WASHaLOT 3.0
Production and Quality Assurance

Instruction video available on YouTube:
www.youtube.com/watch?v=Sob9-NxkOBQ&t=2s
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INTRODUCTION

Handwashing with soap is one of the most effective interventions to prevent infectious diseases. If children adopt regular hygiene behaviour at an early age, they are healthier and less prone to be infected with diseases.

Access to functional and clean group washing facilities in schools allow for WASH activities for a larger number of children at various times throughout the day. Group washing facilities, which need to be water-saving, are designed to enable both group handwashing and individual handwashing. Based on this there is a demand for durable and scalable infrastructure which are long-lasting, low cost and can be mass produced which will facilitate personal hygiene for children in schools. The facility should be pre-fabricated to ensure quality and efficiency to a certain standard.

Pre-fabrication should be done in the respective country or the region, depending on locally available materials, proximity to schools and transportation options as well as location of a technically equipped producer, capable of adhering to certain production quality standards. In addition, pre-fabricated facilities help schools to prevent ‘re-inventing the wheel’, making use of lessons learnt from many places around the world and applying the latest knowledge.

WASHALOT 3.0 MAIN ELEMENTS

Cover → Main pipe → Pipe water connector → Water inlet

Water outlets / stainless nipple feeders

Detachable legs →

FURTHER INFORMATION:

// Factsheet WASHaLOT 3.0 – Group Washing Facility
www.bit.ly/2vwFYnz

// Technology Applicability Framework – TAF Assessment
WASHaLOT 3.0
www.bit.ly/2FvuyqA

STUDY

WASHaLOT 3.0
Group Washing Facility

Handwashing with soap is the single most effective way to prevent infectious diseases. Regular handwashing, specifically after using the toilet and before eating should be part of a daily routine in everyone’s life. Schools, kindergardens, day care centers, hospitals, bus-stations, canteens are public places, where handwashing should be made possible for many people at the same time.

TECHNICAL DETAILS

Dimensions:
length 300cm

Materials used:
HDPE Pipe (Outside Diameter 110mm or 125mm), Stainless Steel Outlets

Number of Outlets:
10

CONTACT

Deutsche Gesellschaft für Internationale Zusammenarbeit (GIZ) GmbH
Sector Programme Sustainable Sanitation
sanitation@giz.de

Regional Fit for School Programme
fitforschool#giz.de

www.fitforschool.international
www.susana.org

sustainable sanitation alliance

70 - 80 cm
120 cm
MATERIALS REQUIRED

<table>
<thead>
<tr>
<th>ITEM</th>
<th>QUANTITY</th>
<th>UNIT</th>
</tr>
</thead>
<tbody>
<tr>
<td>HDPE blue pipe 110 mm SDR 17</td>
<td>320</td>
<td>cm</td>
</tr>
<tr>
<td>1/2&quot; stainless nipple feeder (with strainer)</td>
<td>12*</td>
<td>pcs</td>
</tr>
<tr>
<td>Polyethylene 1/2&quot; adaptor (threaded male, no thread female)</td>
<td>1</td>
<td>pc</td>
</tr>
<tr>
<td>1/2&quot; teflon tape</td>
<td>3</td>
<td>roll</td>
</tr>
<tr>
<td>Black HDPE plate 11 cm x 17 cm x 0.6 cm</td>
<td>2</td>
<td>pcs</td>
</tr>
<tr>
<td>5/32&quot; x 1/2&quot; rivets for the hinge</td>
<td>8</td>
<td>pcs</td>
</tr>
<tr>
<td>No 10 (4.8 mm) x 1/2&quot; stainless screw</td>
<td>6</td>
<td>pcs</td>
</tr>
<tr>
<td>Stainless hinge 5 cm x 3 cm</td>
<td>2</td>
<td>pcs</td>
</tr>
<tr>
<td>1/8&quot; (4.7 mm) x 2&quot; flat bar</td>
<td>130</td>
<td>cm</td>
</tr>
<tr>
<td>1/8&quot; (4.7 mm) x 1/2&quot; flat bar</td>
<td>20</td>
<td>cm</td>
</tr>
<tr>
<td>2&quot; flag triple barrel hinge</td>
<td>3</td>
<td>pcs</td>
</tr>
<tr>
<td>8 mm round bar</td>
<td>60</td>
<td>cm</td>
</tr>
<tr>
<td>1 1/4&quot; schedule 20 GI pipe</td>
<td>360</td>
<td>cm</td>
</tr>
<tr>
<td>Steel welding rods</td>
<td>2</td>
<td>pcs</td>
</tr>
</tbody>
</table>

The following list are the materials required to produce one unit of WASHaLOT 3.0. During material canvassing and sampling make sure that materials are the right materials. This bill of materials reflects the supplies available in the Philippines. If certain materials are not available or only in different unit of measurement or colors, the local producer needs to update this list to the local context.

TIPS

HDPE pipe // SDR 17 HDPE pipe should have a wall thickness of 7.0 mm ± 0.4 mm (min. 6.6 mm and max. 7.4 mm only). Use a caliper to measure the wall thickness of the HDPE pipe.

Stainless nipple feeders // For the stainless nipple feeders, use a magnet to see if it is stainless or just chrome plated. Place the magnet at least half a centimeter apart from the object, if the object is not attracted to it you have a stainless object and if the object is attracted then you might have a nipple feeder which is just chrome plated.

* 10 to be used during production and 2 for spare for schools
## TOOLS AND EQUIPMENT NEEDED

<table>
<thead>
<tr>
<th>ITEM</th>
<th>ITEM</th>
</tr>
</thead>
<tbody>
<tr>
<td>HDPE pipe welding mirror</td>
<td>Electric cutting/grinding machine // cutting and grinding disc should be for stainless steel</td>
</tr>
<tr>
<td>Steel welding machine</td>
<td>Hand tap // M20 x 1.5 or 1/2–14 NPT</td>
</tr>
<tr>
<td>Cut-off saw</td>
<td>Riveter</td>
</tr>
<tr>
<td>Bending table</td>
<td>Protractor</td>
</tr>
<tr>
<td>Drill press // 18 mm or 45/64 inch diameter drill bit to drill holes on the main pipe</td>
<td>Screw driver</td>
</tr>
<tr>
<td>Electric hand drill // with 5/32” or 4mm diameter drill bit to drill holes on the cover</td>
<td>Tape measure</td>
</tr>
</tbody>
</table>
PRODUCTION STEPS

**MAIN PIPE**

- Cut an HDPE pipe with a length of 280 cm.
- At both ends of the 280 cm HDPE pipe, make a cut with an angle of 70 degrees.
- Cut another two shorter HDPE pipes with a length of 20 cm each.
- At both end of the shorter HDPE pipe, cut a 70° angle cut on one side and 40° angle on the other to form the water inlet.
- Butt fuse the two shorter HDPE pipes at both ends of the longer HDPE pipe with the 70° angle cut facing each other.
- Position the newly butt fused main pipe and mark the locations indicated as “hole”. The markings in the bottom part of the main pipe should be aligned to each other and the mark at the top part is directly on the other side of the other holes.
- Using an 18 mm or 45/64 inch drill bit, drill holes on the markings. Make sure that the drill is perpendicular to the main pipe at all times.
- With a tap, make a thread in all 12 holes. Use a tap size of M20 x 1.5 for metric sizes or 1/2–14 NPT whichever is available.
DRAWING 1 // ANGLED CUT FOR THE MAIN PIPE

1. Cut line
2. Cut line
1. Cut line
2. Cut line

280 cm
280 cm
20 cm
20 cm

70°
DRAWING 2 // ANGLED CUT FOR THE SHORTER PIPE

DRAWING 3 // BUTT FUSION CONNECTION

Cut line

Butt fusion hot plate

Butt fusion water inlet to the main pipe
STAINLESS NIPPLE FEEDER (WATER OUTLETS)

- Disassemble the parts of the stainless nipple feeder. Make sure to keep all five parts not to get lost.
- With an electric cutter, cut the bottom part of the body 3.5 cm from the top part of the thread.
- After cutting, grind the cut part to remove sharp edges.
- Assemble back the parts of the nipple feeder to the body. Be sure that parts are arranged in the right sequence as before it was disassembled.

Test the nipple feeder // Modified nipple feeders must be subjected to a simple pressure test. Attach the modified nipple feeder into a water source with a 1/2" coupling that serves as socket for the nipple feeder. Open the valve and check for leaks.
DRAWING 5 // PARTS AND MODIFICATION OF NIPPLE FEEDER

a) Disassembling

b) Cutting & grinding

1. Lock w/ strainer
2. Spring
3. Lever / pin
4. Rubber O-ring
5. Body

Cut line: 3.5 cm

C) Reassembling
WATER INLET COVER

- Prepare a black 6 mm thick HDPE plate with dimensions of 17 cm x 11 cm.

- Cut the corners of the plate to form an elliptical shaped plate.

- From the elliptical plate, cut it horizontally 3.5 cm from the top. The cut should be made slanted at 50–60 degrees angle. The slant cut is to avoid sun light getting into the pipe thus minimizing algae accumulation.

- Position the hinge in the plate. Using a drill bit size of 5/32" or 4 mm, drill the holes for the rivets to anchor. Make sure that clearance between the slant cut should not exceed 1.5 mm.

- Fix the hinge using rivets to the drilled holes to form the cover.
Drill holes using 5/32” or 4 mm drill bit
5/32” x 1/2” rivets

Clearance should not exceed 1.5 mm
50°–60°
→ Position the fabricated cover into the water inlet. Using a drill bit size of 5/32", drill holes on the location marked in drawing 7.

→ Fix the fabricated cover to the water inlet with three No. 10 x 1/2" screws as showed in drawing 8. Leave the hole at the other end of the cover open to serve as a lock hole.

→ Apply a teflon tape to 10 modified stainless nipple feeders and screw into the holes indicated in drawing 8 (water outlets)

→ Apply Teflon to the polyethylene adaptor and screw it at the location marked “pipe water connector”.

TEST THE ASSEMBLED WASHaLOT 3.0 // Test with water to check for leaks. Every finished WASHaLOT 3.0 should be leak tested.
**DRAWING 7 // WATER INLET COVER INSTALLATION**

- Drill holes using 5/32" or 4 mm drill bit
- NO. 10 x 1/2" screw
- Lock hole

**DRAWING 8 // PARTS AND DIMENSIONS OF WASHALOT 3.0**

- Cover
- Main pipe
- Pipe water connector
- Water inlet
- Water outlets / modified nipple feeders

Dimensions:
- 280 cm
- 20 cm
- 30 cm
- 30 cm
- 30 cm
- 30 cm
- 30 cm
- 30 cm
- 30 cm
- 30 cm
- 5 cm
- 5 cm
DETACHABLE LEGS

→ Cut three pcs of 1/8" x 2" flat bar each with a length of 30 cm.

→ Bend the recently cut flat bar to a U-shape to form the pipe holder, follow the profile of the main pipe for the curvature of the bend.

→ At one end of the pipe holder, weld a hinge. At the other side, weld the half part of the lock holder. The lock holder is a 1/8" x 1/2" flat bar with a length of 2.5 cm. Do not forget to drill a hole on the lock holder enough for common locks to go through.

→ At the bottom part of each pipe holder, weld a 1 1/4" Schedule 20 GI pipe with a length of 120 cm to form the legs. Make sure that the leg is directly below of the pipe holder.

→ Cut another three pcs of 1/8" x 2" flat bar each with a length of 11 cm.

→ Weld hinges on both ends of the flat bar to form the press.

→ Cut three pcs of 8 mm round bar each with a length of 18 cm.

→ At one end of the 8 mm round bar cut, measure and put a mark at the 12.5 cm point.

→ At the mark, bend the shorter end of the 8 mm round bar with an angle of 45 degrees to form the handle.

→ Same with that of the pipe holder, weld the other half of the lock holder. Cut a 1/8" x 1/2" flat bar with a length of 2.5 cm. Drill the same hole as that of the one welded to the pipe holder.

→ Assemble the parts with the pin of the barrel hinges. Grind welded parts and sharp edges when finishing the assembly.

→ Apply a base paint into the detachable legs to prevent it from rusting.
DRAWING 9 // DETACHABLE MECHANISM FOR THE LEGS

Barrel hinge
Press
(1/8" x 2" flat bar)
Welded leg
(1 1/4" Sc. 20 Gl pipe)
Pipe Holder
(1/8" x 2" flat bar)
Lock holder
(1/8" x 1/2" flat bar)
Handle
(8 mm iron rod)
**DRAWING 10 // DIMENSION AND DETAILS, PIPE HOLDER**

- Welded barrel hinge
- Radius of bend = 6 cm

**DRAWING 11 // DIMENSION AND DETAILS, PRESS**

- Welded barrel hinge
- 11 cm
- 12 cm
**DRAWING 12 // DIMENSION AND DETAILS, HANDLE**

Welded barrel hinge

- 5 cm
- 12 cm
- 45°
- 4 cm
- 2.5 cm
# CHECKLIST // WASHaLOT 3.0 QUALITY ASSURANCE

This QA form should be used to document quality checking of 10 units of WASHaLOT 3.0 at a time. Every 10 units of WASHaLOT 3.0 should have one QA form. All Units of WASHaLOT 3.0 should have a documented quality checking.

<table>
<thead>
<tr>
<th>DATE PRODUCED MM/DD/YYYY</th>
<th>DATE CHECKED MM/DD/YYYY</th>
</tr>
</thead>
</table>

Check corresponding item under each ID no.

<table>
<thead>
<tr>
<th>ID No.</th>
<th>ID No.</th>
<th>ID No.</th>
<th>ID No.</th>
<th>ID No.</th>
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<th>ID No.</th>
<th>ID No.</th>
<th>ID No.</th>
</tr>
</thead>
</table>

## INSTALLED PARTS

1. 10 water outlets installed
2. Black HDPE plate installed
3. Pipe water connector
4. Drilled lock hole in the cover

## MATERIAL QUALITY

1. Non-magnetic water outlets
2. 6.8 mm HDPE pipe thickness (± 0.3 mm)

## CRAFTSMENSHIP

1. Slanted cut for the cover
2. All water outlets are aligned
3. Clean butt fuse connection
4. Water outlets can’t be turned by hand

## LEAK FREE TEST

1. All water outlets are leak free
2. Leak free butt-fuse connection

## LEGS

1. Main pipe fits to the pipe holder
2. Smooth swinging of the press and handle
3. Painted detachable legs

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**COMPANY / PRODUCER'S NAME**

**QUALITY INSPECTOR // PRINTED NAME & SIGNATURE**

**COMPANY MANAGER // PRINTED NAME & SIGNATURE**

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Prepare an original copy of this signed QA form to be submitted to the buyer/purchaser.
CHECKLIST // NOTES AND INSTRUCTIONS

b  Visually check the part indicated if properly fixed into the main pipe of the WASHaLOT 3.0.

c  Using a magnet, check if all water outlets (modified nipple feeder) installed are stainless. The water outlet should not be attracted to the magnet when placed half a centimeter away.

d  The inspector should have a caliper. Using the caliper, measure the wall thickness of the pipe. The thickness of the pipe should be 7.0 mm ± 0.4 mm.

e  Check the cut of the elliptical plate. The clearance between of the plate should not exceed 1/16 of an inch and the cut should be slanted as indicated in drawing 7.

f  Try turning all installed water outlets. If the outlets can still be turned by hand it can cause leaking. If this is the case, remove the water outlet and add more teflon tape onto the thread of the modified nipple feeder.

g  Try turning all installed water outlets. If the outlets can still be turned by hand it can cause leaking. If this is the case, remove the water outlet and add more teflon tape onto the thread of the modified nipple feeder.

h  Try fitting a sample of the HDPE pipe to ALL detachable legs especially the pipe holder part.

j  ALL detachable legs should have a base paint to avoid rusting.