passageway and a second screen sandwiched between the first insert and the second insert along the second combined passageway.

[0013] In one or more embodiments of any of the foregoing embodiments, expanded material surfaces of the first insert and second insert form surfaces of the first combined passageway and expanded material surfaces of the first insert and second insert form surfaces of the second combined passageway.

[0014] In one or more embodiments of any of the foregoing embodiments, the system further comprises: a container body; a compartment of the container; and a refrigeration system. The refrigeration system comprises: a compressor; a first heat exchanger; an expansion device; a second heat exchanger; and a refrigerant flowpath proceeding sequentially through the compressor, first heat exchanger, expansion device, and second heat exchanger to return to the first heat exchanger; a fan positioned to drive an airflow along an air flowpath from the compartment, across the second heat exchanger and returning to the compartment.

[0015] In one or more embodiments of any of the foregoing embodiments, the container is an intermodal container and the refrigeration system is mounted at a first end of the container.

[0016] In one or more embodiments of any of the foregoing embodiments, the refrigeration system is a removeable module.

[0017] In one or more embodiments of any of the foregoing embodiments, the pre-molded expanded material insert comprises expanded bead material.

[0018] In one or more embodiments of any of the foregoing embodiments, the expanded bead material is expanded polypropylene.

[0019] In one or more embodiments of any of the foregoing embodiments, a method for manufacturing the system comprises inserting the pre-molded expanded material insert to the tub and securing the cover over the insert.

CLAIMS

1. A system comprising:

a molded tub (92A; 92B) comprising:

a base (96);

a sidewall (98) extending from the base; and

a mounting flange (94) extending from the sidewall;

a pre-molded expanded material insert (162, 164; 220, 222; 700, 702) within the tub; and

a cover (90A; 90B) over the insert.

2. The system of claim 1 forming a vent assembly wherein:

the molded tub has a first port (130A) and a second port (130B);

the insert has a first passageway in communication with the tub first port and a second passageway in communication with the second port; and

the system further comprises a rotary gate (138) mounted to rotate around a gate axis (540) between:

a closed condition blocking flow through the first passageway and the second passageway; and

an open condition allowing flow through the first passageway and the second passageway.

3. The system of claim 2 wherein the first port is an upper port and the second port is a lower port.

4. The system of claim 2 further comprising:

a gasket (122) along a rear face of the base of the tub between the first port and the second port.

5. The system of claim 2 wherein the insert is a first insert (164; 702) and the system further comprises:

a second pre-molded expanded material insert (162; 702) in the tub and having a first passageway in communication with the tub first port so that a first combined passageway passes sequentially through the second insert, first insert, and tub and a

second passageway in communication with the second port so that a second combined passageway passes sequentially through the second insert, first insert, and tub.

6. The system of claim 5 further comprising:

a first screen sandwiched (170A) between the first insert and the second insert along the first combined passageway; and

a second screen sandwiched (170B) between the first insert and the second insert along the second combined passageway.

7. The system of claim 5 wherein:

expanded material surfaces of the first insert and second insert form surfaces of the first combined passageway; and

expanded material surfaces of the first insert and second insert form surfaces of the second combined passageway.

8. The system of claim 1 further comprising:

a container body (22);

a compartment (24) of the container; and

a refrigeration system (30) comprising:

a compressor (36);

a first heat exchanger (38);

an expansion device (40);

a second heat exchanger (42); and

a refrigerant flowpath (34) proceeding sequentially through the compressor, first heat exchanger, expansion device, and second heat exchanger to return to the first heat exchanger;

a fan (52A; 52B) positioned to drive an airflow along an air flowpath from the compartment, across the second heat exchanger and returning to the compartment.

9. The system of claim 8 wherein:

the container is an intermodal container; and

the refrigeration system is mounted at a first end of the container.

10. The system of claim 9 wherein:
the refrigeration system is a removeable module.

11. The system of claim 1 wherein:
the pre-molded expanded material insert comprises expanded bead material.

12. The system of claim 11 wherein:
the expanded bead material is expanded polypropylene.

13. A method for manufacturing the system of claim 1, the method comprising:
inserting the pre-molded expanded material insert to the tub; and
securing the cover over the insert.

14. The method of claim 13 further comprising:
securing a rotary gate (138) to the cover.

15. The method of claim 13 wherein the inserting comprises:
first inserting the pre-molded expanded polypropylene insert; and
second inserting a second pre-molded expanded polypropylene insert.

16. The method of claim 15 wherein a combination of the insert and the second insert further comprises:
a first passageway through the insert and second insert;
a second passageway through the insert and second insert;
a first screen (170A) along the first passageway; and
a second screen (170B) along the second passageway.

17. The method of claim 15 further comprising:
securing the insert to the second insert after the inserting of the insert.