

BULLBOX

20'HC

TECHNICAL SPEC. BULLBOX

STEEL DRY

CARGO CONTAINER

BULLBOX 20'HC 20' x 8' x 9'6"

MODELO NO: BULLBOX 20' HC STANDARD

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1.1 General

This specification will cover the design, construction, materials, testing and inspection performances of 20'x8'x9'6" type steel dry cargo containers.

These containers specified herein will be manufactured by Contenedores y Embalajes Normalizados, S.A (hereinafter referred to BULLBOX) under strict quality control by BULLBOX and be **approved by the classification society** (Bureau Veritas, China Classification Society, Lloyd's Register of Shipping, American Bureau of Shipping...)

The container will be designed and constructed for carriage of general cargo by marine (on or below deck), road and rail throughout the world. All materials used in the construction will be to withstand extremes of temperature range from -40°C(-40F) to +70°C(+158°F) without effect on the strength of the basic structure and watertightness.

The container will satisfy the following requirements and regulations, unless otherwise mentioned in this specification.

ISO Container Standards ISO 668. ISO 830 ISO 1161. ISO 1496-1. ISO 6346

T.I.R. Certification : All the containers will be certified and complied with "The Customs Convention on the International Transport of Goods under the cover of T.I.R. Carnets." or "The Customs Convention on Containers."

C.S.C. Certification : All the containers will be certified and complied with the requirements of the "International Convention for the Safe Containers."

T.C.T. Certification: All exposed wooden components used for container will be treated to comply with the requirements of "Cargo Containers-Quarantine Aspects and Procedures" of the Commonwealth Department of Health, Australia

 **1.2 Handling and transportation**

The container will be constructed to be capable of being handled without any permanent deformation under the following conditions:

- a) Lifting, full or empty, at top corner fittings vertically by means of spreaders fitted with hooks, shackles or twistlocks.
- b) Lifting, full or empty, at bottom corner fittings using slings with terminal fittings at any angles between vertical and 45 degrees to the horizontal.
- c) Lifting, full or empty, at forklift pockets using forklift truck.

The container will be constructed to be suitable for transportation in the following modes:

- a) Marine: In the ship cell guides of vessels, seven (7) high stacked.
On the deck of vessels, four (4) high stacked and secured by vertical and diagonal wire lashings.
- b) Road: On flat bed or skeletal chassis, secured by twistlocks or equivalent at the bottom corner fittings.
- c) Rail: On flat cars or special container cars secured by twistlocks or equivalent at the bottom corner fittings.


2. Dimensions and ratings
External

Length	6,058 + 0 mm	19' 10 1/2"+0
	-6 mm	- 1/4"
Width	2,438 + 0 mm	8' + 0
	-5 mm	- 3/16"
Height	2,896 + 0 mm	9' 6" + 0
	-5 mm	- 3/16"

Internal

Length	5,898 mm	19' 4 3/16"
Width	2,352 mm	7' 8 38/64"
Height	2,698 mm	8' 10 14/64"

Door opening dimensions

Width	2,340 + 0 mm	7' 8 1/8" + 0
	-5 mm	- 3/16"
Height	2,280 + 0 mm	8' 5 3/4" + 0
	-5 mm	- 3/16"

Internal cubic capacity (nominal)

37.4 cu.m	1,322 cu.ft
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Forklift pockets

Width	360 mm
Height min	115 mm
Center to center	2,080 mm + / -50 mm

Ratings

Max. Gross Weight (R)	30,480 kgs	67,200 lbs
Tare Weight (design) (T)	2,100 kgs	4,630 lbs
Max. Payload (P)	28,380 kgs	65,570 lbs


3. Materials

The following materials will be used in the construction of containers:


3.1 Part specification

Parts	Materials
1) All steel except screws, rivets, bolts/nuts, door hardwares and other shown on drawings and specification	Anti-corrosive steel. SPA-Hor equivalent Y.P. : 35 kg/ mm ² T.S. : 49 kg/ mm ²
2) Rear corner posts (inner)	Rolled high tensile Steel SM50A Y.P. : 33 kg/mm ² T.S. : 50 kg/mm ²
3) Door hinges	S25C Y.P.: 27kg/mm ² T.S.: 45 kg/mm ²
4) Door locking bars	Structural Steel round pipe STK41 Y.P. : 24 kg/mm ² T.S. : 41 kg/mm ²
5) Corner fittings	Casted weldable steel SCW49 Y.P. : 28 kg/mm ² T.S. : 49 kg/mm ²
6) Locking gear cams and keepers	S20C Y.P. : 25 kg/mm ² T.S. : 41 kg/mm ²
7) Door hinge pins	Stainless steel
8) Door gasket	EPDM
9) Floor board	Hardwood plywood
10) Ventilator	ABS resin labyrinth type

* Note : Y.P. - Yielding Point
T.S. - Tensile Strength



4.1 Construction

The container will be constructed with steel frames, fully vertical-corrugated steel sides and front wall, horizontal-corrugated steel double doors at rear end, diestamped steel roof and corner fittings.

All welds of exterior including the base frames will be continuous welding using CO₂ gas.

Interior welds - when needed - will be stitched with a minimum length of 15 mm.

Gaps between adjacent components to be welded will not exceed 3 mm or the thickness of the parts being welded.

Chloroprene sealant is to be applied at periphery of floor surface and inside unwelded seams, butyl sealant is used to caulk at invisible seam of floor joint area and between door gasket and frame.

The internal bend radii of pressed sections of steel will be not less than 1.5 time the thickness of the materials being pressed.

The wooden floor will be fixed to the base frames by zinc plated self-tapping screws.



4.2 Protrusion

The plane formed by the lower faces of all transverse members shall be positioned by 12.5 mm +5/-1.5 mm above the plane formed by the lower faces of the bottom corner fittings.

The top corner fittings are to protrude 6 mm above the highest point of the roof.

The outside faces of the corner fittings will protrude from the outside faces of the corner posts and nominal 4 mm.

The outside faces of the corner fittings will protrude from the outside faces of the sides and front wall by nominal 8 mm

Under maximum payload, no part of the container will protrude below the plane formed by the lower faces of the bottom corner fittings at the time of maximum deflection.

Under 1.8 x maximum gross weight, no part of the container will protrude more than 6.0 mm below the plane formed by the lower faces of the bottom corner fittings at the time of maximum deflection.

 **4.3 Corner Fittings**

The corner fittings will be designed in accordance with ISO 1161 (1984 edition) and manufactured at the works approved by classification society.

 **4.4 Base Frame structure**

Base frame will be composed of two bottom side rails, eighteen cross members, and a set of forklift pockets.

Each bottom side rail is built of a 155x52x30x28x4.5 mm thick cold formed double "Z" section steel made in one piece.

The lower flange of the bottom side rail is outward so as to facilitate easy removal of the cross members during repair and of less susceptible corrosion.

Reinforcement plates to be made of 4.0 mm thick flat steel is welded to bottom corner fitting.

The cross members are made of pressed channel section steel with a dimension of 45x122x45x3.5 mm for the normal areas and 75x122x45x4.0 mm for the floor butt joints. The large one is reinforced by three 4.0 mm thick gussets.

The cross members are placed fully to withstand floor strength and welded to each bottom side rail.

Each forklift pocket is built of 3.0 mm thick full depth flat steel top plate and two 200 mm deep x 6.0 mm thick flat lower end plates between two channel section cross members.

The upper flange and web area above each forklift pocket is reinforced by 460x4.0 mm thick angle plate.

The one set of forklift pockets is designed in accordance with ISO. Requirements

 **4.5 Flooring**

The floor will consist of six pieces plywood boards, floor center rail, and self-tapping screws.

The wooden/bamboo floor to be constructed with 28 mm thick hardwood plywood boards are laid longitudinally on the transverse members between the 4.0 mm thick flat bar floor center rail to the bottom side rails.

The floor boards are tightly secured to each transverse member by self-tapping screws, and all butt joint areas and peripheries of the floor boards are caulked with sealant.

1) Wood species: Apitong or Hardwood.

2) Glue : Phenol-formaldehyde resin.

3) Treatment:

a) Preservative: Meganium or equivalent.

In accordance with Australian Health Department Regulations.

b) Average moisture content will be 14% before installation.

Each floor board is fixed to the transverse members by zinc plated self-tapping screws that are 8.0 mm dia. shank x 16 mm dia. head x 45 mm length, and fastened by four screws per cross member but five screws at joint areas.

Screw heads are to be countersunk with about 2 mm below the floor top surface.

4.6 Rear frame structure

The rear frame will be composed of one door sill, two corner posts, one door header and four corner fittings, which will be welded together to make the door-way.

The door sill to be made of a 4.5 mm thick pressed open section steel is reinforced by four internal gussets at the back of each locking cam keeper location.

The upper face of the door sill has a 10 mm slope for better drainage. There is cut out at each end of the door sill and reinforced by a 200x75x9.0 mm channel steel as a protection against handling equipment damages.

Each rear corner post of hollow section is fabricated with 6.0 mm thick pressed steel outer part and 40x113x12 mm thick hot rolled channel section steel inner part, which are welded continuously together to ensure a maximum width of the door opening and to give a sufficient strength against stacking and racking forces. Four (4) sets of hinge pin lugs are welded to each rear corner post.

The door header is constructed with a 4.0 mm thick pressed "U" section steel lower part having four internal gussets at the back of each locking cam keeper location and a 3.0 mm thick pressed steel upper part, which are formed into box section by continuous welding.

4.7 Door

Each container will have double wing doors at each end frame, and each door will be capable of swinging approximately 270 degrees.

Each door is constructed with two 3.0 mm thick pressed channel section steel horizontal frames for the top and bottom, two 100x50x3.2 mm thick rectangular hollow section vertical frames for the post and center side of door, 1.6 mm thick horizontally corrugations steel door panel, which are continuously welded within frames.

Two sets of galvanized locking assemblies with forged steel handles are fitted to each door using high tensile zinc plated steel bolts and Huck bolts according to TIR requirements. Locking bar retainers are fitted with nylon bushings at the top, bottom and intermediate bracket.

Locking gears should be assembled after painting of the container. Locking gears should be assembled after painting of container.

The left hand door can not be opened without opening the right hand door when the container is sealed in accordance with TIR requirements.

The door hold-back of nylon rope is provided to the center locking bar on each door and a hook of steel bar is welded to each bottom side rail.

Each door is suspended by four hinges being provided with stainless steel pins, self-lubricating nylon bushings and the stainless steel washers. which are placed at the hinge lugs of the corner posts.

The door gasket to be made of an extruded double lip type (J- type for top & side, C-type for bottom) EPDM rubber is installed to the door peripheral frames with stainless steel gasket retainers which must

be caulked with butyl sealant before installation of gasket, and fastened by stainless steel rivets at a pitch of 150 mm.

4.8 Roof Structure

The roof will be constructed with five five-corrugated (die-stamped) steel panels and four corner protection plates.

The roof panel is constructed with 1.6 mm thick die-stamped steel sheets having about 5.0 mm upward smooth camber, which are welded together to form one panel and continuously welded to the top side rails and top end rails. All overlapped joints of inside unwelded seams are caulked with chloroprene sealant.

Each corner of the roof in the vicinity of top corner fitting is reinforced by 3.0 mm thick rectangular steel plate to prevent the damage caused by the mishandling of lifting equipment.

4.9 Top side rail

Each top side rail is made of a 60x60x3.0 mm thick square hollow section steel.

4.10 Side Wall

The trapezium section side wall is constructed with 1.6 mm thick fully vertically continuous-corrugated steel outer panels near the each post and 1.6 mm thick intermediate inner panels, which are butt welded together to form one panel and continuously welded to the side rails and corner posts

4.11 Front structure

Front end structure will be composed of one bottom end rail, two corner posts, one top end rail, four corner fittings and an end wall, which are welded together

The bottom end rail to be made of a 4.0 mm thick pressed open section steel is reinforced by three internal gussets. There is cut out at each end of the rail and is reinforced by a 200x75x9.0 mm channel steel, as the protection against handling damages.

Each corner post is made of 6.0 mm thick pressed open section steel in a single piece, and designed to give a sufficient strength against stacking and racking forces.

The top end rail is constructed with a 3.5 mm thick "Z" shaped pressing steel plate. The trapezium section front wall is constructed with 1.6 mm thick vertically corrugated steel panels, butt welded together to form one panel, and continuously welded to front end rails and corner posts.



4.12 Special feature

Customs seal and padlock provisions are made on each locking handle retainer to cover the sealed area in accordance with TIR requirements.

Five (5) lashing hoop rings are welded to each top and bottom side rail at recessed corrugations of side panels but not extruded any cargo space (total 20 rings).

Each lashing point is designed to provide a "1,500 kgs test pull load in any direction" without any permanent deformation of lashing ring and surrounding area.

Three (3) lashing rods are welded to each corner post at the position of 200 mm from the bottom surface of top corner fitting and top surface of bottom corner fitting and middle of corner post.

Each lashing rod on the corner post is designed to provide a "1,000 kgs test pull load in any direction" without any permanent deformation.

A shoring slot, having a size of 60 mm width x 40 mm depth is provided on each rear corner post so that 2 1/4" thick battens can be arranged to be able to prevent doors from damage due to shifting cargo.

Each container will have two labyrinth type small plastic ventilators. Each ventilator is fixed to right hand upper part of side wall by three 5.0 mm dia.

Stainless steel Huck bolts after drying of top coating, and caulked with sealant around the entire periphery except underside to prevent the leakage of water.

 **5.1 Surface preparation**

1) All steel surfaces - prior to forming or after - will be fully abrasive shot blasted conforming to Swedish Standard SA 2 1/2 to remove all rust, dirt, mill scale and all other foreign materials.

The shot blasted surface profile shall be have a maximum peak to valley height not exceeding 50 microns and average peak to valley height of about 25 microns.

2) All door hardwires will be hot-dipping zinc galvanized with approximately 75 microns thickness.

3) All fasteners such as self-tapping screws and bolts, nuts, hinges, cam keepers and lashing fittings will be electro-galvanized with approximately 13 microns thickness.

 **5.2 Coating**

Prior to assembly

All steel surfaces will be coated with 10 microns thick two-pack polyamide cured zinc rich epoxy primer immediately after shot blasting, and then dried up in drying room.

After assembly


All weldments will be shot blasted to remove all welding fluxes, splatters, burnt primer coatings caused by welding heat, and other foreign materials. Then all blasted weldments will be coated with zinc rich epoxy primer

The total dry film will be (microns):

All surface of the assembled container will be have coating system as follows:

	Exterior	Interior	Under structure
Zinc rich primer	10	10	10
W/B Zinc rich primer	20	20	20
W/B Epoxi primer	40		
W/B Acrilic top coating	40		
W/B Epoxi topcoat		50	
Bitumen			190
Total	110	80	220

*Epoxy zinc rich primer and pure epoxy are not applied to the wooden/bamboo floor.

 **6. Marking**

The containers will be marked in accordance with ISO, TCT, UIC, CSC and TIR requirements, owner's marking specifications and other required regulations.

Materials

- 1) Decal : - Self-adhesive, high tensile PVC film for seven (7) years guarantee without peeling off, tenting or color fading.
- 2) Certification plate : Stainless steel plates to be chemically etched by acid.

Specifications

- 1) Identification plates such as consolidated data plate consisting of CSC, TIR and TCT will be riveted on the door permanently by stainless steel blind rivets. The entire periphery except underside will be caulked with sealant.
- 2) The owner's serial numbers and manufacturer's serial numbers will be stamped on top face of the bottom corner fitting.


7. Testing

The prototype container manufactured in accordance with this specification will be tested by manufacturer under the supervision of classification society.

<i>Test & loads</i>	<i>Test methods</i>
a) Stacking Internal load : 1.8R-T Test load : 86,400 kg/post.	Hydraulic cylinder load will be applied to each corner post through top corner fittings. Offset : 25.4 mm lateral38.0 mm longitudinal Time duration : 5 minutes
b) Lifting (from top corner fitting) Internal load : 2R-T	Lifting vertically. Time duration : 5 minutes
c) Lifting (from bottom corner fittings) Internal load : 2R-T	Lifting 45 deg. to the horizontal. Time duration : 5 minutes
d) Lifting (for forklift pockets) Internal load : 1.6R-T	Lifting by horizontal bars. Bar length : 1,828 mm Bar width : 200 mm Time duration : 5 minutes
E) Restraint (longitudinal) Internal load : R-T Test load : 2R	Hydraulic cylinder load will be applied to the bottom side rails. Two times for pulling and pushing. Time duration : 5 minutes
F) Floor strength. Test load : 5,460 kgs (12,000 lbs)	Use of a special truck. Total contact area : 284 cm ² Wheel width : 180 mm Wheel center : 760 mm
G) Wall strength (front) Test load : 0.4(R-T)=0.4P	Compressed air bag will be used. Time duration : 5 minutes
H) Wall strength (side) Test load : 0.5(R-T)=0.5P	Compressed air bag will be used on one side only. Time duration : 5 minutes
I) Wall strength (door) Test load : 0.4(R-T)=0.4P	Same as front wall strength test.
J) Roof strength (weakest part) Test load : 300 kg	Applied area will be 600x300 mm longitudinal and transverse.

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<p>K) Racking (transverse)</p> <p>Test load : 15,240 kg</p>	<p>Hydraulic cylinder load will be applied to the header rail through top corner fittings. Two times for pulling and pushing.</p> <p>Time duration : 5 minutes</p>
<p>L) Racking (longitudinal)</p> <p>Test load : 7,620 kg</p>	<p>Hydraulic cylinder load will be applied to the top side rail through top corner fitting on one side only. Two times for pulling and pushing.</p> <p>Time duration : 5 minutes</p>
<p>M) Operation of door</p>	<p>After completion of test, the operation of doors, locks, hinges, etc. will be checked.</p>
<p>N) Dimensions and weight</p>	<p>After completion of test, the dimensions and weight will be checked.</p>
<p>O) Weatherproofness</p>	<p>Inside dia. of nozzle : 12.5mm. Distance : 1.5 m.</p> <p>Speed : 100 mm/sec . Pressure : 1 kg/cm²</p>

* Note : R - Maximum Gross Weight
T - Tare Weight
P - Maximum Payload

 **8.Guarantee****Structure**

All the containers shall be guaranteed by manufacturer to be free from defects in materials, workmanship and structure for a period of one (1) year from the date of acceptance of the container by the buyer.

Painting

The paint system coated on the container surface shall be guaranteed to be free from corrosion and failure for a period of three (3) years from the date of acceptance of the container by the buyer.

Corrosion is defined as rusting which exceeds RE3 (European Scale of degree of Rusting) on at least ten (10) percent of the total container surface, excluding that resulting from impact or abrasion damage, contact with solvents or corrosive chemicals and abnormal use.

If the corrosion exceeds RE3 as defined above within the guarantee period, inspection of the corrosion shall be carried out by the buyer, and paint manufacturer to detect the cause.

As the result of the inspection, if it is mutually agreed and accepted that the defective paint quality and/or poor workmanship have caused the corrosion and/or Paint manufacturer shall correct the defect on their accounts.

Decals

Decals applied on the container shall be guaranteed for a period of seven (7) years without peeling off, tenting or color fading if decals are supplied by factory



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