



Container and Seal Inspection Workshop



Supply Chain Security in a New Business Environment



Inspection Workshop

Intro

This inspection workshop is intended to help you recognize containers and seals that have been compromised for the purpose of smuggling terrorist, terrorist weapons and contraband.

The methods used within this workshop handout do not supersede company policies and procedures regarding security at the workplace.

If suspicious cargo and/or contraband is detected, immediately notify your Supervisor. If needed, contact the proper authorities and U.S. Customs & Border Protection.



1-800-Be-Alert



Supply Chain Security in a New Business Environment



Inspection Workshop

The inspection workshop will cover:

- Seal Affixing Process
- Seal Verification and Inspection Process
- 7-Point Container Inspection Process
- 17-Point Truck and Trailer Inspection Process



Supply Chain Security in a New Business Environment



Policies and Procedures...

All containers, tractors and trailers arriving at facility should have:

- Documentation verified.
- Seal number verified and inspected for tampering.
- 7-Point container inspection conducted.
- 17-Point tractor and trailer inspection conducted



7-Point Inspection



17-Point Inspection



Supply Chain Security in a New Business Environment



Policies and Procedures...

Inspection processes should be implemented at all foreign and domestic locations:

- Manufacturers
- Suppliers
- Vendors
- Sea Carriers
- Logistical Service Providers
- Distribution Centers
- Container Storage Depots
- Warehouses



*** The more locations these processes are implemented, the higher level of security your shipment will have.**



Supply Chain Security in a New Business Environment



Container Seals...

Seal Affixing Process:

- Written procedures must stipulate how seals are to be controlled and affixed to loaded containers - to include procedures for recognizing and reporting compromised seals and/or containers to U.S. Customs and Border Protection or the appropriate foreign authority.

Affix
Seal



Supply Chain Security in a New Business Environment



Container Seals...

Seal Affixing Process:

- Only designated, authorized employees must distribute and affix container seals for integrity purposes. The fewer people who have access to seal(s), the better!
- Unauthorized employees must never handle container seals!

Affix
Seal



Supply Chain Security in a New Business Environment



Container Seals...

Seal Affixing Process:

Affix
Seal

- At point of stuffing, procedures must be in place to properly seal and maintain the integrity of shipping containers.
- All seals used must meet or exceed the current PAS/ ISO 17712 standards for high security seals.
- Seals should be affixed to the right door of the container on the hasp that has the welded rivet. This practice will raise the level of security for your shipment.
- After the seal is affixed to the container, an authorized employee should make sure that the seal is secure by pulling down on it.



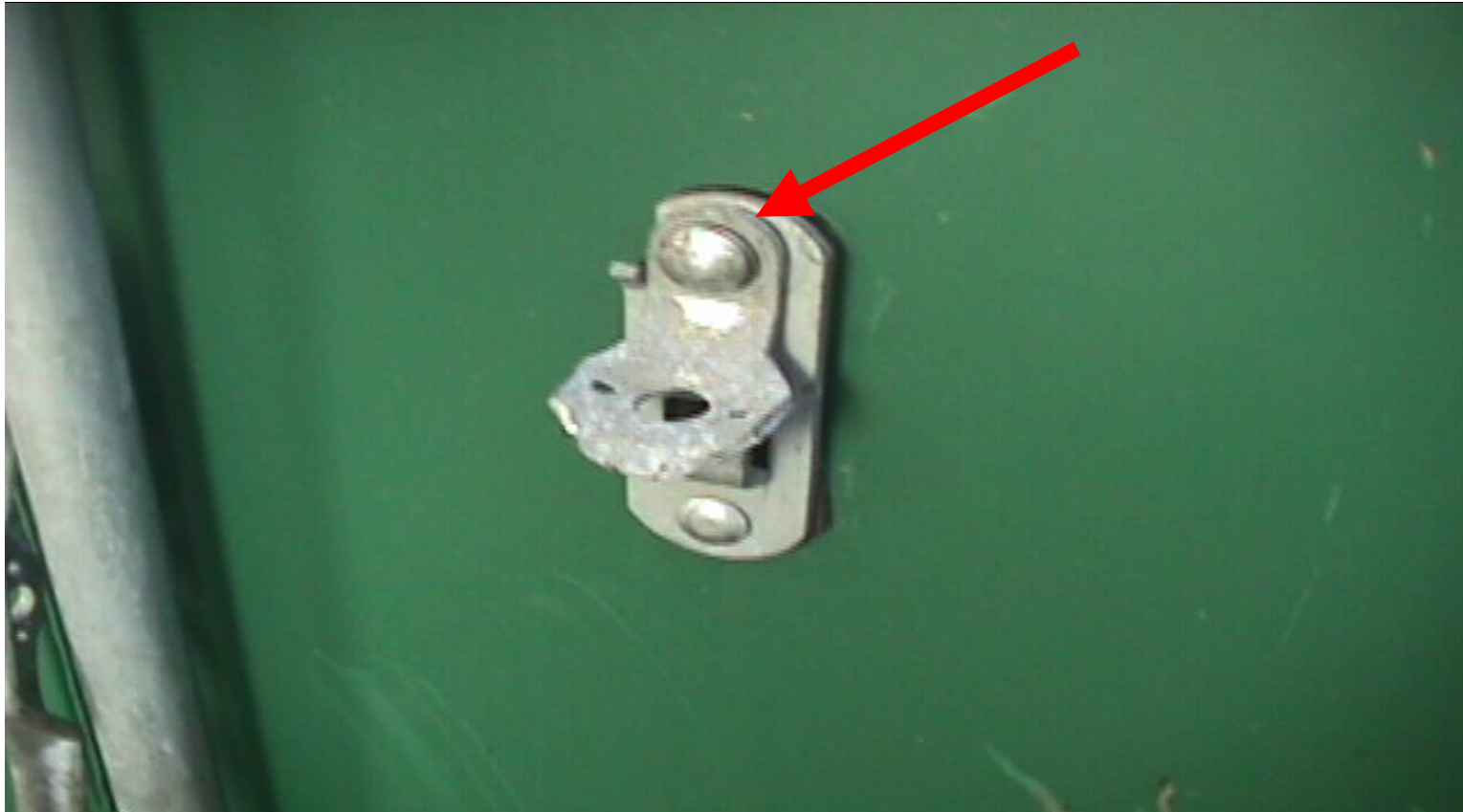
Supply Chain Security in a New Business Environment



Container Seals...

Seal Affixing Process:

Affix
Seal



Seals should be affixed to the right door
on the hasp that has the welded rivet.



Supply Chain Security in a New Business Environment



Container Seals...

Seal Affixing Process:



Verify
Seal

Make sure seal is affixed properly,
then pull down on seal.



Supply Chain Security in a New Business Environment



Seal Inspection...

Seal Verification and Inspection Process:

- A seal inspection process should be implemented throughout the supply chain. The V.V.T.T. Seal Inspection Process is a good example of one:

Verify
Seal

V – View seal & container locking mechanisms.

V – Verify seal number for accuracy.

T – Tug on seal to make sure it is affixed properly.

T – Twist & Turn seal to make sure it does not unscrew.



Supply Chain Security in a New Business Environment



Seal Inspection...

Seal Verification and Inspection Process:

- **V**iew seal & container locking mechanisms. Excessive damage to the seal or locking mechanisms must be reported to a Supervisor before opening the container.

Verify
Seal



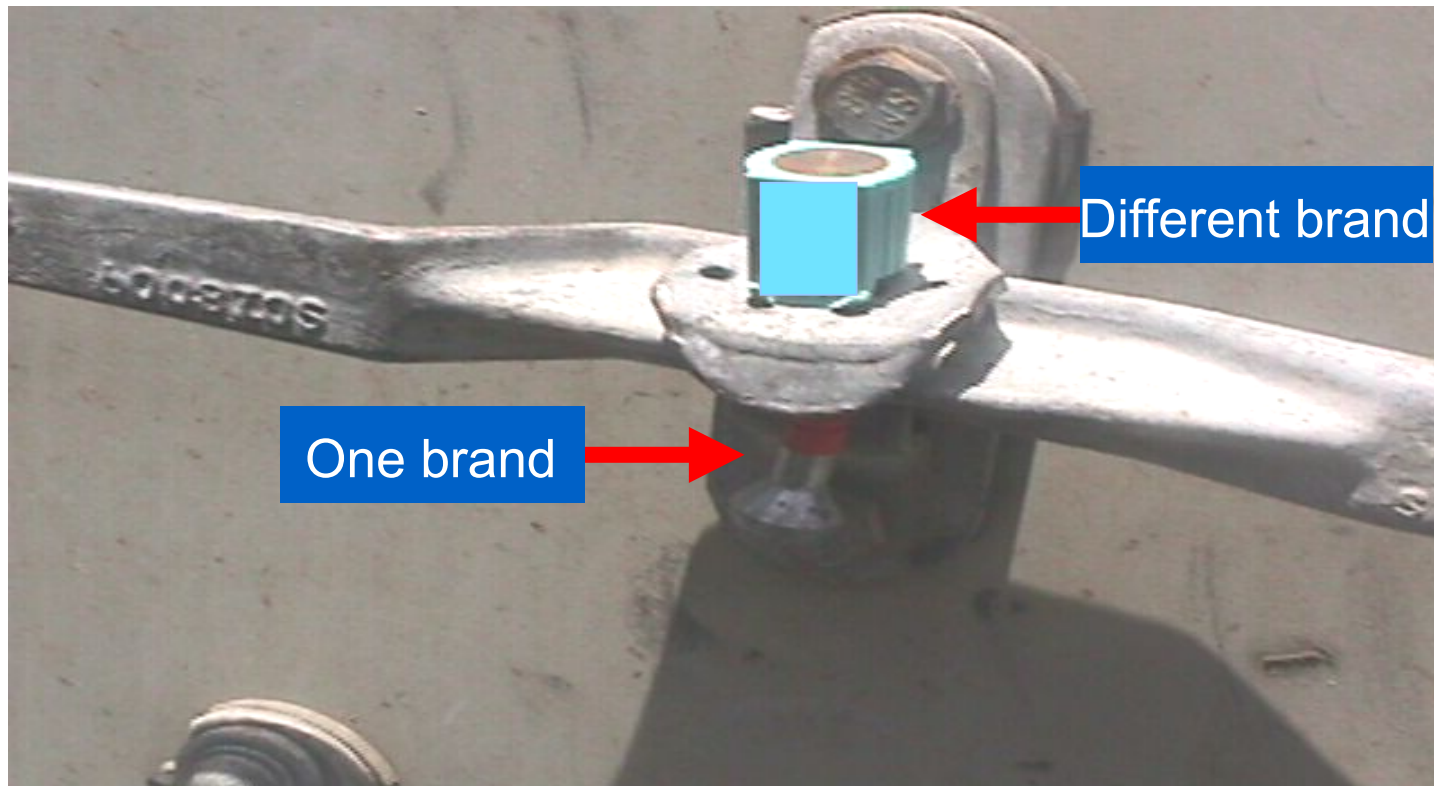
Supply Chain Security in a New Business Environment



Seal Inspection...

Seal Verification and Inspection Process:

- **V**iew seal & container locking mechanisms.



Verify
Seal

Different brands of seals attached together.



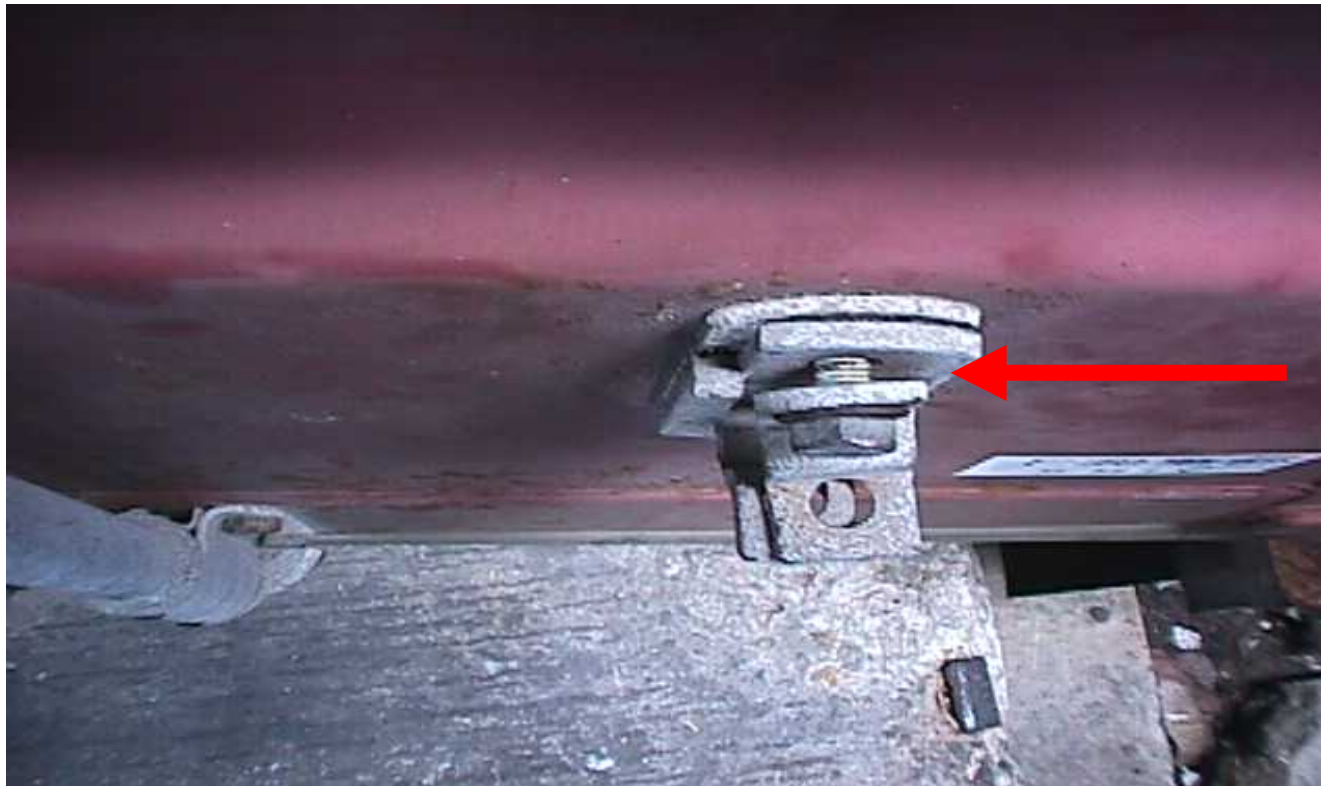
Supply Chain Security in a New Business Environment



Seal Inspection...

Seal Verification and Inspection Process:

- **V**iew seal & container locking mechanisms.



Verify
Seal

Look for loose bolt and hasp.



Supply Chain Security in a New Business Environment



Seal Inspection...

Seal Verification and Inspection Process:

- **V**erify seal number for accuracy. Compare with shipping documents, and look for alterations to the seal numbers!

Verify
Seal



Supply Chain Security in a New Business Environment



Seal Inspection...

Seal Verification and Inspection Process:

- **V**erify seal number for accuracy.

Verify
Seal



Seal number manifested is correct. Wrong seal brand normally used by company.



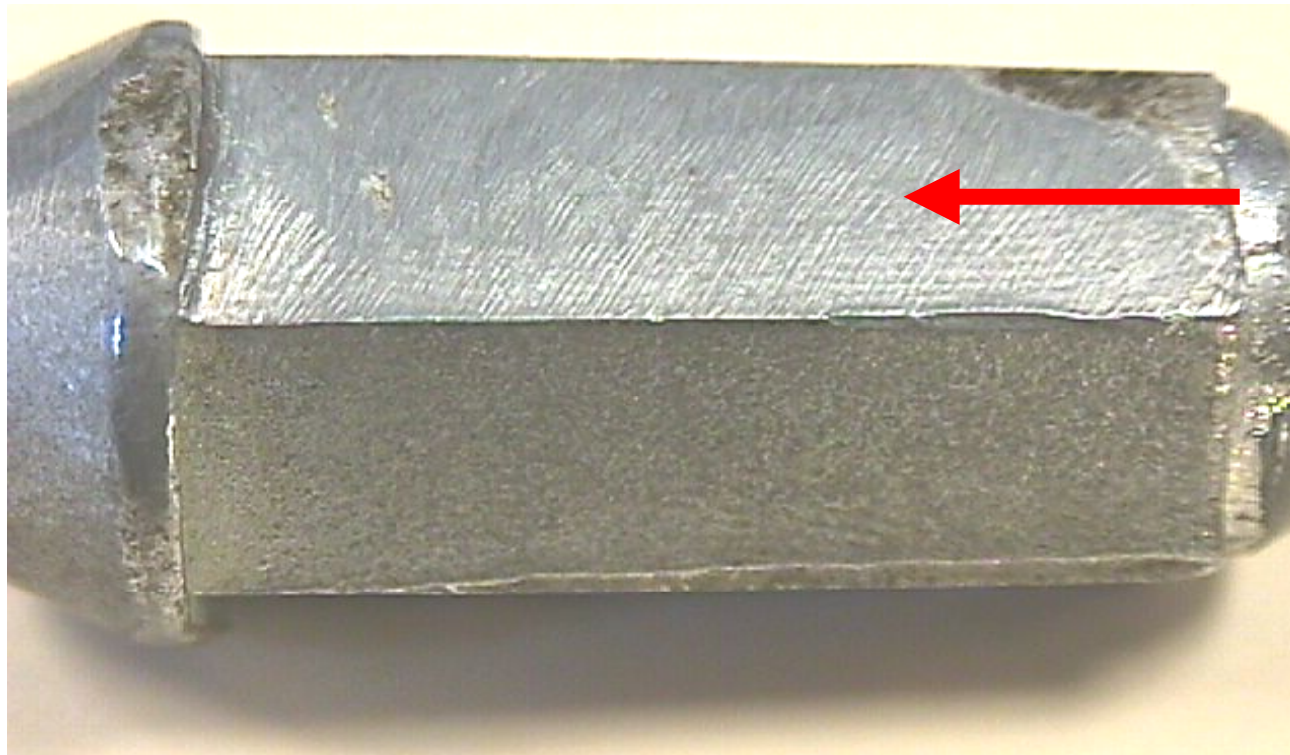
Supply Chain Security in a New Business Environment



Seal Inspection...

Seal Verification and Inspection Process:

- **V**erify seal number for accuracy.



Verify
Seal

Original number's sanded off.



Supply Chain Security in a New Business Environment



Seal Inspection...

Seal Verification and Inspection Process:

- **T**ug on seal to make sure it is affixed properly. Seals that come apart must be reported to a Supervisor before opening the container. Human error might cause this to happen, or the container might have contraband inside!

Verify
Seal



Supply Chain Security in a New Business Environment



Seal Inspection...

Seal Verification and Inspection Process:

- **T**ug on seal to make sure it is affixed properly.



Verify
Seal

Seal stem is bent. Seal does not lock properly.



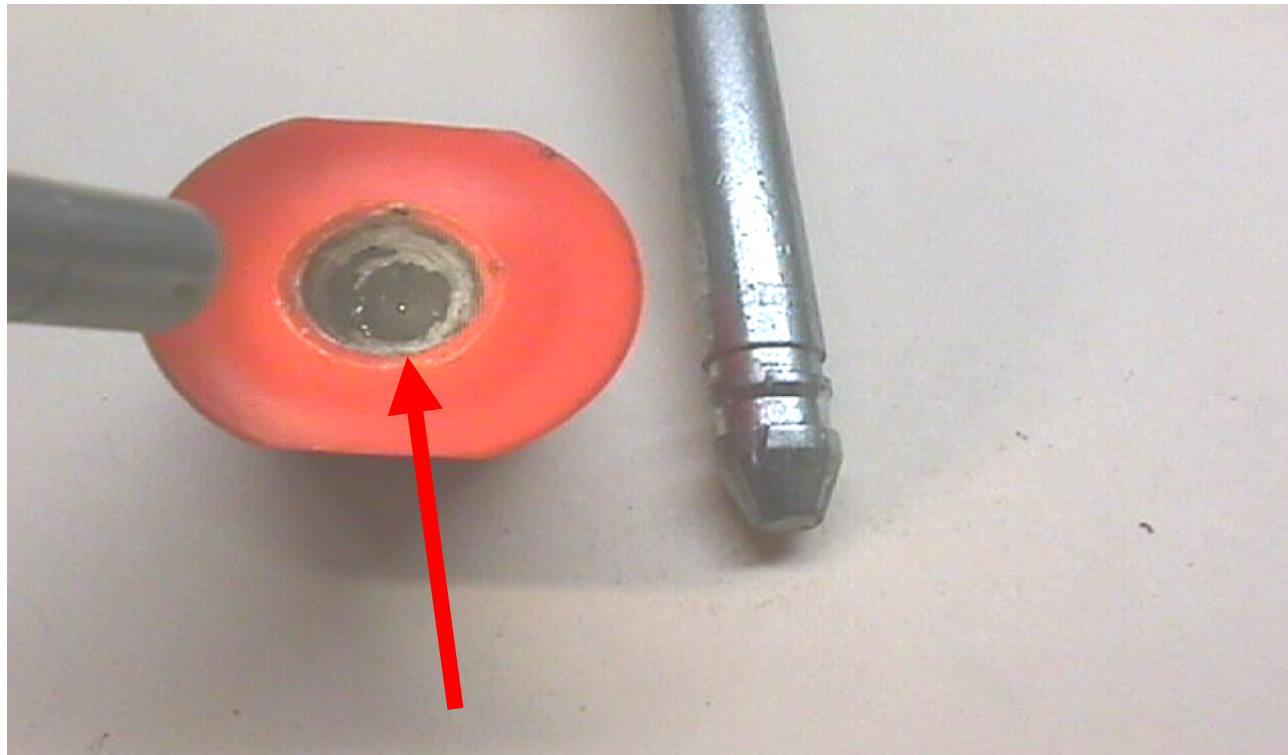
Supply Chain Security in a New Business Environment



Seal Inspection...

Seal Verification and Inspection Process:

- **T**ug on seal to make sure it is affixed properly.



Verify
Seal

Glue inside locking mechanism. Seal does not lock properly.



Supply Chain Security in a New Business Environment



Seal Inspection...

Seal Verification and Inspection Process:

- **T**wist & Turn seal to make sure it does not come off. Seals are threaded, so they can be unscrewed. These altered seals are reusable throughout the supply chain for multiple attacks!

Verify
Seal



Supply Chain Security in a New Business Environment



Seal Inspection...

Seal Verification and Inspection Process:

- **T**wist & Turn seal to make sure it does not unscrew.



Verify
Seal

Twist counter-clockwise to unscrew.



Supply Chain Security in a New Business Environment



Seal Inspection...

Seal Verification and Inspection Process:

- **T**wist & Turn seal to make sure it does not unscrew.



Verify
Seal

Multiple tampered seals.



Supply Chain Security in a New Business Environment



Container Inspection...

***Empty containers arriving at your facility might not always be empty!**



Inspect



Supply Chain Security in a New Business Environment



Container Inspection...

Ammunition/Weapons:



Inspect

155-Millimeter Howitzer Shell



Supply Chain Security in a New Business Environment



Container Inspection...

Ammunition/Weapons:



Inspect

500-LB Spent Training Missile

Supply Chain Security in a New Business Environment



Container Inspection...

Stowaways:



Inspect

32 Illegal Stowaways!

Supply Chain Security in a New Business Environment



Container Inspection...

Contraband:



Inspect

Over 3,000 lbs. of Cocaine!



Supply Chain Security in a New Business Environment

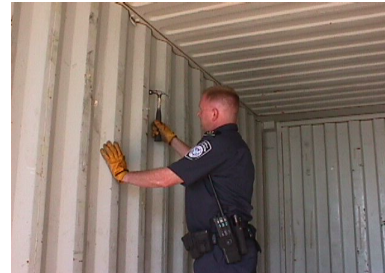


Container Inspection...

7-Point Container Inspection Process:

- Procedures must be in place to verify the physical integrity of the container structure prior to stuffing, to include the reliability of the locking mechanisms of the doors.
- A 7-point Container Inspection Process is recommended for all containers.

Inspect



Supply Chain Security in a New Business Environment



Container Inspection...

7-Point Container Inspection Process:

1. Outside/ Undercarriage (before entering facility)
2. Inside/ Outside doors
3. Right side
4. Left Side
5. Front Wall
6. Ceiling/Roof
7. Floor (Inside)



7
Point



Supply Chain Security in a New Business Environment



7-Point Container Inspection



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

1. Undercarriage:

- Inspect prior to entering facility
- Support beams should be visible



7
Point
Under



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

1. Undercarriage:



7
Point
Under

Solid plate/ Support beams not visible.



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

1. Undercarriage:



7
Point
Under

432 lbs. of cocaine!



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

2. Outside/Inside Doors:

- Secure and reliable locking mechanisms
- Look for different color bonding material
- Loose Bolts
- Plates and repairs



7
Point
Doors



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

2. Outside Doors:



7
Point
Doors

Rivet type & color/ New & old rivets together.



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

2. Outside Doors:



7
Point
Doors

Detachable or loose bolts can allow access inside container.



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

2. Inside Doors:



7
Point
Doors

Chemicals are used to make bolts look old and rusty.



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

2. Inside Doors:



7
Point
Doors

Non-factory putty keeps bolts in place.



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

2. Inside Doors:



7
Point
Doors

Solid plates should not cover standard container cavities.



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

2. Inside Doors:



7
Point
Doors

Container cavities. Five container shipment/ 837 lbs. of cocaine.



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

3 & 4. Right/Left Sides:

- Unusual repairs to structural beams.
- Repairs to the walls on the inside of the container must be visible on the outside.
- Use tool to tap side walls. Listen & feel for hollow sound!



7
Point
Sides

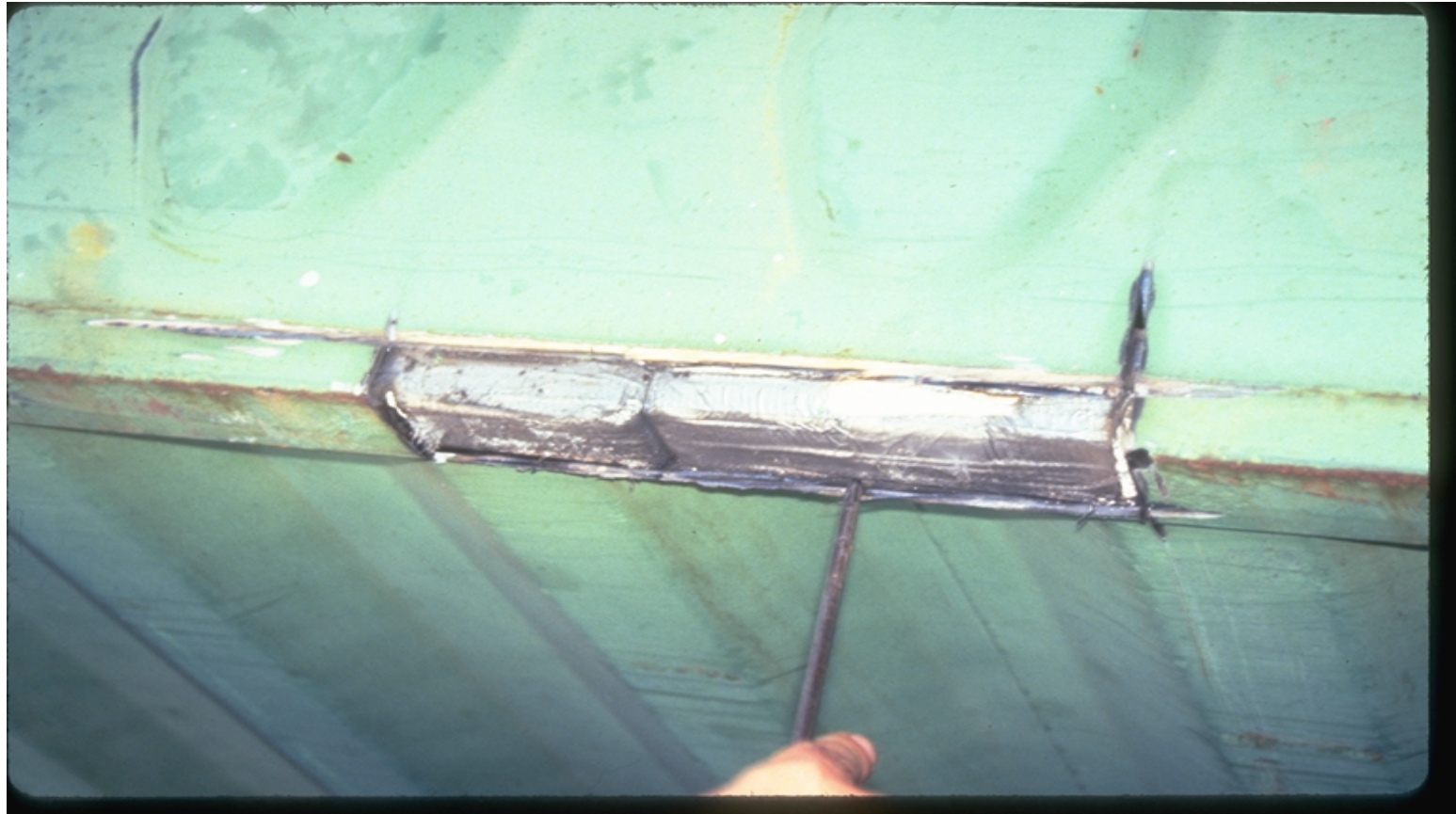


Supply Chain Security in a New Business Environment



7-Point Container Inspection...

3 & 4. Right/Left Sides:



7
Point
Sides

17 Container Shipment/ 1,275 lbs. of cocaine



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

3 & 4. Right/Left Sides:



7
Point
Sides

55 lbs. of cocaine/ One beam!



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

5. Front wall:

- Blocks and vents are visible.
- Use tool to tap front wall. Listen and feel for hollow sound!
- Range finder, measuring tape and/or string can be utilized to determine the length of container.



7
Point
Wall



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

5. Front wall:



7
Point
Wall

Use laser range finder from door opening.



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

5. Front wall:



7
Point
Wall

Normal block and air vent



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

5. Front wall:



7
Point
Wall

Short distance between block and vent. Wall colors are different!



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

5. Front wall:



7
Point
Wall

Fake block made out of cardboard!



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

5. Front wall:



7
Point
Wall

Real block concealed behind false wall.



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

5. Front wall:



7
Point
Wall

1,290 lbs. Marijuana. Range finder used.



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

6. Ceiling/ Roof:

- Ceiling is a certain height from floor. Blocks & vents are visible.
- Uncomfortable feeling inside container.
- Repairs to the ceiling on the inside of the container should be visible on the outside.
- Use tool to tap ceiling. Listen for hollow sound.



7
Point
Ceiling



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

6. Ceiling/ Roof:



7
Point
Ceiling

One row of vent holes visible.



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

6. Ceiling/ Roof:



7
Point
Ceiling

Blocks are not visible.



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

6. Ceiling/ Roof:



7
Point
Ceiling

1,200 lbs. of cocaine!



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

7. Floor:

- Floor should be a certain height from the ceiling
- Floor should be flat. Do not need to step up to get inside!
- Different floor heights
- Unusual repairs



7
Point
Floor

Supply Chain Security in a New Business Environment



7-Point Container Inspection...

7. Floor:



7
Point
Floor

Step up to get inside! Why?



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

7. Floor:



7
Point
Floor

Sloppy repairs and welding.



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

7. Floor:



7
Point
Floor

Welded steel plates/1,300 lbs. of cocaine underneath the plates!



Supply Chain Security in a New Business Environment



7-Point Container Inspection...

7. Floor:



7
Point
Floor

False compartment/ 550 lbs. of cocaine within compartment!



Supply Chain Security in a New Business Environment



Container Inspection...

17-Point Tractor & Trailer Inspection Process:

- Procedures should be in place to verify the physical integrity of the trailer structure prior to stuffing, to include the reliability of the locking mechanisms of the doors.
- Border crossing tractors & trailers should be inspected upon arrival at the domestic facility.
- A 17-point Tractor & Trailer Inspection Process is recommended for all trucks and trailers arriving from foreign.



Northern Border



Southern Border

17
Point



Supply Chain Security in a New Business Environment



17-Point Tractor & Trailer Inspection

- | | |
|------------------------------|----------------------------|
| 1. Bumper | 10. Outside/ Undercarriage |
| 2. Engine | 11. Floor |
| 3. Tires (truck & trailer) | 12. Inside/ Outside Doors |
| 4. Floor | 13. Side Walls |
| 5. Fuel Tanks | 14. Ceiling/ Roof |
| 6. Cab/ Storage Compartments | 15. Front Wall |
| 7. Air Tanks | 16. Refrigerated Unit |
| 8. Drive Shafts | 17. Exhaust |
| 9. Fifth Wheel | |



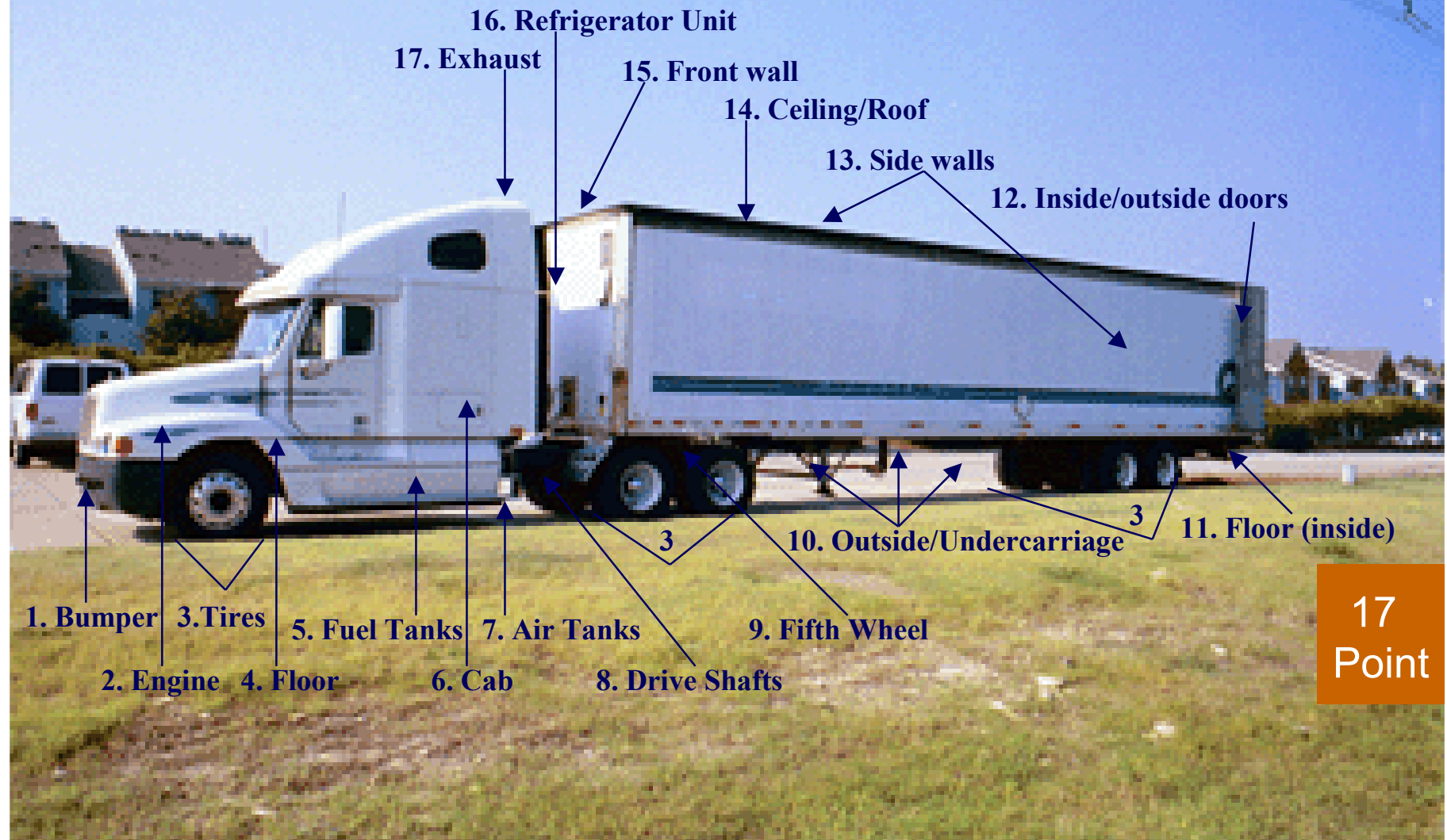
17
Point

17-Point Tractor & Trailer Inspection

Supply Chain Security in a New Business Environment



17-Point Tractor & Trailer Inspection



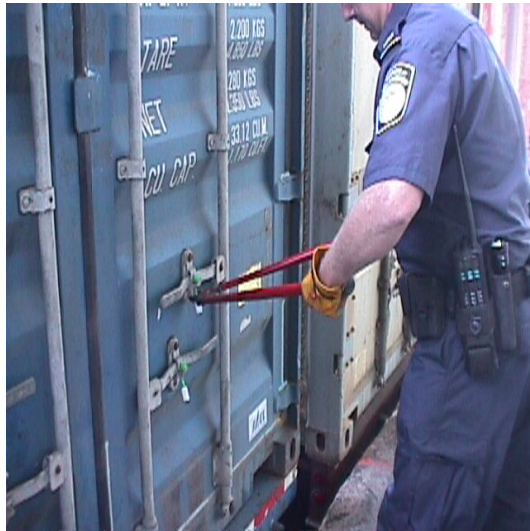
Supply Chain Security in a New Business Environment



Container Inspection...

Seal Verification and Inspection Process:

- After seal(s), container, tractor and trailer pass all inspections, the container/trailer doors can be opened. Seals should be kept for investigative purposes!



Verify



Supply Chain Security in a New Business Environment



Container Inspection...

Inspection of Cargo:

- A cursory inspection of cargo should be conducted when container/trailer doors are opened.
- If contraband is encountered, close container/trailer doors and contact a Supervisor. The Supervisor will contact the proper authorities and CBP.
- Overages or shortages of cargo should be documented and recorded. These records may be needed to conduct future investigations!



Verify



Supply Chain Security in a New Business Environment