflow
Tetsu™ 5-1/2' x 32" (140 x 813mm) 60525	X 17" (432mm) Y 10-1/8" (257mm) Z 7-1/8" (181mm)	64-1/2" x 30-1/2" (1638 x 775mm)	66" x 32" (1677 x 813mm)	50 lbs./ft²	85 lbs. (39 kg.)	78 gal. (295 l.)
Tetsu™ 5-1/2' x 36" (140 x 914mm) 60545	X 17-1/4" (438mm) Y 10" (254mm) Z 5-1/4" (133mm)	64-1/2" x 34-1/2" (1638 x 880mm)	66-1/4" x 36-1/4" (1682 x 920mm)	40 lbs./ft²	85 lbs. (39 kg.)	68 gal. (260 l.)
Lutezia™ 5-1/2' x 36" (140 x 914mm) 60645	X 17-3/8" (441mm) Y 10" (254mm) Z 7" (178mm)	64-1/4" x 34-1/2" (1630 x 880mm)	66" x 36" (1677 x 914mm)	48 lbs./ft²	85 lbs. (39 kg.)	84 gal. (320 l.)
Archive™ Oval 5-1/2' x 36" (140 x 914mm) 60745	X 17-3/8" (441mm) Y 9-1/2" (241mm) Z 6-3/8" (62mm)	Use Template Provided	See Template Dimensions -Next Page-	54 lbs./ft²	121 lbs. (55 kg.)	80 gal. (300 l.)

**TABLE 1**

For more details, see specification page per model at [www.porcher-us.com](http://www.porcher-us.com)

\*note - on Air Baths the drain included with the tub must be used. The drain outlet is directly under the drain hole in the tub.

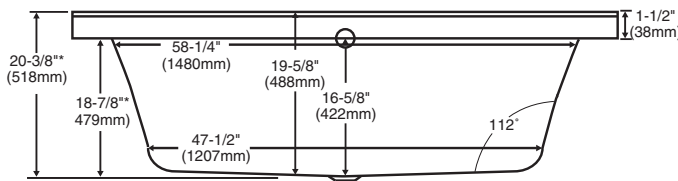
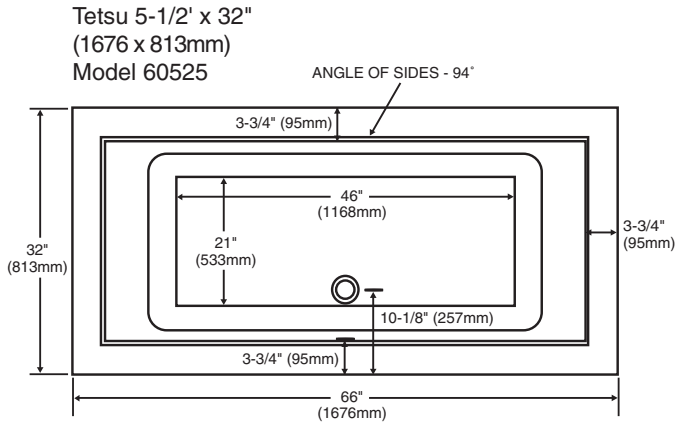
# Archive Drop-In Cutout Template



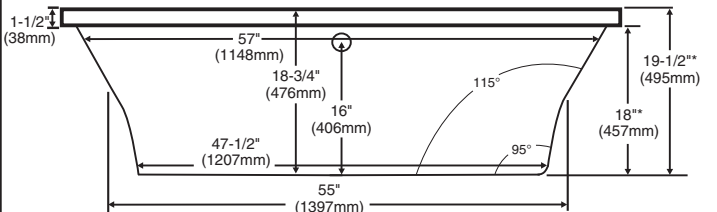
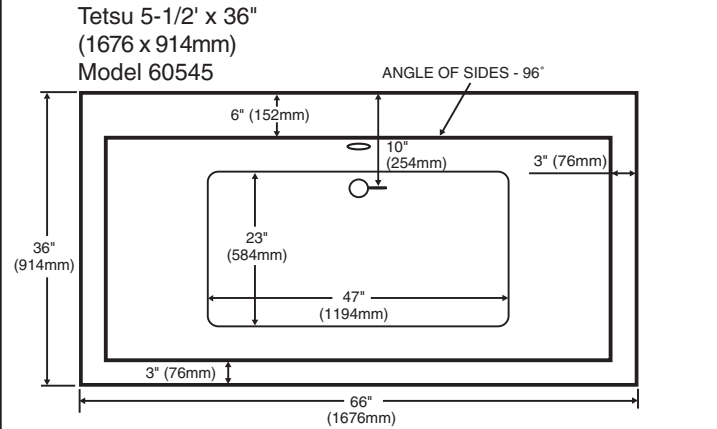
## Roughing In References

### Soaker, Soaker with Lights, Air Bath, Air Bath with Lights

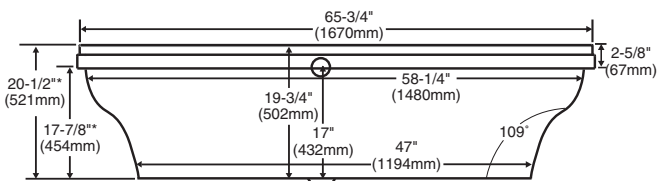
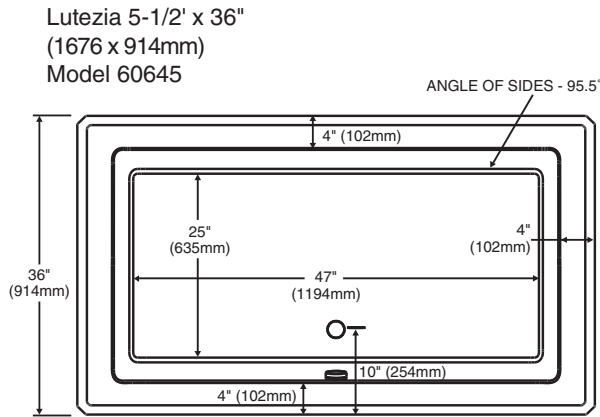
-see appropriate sections for details - support soakers with bedding material, rim must NOT support weight



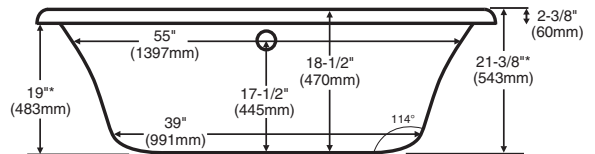
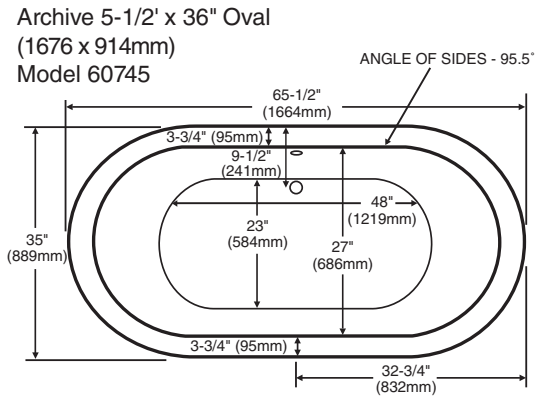
\*For Air Baths Add 2-1/2" (64mm)



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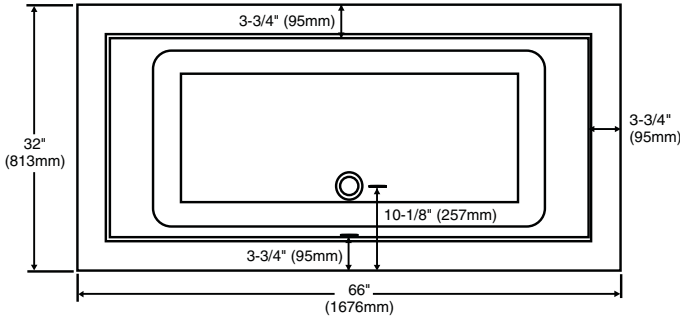
\*For Air Baths Add 2-1/2" (64mm)

## Roughing In References Freestanding Models

-see appropriate sections for details

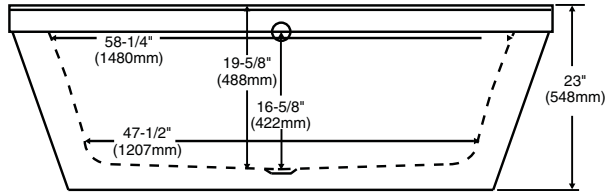
A - For Air Equipped Tubs Only  
Do Not drill in this area  
Air Component will be damaged.

**Tetsu 5-1/2' x 32"**  
(1676 x 813mm)  
Model 60525



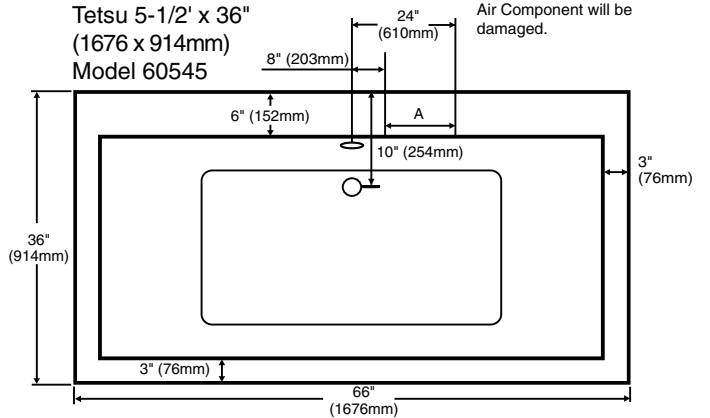
freestanding tubs use wall-mounted or freestanding faucets. The waste and overflow assembly is concealed between the walls of the tub, eliminating the need for a decorative exposed drain kit.

Dotted Line Represents Bathing Well



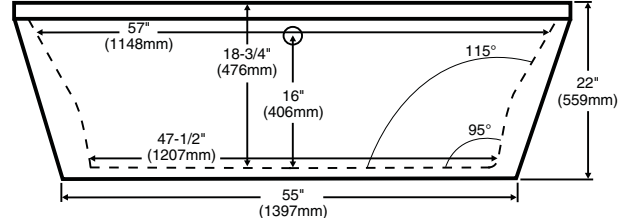
Measurements are  $\pm 1/2"$  (13mm) and are subject to change without notice. Data herein supersedes all previous prior to publication date shown below.

**Tetsu 5-1/2' x 36"**  
(1676 x 914mm)  
Model 60545



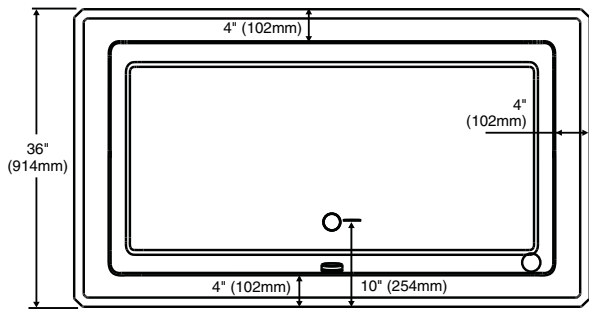
Freestanding tubs use wall-mounted or freestanding faucets. The waste and overflow assembly is concealed between the walls of the tub, eliminating the need for a decorative exposed drain kit.

Dotted Line Represents Bathing Well



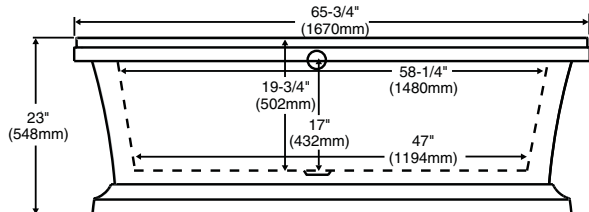
Measurements are  $\pm 1/2"$  (13mm) and are subject to change without notice. Data herein supersedes all previous prior to publication date shown below.

**Lutezia 5-1/2' x 36"**  
(1676 x 914mm)  
Model 60645



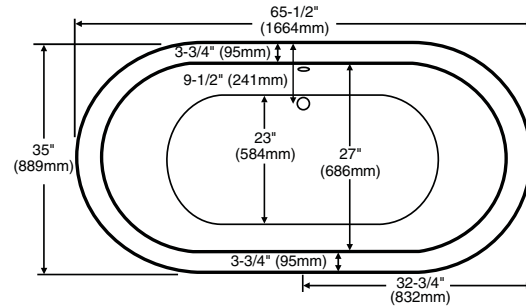
Freestanding tubs use wall-mounted or freestanding faucets. The waste and overflow assembly is concealed between the walls of the tub, eliminating the need for a decorative exposed drain kit.

Dotted Line Represents Bathing Well



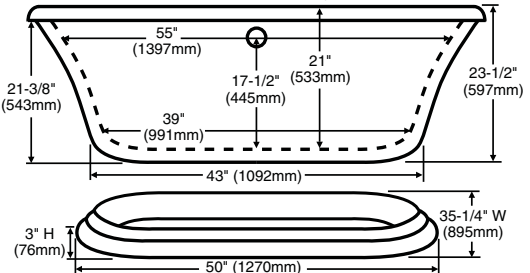
Measurements are  $\pm 1/2"$  (13mm) and are subject to change without notice. Data herein supersedes all previous prior to publication date shown below.

**Archive 5-1/2' x 36" Oval**  
(1676 x 914mm)  
Model 60745



Freestanding tubs use wall-mounted or freestanding faucets. The waste and overflow assembly is concealed between the walls of the tub, eliminating the need for a decorative exposed drain kit.

Dotted Line Represents Bathing Well



Optional one-piece pedestal base.

Measurements are  $\pm 1/2"$  (13mm) and are subject to change without notice. Data herein supersedes all previous prior to publication date shown below.



## DROP IN AND RECESS MODELS INSTALLATION AND FRAMING OPTIONS

The variety of installations possible for these products may require framing procedures other than those shown. Locate studs as required. Ensure roughing-in dimensions are proper, plumb and square. Provisions must be made in all installations for an access opening for servicing the air blower and controls. It is strongly recommended that an additional opening be provided for access to the drain components and fixtures. The apron should not be used as the primary access opening.

1. Position the bath into the installation opening and level the deck in both directions. Mark the final position of the underside of the deck by tracing a line on to the studs (see Figure 1)  
The bath must be supported by bedding compound underneath the entire length of the bath. If your bath arrived with the pre-leveled foam base, no bedding compound is necessary (although some bedding compound may be needed to level the tub if the sub-floor is not perfectly level).
2. Remove the bath and attach a 1 x 4 stringer to the studs, with the top of the stringer touching the traced line.

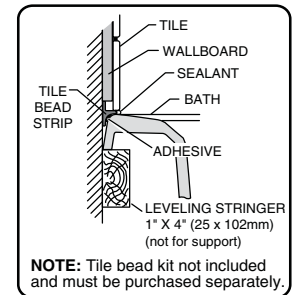
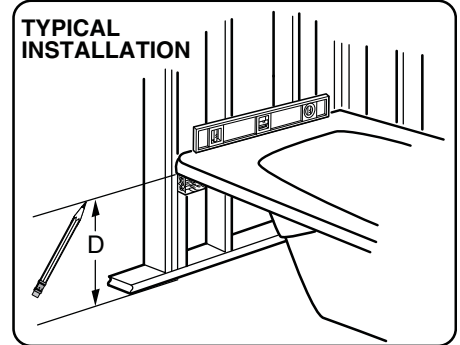
**!** The rim of the bath **must not** support weight.

Additional instructions for Air Baths:

3. Install supplied cable drain components to the air massage bath according to the enclosed drain installation instructions. Before replacing your air bath for final installation, be certain that an opening has been provided in the sub-floor for the drain. See the roughing-in drawing for suggested opening size (shaded) and location dimensions. The drain/overflow of the bath extends below the bottom of the bath. Note that this requires a cutout in the floor.
4. Replace air massage bath, using bedding compound as needed to completely support and level the bath.

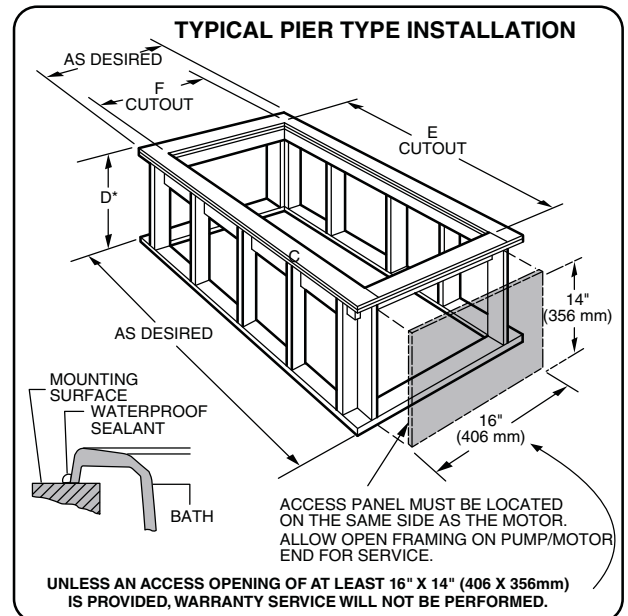
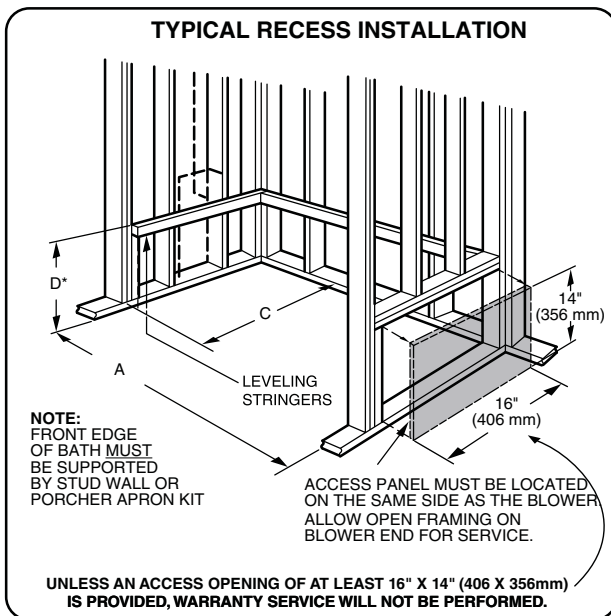
**!** The rim of the bath **must not** support weight. Any finish material such as tile or wall board must be self-supporting if it contacts the deck of the bath.

FIGURE 1



### NOTICE:

DO NOT BUILD THE SURROUNDING STRUCTURE BEFORE RECEIVING YOUR AIR BATH. STRUCTURE MEASUREMENTS SHOULD BE VERIFIED AGAINST THE ACTUAL AIR BATH RECEIVED TO ENSURE PROPER FIT.



Refer to Specification Sheets and Diagram for appropriate dimensions.

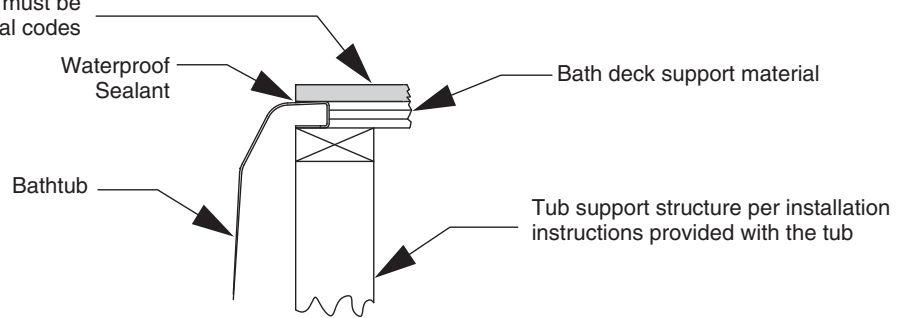
\* Dim D - See Roughing-In References Page

## UNDER DECK MOUNTING INSTRUCTIONS

Please note that care must be taken to protect the surface of the tub during all aspects of the installation. Do not drill or cut the bath deck with the tub directly beneath it as damage to the tub may result.

1. Install the tub per the installation instructions provided with the unit.
2. Prepare the bath deck support structure per the local codes. Note - the bath deck must be self supporting.
3. Cut bath deck to your specifications. A professional solid surface installer should template product on site for exact cut out dimension.
4. Replace the bath deck and secure it into place.
5. Apply additional sealant along the tub and bath deck interface as necessary to ensure a watertight seal.
6. Remove excess sealant per the manufacturer's instructions.

Finished bath deck surface material must be self-supporting and secured per local codes

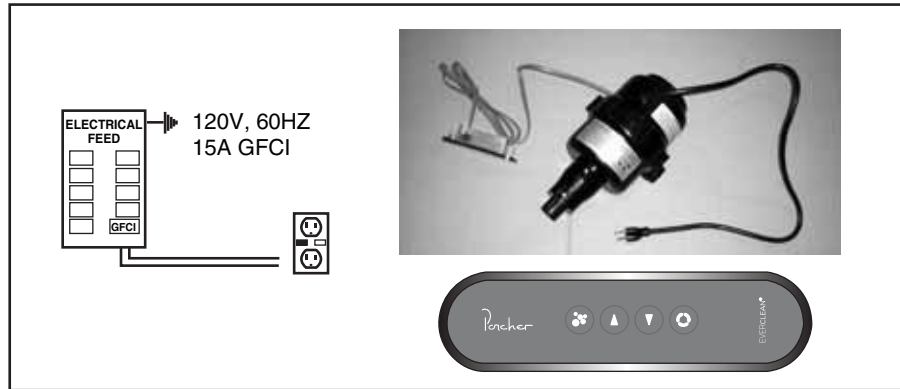


## ELECTRICAL INSTALLATION INSTRUCTIONS

All wiring must be performed by a licensed electrician in accordance with the national electrical code and all other applicable codes.

**⚠ WARNING:** When using electrical products, basic precautions should always be observed, including the following:

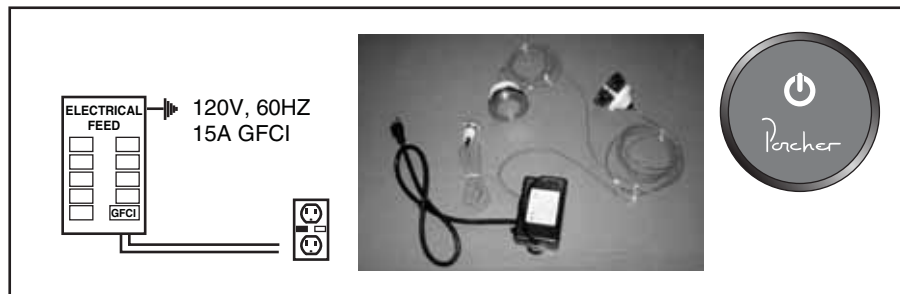
1. **DANGER: RISK OF ELECTRIC SHOCK!** Connect only to a circuit protected by a ground-fault circuit interrupter.
2. Permit access for servicing blower (if equipped) as noted.
3. All building materials and wiring should be routed away from the pump body and heater (if equipped).



ELECTRONIC ACTIVATED AIR BATH (4 BUTTON PANEL)



ELECTRONIC ACTIVATED AIR BATH WITH LIGHTS (5 BUTTON PANEL)

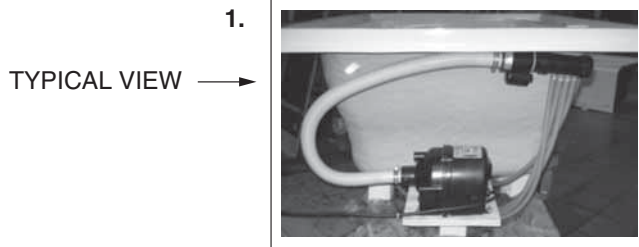


ELECTRONIC ACTIVATED LIGHTS ONLY SYSTEM (1 BUTTON PANEL)

**REMOTE BLOWER LOCATION OPTION**

**IMPORTANT!** It is not necessary that the blower motor be relocated. This option is provided for the case that a particular installation makes this effort practical.

**NOTE:** Relocating blower motor from factory installed location, see photo 1, will require disassembly of air blower from mounting board. Keep all hardware for reattachment at new location. Additional hardware will be required depending upon final desired position of air blower. Follow all instructions listed below.



**NOTE:** Installing the blower in a remote location will reduce the system efficiency.

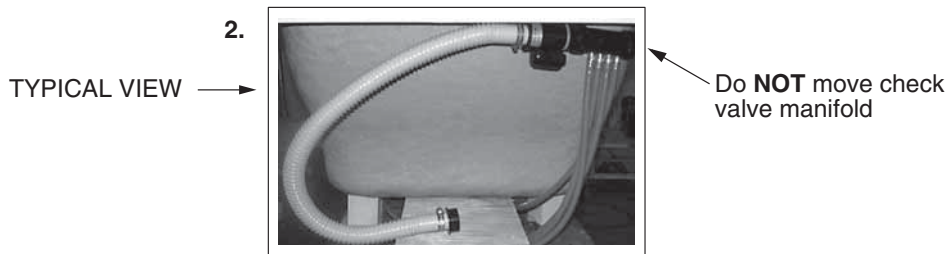
**NOTE:** Relocating a blower motor still requires a service access for the blower.

**NOTE:** All materials needed for the relocation must be supplied by the installer. This includes ordering a longer control panel cable (754025-0073A), a longer flexible blower hose (753960-2030A), and up to two lighting cable extensions for combo models (754512-0070A).

A separate circuit, which must be protected by the Ground Fault Circuit Interrupter (GFCI), is required in the remote location. Electrical connections should be performed by a licensed electrician.

The blower motor must be located within 12 feet of rigid piping from the bath air manifold. This limitation is for the total pipe length and applies to any direction changes and elbows. There can be no more than six changes of direction. There should be as few direction changes as possible and the piping installation must meet all requirements of local plumbing and building codes.

Disconnect the blower from the flexible hose as shown in photo 2. Do NOT remove the check valve manifold that is mounted to the underside of the air bath. The manifold MUST remain mounted above the tub overflow level as shown in 2.



Replace the flexible hose shown in photo 2 with the longer flexible hose (P/N 753960-2030A) using the existing hose clamps.

**NOTE:** Do NOT remove the original cable coming out of the blower. Instead, plug the longer cable (P/N 754025-0073A) into the existing cable that is coming out of the blower as shown in photo 3. Then plug the remaining end of the longer cable into the control panel which remains on the tub wall.



# Freestanding Tubs

## General Information

Rough in dimensions For critical dimensions, we suggest taking the measurements of the actual tub on site. All printed specifications are +/- 1/2 inch (13mm) and subject to change without notice.

Access panel- A removable access panel is located on the drain side (rear) of the bath. It provides access for installation of the waste and overflow. It is held in place by covered stainless steel screws. On freestanding air bath models, keypad wire and hose exit the bottom of the bath.

Pedestal Base - The optional pedestal base available on some models does not raise the height of the tub, as the tub actually sits down into the base. The base does, however, extend beyond the top rim of the tub by approximately 1" (25mm). Use care when selecting your free-standing faucet, ensuring that the reach of the spout is adequate so that no modification to the pedestal base will be necessary. If wall mounted fixtures are being used, again be careful to ensure the spout will extend out far enough to clear the tub flange and the falling water will not hit too high up on the side wall of the tub and splash. It may be necessary to omit or trim the baseboard or molding to allow the tub to sit close to the wall. Please note: The pedestal base is not symmetrical; if it does not fit, rotate the base 180°.

## Fixtures

No fixtures can be mounted on the tub deck freestanding tubs. Floor or wall-mounted fixtures are *required*. (Except for Model 60545)

Wall-Mounted - The position of the tub and the reach of the spout are critical. Pay special attention to the spout reach when choosing your fixtures. Be careful to ensure the spout will extend out far enough to clear the tub flange and the falling water will not hit too high up on the side wall of the tub and splash.

Floor-Mounted - Some freestanding fixtures must be anchored to the tub drain for stabilization. The waste and overflow on freestanding tubs are concealed under the access cover so anchoring to the overflow pipe (or tub structure) is not possible. Many kits (with minor modification) can be mounted to the wall (rather than the drain pipe) for stabilization.

## Basic Installation Procedure

- Determine final location of tub. Tub will sit on top of finished flooring.
- Ensure location is structurally sound, flat and level.
- Remove access panel to gain access for waste and overflow installation. Be careful not to damage the access panel during installation.
- Roll tub onto front face, being careful not to damage the acrylic finish. Use packing blanket or other suitable material to protect the surface of the tub.
- Install waste and overflow.
- Using two 2' x 4's to elevate the tub above the floor, align the tub so that the drain lines up with the P-trap in the floor. **DO NOT LET THE TUB REST ON THE DRAIN PLUMBING.**
- Apply a 3/8" bead of Liquid Nails to the bottom of the tub to adhere it to the floor.  
Use care not to allow adhesive to get on the outside surface of tub or surrounding floor area. Wipe any excess immediately with a soft, damp cloth.
- Carefully remove the 2' x 4' supports and lower the tub to the floor, making sure that the drain drops into the P-trap.
- Check that the drain is properly aligned, complete drain installation and reinstall the access cover.
- Allow to set for 24 hours before using.

# Freestanding Tubs

(continued)

## Waste and Overflow

- Due to limited space between the inner and outer tub shells, use care when selecting your drain kit. Use a cable driven or toe-tap style. If you ordered your bath with an air system, you **MUST** use the drain kit included. If access is available from below during the final installation, it is easier to make precise adjustments in the final location of the tub.
- Remote Mounting Blower - Due to the limited space between the inner and outer shells of the freestanding tubs, the blower must be remote mounted. In addition to the air hose, there are two electrical connections between the tub and the blower. Both electrical connections and the air hose exit through the bottom of the bath. It is always desirable to remote mount the air blower as close to the tub as possible to minimize the loss of heat. Pipe insulation may be used on the blower hose to minimize heat loss.

**NOTE:** Relocating a blower motor still requires a service access for the blower.

**NOTE:** All materials needed for the relocation must be supplied by the installer. This includes ordering a longer control panel cable (P/N 754025-0071A).

A separate circuit, which must be protected by the Ground Fault Circuit Interrupter (GFCI), is required in the remote location. Electrical connections should be performed by a licensed electrician.

## ADDITIONAL INSTRUCTIONS FOR FREESTANDING AIR BATHS

All freestanding air baths may be installed in the center of the room. Keep in mind that the placement of the blower can be challenging or problematic. All models have a built in access panel for drain installation that you may prefer to place on the less visible side of the bath. Although each installation may vary, Porcher offers two solutions to blower placement.

- a) Adjacent to the tub: A decorative box to hide the blower may be custom built on site. The box should always provide access for future servicing of the blower, as well as the required minimum 5" x 7" (127 x 178mm) ventilation panel.
  - b) Remote mounting the blower: The blower may be remote mounted up to 8' (2438mm) from the bath. The air hose leading to the blower may be installed under the floor and the blower located inside a utility or linen closet. Use care not to crush or restrict the airflow in the line in any way. The blower may also be located underneath the tub. In either case, access to the blower must be provided for any future service.
1. Disconnect the air hose from the blower and use the provided clamps and coupling to attach extension hose.
  2. Reconnect hose to blower.
  3. The wires leading from the keypad to the blower are standard 6' (1829mm) in length. Up to 12' (3658mm) is available upon request. The wires on the sensors are 10' (3048mm) in length standard.
  4. Secure blower using wood screws through the mounting feet.

**Note:** Pipe insulation may be used on the air hose to help retain warmth from the blower. Do not use insulation within 8" (203mm) of the blower. The blower needs sufficient air space surrounding it for circulation. The blower requires a separate 110VAC, 15 amp GFCI circuit.

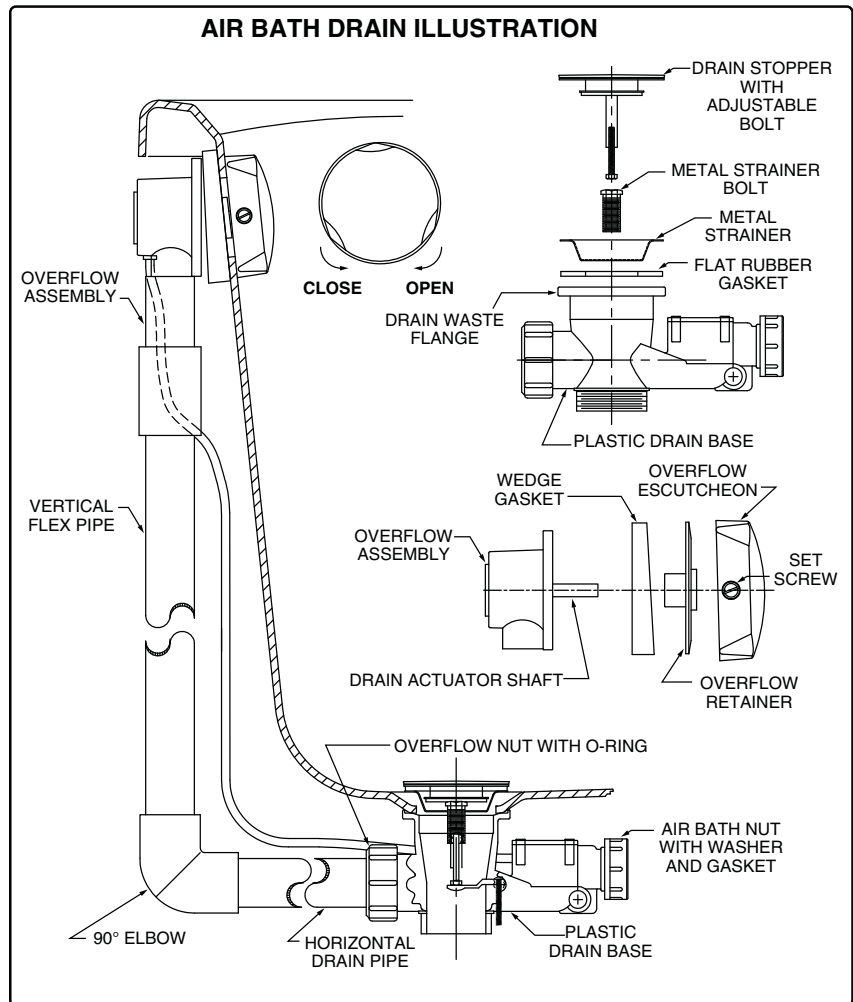
## AIR BATH DRAIN INSTALLATION - ALL AIR BATHS

**NOTE:** All Porcher Air Bath configurations include a drain. Other drains cannot be used.

**NOTE:** Include a 9" (229mm) wide by 18" (457mm) long cut-out in floor for drain.

### DRAIN CONNECTION AND SYSTEM TEST (before installing bath)

With supplied cable drain assembled to bath, connect drain outlet to waste line in accordance with the drain assembly instructions. Tighten all drain joints securely. Check the couplings and make sure they are hand-tight. Clean the air bath and fill with water to a point 2" (51mm) below the overflow. Recheck the couplings and make certain that they are not leaking. (Although the couplings are factory tightened and inspected, some loosening may have occurred during transit.) Make sure the air bath is connected to the electrical supply and turn the air bath on. Check for leaks around all piping connections while the air bath is running.



## DRAIN CONNECTION

1. Remove and identify all drain components as defined in air bath drain illustration.
2. Find 1" schedule 40 PVC pipe, 12" length, **HORIZONTAL DRAIN PIPE**.  
Cut pipe to nominal 5" length and mark as "horizontal pipe", drain to elbow section.
3. Find 1" diameter **VERTICAL FLEX PIPE**. Mark as "vertical pipe", drain to elbow section.
4. Install drain from below unit through opening as shown in photo **A**.



5. Apply 3 or 4 pea sized dabs of 100% silicone sealant to bottom waste drain flange and press flat rubber gasket into place as shown in photos **B** and **C**.



6. Apply 1/8" continuous bead of 100% silicone sealant to flat rubber gasket as shown in photo **D**. Set aside and be sure not to disturb silicone bead.



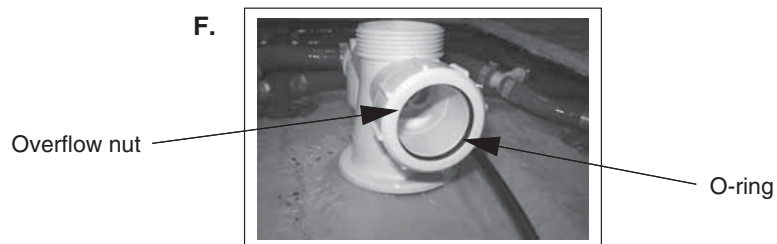
7. Apply 1/8" continuous bead of 100% silicone sealant to back side to metal strainer as shown in photo **E**. Press Strainer retaining bolt into metal strainer and insert into drain hole of acrylic bath.



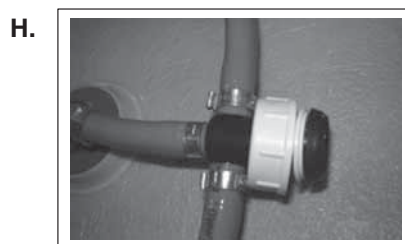
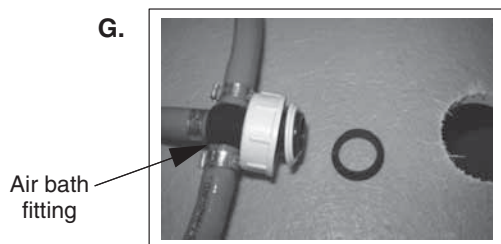


## DRAIN CONNECTION *continued...*

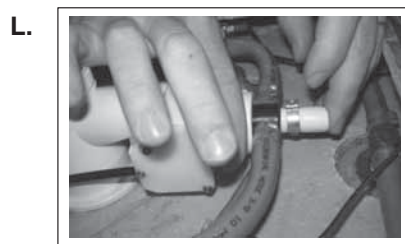
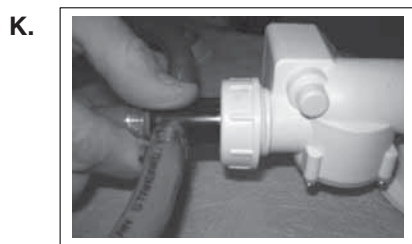
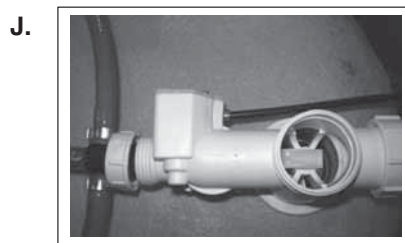
8. Have assistant take drain assembly from step 6 and place over back surface of drain hole to engage the metal strainer bolt. Secure plastic drain base to metal strainer in drain opening using nut driver shaft. **DO NOT OVER TIGHTEN!** Carefully remove excess silicone from acrylic surface as directed by silicone sealant directions.
9. From unit back side, overflow nut should be in alignment with overflow opening, as shown in photo **F**.



10. Slide air bath fitting nut, washer and gasket onto air bath fitting as shown in photos **G** and **H**.



11. Assemble air bath fitting to plastic drain base as shown in photos **I**, **J**, **K** and **L**. Hand tighten nut to create watertight joint.



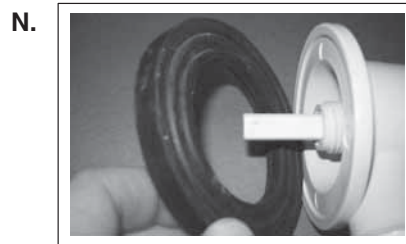
12. Apply PVC cement to **Horizontal Drain Pipe** PVC and assemble to 90 degree elbow.

**DRAIN CONNECTION** *continued...*

13. Disassemble overflow wedge gasket and chrome overflow retainer as shown in photo **M**.



14. Place overflow wedge gasket onto plastic overflow pipe flange with round raised rib surface contacting flange as shown in photo **N**.



15. Tighten chrome overflow retainer onto drain overflow assembly pipe per photo **O**.

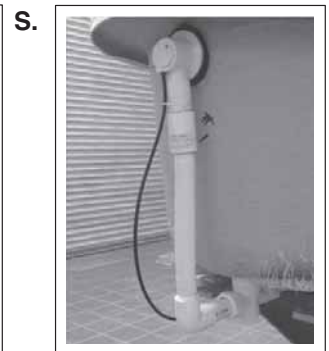
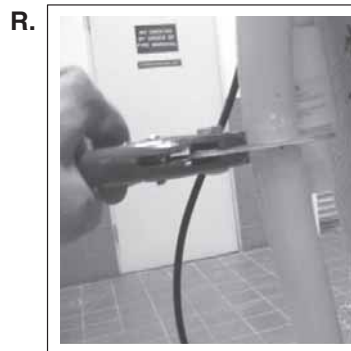
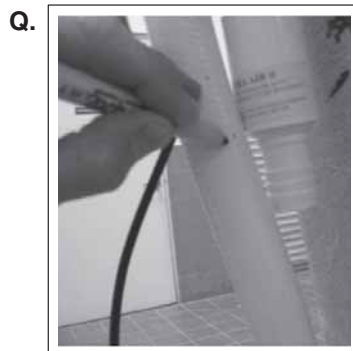
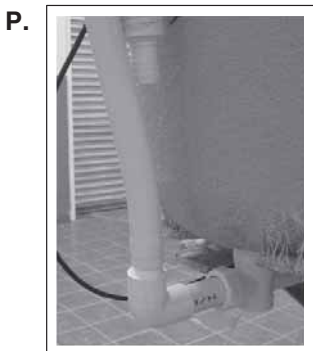


16. Apply PVC cement to barbed end of 90 degree elbow and insert vertical flex hose over barbs as shown in photo **P**.

17. Align vertical flex hose end of piping with top of barbed fitting located on the overflow fitting and mark the flex hose to be trimmed as shown in photo **Q**.

18. Cut off excess vertical flex hose as shown in photo **R**.

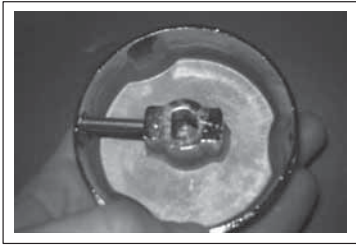
19. Attach vertical flex hose to barbed fitting on overflow fitting by preheating tubing and/or soaping barbed fitting with dish soap as shown in photo **S**.



## DRAIN CONNECTION *continued...*

20. Align flat on drain actuator shaft with corresponding flat in chrome metal overflow escutcheon and tighten set screw to fix overflow escutcheon in place per photos **T** and **U**.

**T.**



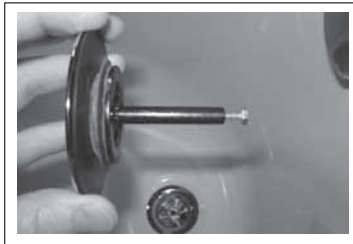
**U.**



21. Rotate left and right lightly to feel stops in drain cable control. This opens and closes drain.

22. Place drain stopper into drain waste hole as shown in photo **V**.

**V.**



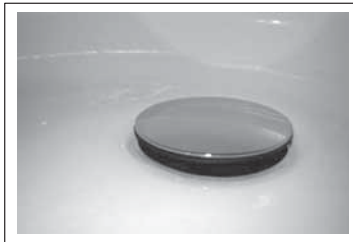
23. The drain stopper should prevent water from draining out of tub when the escutcheon is in the fully counterclockwise position as shown in photo **W**. Adjust the drainstopper bolt to obtain the best water seal in the tub.

**W.**



24. Rotate Drain Escutcheon to clockwise stop. This should open drain, between 1/8" (3mm) and 1/4" (6mm), to allow water to exit bath. If not adjust metal bolt in drain stopper to allow draining function, but not so high that drain will not seal when closed to hold water during use. See photo **X**.

**X.**



## **POST INSTALLATION CLEAN-UP**

Remove all construction debris from bath. Tile grout can be removed with a wooden Popsicle stick or tongue depressor. Do not use wire brushes or any other metal implement on bath surface.

Post installation clean-up generally can be completed using warm water and liquid dishwashing detergent. Stubborn dirt or stains may be removed using granular Spic and Span® mixed with water.

Painter's naphtha can be used to remove excess adhesives and/or wet oil-base paint.

## **AFTERCARE and CLEANING**

- The high gloss surface is resistant to impact and chemicals and will retain its lasting luster with proper care and maintenance.
- Always fill the tub with temperate water. Excessively hot water may cause surface damage
- Clean after use with a mild liquid household detergent cleaner. Do not use Lestoil, Lysol Disinfectant (spray or concentrate), or Lysol Basin, Tub and Tile Cleaner, Windex, Mr. Clean, Dow Disinfectant Bathroom Cleaner, or cleaning products in aerosol cans.

## **HARSH CHEMICALS SHOULD NEVER BE USED ON ACRYLIC SURFACES.**

- Do not use wire brushes, knives or sharp objects to remove stains, cigarette tar deposits, or other surface blemishes.
- Abrasive cleaners or powders must not be used, since they will dull the surface. If the glossy surface loses its sheen, dulled areas can be restored by rubbing with a white "automotive type" polishing compound and waxing with a "liquid wax."
- **Do not wax areas where you walk or stand.**
- Do not allow nail polish remover, acetone, dry cleaning fluid, paint remover or other solvents to come into contact with the surface.
- Clean the surrounding surface immediately after using caustic drain cleaners.
- Burning cigarettes will damage the surface.
- Should damage to the fixture occur, repairs can be made quickly and easily. Your distributor or builder can provide details.
- Do not permit drain cleaner to enter the circulation system.

# Operation: Bath with Lights

## BATHING:

- Close drain by rotating Drain Overflow Knob COUNTER-CLOCKWISE.
- Fill bath with water at a comfortable bathing temperature, adding bath oils or salts as desired.

## OPERATING CHROMATHERAPY



DISPLAY COLORS	
1 <sup>ST</sup>	WHITE
2 <sup>ND</sup>	SLOW RAINBOW CYCLE
3 <sup>RD</sup>	FAST RAINBOW CYCLE
4 <sup>TH</sup>	TURQUOISE
5 <sup>TH</sup>	BLUE
6 <sup>TH</sup>	MAGENTA
7 <sup>TH</sup>	RED
8 <sup>TH</sup>	ORANGE
9 <sup>TH</sup>	YELLOW
10 <sup>TH</sup>	GREEN
11 <sup>TH</sup>	RETURN TO SLOW RAINBOW CYCLE



- **CYCLE**• To turn on Chromatherapy lights, press light button once. The cycle will start on white.
- Turn off and on within 3 seconds; it will change to slow rainbow cycle and so on per the display color table shown above.

## Enjoy the Ultimate Air Massage System

When you look at a new Porcher air bath, all you'll see is a smooth and comfortable interior surface. There are no bulky jet covers to sit on, and no hard-to-clean crevices. That's because we've incorporated new "illusion" air jets directly into the bottom of each tub. Each air jet is a tiny hole that's entirely flush with the bottom of the tub. You won't find an air bath system that's more comfortable or easier to clean than ours.



Unlike some manufacturers, we don't just provide bubbles around the perimeter of the tub. We placed our bubble jets throughout the entire bottom of the tub so you're not only surrounded, you're entirely immersed in the bubble experience. We then developed a loop-back air system that balances the air pressure for smooth and even performance throughout the bath.

Designed to make sure nothing comes between you and the relaxation you crave, we've made every effort to eliminate all distractions. For starters, we use air blowers that are whisper quiet. All you'll hear is the insistent bursting of thousands of tiny bubbles. We also incorporated a built-in air heater that warms each and every bubble. No matter how long you enjoy your air massage, the water will always stay warm and comforting.

### EVERCLEAN™ SYSTEM

Our goal is to deliver the cleanest, most hygienic air bath system on the market. So we started with a state-of-the-art, self-cleaning system and enhanced it with EverClean. The EverClean antimicrobial system incorporates AlphaSan®, a patented antimicrobial agent manufactured right into the air lines, which suppresses the growth of unsightly algae, fungus, mold and mildew. EverClean helps keep your air system clean and fresh.

When not being used for bathing, all of our air jets are self-draining through the included bath drain. This eliminates standing water in the air lines that can lead to mold and mildew growth. It also avoids the need for check-valves that can fail over time, resulting in clogged jets or water-filled air lines.

### AUTOMATIC PURGE

Finally, to make sure the system is sparkling clean between uses, the blower will turn-on automatically after each use to purge the lines of any remaining water.



### ULTIMATE CONTROL

We know that some days it takes more work than others to achieve that peaceful calm. That's why our air blowers have four speeds ranging from gentle to invigorating. Simply select the appropriate button on our electronic backlit control panel. And if you can't decide which one to use, just choose the wave function for a continuous cycle that both stimulates and relaxes.

### OPTIONAL CHROMATHERAPY

To further enhance your quest for inner peace, our air baths are also offered with optional chromatherapy. Using the electronic control panel, you can select from a range of underwater light colors that match your mood, or let the system continuously cycle through the colors and feel your tensions melt away.



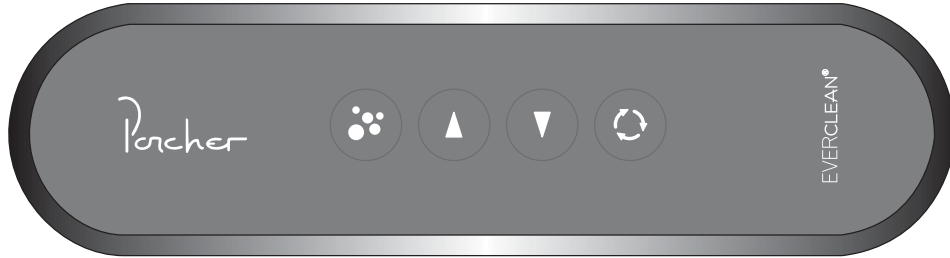
AlphaSan® is a registered trademark of Milliken & Co.




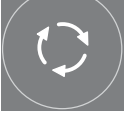
# Operation: Air Bath

## BATHING:

- Close drain by rotating Drain Overflow Knob COUNTER-CLOCKWISE
- Fill bath with water at a comfortable bathing temperature, adding bath oils or salts as desired.

## OPERATING AIR MASSAGE SYSTEM:



	<b>ON/OFF:</b> Press this button once to turn air-blower on. Press again to turn air-blower off.
	<b>AIR SPEED INCREASE:</b> Pressing this button will increase to the next higher speed.
	<b>AIR SPEED DECREASE:</b> Pressing this button will decrease to the next lower speed.
	<b>WAVE FUNCTION:</b> Press this button to start the wave function (button will light). Blower speed will continuously vary between high and low. Press again to exit wave function (button light will go out).

## EXITING THE BATH:

- Be sure to turn off the air-blower before draining bath.
- Open drain by rotating Drain Overflow Knob CLOCKWISE.

## DRYING CYCLE OPTIONS

### STANDARD DRYING CYCLE

An automatic drying cycle will start 20 minutes after the blower is turned off. The blower LED blinks while waiting for the purger cycle.

### 24H PROGRAMMABLE DRYING CYCLE

The system must be stopped prior to activation or deactivation.

Activation: Determine at which time you wish the purge to activate. At that precise time, press and hold the second button on the keypad for 5 seconds, all LEDs will flash twice to confirm activation. The purge cycle will now start at the programmed time every 24 hours. In the event of a power failure, the program will be automatically deactivated.

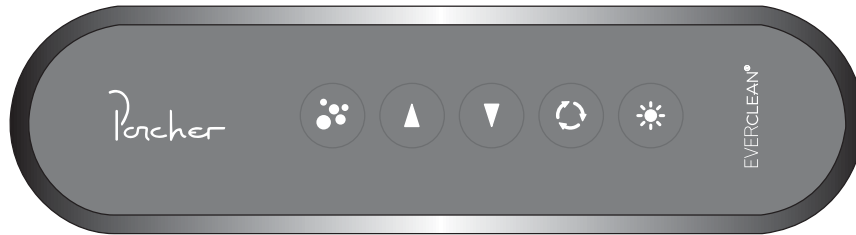
Deactivation: Press and hold the second button on the keypad for 5 seconds, all LEDs will flash once to confirm deactivation.





# Operation: Air Bath with Lights

## BATHING:


- Close drain by rotating Drain Overflow Knob COUNTER-CLOCKWISE
- Fill bath with water at a comfortable bathing temperature, adding bath oils or salts as desired.

## OPERATING AIR MASSAGE AND CHROMATHERAPY SYSTEM:



	<b>ON/OFF:</b> Press this button once to turn air-blower on. Press again to turn air-blower off.
	<b>AIR SPEED INCREASE:</b> Pressing this button will increase to the next higher speed.
	<b>AIR SPEED DECREASE:</b> Pressing this button will decrease to the next lower speed.
	<b>WAVE FUNCTION:</b> Press this button to start the wave function (button will light). Blower speed will continuously vary between high and low. Press again to exit wave function (button light will go out).

DISPLAY COLORS	
1 <sup>ST</sup>	WHITE
2 <sup>ND</sup>	SLOW RAINBOW CYCLE
3 <sup>TH</sup>	FAST RAINBOW CYCLE
4 <sup>TH</sup>	TURQUOISE
5 <sup>TH</sup>	BLUE
6 <sup>TH</sup>	MAGENTA
7 <sup>TH</sup>	RED
8 <sup>TH</sup>	ORANGE
9 <sup>TH</sup>	YELLOW
10 <sup>TH</sup>	GREEN
11 <sup>TH</sup>	RETURN TO SLOW RAINBOW CYCLE

	<ul style="list-style-type: none"> <li>• To turn on Chromatherapy lights, press light button once. The cycle will start on white.</li> <li>• Turn off and on within 3 seconds; it will change to slow rainbow cycle and so on per the display color table shown above.</li> </ul>
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# Operation: Air Bath with Lights (continued)

## EXITING THE BATH:

- Be sure to turn off the air-blower before draining bath.
- Open drain by rotating Drain Overflow Knob CLOCKWISE.

## DRYING CYCLE OPTIONS

### STANDARD DRYING CYCLE

An automatic drying cycle will start 20 minutes after the blower is turned off. The blower LED blinks while waiting for the purger cycle.

### 24H PRO PROGRAMMABLE DRYING CYCLE

The system must be stopped prior to activation or deactivation.

Activation: Determine at which time you wish the purge to activate. At that precise time, press and hold the second button on the keypad for 5 seconds, all LEDs will flash twice to confirm activation. The purge cycle will now start at the programmed time every 24 hours. In the event of a power failure, the program will be automatically deactivated.

Deactivation: Press and hold the second button on the keypad for 5 seconds, all LEDs will flash once to confirm deactivation.

Your Porcher air bath is designed to give you many years of pleasure with reasonable care and maintenance.

Your new acrylic bathtub is tough, durable and easy to care for. The colors have been formulated to match other Porcher fixtures and enhance your choice of bathroom decorations. The high gloss surface will retain its lasting luster with proper care and maintenance.

#### **CLEANING AND MAINTENANCE:**

- Always fill the tub with temperate water. Excessively hot water (greater than 130° F) may cause surface damage.
- Remove bath mat after use and hang to dry. Allowing bath mat to dry in the tub may cause surface damage.
- Clean after use with a mild liquid household detergent cleaner. Do not turn on jets when such cleaners are present.

**Do not use:** Lestoil® Cleaner; Lysol® Disinfectant (spray or concentrate); or Lysol® Basin, Tub and Tile Cleaner; Windex® Cleaner; Mr. Clean® Cleaner; Dow® Disinfectant Bathroom Cleaner\*; or other cleaning products in aerosol cans.

#### **HARSH CHEMICALS, SHARP AND ABRASIVE OBJECTS SHOULD NEVER BE USED ON ACRYLIC SURFACES**

- Do not use wire brushes, knives or sharp objects to remove stains or other surface blemishes.
- Use of abrasive cleaners or powders will dull the surface. If the glossy surface loses its sheen, dulled areas can be partially restored by rubbing with a white automotive body polishing compound and waxing with a liquid wax.  
**Do not wax surfaces where you walk or stand.**
- Do not allow nail polish remover, acetone, dry-cleaning fluid, paint remover, or other solvents to come into contact with the surface.
- Clean the surrounding surface immediately after using caustic drain cleaners.  
**Do not permit drain cleaner to enter circulation system.**
- Burning cigarettes will irreparably damage the surface of the whirlpool.

#### **CLEANING/PURGING THE AIR SYSTEM**

Once every month the air system must be purged and cleaned. Follow the steps outlined below:

1. Fill air bath with warm water and add two teaspoons of powdered automatic dishwasher (not laundry) detergent and one-half cup of household bleach to filled air bath.
2. Activate air system in accordance with operating instructions and run system for two minutes.
3. Drain and refill with cold water. Circulate for five minutes.
4. Drain completely after step 3 (above) is completed.

For Troubleshooting and Repair Parts please log on to [www.porcher-us.com](http://www.porcher-us.com)

\* Lestoil® is a registered trademark of The Clorox Company.  
Lysol® is a registered trademark of The Linden Company.  
Windex® is a registered trademark of S.C. Johnson and Son, Inc.  
Mr. Clean® is a registered trademark of The Proctor and Gamble Company.  
Dow® is a registered trademark of The Dow Chemical Company.

## Porcher Limited Lifetime Warranty for Premium Acrylic Air Baths and Suites

Porcher warrants to the original consumer purchaser that it will, at its option, repair or replace this whirlpool or any of its parts that are found by Porcher, in its sole judgment, to be defective under normal residential use and maintenance so long as it is owned by the original consumer purchaser.

This warranty shall only become effective upon receipt by Porcher of a completely filled out Warranty Registration Card evidencing proof of purchase. Warranty begins on date of purchase (regardless of installation date).

This limited warranty does not apply to commercial, multi-family or rental installations.

THIS WARRANTY SHALL BE VOID IF THE ACCESS PANEL TO THE WHIRLPOOL IS COVERED IN ANY MANNER CONTRARY TO THE INSTALLATION INSTRUCTIONS. In no event will Porcher be liable for the cost of repair or replacement of any installation materials including but not limited to tiles, marble etc.

This limited warranty DOES NOT COVER the following:

1. Defects or damages arising from shipping, installation, alterations, accidents, abuse, misuse, lack of proper maintenance and cleaning as directed in the owner's manual and use of other than genuine Porcher replacement parts, in all cases whether caused by a plumbing contractor, service company, the owner or any other person.
2. Deterioration through normal wear and tear and the expense of normal maintenance.
3. Commercial application. (Hotel, multi-family dwelling, rental property, etc.)
4. Options and accessories. Porcher's limited warranty on these items is one year for parts only and excludes labor. This one year limited warranty covers accessories manufactured by Porcher (e.g. aprons, drains, grab bars, heaters, trim kits) against defects of material or workmanship. Warranty coverage begins on the date the accessory was originally purchased by the owner.
5. Postage or shipping costs for returning products for repairs or replacement under this limited warranty and labor or other costs incurred in connection with product removal or installation under this limited warranty.
6. ANY LIABILITY FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES, ALL OF WHICH ARE HEREBY EXPRESSLY DISCLAIMED, OR THE EXTENSION BEYOND THE DURATION OF THIS LIMITED WARRANTY OF ANY IMPLIED WARRANTIES, INCLUDING THOSE OF MERCHANTABILITY OR FITNESS FOR AN INTENDED PURPOSE. (Some jurisdictions do not allow limitations on how long an implied warranty lasts, or the exclusion or limitation of incidental or consequential damages, so these limitations and exclusions may not apply to you.)
7. Responsibility for compliance with local code requirements. (Since local code requirements vary greatly distributors, retailers, dealers, installation contractors and users of plumbing products should determine whether there are any code restrictions on the installation or use of a specific product.)

This warranty gives you specific legal rights. You may have other legal rights that vary from state to state. For service under this warranty, you should contact the following:

**In the United States:**

Porcher  
P.O. Box 6820  
Piscataway, N.J. 08855  
Attention: Director of Consumer Affairs

For residents of the United States, warranty information may be obtained by calling the following toll free number: (800) 359-3261

[www.porcher-us.com](http://www.porcher-us.com)

**In Canada:**

Porcher  
5900 Avebury Ave.  
Mississauga, Ontario  
Canada L5R 3M3

Toll Free: (800) 387-0369

[www.porcher.ca](http://www.porcher.ca)

**In Mexico:**

Porcher  
Planta Santa Clara  
Via Morelos #330  
Santa Clara Coatitla  
Ecatepec de Morelos 55540  
Estado de Mexico, Mexico