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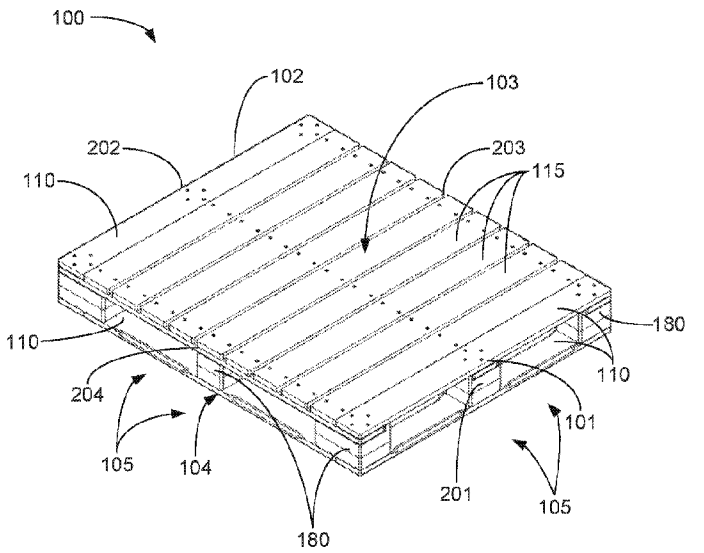
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(54) Title: COMPOSITE PALLET



(57) Abrégé/Abstract:
A pallet (100) may include a base layer (125), an intermediate layer (145), two or more support blocks (180), and a top layer (165). The support blocks may be removably attached to the base layer and the intermediate layer such that the support blocks are positioned between the base layer and the intermediate layer. The base layer may include two or more base members (120), the intermediate layer may include two or more intermediate members (140) and the top layer may include two top outside members (160), which all may be described as structural members (110). The structural members may include two or more ribs, may include fiber dispersed in a thermoplastic material, and may include a continuous fiber bundle within each rib.

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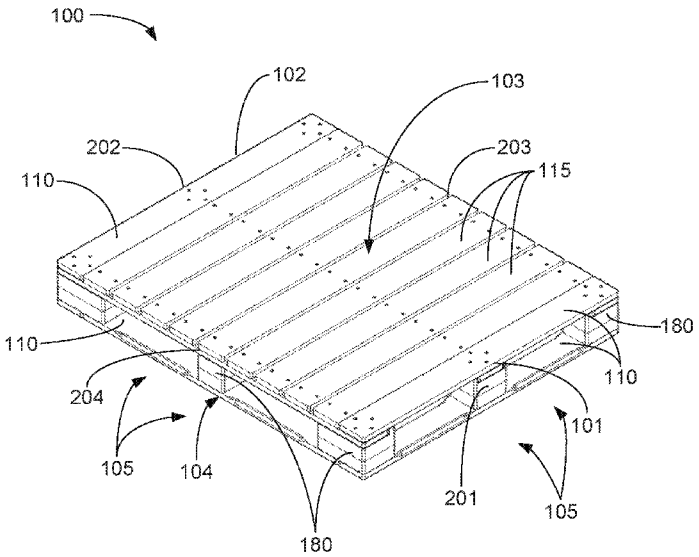


FIG. 1

(57) Abstract: A pallet (100) may include a base layer (125), an intermediate layer (145), two or more support blocks (180), and a top layer (165). The support blocks may be removably attached to the base layer and the intermediate layer such that the support blocks are positioned between the base layer and the intermediate layer. The base layer may include two or more base members (120), the intermediate layer may include two or more intermediate members (140) and the top layer may include two top outside members (160), which all may be described as structural members (110). The structural members may include two or more ribs, may include fiber dispersed in a thermoplastic material, and may include a continuous fiber bundle within each rib.

[Continued on next page]

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COMPOSITE PALLET

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application claims priority to U.S. Provisional Application Serial No. 62/452,159, filed January 30, 2017.

BACKGROUND

[0002] The present disclosure relates generally to composite pallets that may provide a robust loading surface and may be readily assembled and disassembled to help simplify repairs. Current pallet options are often not able to be disassembled and may require "complex repairs" (e.g., breaking components, glue, welds, etc.). For example, wood pallets may be assembled using nails such that removal of the nails for disassembly of the pallet may be difficult and may produce nail holes that make reassembly also difficult. Also, for example, typical composite pallets may be completely fused together to eliminate the use of multiple parts such that disassembly may be almost impossible without damaging the composite pallet. It may be desirable to produce a pallet that is configured to be readily assembled and disassembled, while maintaining rigidity and durability.

SUMMARY

[0003] The present disclosure relates to a pallet including multiple structural members with fiber dispersed in a thermoplastic material and fiber reinforcing members located within ribs of the structural member. Each structural member may be specifically engineered (e.g., with injection molding, base molding compound thermoplastic resin selection (e.g., polypropylene, high density polyethylene, nylon, etc.) base molding compound thermoplastic fiber concentrations, fiber type (long fiber, short fiber, etc.) dispersion, continuous fiber bundles within ribs, continuous fiber meshes, other features, etc.) to serve a purpose within the pallet. In other words, each structural member may be selectively reinforced in such a way to enhance performance when coupled with a specifically formulated base molding compound. For example, the multiple structural members may include base members, intermediate members, and top outside members

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that each contribute to the complete pallet assembly and provide specifically tailored characteristics to appropriately reinforce the complete pallet assembly. Further, the pallet includes support blocks that couple to the structural members and provide separation between the structural members. Each of the components of the pallet may be easily attached to and removed from one another to provide improved ability to repair the complete pallet and components thereof.

[0004] In one aspect, an exemplary pallet may include a base layer, an intermediate layer, two or more thermoplastic support blocks, and a top layer. The base layer may include two or more thermoplastic base members. Each thermoplastic base member of the two or more thermoplastic base members may define a first surface and a second surface opposing the first surface and each thermoplastic base member of the two or more thermoplastic base members may extend between a first end and a second end. The intermediate layer may include two or more thermoplastic intermediate members. Each thermoplastic intermediate member of the two or more thermoplastic intermediate members may define a first surface and a second surface opposing the first surface and each thermoplastic intermediate member of the two or more thermoplastic intermediate members may extend between a first end and a second end.

[0005] The two or more thermoplastic support blocks may be removably attached to the base layer proximate the first surfaces of the two or more thermoplastic base members and may be removably attached to the intermediate layer proximate the second surfaces of the two or more thermoplastic intermediate members such that the two or more thermoplastic support blocks may be positioned between the base layer and the intermediate layer. The two or more thermoplastic support blocks may separate the base layer from the intermediate layer. The top layer may include two thermoplastic top outside members removably attached to the intermediate layer proximate the first surfaces of the two or more thermoplastic intermediate members. Each thermoplastic top outside member of the two thermoplastic top outside members may define a first surface and a second surface opposing the first surface and each thermoplastic top outside member of the two thermoplastic top outside members may extend between a first end and a second end.

[0006] The two or more thermoplastic base members, the two or more thermoplastic intermediate members, and the two thermoplastic top outside members may be described as thermoplastic structural members. Each thermoplastic structural member

may include two or more ribs extending away from the second surface to a rib end portion between the first and second ends of the thermoplastic structural member. Each thermoplastic structural member may include fiber dispersed in a thermoplastic material and each of the two or more ribs of the thermoplastic structural member may include a continuous fiber bundle within each rib proximate the rib end portion.

[0007] In another aspect, an exemplary kit may include two or more thermoplastic base members, two or more thermoplastic intermediate members, two or more thermoplastic support blocks, and fasteners. Each thermoplastic base member of the two or more thermoplastic base members may define a first surface and a second surface opposing the first surface and each thermoplastic base member of the two or more thermoplastic base members may extend between a first end and a second end. Each thermoplastic intermediate member of the two or more thermoplastic intermediate members may define a first surface and a second surface opposing the first surface. Each thermoplastic intermediate member of the two or more thermoplastic intermediate members may extend between a first end and a second end and may include two or more ribs extending away from the second surface to a rib end portion between the first and second end of the thermoplastic intermediate member. Each thermoplastic intermediate member may include fiber dispersed in a thermoplastic material and each of the two or more ribs of the thermoplastic intermediate member may include a continuous fiber bundle within each rib proximate the rib end portion. Each thermoplastic intermediate member of the two or more thermoplastic intermediate members may define recesses proximate the second surface of each thermoplastic intermediate member.

[0008] The two or more thermoplastic support blocks may be configured to be removably attached to the two or more thermoplastic base members and the two or more thermoplastic intermediate members. The two or more thermoplastic support blocks may be configured to separate the two or more thermoplastic base members from the two or more thermoplastic intermediate members. The two or more thermoplastic support blocks may include protrusions configured to be received by the recesses of the two or more thermoplastic intermediate members. The fasteners may be configured to removably attach the two or more thermoplastic base members to the two or more thermoplastic support blocks, to removably attach the two or more thermoplastic intermediate members to the two or more thermoplastic support blocks, and to removably

attach the two thermoplastic top outside members to the two or more thermoplastic intermediate members.

[0009] In yet another aspect, an exemplary pallet may include a plurality of thermoplastic structural members and two or more thermoplastic support blocks. Each thermoplastic structural member of the plurality of thermoplastic structural members may define a first surface and a second surface opposing the first surface. Each of the plurality of thermoplastic structural members may extend between a first end and a second end and may include two or more ribs extending away from the second surface to a rib end portion between the first and second end of each thermoplastic structural member. Each thermoplastic structural member may include fiber dispersed in a thermoplastic material and each of the two or more ribs of the thermoplastic structural member may include a continuous fiber bundle within each rib proximate the rib end portion.

[0010] The two or more thermoplastic support blocks may be removably attached to the plurality of thermoplastic structural members such that the blocks may separate a first portion of the plurality of thermoplastic structural members from a second portion of the plurality of thermoplastic structural members. The two or more thermoplastic support blocks, the first portion of the plurality of thermoplastic structural members, and the second portion of the plurality of thermoplastic structural members may define at least two discrete openings for inserting a lifting tool.

[0011] A pallet is disclosed. The pallet comprises: a base layer comprising two or more thermoplastic base members, wherein each thermoplastic base member of the two or more thermoplastic base members defines a first surface and a second surface opposing the first surface, wherein each thermoplastic base member of the two or more thermoplastic base members extends between a first end and a second end; an intermediate layer comprising two or more thermoplastic intermediate members, wherein each thermoplastic intermediate member of the two or more thermoplastic intermediate members defines a first surface and a second surface opposing the first surface, wherein each thermoplastic intermediate member of the two or more thermoplastic intermediate members extends between a first end and a second end; two or more thermoplastic support blocks removably attached to the base layer proximate the first surfaces of the two or more thermoplastic base members and removably attached to the intermediate layer proximate the second surfaces of the two or more thermoplastic intermediate members such that the two or more thermoplastic support blocks are positioned between

the base layer and the intermediate layer, wherein the two or more thermoplastic support blocks separate the base layer from the intermediate layer; and a top layer comprising two thermoplastic top outside members removably attached to the intermediate layer proximate the first surfaces of the two or more thermoplastic intermediate members, wherein each thermoplastic top outside member of the two thermoplastic top outside members defines a first surface and a second surface opposing the first surface, wherein each thermoplastic top outside member of the two thermoplastic top outside members extends between a first end and a second end, wherein the two or more thermoplastic base members, the two or more thermoplastic intermediate members, and the two thermoplastic top outside members are thermoplastic structural members, wherein each thermoplastic structural member comprises two or more ribs extending away from the second surface to a rib end portion between the first and second ends of the thermoplastic structural member, wherein each thermoplastic structural member comprises fiber dispersed in a thermoplastic material and each of the two or more ribs of the thermoplastic structural member comprises a continuous fiber bundle within each rib proximate the rib end portion.

[0012] Alternatively or additionally to any of the embodiments above, each thermoplastic intermediate member of the two or more thermoplastic intermediate members comprises an open mesh proximate the first surface.

[0013] Alternatively or additionally to any of the embodiments above, the top layer comprises one or more top middle members positioned between the two thermoplastic top outside members, wherein each of the one or more top middle members defines a first surface and a second surface opposing the first surface, wherein each of the one or more top middle members extends between a first end and a second end, wherein the one or more top middle members are removably attached to the intermediate layer such that the second surface of the one or more top middle members is proximate the first surfaces of the two or more thermoplastic intermediate members.

[0014] Alternatively or additionally to any of the embodiments above, the structural members and the two or more thermoplastic support blocks comprise a non-halogenated, non-brominated food-contact-safe fire retardant.

[0015] Alternatively or additionally to any of the embodiments above, the two or more thermoplastic base members are coplanar such that the first surfaces of each of the thermoplastic base members are coplanar.

[0016] Alternatively or additionally to any of the embodiments above, the two or more ribs of each thermoplastic structural member comprise four ribs that are parallel to and equidistant from one another.

[0017] Alternatively or additionally to any of the embodiments above, the two or more thermoplastic support blocks are removably attached to both of the base layer and the intermediate layer using fasteners, such as screws.

[0018] Alternatively or additionally to any of the embodiments above, the continuous fiber bundle comprises at least 1000 continuous fibers dispersed in a thermoplastic material.

[0019] Alternatively or additionally to any of the embodiments above, at least one thermoplastic support block of the two or more thermoplastic support blocks couples two thermoplastic base members of the two or more thermoplastic base members together.

[0020] Alternatively or additionally to any of the embodiments above, the thermoplastic structural members comprise a first thermoplastic material and the two or more support blocks comprise a second thermoplastic material and the first thermoplastic material is a different type of thermoplastic material than the second thermoplastic material.

[0021] Alternatively or additionally to any of the embodiments above, each of the thermoplastic structural members comprises polyolefin, such as polypropylene, wherein the two or more support blocks comprise a polyolefin, such as polyethylene or high-density polyethylene.

[0022] Alternatively or additionally to any of the embodiments above, the base layer, the two or more support blocks, and the top layer define at least two discrete openings for inserting a lifting tool, such as a mechanically assisted lifting device.

[0023] Alternatively or additionally to any of the embodiments above, the two or more thermoplastic support blocks comprise protrusions and the two or more thermoplastic intermediate members comprise recesses such that the protrusions are received by the recesses to position or align or mate the two or more thermoplastic intermediate members relative to the two or more thermoplastic support blocks.

[0024] Alternatively or additionally to any of the embodiments above, the two or more thermoplastic intermediate members comprise two thermoplastic intermediate outside members and one or more thermoplastic intermediate inside member, wherein the two or more thermoplastic support blocks comprise corner blocks, center blocks, and

middle blocks, wherein the middle blocks are positioned proximate a center point of each thermoplastic intermediate member, wherein the corner blocks are positioned proximate the first and second ends of each of the two thermoplastic intermediate outside members, and wherein the center blocks are positioned proximate the first and second ends of the one or more thermoplastic intermediate inside member.

[0025] Alternatively or additionally to any of the embodiments above, each thermoplastic support block of the two or more thermoplastic support blocks defines a first surface proximate the intermediate layer and a second surface proximate the base layer, wherein a portion of the two or more thermoplastic support blocks comprise an alignment wall extending from the first surface of the thermoplastic support block, wherein the alignment wall aligns a thermoplastic intermediate member on a thermoplastic support block and contacts the top layer.

[0026] Alternatively or additionally to any of the embodiments above, the two or more thermoplastic support blocks comprise corner blocks, center blocks, and middle blocks, wherein each thermoplastic support block of the two or more thermoplastic support blocks defines a first surface proximate the intermediate layer and a second surface proximate the base layer, wherein the center blocks comprise two alignment walls extending from the first surface of the center block, wherein the first end of a thermoplastic intermediate member is positioned on the first surface of a first center block of the center blocks between the two alignment walls and the second end of a thermoplastic intermediate member is positioned on the first surface of a second center block of the center blocks between the two alignment walls.

[0027] Alternatively or additionally to any of the embodiments above, each of the two or more thermoplastic support blocks, the base layer, and the intermediate layer defines fastener apertures through which fasteners are inserted to removably attach the two or more thermoplastic support blocks to the base layer and to removably attach the two or more thermoplastic support blocks to the intermediate layer.

[0028] Alternatively or additionally to any of the embodiments above, each thermoplastic support block of the two or more thermoplastic support blocks defines a first surface proximate the intermediate layer and a second surface proximate the base layer, wherein each thermoplastic support block comprises support ribs for at least a portion between the first and second surfaces of each thermoplastic support block.

[0029] Alternatively or additionally to any of the embodiments above, the two or more thermoplastic intermediate members comprise protrusions extending from the first surface of each of the two or more thermoplastic intermediate members and the one or more top middle members defines recesses proximate the second surface of each of the one or more top middle members, wherein the protrusions of the two or more thermoplastic intermediate members are received by the recesses of the one or more top middle members.

[0030] A kit for assembling a pallet is disclosed. The kit comprises: two or more thermoplastic base members, wherein each thermoplastic base member of the two or more thermoplastic base members defines a first surface and a second surface opposing the first surface, wherein each thermoplastic base member of the two or more thermoplastic base members extends between a first end and a second end; two or more thermoplastic intermediate members, wherein each thermoplastic intermediate member of the two or more thermoplastic intermediate members defines a first surface and a second surface opposing the first surface, wherein each thermoplastic intermediate member of the two or more thermoplastic intermediate members extends between a first end and a second end and comprises two or more ribs extending away from the second surface to a rib end portion between the first and second end of the thermoplastic intermediate member, wherein each thermoplastic intermediate member comprises fiber dispersed in a thermoplastic material and each of the two or more ribs of the thermoplastic intermediate member comprises a continuous fiber bundle within each rib proximate the rib end portion, wherein each thermoplastic intermediate member of the two or more thermoplastic intermediate members defines recesses proximate the second surface of each thermoplastic intermediate member; two or more thermoplastic support blocks configured to be removably attached to the two or more thermoplastic base members and the two or more thermoplastic intermediate members, wherein the two or more thermoplastic support blocks are configured to separate the two or more thermoplastic base members from the two or more thermoplastic intermediate members, wherein the two or more thermoplastic support blocks comprise protrusions configured to be received by the recesses of the two or more thermoplastic intermediate members; and fasteners configured to removably attach the two or more thermoplastic base members to the two or more thermoplastic support blocks, to removably attach the two or more thermoplastic intermediate members to the two or more thermoplastic support blocks, and to removably

attach the two thermoplastic top outside members to the two or more thermoplastic intermediate members.

[0031] Alternatively or additionally to any of the embodiments above, each thermoplastic intermediate member of the two or more thermoplastic intermediate members comprises an open mesh proximate the first surface.

[0032] Alternatively or additionally to any of the embodiments above, further comprising two thermoplastic top outside members configured to be removably attached to the two or more thermoplastic intermediate members proximate the first surfaces of the two or more thermoplastic intermediate members, wherein each thermoplastic top outside member of the two thermoplastic top outside members defines a first surface and a second surface opposing the first surface, wherein each thermoplastic top outside member of the two thermoplastic top outside members extends between a first end and a second end.

[0033] Alternatively or additionally to any of the embodiments above, further comprising one or more top middle members positioned between the two thermoplastic top outside members, wherein each of the one or more top middle members defines a first surface and a second surface opposing the first surface, wherein each of the one or more top middle members extends between a first end and a second end, wherein the one or more top middle members are configured to be removably attached to the two or more thermoplastic intermediate members such that the second surface of the one or more top middle members is proximate the first surfaces of the two or more thermoplastic intermediate members.

[0034] Alternatively or additionally to any of the embodiments above, the two or more thermoplastic base members, the two or more thermoplastic intermediate members, and the two or more support blocks comprise a non-halogenated, non-brominated food-contact-safe fire retardant.

[0035] Alternatively or additionally to any of the embodiments above, the two or more thermoplastic base members are coplanar such that the first surfaces of each of the thermoplastic base members are coplanar.

[0036] Alternatively or additionally to any of the embodiments above, the two or more ribs of each thermoplastic intermediate member comprise four ribs that are parallel to and equidistant from one another.

[0037] Alternatively or additionally to any of the embodiments above, the continuous fiber bundle comprises at least 1000 continuous fibers dispersed in a thermoplastic material.

[0038] Alternatively or additionally to any of the embodiments above, at least one thermoplastic support block of the two or more thermoplastic support blocks couples two thermoplastic base members of the two or more thermoplastic base members together.

[0039] Alternatively or additionally to any of the embodiments above, the thermoplastic intermediate members comprise a first thermoplastic material and the two or more support blocks comprise a second thermoplastic material and the first thermoplastic material is a different type of thermoplastic material than the second thermoplastic material.

[0040] Alternatively or additionally to any of the embodiments above, each of the thermoplastic intermediate members comprises polyolefin, such as polypropylene, wherein the two or more support blocks comprise a polyolefin, such as polyethylene or high-density polyethylene.

[0041] Alternatively or additionally to any of the embodiments above, the two or more base members, the two or more support blocks, and the top outside members define at least two discrete openings for inserting a lifting tool, such as a mechanically assisted lifting device.

[0042] Alternatively or additionally to any of the embodiments above, the two or more thermoplastic support blocks comprise protrusions and the two or more thermoplastic intermediate members comprise recesses such that the protrusions are received by the recesses to position or align or mate the two or more thermoplastic intermediate members relative to the two or more thermoplastic support blocks.

[0043] Alternatively or additionally to any of the embodiments above, the two or more thermoplastic intermediate members comprise two thermoplastic intermediate outside members and one or more thermoplastic intermediate inside member, wherein the two or more thermoplastic support blocks comprise corner blocks, center blocks, and middle blocks, wherein the middle blocks are positioned proximate a center point of each thermoplastic intermediate member, wherein the corner blocks are positioned proximate the first and second ends of each of the two thermoplastic intermediate outside members, and wherein the center blocks are positioned proximate the first and second ends of the one or more thermoplastic intermediate inside member.

[0044] Alternatively or additionally to any of the embodiments above, each thermoplastic support block of the two or more thermoplastic support blocks defines a first surface proximate the intermediate members and a second surface proximate the base members, wherein a portion of the two or more thermoplastic support blocks comprise an alignment wall extending from the first surface of the thermoplastic support block, wherein the alignment wall is configured to align a thermoplastic intermediate member on a thermoplastic support block and configured to contact the top outside members.

[0045] Alternatively or additionally to any of the embodiments above, the two or more thermoplastic support blocks comprise corner blocks, center blocks, and middle blocks, wherein each thermoplastic support block of the two or more thermoplastic support blocks defines a first surface proximate the intermediate members and a second surface proximate the base members, wherein the center blocks comprise two alignment walls extending from the first surface of the center block, wherein the first end of a thermoplastic intermediate member is positioned on the first surface of a first center block of the center blocks between the two alignment walls and the second end of a thermoplastic intermediate member is positioned on the first surface of a second center block of the center blocks between the two alignment walls.

[0046] Alternatively or additionally to any of the embodiments above, each of the two or more thermoplastic support blocks, the base members, and the intermediate members defines fastener apertures through which fasteners are inserted to removably attach the two or more thermoplastic support blocks to the base members and to removably attach the two or more thermoplastic support blocks to the intermediate members.

[0047] Alternatively or additionally to any of the embodiments above, each thermoplastic support block of the two or more thermoplastic support blocks defines a first surface proximate the intermediate members and a second surface proximate the base members, wherein each thermoplastic support block comprises support ribs for at least a portion between the first and second surfaces of each thermoplastic support block.

[0048] Alternatively or additionally to any of the embodiments above, the two or more thermoplastic intermediate members comprise protrusions extending from the first surface of each of the two or more thermoplastic intermediate members and the one or more top middle members defines recesses proximate the second surface of each of the one or more top middle members, wherein the protrusions of the two or more

thermoplastic intermediate members are received by the recesses of the one or more top middle members.

[0049] A pallet is disclosed. The pallet comprises: a plurality of thermoplastic structural members, wherein each thermoplastic structural member of the plurality of thermoplastic structural members defines a first surface and a second surface opposing the first surface, wherein each of the plurality of thermoplastic structural members extends between a first end and a second end and comprises two or more ribs extending away from the second surface to a rib end portion between the first and second end of each thermoplastic structural member, wherein each thermoplastic structural member comprises fiber dispersed in a thermoplastic material and each of the two or more ribs of the thermoplastic structural member comprises a continuous fiber bundle within each rib proximate the rib end portion; and two or more thermoplastic support blocks removably attached to the plurality of thermoplastic structural members such that the blocks separate a first portion of the plurality of thermoplastic structural members from a second portion of the plurality of thermoplastic structural members, wherein the two or more thermoplastic support blocks, the first portion of the plurality of thermoplastic structural members, and the second portion of the plurality of thermoplastic structural members define at least two discrete openings for inserting a lifting tool.

[0050] Alternatively or additionally to any of the embodiments above, the second portion of the plurality of thermoplastic structural members are coupled to define a parallelogram shape, wherein a thermoplastic support block of the two or more thermoplastic support blocks is positioned on each corner of the parallelogram shape and at each midpoint between each corner of the parallelogram shape.

[0051] Alternatively or additionally to any of the embodiments above, each thermoplastic structural member of the plurality of thermoplastic structural members comprises an open mesh proximate the first or second surface.

[0052] Alternatively or additionally to any of the embodiments above, the structural members and the two or more thermoplastic support blocks comprise a non-halogenated, non-brominated food-contact-safe fire retardant.

[0053] Alternatively or additionally to any of the embodiments above, the two or more ribs of each thermoplastic structural member comprise four ribs that are parallel to and equidistant from one another.

[0054] Alternatively or additionally to any of the embodiments above, the two or more thermoplastic support blocks are removably attached to the plurality of thermoplastic structural members using fasteners, such as screws.

[0055] Alternatively or additionally to any of the embodiments above, the continuous fiber bundle comprises at least 1000 continuous fibers dispersed in a thermoplastic material.

[0056] Alternatively or additionally to any of the embodiments above, the thermoplastic structural members comprise a first thermoplastic material and the two or more support blocks comprise a second thermoplastic material and the first thermoplastic material is a different type of thermoplastic material than the second thermoplastic material.

[0057] Alternatively or additionally to any of the embodiments above, each of the thermoplastic structural members comprises polyolefin, such as polypropylene, wherein the two or more support blocks comprise a polyolefin, such as polyethylene or high-density polyethylene.

[0058] Alternatively or additionally to any of the embodiments above, the plurality of thermoplastic structural members and the two or more support blocks define at least two discrete openings for inserting a lifting tool, such as a mechanically assisted lifting device.

[0059] Alternatively or additionally to any of the embodiments above, the two or more thermoplastic support blocks comprise protrusions and the plurality of thermoplastic structural members comprise recesses such that the protrusions are received by the recesses to position or align or mate the plurality of thermoplastic structural members relative to the two or more thermoplastic support blocks.

[0060] Alternatively or additionally to any of the embodiments above, each thermoplastic support block of the two or more thermoplastic support blocks defines a first surface proximate the first portion of thermoplastic structural members and a second surface proximate the second portion of thermoplastic structural members, wherein a portion of the two or more thermoplastic support blocks comprise an alignment wall extending from the first surface of the thermoplastic support block, wherein the alignment wall aligns the first portion of thermoplastic structural members.

[0061] Alternatively or additionally to any of the embodiments above, each of the two or more thermoplastic support blocks and the plurality of thermoplastic structural

members defines fastener apertures through which fasteners are inserted to removably attach the two or more thermoplastic support blocks to the plurality of thermoplastic structural members.

[0062] Alternatively or additionally to any of the embodiments above, each thermoplastic support block of the two or more thermoplastic support blocks defines a first surface proximate the first portion of the plurality of thermoplastic structural members and a second surface proximate the second portion of thermoplastic structural members, wherein each thermoplastic support block comprises support ribs for at least a portion between the first and second surfaces of each thermoplastic support block.

[0063] These and various other features and advantages will be apparent from a reading of the following detailed description.

BRIEF DESCRIPTION OF THE DRAWINGS

[0064] The disclosure may be more completely understood in consideration of the following detailed description of various embodiments of the disclosure in connection with the accompanying drawings, in which:

[0065] **FIG. 1** is a perspective view of an exemplary pallet in assembled form;

[0066] **FIG. 2** is an exploded perspective view of the exemplary pallet of **FIG. 1**;

[0067] **FIG. 3A** is a top perspective view of an exemplary intermediate member of the exemplary pallet of **FIG. 1**;

[0068] **FIG. 3B** is a bottom plan view of the exemplary intermediate member of **FIG. 3A**;

[0069] **FIG. 3C** is a bottom perspective view of the exemplary intermediate member of **FIG. 3A**;

[0070] **FIG. 3D** is a cross-sectional view of the exemplary intermediate member of **FIG. 3B** taken across line **3D'-3D**;

[0071] **FIG. 3E** is another cross-sectional view of the exemplary intermediate member of **FIG. 3B** taken across line **3E'-3E**;

[0072] **FIG. 3F** is yet another cross-sectional view of the exemplary intermediate member of **FIG. 3B** taken across line **3F'-3F**;

[0073] **FIG. 3G** is yet another cross-sectional view of the exemplary intermediate member of **FIG. 3B** taken across line **3G'-3G**;

[0074] **FIG. 4A** is a top perspective view of an exemplary base member of the exemplary pallet of **FIG. 1**;

[0075] **FIG. 4B** is a bottom plan view of the exemplary base member of **FIG. 4A**;

[0076] **FIG. 4C** is a bottom perspective view of the exemplary base member of **FIG. 4A**;

[0077] **FIG. 5A** is a top perspective view of an exemplary top outside member of the exemplary pallet of **FIG. 1**;

[0078] **FIG. 5B** is a bottom plan view of the exemplary top outside member of **FIG. 5A**;

[0079] **FIG. 5C** is a bottom perspective view of the exemplary top outside member of **FIG. 5A**;

[0080] **FIG. 6A** is a top perspective view of an exemplary top middle member of the exemplary pallet of **FIG. 1**;

[0081] **FIG. 6B** is a bottom plan view of the exemplary top middle member of **FIG. 6A**;

[0082] **FIG. 6C** is a bottom perspective view of the exemplary top middle member of **FIG. 6A**;

[0083] **FIG. 7** is a top perspective view of an exemplary middle block of the exemplary pallet of **FIG. 1**;

[0084] **FIG. 8** is a top perspective view of an exemplary center block of the exemplary pallet of **FIG. 1**;

[0085] **FIG. 9** is a top perspective view of an exemplary corner block of the exemplary pallet of **FIG. 1**; and

[0086] **FIG. 10** is a top perspective view of another exemplary corner block of the exemplary pallet of **FIG. 1**.

DETAILED DESCRIPTION

[0087] In the following detailed description, reference is made to the accompanying drawings that form a part hereof, and in which are shown by way of illustration several specific embodiments. It is to be understood that other embodiments are contemplated and may be made without departing from the scope or spirit of the present disclosure. The following detailed description, therefore, is not to be taken in a limiting sense.

[0088] All scientific and technical terms used herein have meanings commonly used in the art unless otherwise specified. The definitions provided herein are to facilitate understanding of certain terms used frequently herein and are not meant to limit the scope of the present disclosure.

[0089] Unless otherwise indicated, all numbers expressing feature sizes, amounts, and physical properties used in the specification and claims are to be understood as being modified in all instances by the term "about." Accordingly, unless indicated to the contrary, the numerical parameters set forth in the foregoing specification and attached claims are approximations that can vary depending upon the properties sought to be obtained by those skilled in the art utilizing the teachings disclosed herein.

[0090] The recitation of numerical ranges by endpoints includes all numbers subsumed within that range (e.g. 1 to 5 includes 1, 1.5, 2, 2.75, 3, 3.80, 4, and 5) and any range within that range.

[0091] As used in this specification and the appended claims, the singular forms "a", "an", and "the" encompass embodiments having plural referents, unless the content clearly dictates otherwise.

[0092] As used in this specification and the appended claims, the term "or" is generally employed in its sense including "and/or" unless the content clearly dictates otherwise.

[0093] As used herein, "have", "having", "include", "including", "comprise", "comprising" or the like are used in their open ended sense, and generally mean "including, but not limited to". It will be understood that "consisting essentially of", "consisting of", and the like are subsumed in "comprising," and the like.

[0094] It should be noted that "top" and "bottom" (or other terms like "upper" and "lower" or "first" and "second") are utilized strictly for relative descriptions and do not imply any overall orientation of the article in which the described element is located.

[0095] The present disclosure provides selectively reinforced structural members that are combined to assemble a pallet that may be disassembled and reassembled easily and readily (e.g., to make repairs to individual components such as structural members or support blocks). Each of the structural members may be selectively reinforced using fiber dispersed in thermoplastic material, positioning continuous fiber bundles in ribs of the structural member, and/or including an open mesh. Various combinations of these

reinforcements may be used in various different types of structural members. Further, the structural members may be selectively reinforced in any other suitable way.

[0096] Providing selective reinforcements in the structural members that are used to assemble a pallet may improve the structural properties while reducing the weight, failure points, and/or cost of the composite structural member. The selective reinforcements may be placed strategically within the structural members to provide improved performance (e.g., flexural strength, modulus, impact, durability, etc.) at specific locations. For example, a continuous fiber bundle positioned within the structural member may provide an increased tensile strength to each of the structural members such that the pallet assembly may be lifted or a payload disposed thereon while maintaining structural strength.

[0097] Constructing a pallet from selectively reinforced structural members also provides the opportunity for the individual structural members to be easily replaced (in addition to the individual structural members being independently engineered to serve specific purposes that may include flexural strength, modulus, impact, durability, load bearing, etc.). Contrarily, with regards to conventional composite pallets, the pallet is fused together in, e.g., one, two, three pieces (or a small number of parts that may be welded, glued, or semi-permanently bonded), making it nearly impossible to disassemble or repair, which may be described as complex repairs. In other words, to repair conventional composite pallets, a component (that may be effectively a group of components that may be bonded together) of the pallet may need to be broken off so that the component may be replaced or the whole pallet may need to be replaced if the components cannot be independently repaired. The exemplary pallets described herein are specifically reinforced based on the exact location of the structural member and are designed to be disassembled and reassembled easily and readily.

[0098] An exemplary pallet **100** including a plurality of structural members **110** and a plurality of support blocks **180** is shown in **FIG. 1**. The pallet **100** defines a first surface **103** (e.g., a top surface) and a second surface **104** (e.g., a bottom surface) opposite the first surface **103**. The top surface **103** may be described as a deck, a cargo surface, a loading surface, etc. and may be configured to support any type of payload, freight, shipment, etc. that is positioned on the first surface **103**. Also, the pallet may extend between a first end **101** and a second end **102**. The pallet **100** may define a variety of different shapes suitable for carrying a payload. For example, the pallet **100** illustrated in

FIG. 1 defines a parallelogram shape, specifically rectangular, when viewing orthogonal to the first surface **103**. The overall size of the pallet **100** may be the same as most conventional pallets, e.g., 48 inches (1.2 m) x 40 inches (1.0 m).

[0099] The plurality of structural members **110** may be positioned relative to one another such that at least two discrete openings **105** are defined. For example, the plurality of support blocks **180** are positioned between a first portion of the plurality of structural members **110** (e.g., a top portion) and a second portion of the plurality of structural members **110** (e.g., a bottom portion) such that the first portion of the plurality of structural members **110** are separated (e.g., not in contact with) the second portion of the structural members **110**. The plurality of structural members **110** may be removably attached or coupled to the plurality of support blocks **180**. In other words, each of the plurality of structural members **110** may be easily and readily attached and removed (e.g., without damaging or destroying (or while maintaining the integrity and form of) the structural members **110** or support blocks **180** that are not being replaced) from the plurality of support blocks **180** (e.g., to easily replace a damaged structural member **110**). The at least two discrete openings **105** may be defined between the first portion of the plurality of structural members **110**, the second portion of the plurality of structural members **110**, and the plurality of support blocks **180**.

[0100] As described further herein, the top outside members may be structural members **110** and the one or more members therebetween may be fill members **115** (e.g., members that are not considered structural as defined further herein). In other words, the first top member closest to each of the first and second ends **101**, **102** of the pallet **100** may be considered structural members **110**, but the fill members **115** in between may not be considered structural as further defined herein (e.g., may not include continuous fiber bundles contained therein). The fill members **115** may include one or more multiple members that are spaced across the first surface **103** of the pallet **100** or may include one member that spans between the structural member **110** closest the first end **101** of the pallet **100** and closest the second end **102** of the pallet **100**.

[0101] The pallet **100** illustrated in **FIG. 1** defines four side surfaces that are adjacent to and between the first and second surfaces **103**, **104**. For example, the pallet **100** may define a side surface 201 at the first end **101**, a side surface **202** at the second end **102**, and side surfaces **203**, **204** between the first and second ends **101**, **102** (and between the first and second surfaces **103**, **104**) on either side. Each of the four side

surfaces may define various openings that may be used to allow a lifting device (e.g., tines of a mechanically assisted lifting device, such as a forklift or hand jack) to access the pallet **100** such that the pallet **100** may be lifted and moved. For example, the pallet **100** may define at least two discrete openings **105** on each of the four side surfaces **201**, **202**, **203**, **204**. Also, in one or more embodiments, the side surfaces **201**, **202**, **203**, **204** may define a flush surface due to the relative arrangement of the structural members **110** and the support blocks **180**. A pallet **100** defining openings on each of the four side surfaces may be described as providing four-way entry because the lifting device may access the pallet **100** from each of those four side surfaces.

[0102] The at least two discrete openings **105** may be arranged in a variety of different ways. For example, the at least two discrete openings **105** on each of the side surfaces of the pallet **100** may be the same dimensions and also symmetric across the center point of the side surface. In one or more embodiments, the at least two discrete openings **105** of each side surface of the pallet **100** may have identical dimensions such that each of the side surfaces provide an identical access to the lifting device so that, e.g., the pallet **100** may be accessed similarly from each side surface (e.g., the height from the ground to the opening **105** may be similar). In one or more embodiments, the structural member 110 that defines the bottom layer of the pallet **100** may include a bevel or chamfer that allows easier access for "walkies" (tines of a lifting device that have wheels that roll into the access openings) by providing a gradual ramp into the discrete openings **105** of the pallet **100**.

[0103] The plurality of structural members **110** may include a variety of different types of structural members that may be positioned in different locations on the pallet **100** and each may be engineered (i.e., using selective reinforcements or material systems) for different purposes. For example, the plurality of structural members **110** may include two or more base members **120**, two or more intermediate members **140**, and two top outside members **160** as shown in the exploded perspective view of the pallet **100** in **FIG. 2**. In one or more embodiments, the plurality of structural members **110** may include additional types of structural members **110**.

[0104] By separating the plurality of structural members **110** into multiple subsets, each type of structural member **110** may be selectively engineered for a different purpose to, e.g., increase overall performance of the pallet **100**, reduce the cost of the pallet **100**, reduce the weight of the pallet **100**, improve the performance of the pallet **100** (in flexural

or tensile strength, modulus, etc.), improve the predictive capability of design performance to actual performance of the pallet **100**, improve the points and mode of failure of the pallet **100**, etc. Other factors that are taken into account for each structural member **110** may include overall strength (e.g., long-term force applied) provided by each structural member **110** and impact resistance (e.g., energy dissipation from and rigidity to sudden impact) of each structural member **110**. For example, many different characteristics of each structural member **110** may be modified to optimize these factors. Specifically, some examples of variables that may be modified within each structural member **110** may be the size, shapes, composition and formulation of base molding compounds or materials, the composition and formulation of selective reinforcements (including size shapes, diameter of fibers, type of fibers, number of fibers, fiber coatings, size of mesh openings or gaps, coatings, fiber manufacturing methods, fiber to resin percentages, etc.

[0105] For example, the material of the plurality of structural members **110** may affect the weight of each individual structural member **100**. The weight of the overall pallet **100** may be important because the Occupational Safety and Health Administration (OSHA) requires a weight of less than 50 pounds (22.7 kg) to be suitable for one person manually lifting the pallet **100**. In other words, a pallet **100** weighing over 50 pounds would require more than one person to move under OSHA standards unless using a mechanical assist device (e.g., a fork lift, a walkie, etc.). It is difficult to stay below this weight threshold with a composite pallet while maintaining the required physical performance, cost and durability. However, by using composite members with selective reinforcements (e.g., advanced fiber reinforcements), as described herein, this exemplary pallet **100** may be able to stay under 50 pounds and may meet a wide range of performance requirements (e.g., physical performance, cost, weight, durability, etc.).

[0106] The plurality of structural members may include (e.g., be made of or formed of) any suitable plastic or composite material. For example, the plurality of structural members **110** (e.g., base members **120**, intermediate members **140**, and/or top outside members **160**) may include a thermoset, or thermoplastic (e.g., including a polyolefin such as polyethylene, or polypropylene). Using a composite material may prevent the structural members **110** from absorbing water or spilled product that comes into contact with the structural members **110**, which may result in the members, e.g., being more sanitary, easier to clean, and less attractive to insects and fungi.

[0107] As shown in **FIG. 2**, each of the plurality of structural members **110** may be coupled to one another and the two or more support blocks **180** to form (e.g., assemble, construct, manufacture) the pallet **100**. In one or more embodiments, the structural members **110** being removably coupled to the support blocks **180** may include any type of coupling or connecting that does not include adhesive or welding. Each of the plurality of structural members **110** may be grouped and arranged in layers for construction of the pallet **100**. For example, the pallet **100** may include a base layer **125**, an intermediate layer **145**, and a top layer **165**. Additionally, as shown, the pallet **100** may include two or more support blocks that separate the top and intermediate layers **165**, **145** from the base layer **125** (e.g., to form openings **105** allowing the middle of the pallet **100** to be accessed such that the pallet **100** may be moved).

[0108] The base layer **125** may include two or more base members **120** that are positioned together to form the base layer **125**. The base layer **125** may be described as a layer because the two or more base members **120** that make up the base layer **125** may create a generally even surface for each of the top and bottom surfaces. In other words, the top surfaces (e.g., a first surface **123** of each base member **120** as shown in **FIG. 1**) may be generally coplanar to form an even common surface layer. The base layer **125** may form a foundation on which the remainder of the pallet **100** may be located or positioned. For example, the two or more base members **120** of the base layer **125** may be removably coupled or connected or attached to the two or more support blocks **180** (e.g., using fasteners **109**). The fasteners **109** may include any suitable component that may be used to connect elements. For example, the fasteners **109** may include screws or other easily removable fasteners. In one or more embodiments, the fasteners **109** may include any suitable fastener **109** that may be easily and readily removed and attached such that components may be repeatedly assembled, disassembled and reassembled easily and readily (e.g., without damaging or destroying components that are not being replaced in the pallet **100**) without materially reducing the fasteners ability to provide a connection/coupling and without reducing the material performance of the components or pallet **100**. Also, as shown in **FIG. 2**, the coupling of the base members **120** to the support blocks **180** may result in the coupling or connecting of two adjacent base members **120** (e.g., each adjacent base member **120** is removably coupled to a support block **180** such that each adjacent base member **120** is positioned relative to the other). In some embodiments, the base members **120** may be directly coupled to one another. As

discussed herein, the two or more base members **120** may be arranged to form a rectangular base layer **125** (e.g., the typical shape formed by a pallet **100**).

[0109] The two or more support blocks **180** may be coupled to the two or more base members **120** of the base layer **125** such that the support blocks **180** extend away from the base layer **125**. Each support block **180** of the two or more support blocks **180** may define a first surface **183** and a second surface **184** opposite the first surface **183**. The support blocks may be positioned such that the second surface **184** of the support block **180** is adjacent the base layer **125** when the support blocks **180** are removably coupled to the base members **120** and the first surface **183** of the support block **180** is adjacent the intermediate layer **145** when the support blocks are removably coupled to the intermediate members **140**.

[0110] The two or more support blocks **180** may include various numbers of support blocks **180** to help support and separate the base layer **125** and the intermediate layer **145**. For example, as shown in **FIG. 2**, a support block **180** is positioned in each corner of the base layer **125** as well as in between the corners and in the middle of the base layer **125**. Additionally, the support blocks **180** are positioned at each end of the intermediate members 140 and in between each end of the intermediate members **140**. Furthermore, the support blocks 180 may include a variety of different types of support blocks **180**, which will be discussed further herein, including the specific arrangement of the different types of support blocks **180**.

[0111] The intermediate layer **145** may include two or more intermediate members **140** that are positioned together to form the intermediate layer **145**. The intermediate members **140** may be positioned on the support blocks **180** opposite the base members **120**. In other words, the intermediate members **140** may be positioned on the first surface **183** of the support blocks **180** (with the base members **120** positioned on or removably coupled to the second surface **184** of the support blocks **180**). Specifically, the intermediate members **140** may be removably coupled to first surface **183** of the support blocks **180** (e.g., using fasteners 109). As a result, the two or more intermediate members **140** may be separated from and positioned relative to the two or more base members **120** by the two or more support blocks **180** because each may be removably coupled to opposing sides of the support blocks **180** (e.g., the base members **120** removably coupled to the second surface **184** of the support blocks **180** and the intermediate members **140** removably coupled to the first surface **183** of the support blocks **180**).

[0112] The intermediate layer **145** may be described as a layer because the two or more intermediate members **140** that make up the intermediate layer **145** may create a generally even surface for each of the top and bottom surfaces of the intermediate members **140**. In other words, the top surfaces (e.g., a first surface **143** of each intermediate member **140**) may be generally coplanar to form an even common surface layer. In this way, the intermediate members **140** may be positioned on an even surface (e.g., the support blocks **180**) and result in an even surface (e.g., for which the top layer **165** may be positioned).

[0113] The top layer **165** may include two top outside members **160** and one or more top middle members **170** positioned between the two top outside members **160**. The two top outside members **160** may be described as structural members **110** and the one or more top middle members **170** may be described as "non-structural" or fill members. The term "non-structural" is not intended to denote that the one or more top middle members **170** do not provide structure, but rather, may not include certain selective reinforcements (e.g., continuous fiber bundles disposed therein) that may be found in structural members **110**. The top outside members **160** and the one or more top middle member **170** may be positioned on the intermediate members **140**. The top layer **165** may be described as a layer because the two top outside members **160** and the one or more top middle members **170** that make up the top layer **165** may create a generally even surface for each of the top and bottom surfaces of the two top outside members **160** and the one or more top middle member **170**. In other words, the top surfaces (e.g., a first surface **163** of the two top outside members **160** and a first surface **173** of the one or more top middle members **170**) may be generally coplanar to form an even common surface layer. This even common surface layer (of the top layer **165**) may be one that any sort of cargo or payload may be placed.

[0114] The top outside members **160** and the one or more top middle members **170** may be removably coupled to the intermediate members **140**. Further, the top outside members **160** and the one or more top middle members **170** may be removably coupled to the support blocks **180**. For example, in one more embodiments, the top outside members **160** and the one or more top middle members **170** may be removably coupled to the support blocks 180 through the intermediate members **140**.

[0115] One exemplary intermediate member **140** of the two or more intermediate members 140 is shown in **FIGS. 3A-3C**. The intermediate member **140** may define a

first surface **143** and a second surface **144** opposite the first surface **143** (e.g., the second surface **144** may be parallel to the first surface **143**). Also, the intermediate member **140** may extend between a first end **141** and a second end **142**. The intermediate member **140** may define a variety of different shapes and sizes. For example, the intermediate member **140** may define a rectangular prism shape or a "board-like" shape. Specifically, the first and second surfaces **143**, **144** of the intermediate member **140** may define a major surface such that the surface areas of each of the first and second surfaces **143**, **144** of the intermediate member **140** are significantly larger than the other surfaces of the intermediate member **140**. For example, the length **151** of the intermediate member **140** measured between the first end **141** and the second end **142** may be 48 inches (e.g., about 1.2 m). The width **153** of the intermediate member **140** (e.g., along the first or second surface **143**, **144** and perpendicular to the length **151**) may be 4 inches (e.g., about 10 cm). The thickness of the intermediate member **140** (e.g., perpendicular to both the length **151** and width **153**, measured from the first surface **143** to a rib end portion 148) may be 0.75 inches (e.g., about 1.9 cm). Additionally, each of the intermediate members **140** may weigh about greater than or equal to 1 pound, greater than or equal to 1.5 pounds, greater than or equal to 2 pounds, greater than or equal to 2.5 pounds, etc. and/or less than or equal to 5 pounds, less than or equal to 4 pounds, less than or equal to 3.5 pounds, less than or equal to 3 pounds, etc. More specifically, each of the intermediate members **140** may weigh about 2.4 pounds to 3.2 pounds (e.g., for a base molding compound of about 40% to 50% long fiber thermoplastic).

[0116] As discussed herein, the intermediate members **140** may include selective reinforcements (e.g., advanced fiber reinforcements) to improve the strength and impact resistance of the member. The selective reinforcements (e.g., advanced fiber reinforcements) are described herein with respect to the intermediate members **140** shown in **FIGS. 3A-3G**, however, the selective reinforcements may apply to any of the structural members **110** (e.g., the base members **120**, the intermediate members **140**, and the top outside members **160**). Additionally, in some embodiments, the selective reinforcements may apply to the one or more top middle members **170** and the support blocks **180** as well. The selective reinforcements may include ribs extending from a major surface of the structural member **110**, fiber dispersed within the structural member **110**, a continuous fiber bundle located in the ribs of the structural member **110**, and/or a mesh disposed within the structural member **110**.

[0117] For example, the structural members **110** (e.g., base member **120**, intermediate member **140**, top outside member **160**) may comprise (e.g., be made of or formed of) a base molding compound (e.g., a composite material such as polypropylene) with fiber dispersed in the compound (e.g., using injection molding, compression molding, etc.). For example, base molding compound may include fiber (e.g., glass, carbon, etc.) reinforced materials (e.g., long or short fiber) dispersed in the compound.

[0118] The structural members **110** may be formed of any suitable polymeric material. In many embodiments the polymeric material is a thermoplastic material. Useful polymeric material includes polypropylene, polyethylene, nylon, acrylonitrile butadiene styrene, styrene acrylonitrile, acrylic or styrene, for example. Further useful polymers include PBT polyester, PET polyester, polyoxymethylene, polycarbonite or polyphenylene sulfide for example. Higher temperature polymeric material includes polysulfone, polyethersulfone, polyethereetherketone, or liquid crystal polymer, for example.

[0119] Specifically, the structural members **110** may include about greater than or equal to 20%, greater than or equal to 30%, greater than or equal to 35%, greater than or equal to 40%, greater than or equal to 45%, etc. and/or less than or equal to 60%, less than or equal to 55%, less than or equal to 50%, less than or equal to 42%, etc. long or short fiber (by weight). More specifically, the structural members **110** may include about 40% to 50% of the base wt long fiber thermoplastic. The types of long or short fiber included in the base molding compound may include glass or carbon and may be sized at an average length of about less than 15mm and an average diameter of about less than 50 micrometers. For example, the fiber dispersion may be as described in U.S. Patent Application No. 14/621,188, filed on February 12, 2015, and entitled, "COMPOSITE STRUCTURAL ARTICLE". In one or more embodiments, the material of the structural member 110 may be described as a long fiber thermoplastic material.

[0120] In many embodiments a plurality of fibers form a fiber dispersion within the structural members **110**. The fibers forming this fiber dispersion have an average length of less than 15 mm and an average diameter of less than 50 micrometers. The polymeric material forming the solid or polymeric body may include a plurality of random fibers forming a fiber dispersion in the polymeric material. This fiber dispersion has an average

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fiber length of less than 15 mm or less than 12 mm or less than 5 mm or less than 1 mm. The fiber dispersion has an average fiber length in a range from 1 to 15 mm or in a range from 5 to 12 mm and can be termed "long fiber thermoplastic". In other embodiments, the fiber dispersion has an average fiber length in a range from 0.1 to 1 mm or in a range from 0.25 to 0.75 mm and can be termed "short fiber thermoplastic".

[0121] The fibers forming the fiber dispersion can be formed of materials that are the same or different than the material forming the continuous fiber bundle **149** such as glass, carbon, basalt, graphite, DuPont Kevlar brand aramid fibers, ceramics, natural fibers, polymeric fibers, and various metals, for example. Preferably fibers forming the fiber dispersion can be composed of glass, carbon, graphite or Kevlar (i.e., poly-paraphenylene terephthalamide) fibers. In some embodiments the fibers forming the fiber dispersion are a mixture of glass and carbon fibers or glass and Kevlar fibers or glass and graphite fibers. In some embodiments the fibers forming the fiber dispersion is glass and the fibers forming the continuous fiber bundle **149** are carbon, Kevlar or graphite or a mixture of glass and carbon, Kevlar or graphite.

[0122] Polymer material "wets out" the co-extending continuous fibers forming the continuous fiber bundle **149**. Thus resin or polymeric material is dispersed about all of the co-extending continuous fibers forming the continuous fiber bundle **149.** The forming the continuous fiber bundle **149** can include at least 1000, or at least 5000, or at least 10000 or at least 15,000 co-extending continuous glass fibers.

[0123] In many embodiments, the continuous fiber bundle **149** contains co-extending continuous fibers that are not uniformly distributed throughout a cross-section of the continuous fiber bundle **149** and may concentrate towards the longitudinal axis of the continuous fiber bundle **149**. This may occur due as the fibers are twisted. In many of these embodiments a skin layer of polymer (that forms the polymeric body) may form on the outer surface of the continuous fiber bundle **149** where there is no co-extending continuous fibers. This skin layer may form 10% or less or from 1 to 10% of the diameter of the continuous fiber bundle **149.** In some embodiments the co-extending continuous fibers are uniformly distributed throughout a cross-section of the continuous fiber bundle **149.**

[0124] Furthermore, the intermediate members **140** (or base members **120**/top outside members **160**) may include two or more ribs **146** that extend away from the second surface **144** of the intermediate member **140** to a rib end portion **148** (e.g., as

shown in **FIG. 3D**) between the first and second ends **141**, **142** of the intermediate member **140**. The intermediate member **140** may include any number of ribs positioned in this fashion. For example, as shown in **FIGS. 3B and 3C**, the intermediate member **140** includes four ribs **146** extending (e.g., parallel and equidistant from one another) from the second surface **144** (e.g., extending from a major surface of the intermediate member **140**) of the intermediate member **140**. In other embodiments, the structural member **110** may include two, three, four, five, six, etc. ribs. A cross-section of the four ribs **146** is shown in the cross-sectional view illustrated in **FIG. 3D** (which is a cross-sectional view of the intermediate member **140** of **FIG. 3B** taken across line **3D-3D'**).

[0125] The two or more ribs **146** may define various different sizes. For example, a wider rib **146** (measured perpendicular to the direction the rib extends) may provide increased structural rigidity by, e.g., increasing the amount of material contained within the rib or allowing for a larger fiber bundle (further described herein) to be disposed therein. Specifically, the width of the rib **146** may be about greater than or equal to 0.1 inches, greater than or equal to 0.125 inches, greater than or equal to 0.147 inches, etc. and/or less than or equal to 0.25 inches, less than or equal to 0.212 inches, less than or equal to 0.193 inches, etc. As shown in **FIG. 3D**, the width of the rib **146** may be substantially smaller than the width of the member from which the rib **146** extends. For example, each rib **146** may define a width that is only 5% to 15% of the width **153** (e.g., as shown in **FIG. 3B**) of the intermediate member **140**. The two or more ribs **146** may all define the same width or the two or more ribs **146** may define varying widths. For example, ribs **146** on the outside of the intermediate member **140** may define a width that is greater than ribs **146** located between the outside ribs. This configuration (wider outside ribs than inside ribs) may provide for increased support and impact resistance because the outside ribs may be more exposed to external factors (e.g., impact from lifting devices).

[0126] The two or more ribs **146** may also define a length extending away from and perpendicular to the second surface **144** of the intermediate member **140**. As described herein, the thickness of the structural member **110** (e.g., the base member **120**, the intermediate member **140**, the top outside member **160**) from a first surface (e.g., first surface **143**) to a rib end portion (e.g., the rib end portion **148**) may be about 0.75 inches, which, for example, is a combination of distances between the first and second surfaces **143**, **144** and between the second surface **144** and rib end portion **148**. In other words, an

increase or decrease in the distance between first and second surfaces **143**, **144** may result in a corresponding decrease or increase, respectively, in the distance between the second surface **144** and the rib end portion **148**. The distance between the first and second surfaces **143**, **144** of the intermediate member **140** (or, e.g., any other structural member **110**) may be about 0.075 inches to 0.2 inches. Therefore, the distance between the second surface **144** of the intermediate member **140** (or, e.g., any other structural member 110) may be about 0.675 inches to 0.55 inches. In other words, the cumulative thickness of the intermediate member **140** (e.g., from the first surface **142** to the rib end portion **148**) may add up to 0.75 inches.

[0127] The intermediate member **140** may also include one or more angled portions **117** as shown in **FIGS. 3B and 3C**. The one or more angled portions **117** may be positioned between and coupled to each of the second surface **144** and the outside rib **146**. The one or more angled portions **117** may provide additional structural rigidity and strength to the intermediate member **140**. For example, the one or more angled portions **117** may prevent the outside rib **146** from deflecting inwards or outwards.

[0128] Another type of selective reinforcement that may be included in the structural members **110** (e.g., the base member **120**, intermediate member **140**, top outside member **160**) may be a continuous fiber bundle **149** as illustrated in the cross-sectional view of **FIG. 3D** (as well as **FIGS. 3E-3G**). In some embodiments, the continuous fiber bundle **149** may be described as a tension member that is, e.g., a pultruded rod with continuous co-axial glass fibers in a thermoplastic resin matrix. The continuous fiber bundle may be a bundle of fibers that may provide strength in tension to increase the overall strength of the intermediate member **140** by preventing the intermediate member **140** from bowing or cracking or breaking when a force is applied to the intermediate member **140** (e.g., the continuous fiber bundle **149** provides increased strength for a force applied on a surface opposite where the continuous fiber bundle **149** is embedded, thus, placing the continuous fiber bundle **149** in tension). The continuous fiber bundle **149** may include a range of thickness/filament counts to vary the overall strength of the continuous fiber bundle **149**. For example, the continuous fiber bundles **149** may define a thickness (e.g., a diameter) of about greater than or equal to 0.05 inches, greater than or equal to 0.1 inches, greater than or equal to 0.125 inches, etc. and/or less than or equal to 0.25 inches, less than or equal to 0.2 inches, less than or equal to 0.15 inches, etc. Also, for example, the continuous fiber bundles **149** may include at least

between 1,000 and 20,000 continuous fibers dispersed in a thermoplastic material. In one or more embodiments, the continuous fiber bundles **149** may be twisted to further increase the tensile strength. For example, the continuous fiber bundles **149** may be grouped in portions of 4,000 continuous fibers that are twisted and combined with additional groups of continuous fibers that may be twisted. Specifically, the continuous fiber bundles **149** may be as described in U.S. Patent Application No. 14/621,188, filed on February 12, 2015, and entitled, "COMPOSITE STRUCTURAL ARTICLE," and International Patent Application No. PCT/US16/17519, filed on February 11, 2016, and entitled, "PRE-STRESSED FIBER REINFORCING MEMBER," and International Application No. PCT/US2015/044789, filed on August 12, 2015, and entitled, "REINFORCING ARTICLE".

[0129] In many embodiments the polymer utilized to form the continuous fiber bundle **149** is compatible with, or is the same type or kind of, polymer material forming the structural members **110**. In some embodiments the polymer utilized to form the continuous fiber bundle **149** is a different type or kind of polymer material forming the structural members **110**. The polymer material forming the continuous fiber bundle **149** may be free of a long or short fiber dispersion. In many embodiments the continuous fiber bundle **149** has an outer "skin" layer that does not include, or is free of the fiber dispersion that is present in the structural members **110**.

[0130] The continuous fiber bundle **149** may be positioned at any location within any or all of the structural members **110** (e.g., base member **120**, intermediate member **140**, top outside member **160**). For example, as shown in the cross-sectional view illustrated in **FIGS. 3D-3G**, the continuous fiber bundle **149** may be positioned in each of the two or more ribs 146 proximate the rib end portion **148**. For example, the continuous fiber bundle **149** may extend along the corresponding rib **146** (e.g., at the rib end portion **148**) between the first and second ends **141**, **142** of the intermediate member **140**. As described herein, the width of each rib **146** may vary, which may accommodate a wider continuous fiber bundle **149** to, e.g., increase the strength of the intermediate member **140**.

[0131] Yet another type of selective reinforcement that may be included in the structural members **110** (e.g., base members **120**, intermediate members **140**, top outside members **160**) and the top middle members **170** may be an open mesh **107**, e.g., as shown

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in **FIG. 3A**. It is noted that the mesh **107** may be located on any of the structural members **110** and/or the top middle members **170** even though the mesh is only illustrated relative to the intermediate member **140** illustrated in **FIG. 3A**. The mesh **107** may be either a structural mesh or an impact mesh.

[0132] The structural mesh **107** can have any useful void size separating the intersecting continuous fiber members. In preferred embodiments the openings are in a range from about 1/8 inch to about ½ inch square or in mesh size of about 8 to about 2 mesh or from about 4 to about 5 mesh (openings per inch). In many embodiments the openings have an average lateral distance of at least 1 mm or at least 2 mm or at least 5 mm. The opening allows molten polymer to flow through the structural mesh **107** during a molding process.

[0133] The structural mesh may help to improve the structural strength of the structural member **110**. For example, placing the mesh **107** close to the first surface **143** of the intermediate member **140** may improve the strength of the intermediate member **140** when force is applied on the second surface **144** (or two or more ribs **146**) towards the first surface **143** of the intermediate member **140**, e.g., when the tines of a lifting device is lifting the pallet **100** or if the pallet **100** is rail racked (placing concentrated force at specific points proximate the effectively bottom surface or the end of the ribs at the rib end portion **148**). For example, the force may be applied to the rib end portions **148**, which may then be transmitted up through the ribs **146** to distribute pressure to the second surface **144** (e.g., rail racked against the bottom layer of the rib plane in a concentrated way because the force may be applied only on a narrow portion of the intermediate member **140**, e.g., the rib **146**). The structural mesh may include flexible meshes of continuous glass fibers with a resin coating and may be a similar material to the remainder of the structural member **110** for which it is embedded.

[0134] The impact mesh may help to improve resilience to harsh impact from the external factors such as tines of a lifting device or dropped cargo. For example, the impact mesh may be included in the top layer **165** (e.g., the top outside members **160** and the one or more top middle member **170**) to withstand impact forces from cargo or payloads that may be dropped onto the pallet **100**. Similar to the structural mesh, the impact mesh may be embedded or positioned in the intermediate member **140** (or any other structural member **110**/top middle member **170**) proximate the first surface **143** of the intermediate member **140**. The impact mesh may include woven mesh with a

modified resin formulation to impart flexibility for impact absorption and may be a different type of material as compared to the remainder of the member (e.g., structural member **110** or top middle member **170**) for which it is embedded. It is also noted that the mesh **107** (e.g., structural mesh or impact mesh) illustrated in **FIG. 3A** is visible on the first surface **143** of the intermediate surface **140** for illustrative purposes and the mesh **107** may be embedded in the intermediate member **140** such that the mesh **107** may be located just under the first surface **143** of the intermediate member **140**.

[0135] The structural members **110** may also define apertures **108** or bosses/holes/openings (e.g., molded-in bosses) through which the fasteners **109** may extend to attach different components (e.g., base/intermediate/top outside members **120**, **140**, **160** and support blocks **180**) of the pallet 100. For example, the apertures **108** may extend through the thickness of the intermediate member **140** as shown in the cross-sectional view illustrated in **FIG. 3E**. Specifically, the aperture **108** extends from the first surface **143** of the intermediate member **140** through the entirety of the intermediate member **140**. The apertures **108** illustrated in **FIG. 3E** may specifically be used for the insertion of a fastener **109** through the intermediate member **140** and into a support block **180** (which may be removably attached proximate the two or more ribs **146** of the intermediate member **140**). The apertures **108** may be dimensioned such that the diameter of each aperture **108** is slightly smaller than the diameter of the fasteners **109** (e.g., screws) so that the fasteners **109** contact the inner surfaces of the apertures **108**, which may provide a stronger bond between the fasteners **109** and the pallet **100** components (e.g., structural members **110**, base members **120**, intermediate members **140**, top outside members **160**, top middle members **170**, support blocks **180**, etc.). However, the repeated insertion and removal of the fastener **109** from the aperture **108** may not degrade the aperture **108** for future fastener **109** attaching.

[0136] In one or more embodiments, the intermediate members **140** may also include protrusions **154** located on the first surface **143** of the intermediate member **140** as shown in **FIG. 3A**. In other words, protrusions **154** may extend from the first surface **143** of the intermediate member **140**. These protrusions **154** may be used to help locate the top layer **125** such that the top outside members **160** and the top middle members **170** are properly positioned on the intermediate members **140** and relative to each other. For example, the one or more top middle member **170** may define recesses **175** (e.g., as described further herein and shown in **FIGS. 6B and 6C**) that may receive the

protrusions **154** of the intermediate members **140** when the intermediate members **140** and the one or more top middle member **170** are removably coupled. The receiving of the protrusions **154** of the intermediate members **140** by the recesses **175** of the one or more top middle members **170** may provide advantages such as, locating and positioning the one or more top middle member **170**, improving ease of assembly, increasing the impact strength and energy dissipation (e.g., by increasing the surface area for which the members may apply forces on one another in a shear direction), ensuring squareness of the members relative to one another, etc.

[0137] Additionally, the intermediate member **140** may define an aperture **108** that extends through the protrusion **154** as shown in **FIG. 3F**. The aperture **108** illustrated in **FIG. 3F** may be used for insertion of a fastener **109** through the one or more top middle member **170** and into the intermediate member **140** (e.g., through the aperture **108** shown in **FIG. 3F**) to removably couple the intermediate members **140** to the one or more top middle member **170**. The aperture **108** may extend from the first surface **143** or protrusion **154** of the intermediate member **140** through the entirety of the intermediate member **140**. In other embodiments, the aperture **108** may extend from the first surface **143** or protrusion **154** of the intermediate member **140**, but not all the way through the intermediate member **140**. For example, the aperture **108** may be effectively used as a guide for the fastener **109**, but may not need to extend through the entirety of the intermediate member **140** (e.g., because the intermediate member **140** may be only coupled to the top layer **125** above it). Further, the aperture **108** may not extend through the entirety of the intermediate member **140** because there may be a possibility of interference during assembly with a top surface of a component positioned below the second surface **144** of the intermediate member **140**. However, in some embodiments, the aperture **108** may extend through the entirety of the intermediate member **140** to couple the intermediate member **140** something both above (e.g., the top layer **125**) and below (e.g., the support blocks **180**) the intermediate member **140**.

[0138] Further, the intermediate member **140** may define recesses **152** proximate the second surface **144** of the intermediate member **140** as shown in the cross-sectional view illustrated in **FIG. 3G**. The recesses **152** of the intermediate member **140** may be configured to receive components of the support blocks 180 (e.g., protrusions **185** of the support blocks **180**) to position the intermediate members **140** relative to the support blocks **180**. The interaction of the recesses **152** of the intermediate member **140** and the

protrusions **185** of the support blocks **180** may also provide, e.g., easier locating of the intermediate members **140** relative to the support blocks **180** (including lining up the apertures **108** of each such that a fastener **109** may be inserted for removably coupling), easier assembly, increased impact strength and energy dissipation (through interlocking of protrusions **185** and recesses **152**), squareness of the intermediate members **140** relative to the support blocks **180**. With respect to the increased impact strength and energy dissipation, the insertion of the protrusions **185** of the support blocks **180** into the recesses **152** of the intermediate members **140** may provide surfaces (of the protrusion **185** and recesses **152**) that contact perpendicular to the second surface **144** of the intermediate member **140**, and thus, may help dissipate shear forces due to a greater surface area interface. Without the protrusions **185** and recesses **152**, the fasteners **109** connecting the support block **180** to the intermediate member **140** may be exposed to a shear force that could result in damage to, e.g., the fasteners **109**. In some embodiments, the protrusions 185 of the support blocks **180** may provide an interference fit with the recesses **152** of the intermediate members **140** to assist in coupling them together.

[0139] The recesses **152** of the intermediate members **140** may be any shape or size. For example, the recesses **152** of the intermediate member **140** may be sized such that the recesses **152** receive the protrusions **185** of the support block **180** without slack or gaps between them. Also, the recesses **152** of the intermediate members **140** may be defined at least partially by the two or more ribs **146** of the intermediate members **140** as shown in **FIGS. 3B, 3C, and 3G**. Further, the recesses **152** of the intermediate members **140** may be defined by cross ribs that extends perpendicular to the two or more ribs **146** (e.g., across the width **153** of the intermediate member **140**). It is noted that the cross ribs of the intermediate member may or may not include continuous fiber bundles **149** similar to those located within the two or more ribs **146** of the intermediate member **140**.

[0140] One exemplary base member **120** of the two or more base members **120** is shown in **FIGS. 4A-4C**. The base member **120** may define a first surface **123** and a second surface **124** opposite the first surface **123**. Also, the base member **120** may extend between a first end **121** and a second end **142**. The base member **140** may define a variety of different shapes and sizes. For example, the base member **120** may define a rectangular prism shape or a "board-like" shape. Specifically, the first and second surfaces **123**, **124** of the base member **120** may define a major surface such that the surface areas of each of the first and second surfaces **123**, **124** of the base member **120** are

significantly larger than the other surfaces of the base member **120**. For example, the length **131** of the base member **120** measured between the first end **121** and the second end **122** may be 40 inches (e.g., about 1.0 m). The width **133** of the base member **120** (e.g., along the first or second surface **123**, **124** and perpendicular to the length **131**) may be 4 inches (e.g., about 10 cm). The thickness of the base member 120 (e.g., perpendicular to both the length **131** and width **133**, measured from first surface **133** to rib end portion **128**) may be 0.75 inches (e.g., about 1.9 cm). Additionally, each of the base members **120** may weigh about greater than or equal to 1 pound, greater than or equal to 1.4 pounds, greater than or equal to 1.8 pounds, greater than or equal to 2 pounds, etc. and/or less than or equal to 5 pounds, less than or equal to 4 pounds, less than or equal to 3 pounds, less than or equal to 2.5 pounds, etc. More specifically, each of the base members **120** may weigh about 1.8 pounds to 2.5 pounds (e.g., for a base molding compound of about 40% to 50% long fiber thermoplastic).

[0141] Each base member **120** may include any combination of selective reinforcements (e.g., ribs, fiber dispersion, continuous fiber bundle, mesh, etc.) as described with respect to the intermediate member **140** herein. For example, as shown in **FIGS. 4B and 4C**, the base member **120** may include two or more ribs **126** that may extend away from the second surface **124** to a rib end portion **128** between the first and second ends **121**, **122** of the base member **120**. Also, the base member **120** may include fiber dispersed in a thermoplastic material and each of the two or more ribs **126** of the base member **120** may include a continuous fiber bundle (e.g., similar to the continuous fiber bundles **149** described with respect to the intermediate member **140**). Furthermore, for example, the base member **120** may include a structural mesh positioned proximate the first surface **123** of the base member **120** to improve the structural rigidity of the base members **120**. For example, any force applied towards the first surface **123** of the base member **120** (e.g., payload forcing down on the pallet **100**) may be counteracted or resisted by the continuous fiber bundles in the two or more ribs **126** and any force applied towards the second surface **124** of the base member **120** (e.g., upward force due to tines or racks on which the pallet **100** is resting) may be counteracted or resisted by the structural mesh.

[0142] The base member **120** may also define a bevel **132** along the length **131** of the base member **120** between the first surface **123** and an adjacent side surface as shown in **FIG. 4A**. The bevel **132** may be described as a sloped surface or edge between the

first surface **123** and the adjacent side surface. The base member **120** may have any number of bevels **131**. For example, as shown in **FIG. 4A**, the base member **120** defines two bevels **132** on each side of the base member **120**. The bevel **132** may be positioned at any location along the base member **120**. For example, the bevel **132** may be lined up with any or all of the at least two discrete openings **105** shown in **FIG. 1**. The bevel **132** may allow for easy access by a material handling equipment such as "walkies" (e.g., manually operated lifting devices that roll up and over the base member **120** to access the middle of the pallet **100** through the at least two discrete openings **105**).

[0143] As shown in **FIGS. 1 and 2**, the base member **120** is oriented such that the first surface **123** may be adjacent the support blocks **180** when the base member **120** is removably coupled to the support blocks **180**. In some embodiments, the base member **120** may be "flipped" or rotated such that the two or more ribs **126** of the base member **120** may be adjacent the support blocks **180**. In such embodiments, the support blocks **180** may include a protrusion (e.g., extending away from the second surface **184** of the support blocks **180**) that may be received by a recess defined by the base member **120**. In other words, a protrusion of the support block **180** and a recess of the base member **120** may interact to help position or locate the base member **120** relative to the support block **180** and provide the same benefits as discussed herein with respect to the intermediate member **140** (e.g., recesses **152**) and the support blocks **180** (e.g., protrusions **185**).

[0144] One exemplary top outside member **160** of the two top outside members **160** is shown in **FIGS. 5A-5C**. The top outside member **160** may define a first surface **163** and a second surface **164** opposite the first surface **163**. Also, the top outside member **160** may extend between a first end **161** and a second end **162**. The top outside member **160** may define a variety of different shapes and sizes. For example, the top outside member **160** may define a rectangular prism shape or a "board-like" shape. Specifically, the first and second surfaces **163**, **164** of the top outside member **160** may define a major surface such that the surface areas of each of the first and second surfaces **163**, **164** of the top outside member **160** are significantly larger than the other surfaces of the top outside member **160**. For example, the length **191** of the top outside member **160** measured between the first end **161** and the second end **162** may be 40 inches (e.g., about 1.2 m). The width **193** of the top outside member **160** (e.g., along the first or second surface **163**, **164** and perpendicular to the length **191**) may be 4 inches (e.g., about 10 cm). The thickness of the top outside member **160** (e.g., perpendicular to both the length **191** and

width **193**, measured from first surface **163** to rib end portion **168)** may be 0.75 inches (e.g., about 1.9 cm). Additionally, each of the top outside members **160** may weigh about greater than or equal to 1 pound, greater than or equal to 1.5 pounds, greater than or equal to 2 pounds, greater than or equal to 2.4 pounds, etc. and/or less than or equal to 5 pounds, less than or equal to 4 pounds, less than or equal to 3 pounds, less than or equal to 2.7 pounds, etc. More specifically, each of the top outside members **160** may weigh about 2 pounds to 2.7 pounds (e.g., for a base molding compound of about 40% to 50% long fiber thermoplastic).

[0145] Each top outside member **160** may include any combination of selective reinforcements (e.g., ribs, fiber dispersion, continuous fiber bundle, mesh, etc.) as described with respect to the intermediate member **140**. For example, as shown in **FIGS. 5B and 5C**, the top outside member **160** may include two or more ribs **166** that may extend away from the second surface **164** to a rib end portion **168** between the first and second ends **161**, **162** of the top outside member **160**. Also, the top outside member **160** may include fiber dispersed in a thermoplastic material and each of the two or more ribs **166** of the top outside member **160** may include a continuous fiber bundle (e.g., similar to the continuous fiber bundles **149** described with respect to the intermediate member **140)**. The continuous fiber bundle located in each rib of the two or more ribs **166** may help to provide strength due to, e.g., forces or deflection caused by a payload that is located on one edge of the top outside member **160**. In one or more embodiments, the ribs **166** located at the edge of the top outside member **160** may be thicker (and, e.g., containing a thicker continuous fiber bundle) to account for such an edge-racked loading. Furthermore, for example, the top outside member **160** may include an impact mesh positioned proximate the first surface **163** of the top outside member **160** to improve the impact resiliency of the top outside member **160**. For example, any impact force applied on the first surface **163** of the top outside member **160** (e.g., payload dropped down on the pallet **100)** may be deflected and absorbed by the impact mesh.

[0146] One exemplary top middle member **170** of the one or more top middle members **170** is shown in **FIGS. 5A-5C**. The top middle member **170** may define a first surface **173** and a second surface **174** opposite the first surface **173**. Also, the top middle member **170** may extend between a first end **171** and a second end **172**. The top middle member **170** may define a variety of different shapes and sizes. For example, the top middle member **170** may define a rectangular prism shape or a "board-like" shape.

Specifically, the first and second surfaces **173**, **174** of the top middle member **170** may define a major surface such that the surface areas of each of the first and second surfaces **173**, **174** of the top middle member **170** are significantly larger than the other surfaces of the top middle member **170**. For example, the length of the top middle member **170** measured between the first end **171** and the second end **172** may be 40 inches (e.g., about 1.0 m). The width of the top middle member **170** (e.g., along the first or second surface **173**, **174** and perpendicular to the length) may be 4 inches (e.g., about 10 cm). The thickness of the top middle member **170** (e.g., perpendicular to both the length and width, measured from first surface **173** to the opposing edge) may be 0.75 inches (e.g., about 1.9 cm). Additionally, each of the top middle members **170** may weigh about greater than or equal to 0.5 pounds, greater than or equal to 1 pound, greater than or equal to 1.1 pounds, greater than or equal to 1.2 pounds, etc. and/or less than or equal to 4 pounds, less than or equal to 3 pounds, less than or equal to 2 pounds, less than or equal to 1.5 pounds, etc. More specifically, each of the top middle members **170** may weigh about 1.1 pounds to 1.5 pounds (e.g., for a base molding compound of about 40% to 50% long fiber thermoplastic).

[0147] The one or more top middle members **170** may include one large article or member that spans the space between the two top outside members **160** or multiple top middle members **170** (e.g., nine top middle members **170** as shown in **FIG. 1**) that are spaced across the top layer **165** of the pallet **100**. The one or more top middle members **170** may be described as fill members or "non-structural" members because the one or more top middle members **170** may not necessarily include selective reinforcements similar to the structural members **110**. However, in one or more embodiments, the top middle members **170** may include some selective reinforcements, e.g., the top middle members 170 may include two or more ribs **176** that may extend away from the second surface **174** to a rib end portion **178** between the first and second ends **171**, **172** of the top middle member **170**. In other embodiments, the top middle member **170** defines a rectangular cross-section that does not include any rib sections. Also, the top middle members **170** may include impact mesh, as described herein, to assist in impact resiliency and to, e.g., provide flexibility for sudden impact of payload or cargo dropped on the top middle members **170**.

[0148] Additionally, the one or more top middle members **170** may define recesses **175** proximate the second surface **174** of the top middle members **170**. The recesses **175**

may be configured to locate and position the top middle members **170** relative to the intermediate members **140** by receiving the protrusions **154** of the intermediate member **140** when the intermediate member **160** is removably coupled to the top middle members **170**. Furthermore, the top middle members **170** may define apertures **108** configured to receive fasteners **109** such that the top middle members **170** may be removably coupled to the intermediate members **140**.

[0149] The one or more top middle members **170** may include (e.g., be made of or formed of) a variety of different materials. For example, the one or more top middle members **170** may include a base molding compound including thermoplastic, thermoset, polyolefin, polypropylene, polyethylene, and/or high-density polyethylene. Specifically, the top middle members **170** may include high-density polyethylene because of its lower ignition point and propensity to drip less in a melted state (e.g., as compared to polypropylene). Also, the top middle members **170** may include no or low fiber dispersion reinforcement (e.g., as compared to structural members **110**). For example, the top middle members **170** may include greater than or equal to 0% wt, greater than or equal to 5% wt, greater than or equal to 10% wt, greater than or equal to 15% wt, etc. and/or less than or equal to 30% wt, less than or equal to 25% wt, less than or equal to 20% wt, less than or equal to 17% wt, etc. of reinforced materials (e.g., long or short fiber).

[0150] The pallet **100** may also include a plurality of support blocks **180** that may be positioned to separate the base layer **125** from the intermediate layer **145** and the top layer **165** to define at least two discrete openings **105** so that the pallet **100** may be moved and/or lifted. Each of the support blocks **180** may define a first surface **183** and a second surface **184** opposite the first surface **183**. In one or more embodiments, the support blocks **180** include protrusions **185** (e.g., castles) extending from the first surface **183** of the support block **180**. The protrusions **185** of the support blocks **180** may be any size or shape (e.g., circular, rectangular, triangular, square, etc.). The protrusions **185** may be configured to be inserted into recesses (e.g., recesses **152** of the intermediate members **140**) to help locate the intermediate members **140** relative to the support blocks and strengthen the pallet **100** as further described herein. In some embodiments, the support blocks **180** may include protrusions **185** extending from the second surface **184** of the support blocks **180**. Protrusions **185** of the support blocks **180** extending from the second surface **184** may interface with the base members **120** in an embodiment in which the

base members **120** are rotated such that recesses of the base members **120** are adjacent the protrusions **185** of the support blocks **180**.

[0151] The support blocks **180** may include (e.g., be made of or formed of) a variety of different materials. For example, the support blocks **180** may include a base molding compound including thermoplastic, thermoset, polyolefin, polypropylene, polyethylene, and/or high-density polyethylene. Specifically, the support blocks **180** may include high-density polyethylene. Also, the support blocks **180** may include no or low fiber dispersion reinforcement. For example, the top middle members **170** may include greater than or equal to 0% wt, greater than or equal to 5% wt, greater than or equal to 10% wt, greater than or equal to 15% wt, etc. and/or less than or equal to 30% wt, less than or equal to 25% wt, less than or equal to 20% wt, less than or equal to 17% wt, etc. of glass reinforced materials (e.g., long or short fiber). In one or more embodiments, the support blocks **180** may include a different material than the structural members **110** (e.g., base members **120**, intermediate members **140**, top outside members **160**). For example, the structural members **110** may include a first thermoplastic material and the support blocks **180** may include a second thermoplastic material; and the first thermoplastic material may be a different type of thermoplastic material than the second thermoplastic material.

[0152] In some embodiments, the support blocks **180** may be solid throughout or hollow through the middle, however, as shown in **FIGS. 7-10**, the support blocks **180** may include support ribs **188** extending for at least a portion between the first and second surfaces **183**, **184** of the support blocks **180**. The support ribs **188** of the support blocks **180** may be positioned to provide specific rigidity and resilience/flexibility to the support blocks **180**. For example, the support blocks **180** may often be impacted or jabbed by tines of a lifting device (e.g., to better position the pallet **100** for lifting). The support ribs **188** of the support blocks **180** and the high-density polyethylene composition may help provide pliability to help counter the sudden impacts. The support blocks **180** may also include one or more alignment walls **186** as shown in **FIGS. 8-10**. The alignment walls **186** may help to align the intermediate member **140** positioned on the support block **180** and may help to support the top outside members **160** (e.g., by increasing the surface area on which the top outside member **160** rests). Also, the support blocks **180** define apertures **108** that are configured to receive fasteners **109** so that the intermediate members **140**, base members **120**, top outside members **160**, and top middle members **170**

may be removably coupled to the support blocks **180**. Additionally, an impact mesh may be embedded in the support blocks **180** to also provide increased flexibility.

[0153] The plurality of support blocks **180** may include a variety of different types of support blocks **180** as shown **in FIGS. 7-10**. For example, **FIG. 7** illustrates a middle block 250 defining a first surface **253** and a second surface **254** opposite the first surface **253**. The middle block **250** may be positioned at a center point of each intermediate member **140** and the middle block **250** may be removably coupled to the intermediate member **140** (e.g., with the interface proximate the first surface **253** of the middle block **250** and the second surface **144** of the intermediate member **140**) and may be removably coupled to the base member **120** (e.g., with the interface proximate the second surface **254** of the middle block **250** and the first surface **123** of the base member **120**).

[0154] **FIG. 8** illustrates a center block **230** defining a first surface **233** and a second surface **234** opposite the first surface **233**. The center blocks **230** may be positioned on the first and second ends **141**, **142** of the intermediate member **140** located not along the edges (e.g., the intermediate inside member). The center blocks **230** may be removably coupled to the intermediate member **140** (e.g., with the interface proximate the first surface **233** of the center blocks **230** and the second surface **144** of the intermediate member **140**) and may be removably coupled to the base member **120** (e.g., with the interface proximate the second surface **234** of the center blocks **230** and the first surface **123** of the base member **120**). The center blocks **230** may include two alignment walls **186** for the intermediate member **140** to be positioned in between.

[0155] **FIGS. 9 and 10** illustrate two different embodiments of corner blocks **200**, **210** that may define a first surface **203**, **213** and a second surface **204**, **214** opposite the first surface **213**, **214**. The corner blocks **200**, **210** may be positioned in the corners of the pallet **100** on the first and second ends **141**, **142** of the intermediate members **140** located along the edges (e.g., the intermediate outside members). The corner blocks **200**, **210** may be removably coupled to the intermediate member **140** (e.g., with the interface proximate the first surface **203**, **213** of the corner blocks **200**, **210** and the second surface **144** of the intermediate member **140**) and may be removably coupled to the base member **120** (e.g., with the interface proximate the second surface **204**, **214** of the corner blocks **200**, **210** and the first surface **123** of the base member **120**). The corner blocks **200**, **210** may include one alignment wall **186** for the intermediate member **140** to be positioned against. The alignment wall **186** of the corner blocks **200**, **210** may be positioned such

that the alignment wall **186** may also be located on the inside of the pallet **100** closest to the at least two discrete openings **105** (e.g., away from the edges of the pallet **100**) to provide increased surface area support to the top outside members 160.

[0156] The exemplary pallet **100** described herein may also include a flame retardant within the base molding compound. For example, each of the base members **120**, intermediate members **140**, top outside members **160**, top middle members **170**, and support blocks **180** may include some degree of flame retardant (e.g., to meet National Fire Protection Association fire retardant requirements). Specifically, the flame retardant used in the pallet **100** may be a non-halogenated, non-brominated food-contact-safe fire retardant that may be compliant with U.S. Food and Drug Administration regulations.

[0157] The amount of flame retardant used in the structural members **110** may be about 0% to 10% of the base wt flame retardant. Typically the amount of flame retardant in a pallet may be about 30% to 40% of the base wt flame retardant. The lower amount of flame retardant may be included for a variety of reasons. For example, the flame retardant may provide a negative impact on performance that may counter act the increased performance of the selective reinforcements, the lower amount of flame retardant may improve moldability of the base molding compound (as compared to a higher flame retardant percentage), etc. The top middle members **170** may include about 5% to 15% of the base wt flame retardant. In one or more embodiments, the two or more ribs may include a different base wt percent flame retardant than the rest of the member from which the ribs extend. The support blocks **180** generally may include about 0% to 15% wt of the base flame retardant. Specifically, the center blocks **230** and middle blocks **250** may include about 0% to 10% of the base wt flame retardant, and the corner blocks **200**, **210** may include about 5% to 15% of the base wt flame retardant. The corner blocks **200**, **210** may include a higher wt percentage of flame retardant additive because the corners of the pallet **100** may be more exposed to potential fire.

[0158] Furthermore, the pallet **100** may define openings (e.g., at the top layer **165** and/or within the top middle members **170**) to form a certain amount of open surface area to allow for, e.g., easier handling and increased water resonance during a fire (as compared to no or minimal open surface area). For example, the top layer **165** may define at least 10% to 20% surface area that may be open.

[0159] The exemplary pallet **100** described herein may also be described as components of a kit. For example, the kit may include all of the elements described

herein as being configured to be removably coupled to assemble a pallet **100**. Specifically, the kit may include, e.g., structural members **110** (e.g., base members **120**, intermediate members **140**, top outside members **160**), top middle members **170**, support blocks **180**, fasteners **109**, etc.

[0160] Thus, embodiments of COMPOSITE PALLETS are disclosed.

[0161] Although specific embodiments have been illustrated and described herein, it will be appreciated by those of ordinary skill in the art that a variety of alternate and/or equivalent implementations can be substituted for the specific embodiments shown and described without departing from the scope of the present disclosure. This application is intended to cover any adaptations or variations of the specific embodiments discussed herein. Therefore, it is intended that this disclosure be limited only by the claims and the equivalents thereof. The disclosed embodiments are presented for purposes of illustration and not limitation.

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What is claimed is:

1. A rail-rackable composite pallet, comprising:

a base layer comprising two or more thermoplastic base members, wherein each thermoplastic base member of the two or more thermoplastic base members defines a first surface and a second surface opposing the first surface, wherein each thermoplastic base member of the two or more thermoplastic base members extends between a first end and a second end;

an intermediate layer comprising two or more thermoplastic intermediate members, wherein each thermoplastic intermediate member of the two or more thermoplastic intermediate members defines a first surface and a second surface opposing the first surface, wherein each thermoplastic intermediate member of the two or more thermoplastic intermediate members extends between a first end and a second end;

two or more thermoplastic support blocks removably attached to the base layer proximate the first surfaces of the two or more thermoplastic base members and removably attached to the intermediate layer proximate the second surfaces of the two or more thermoplastic intermediate members such that the two or more thermoplastic support blocks are positioned between the base layer and the intermediate layer, wherein the two or more thermoplastic support blocks separate the base layer from the intermediate layer;

wherein the two or more thermoplastic support blocks include a first support block and a second support block, the first support block having a first section with a first width extending between opposing outer surfaces of the first support block in the first section and a second section with a second width extending between opposing outer surfaces of the first support block in the second section, wherein the second width is different from the first width, the second support block having a substantially constant width extending between opposing outer surfaces of the second support block; and

a top layer comprising two thermoplastic top outside members removably attached to the intermediate layer proximate the first surfaces of the two or more thermoplastic intermediate members, wherein each thermoplastic top outside member of the two thermoplastic top outside members defines a first surface and a second surface opposing the first surface, wherein each thermoplastic top outside member of the two thermoplastic top outside members extends between a first end and a second end,

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wherein at least some of the two or more thermoplastic base members, the two or more thermoplastic intermediate members, and the two thermoplastic top outside members are thermoplastic structural members, wherein each thermoplastic structural member comprises two or more ribs extending away from the second surface to a rib end portion between the first and second ends of the thermoplastic structural member, wherein each thermoplastic structural member comprises fiber dispersed in a thermoplastic material and each of the two or more ribs of the thermoplastic structural member comprises a continuous fiber bundle within each rib proximate the rib end portion.

2. The rail-rackable composite pallet of claim 1, wherein each thermoplastic intermediate member of the two or more thermoplastic intermediate members comprises an open mesh proximate the first surface.

3. The rail-rackable composite pallet of claim 1, wherein the top layer comprises one or more top middle members positioned between the two thermoplastic top outside members, wherein each of the one or more top middle members defines a first surface and a second surface opposing the first surface, wherein each of the one or more top middle members extends between a first end and a second end, wherein the one or more top middle members are removably attached to the intermediate layer such that the second surface of the one or more top middle members is proximate the first surfaces of the two or more thermoplastic intermediate members.

4. The rail-rackable composite pallet of claim 1, wherein the structural members and the two or more thermoplastic support blocks comprise a non-halogenated, non-brominated food-contact-safe fire retardant.

5. The rail-rackable composite pallet of claim 1, wherein the two or more thermoplastic base members are coplanar such that the first surfaces of each of the thermoplastic base members are coplanar.

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6. The rail-rackable composite pallet of claim 1, wherein the two or more ribs of each thermoplastic structural member comprise four ribs that are parallel to and equidistant from one another.

7. The rail-rackable composite pallet of claim 1, wherein the two or more thermoplastic support blocks are removably attached to both of the base layer and the intermediate layer using one or more fasteners.

8. The rail-rackable composite pallet of claim 1, wherein the continuous fiber bundle comprises at least 1000 continuous fibers dispersed in a thermoplastic material.

9. The rail-rackable composite pallet of claim 1, wherein at least one thermoplastic support block of the two or more thermoplastic support blocks couples two thermoplastic base members of the two or more thermoplastic base members together.

10. The rail-rackable composite pallet of claim 1, wherein the thermoplastic structural members comprise a first thermoplastic material and the two or more support blocks comprise a second thermoplastic material and the first thermoplastic material is a different type of thermoplastic material than the second thermoplastic material.

11. The rail-rackable composite pallet of claim 1, wherein the base layer, the two or more support blocks, and the top layer define at least two discrete openings for inserting a lifting tool.

12. The rail-rackable composite pallet of claim 1, wherein the two or more thermoplastic support blocks comprise protrusions and the two or more thermoplastic intermediate members comprise recesses such that the protrusions are received by the recesses to position or align or mate the two or more thermoplastic intermediate members relative to the two or more thermoplastic support blocks.

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13. The rail-rackable composite pallet of claim 1, wherein the two or more thermoplastic intermediate members comprise two thermoplastic intermediate outside members and one or more thermoplastic intermediate inside member, wherein the two or more thermoplastic support blocks comprise corner blocks, center blocks, and middle blocks, wherein the middle blocks are positioned proximate a center point of each thermoplastic intermediate member, wherein the corner blocks are positioned proximate the first and second ends of each of the two thermoplastic intermediate outside members, and wherein the center blocks are positioned proximate the first and second ends of the one or more thermoplastic intermediate inside member.

14. The rail-rackable composite pallet of claim 1, wherein each thermoplastic support block of the two or more thermoplastic support blocks defines a first surface proximate the intermediate layer and a second surface proximate the base layer, wherein a portion of the two or more thermoplastic support blocks comprise an alignment wall extending from the first surface of the thermoplastic support block, wherein the alignment wall aligns a thermoplastic intermediate member on a thermoplastic support block and contacts the top layer.

15. The rail-rackable composite pallet of claim 1, wherein the two or more thermoplastic support blocks comprise corner blocks, center blocks, and middle blocks, wherein each thermoplastic support block of the two or more thermoplastic support blocks defines a first surface proximate the intermediate layer and a second surface proximate the base layer, wherein the center blocks comprise two alignment walls extending from the first surface of the center block, wherein the first end of a thermoplastic intermediate member is positioned on the first surface of a first center block of the center blocks between the two alignment walls and the second end of a thermoplastic intermediate member is positioned on the first surface of a second center block of the center blocks between the two alignment walls.

16. The rail-rackable composite pallet of claim 1, wherein each thermoplastic support block of the two or more thermoplastic support blocks defines a first surface proximate the intermediate layer and a second surface proximate the base layer, wherein each thermoplastic

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support block comprises support ribs for at least a portion between the first and second surfaces of each thermoplastic support block.

17. The rail-rackable composite pallet of claim 1, wherein the two or more thermoplastic intermediate members comprise protrusions extending from the first surface of each of the two or more thermoplastic intermediate members and the one or more top middle members defines recesses proximate the second surface of each of the one or more top middle members, wherein the protrusions of the two or more thermoplastic intermediate members are received by the recesses of the one or more top middle members.

18. A kit for assembling a pallet, the kit comprising:

two or more thermoplastic base members, wherein each thermoplastic base member of the two or more thermoplastic base members defines a first surface and a second surface opposing the first surface, wherein each thermoplastic base member of the two or more thermoplastic base members extends between a first end and a second end;

two or more thermoplastic intermediate members, wherein each thermoplastic intermediate member of the two or more thermoplastic intermediate members defines a first surface and a second surface opposing the first surface, wherein each thermoplastic intermediate member of the two or more thermoplastic intermediate members extends between a first end and a second end and comprises two or more ribs extending away from the second surface to a rib end portion between the first and second end of the thermoplastic intermediate member, wherein each thermoplastic intermediate member comprises fiber dispersed in a thermoplastic material and each of the two or more ribs of the thermoplastic intermediate member comprises a continuous fiber bundle within each rib proximate the rib end portion, wherein each thermoplastic intermediate member of the two or more thermoplastic intermediate members defines recesses proximate the second surface of each thermoplastic intermediate member;

a plurality of thermoplastic support blocks configured to be removably attached to the two or more thermoplastic base members and the two or more thermoplastic intermediate members, wherein the plurality of thermoplastic support blocks are configured to separate the two or more thermoplastic base members from the two or more thermoplastic intermediate members, wherein the each of the plurality of thermoplastic support blocks comprise protrusions

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configured to be received by the recesses of the two or more thermoplastic intermediate members;

wherein the plurality of support blocks include a first support block having a first alignment member adjacent to a first side region of the first support block, a second support block having a second alignment member adjacent to a second side region of the second support block, and a third support block having a pair of opposed alignment members, wherein the first, second, and third support blocks each have a different shape; and

fasteners configured to removably attach the two or more thermoplastic base members to the plurality of thermoplastic support blocks, to removably attach the two or more thermoplastic intermediate members to the plurality of thermoplastic support blocks, and to removably attach the two thermoplastic top outside members to the two or more thermoplastic intermediate members.

19. The pallet of claim 7, wherein the one or more fasteners includes a screw.

20. The pallet of claim 11, wherein the lifting tool includes a mechanically assisted lifting device.

21. A composite pallet, comprising:

a plurality of base boards including a first base board and a second base board;

a plurality of support blocks coupled to the plurality of base boards, the plurality of support blocks including a first support block;

wherein the first support block is detachably connected to the first base board, is detachably connected to the second base board, and secures the first base board to the second base board;

wherein the first support block includes a first section with a first width and a second section with a second width different from the first width;

a plurality of intermediate boards coupled to the plurality of support blocks;

a plurality of top boards coupled to the plurality of intermediate boards;

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wherein the plurality of top boards include a top outside board, the top outside board comprising a thermoplastic material, a rib, and a tension member disposed within the rib and positioned adjacent to an end portion of the rib; and

wherein the tension member includes a continuous fiber bundle.

22. The composite pallet of claim 21, wherein the first support block is detachably connected to the first base board with one or more fasteners.

23. The composite pallet of claim 21, wherein the plurality of intermediate boards includes a first intermediate board, wherein the first intermediate board includes a plurality of sockets, and wherein the first support block includes a plurality of protrusions configured to engage the plurality of sockets.

24. The composite pallet of claim 21, wherein the second width is smaller than the first width.

25. The composite pallet of claim 24, wherein the first base board has a third width and wherein the first width is greater than the third width.

26. The composite pallet of claim 25, wherein the second width is substantially equal to the third width.

27. The composite pallet of claim 21, wherein the thermoplastic material includes polypropylene.

28. The composite pallet of claim 21, wherein the top outside board includes an impact member disposed along a top portion thereof.

29. The composite pallet of claim 28, wherein the impact member includes an open mesh.

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30. The composite pallet of claim 21, wherein a plurality of glass fibers having an average length of 1 to 15 millimeters are dispersed in the top outside board.

31. The composite pallet of claim 21, wherein a plurality of glass fibers having an average length of 2 to 12 millimeters are dispersed in the top outside board.

32. A composite pallet, comprising:

a plurality of base boards including a first base board and a second base board;

a plurality of support blocks coupled to the plurality of base boards, the plurality of support blocks including a first support block;

wherein at least a portion of the first support block has a width greater than a width of the first base board;

wherein the first support block is detachably connected to the first base board, is detachably connected to the second base board, and secures the first base board to the second base board;

a plurality of intermediate boards coupled to the plurality of support blocks, the plurality of intermediate boards including a first intermediate board;

wherein the first intermediate board includes a first rib;

a first tension member disposed within the first rib and positioned adjacent to a first end portion of the first rib;

a plurality of top boards coupled to the plurality of intermediate boards, the plurality of top boards including a top outside board;

wherein the top outside board includes a second rib;

a second tension member disposed within the second rib and positioned adjacent to a second end portion of the second rib; and

wherein the first tension member, the second tension member, or both include a continuous fiber bundle.

33. The composite pallet of claim 32, wherein the first intermediate board includes one or more bosses projected from a top potion of the first intermediate board.

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34. The composite pallet of claim 32, wherein a plurality of glass fibers having an average length of 1 to 15 millimeters are dispersed in the top outside board.

35. The composite pallet of claim 32, wherein a plurality of glass fibers having an average length of 2 to 12 millimeters are dispersed in the top outside board.

36. A composite pallet, comprising:

a plurality of base boards including a first base board, a second base board, a third base board, and a fourth base board;

a plurality of support blocks coupled to the plurality of base boards, the plurality of support blocks including a first support block, a second support block, a third support block, and a fourth support block;

wherein the second support block is different from the first support block;

wherein the third support block is different from the first support block and the second support block;

wherein the fourth support block is different from the first support block, the second support block, and the third support block;

wherein the first support block is detachably connected to the first base board, is detachably connected to the second base board, and secures the first base board to the second base board;

wherein the first support block includes a plurality of projections extending from a top surface thereof;

wherein the second support block is detachably connected to the second base board and is free from attachment to any other of the plurality of base boards;

wherein the third support block is detachably connected to the second base board, is detachably connected to the third base board, and secures the second base board to the third base board;

wherein the fourth support block is detachably connected to the third base board, is detachably connected to the fourth base board, and secures the third base board to the fourth base board;

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a plurality of intermediate boards coupled to the plurality of support blocks, the plurality of intermediate boards including a first intermediate board;

wherein the first intermediate board includes a first rib;

a first tension member disposed within the first rib and positioned adjacent to a first end portion of the first rib, the first tension member including a first continuous fiber bundle;

a plurality of top boards coupled to the plurality of intermediate boards, the plurality of top boards including a top outside board;

wherein the top outside board includes a second rib; and

a second tension member disposed within the second rib and positioned adjacent to a second end portion of the second rib, the second tension member including a second continuous fiber bundle.

37. The composite pallet of claim 36, wherein the first support block includes a first section having a first width and a second section having a second width that is smaller than the first width.

38. The composite pallet of claim 37, wherein the first base board has a third width and wherein the first width is greater than the third width.

39. The composite pallet of claim 38, wherein the second width is substantially equal to the third width.

40. The composite pallet of claim 36, wherein the top outside board includes an impact member disposed along a top portion thereof.

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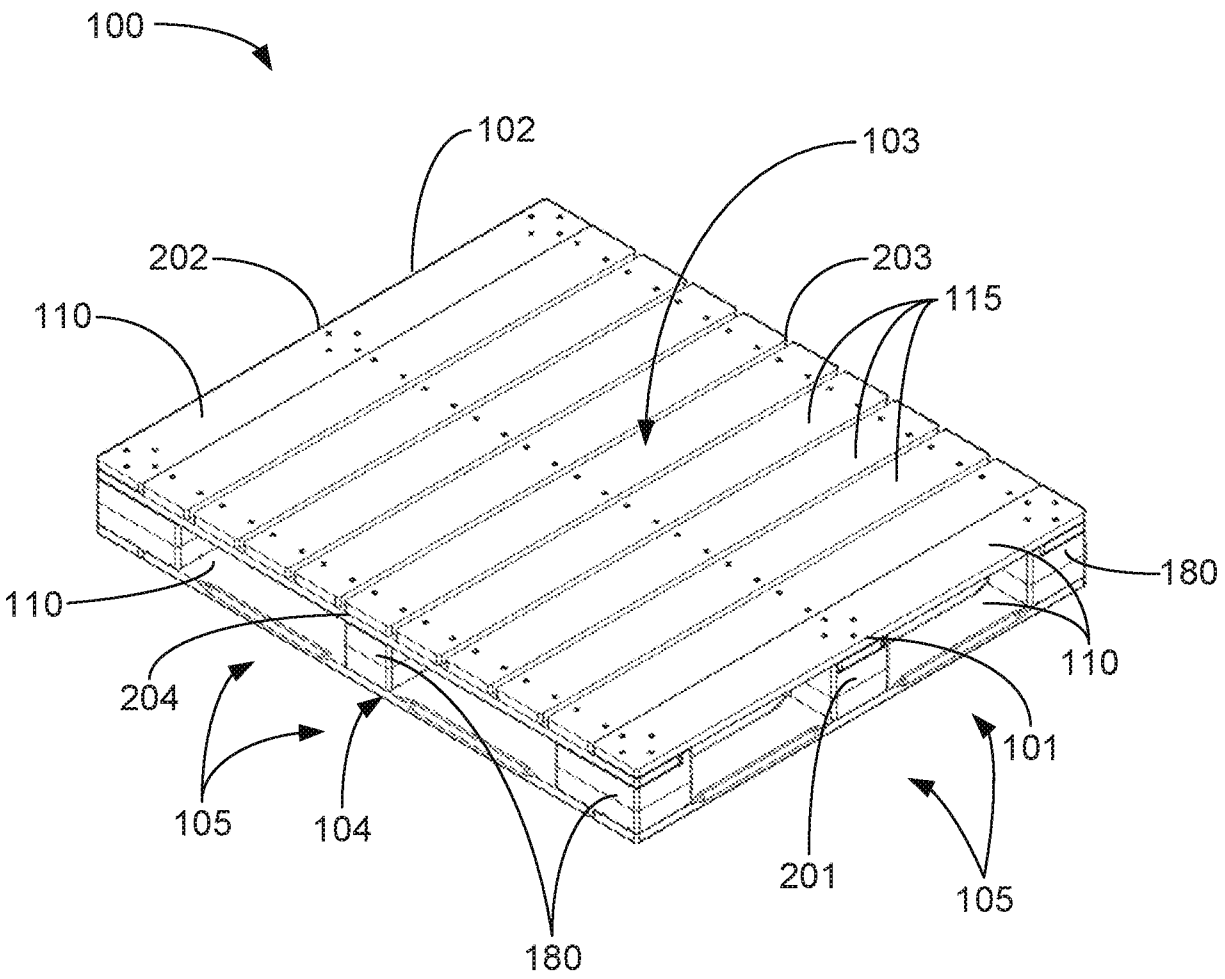

100
102
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202
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110
115
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FIG. 1

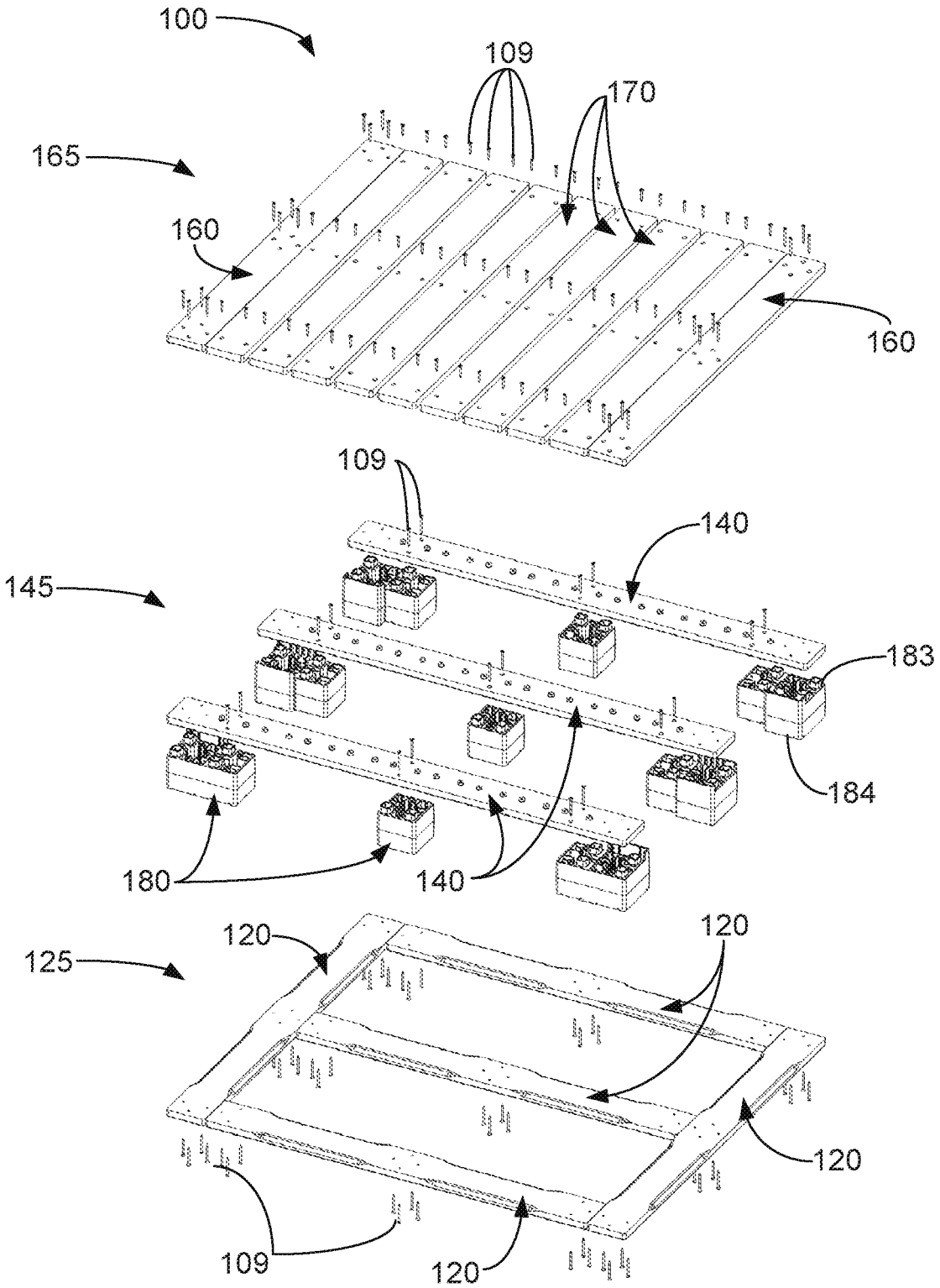

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120

FIG. 2

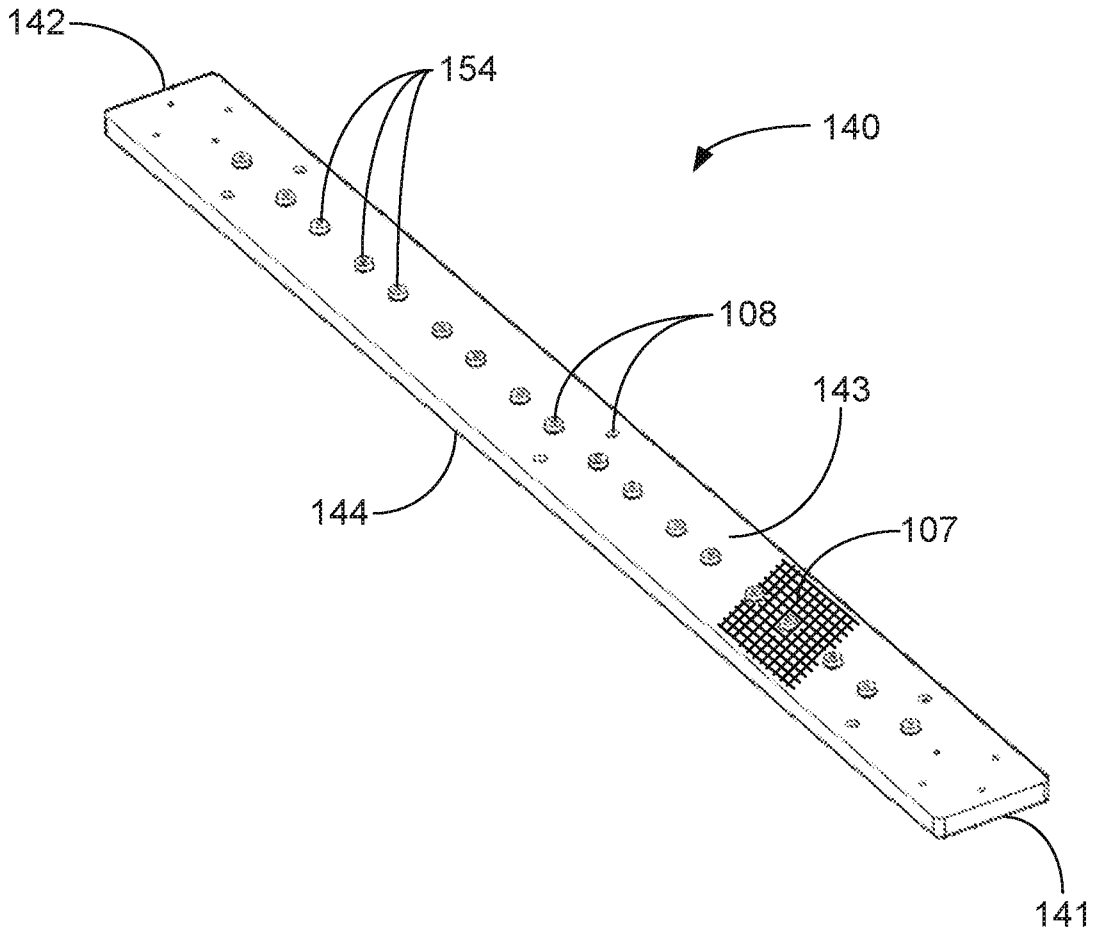

142
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143
144
107
141

FIG. 3A

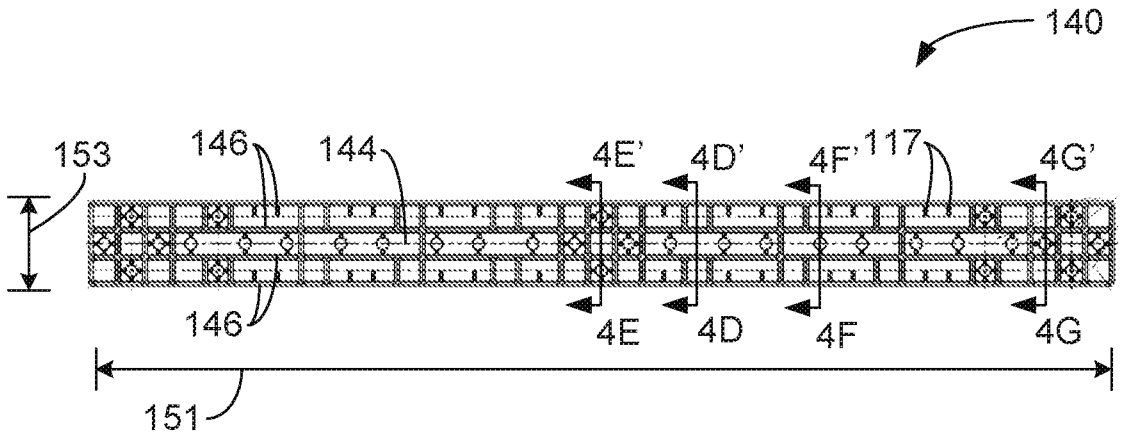

140
153
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4E'
4D'
4F'
117
4G'
146
4E
4D
4F
4G
151

FIG. 3B

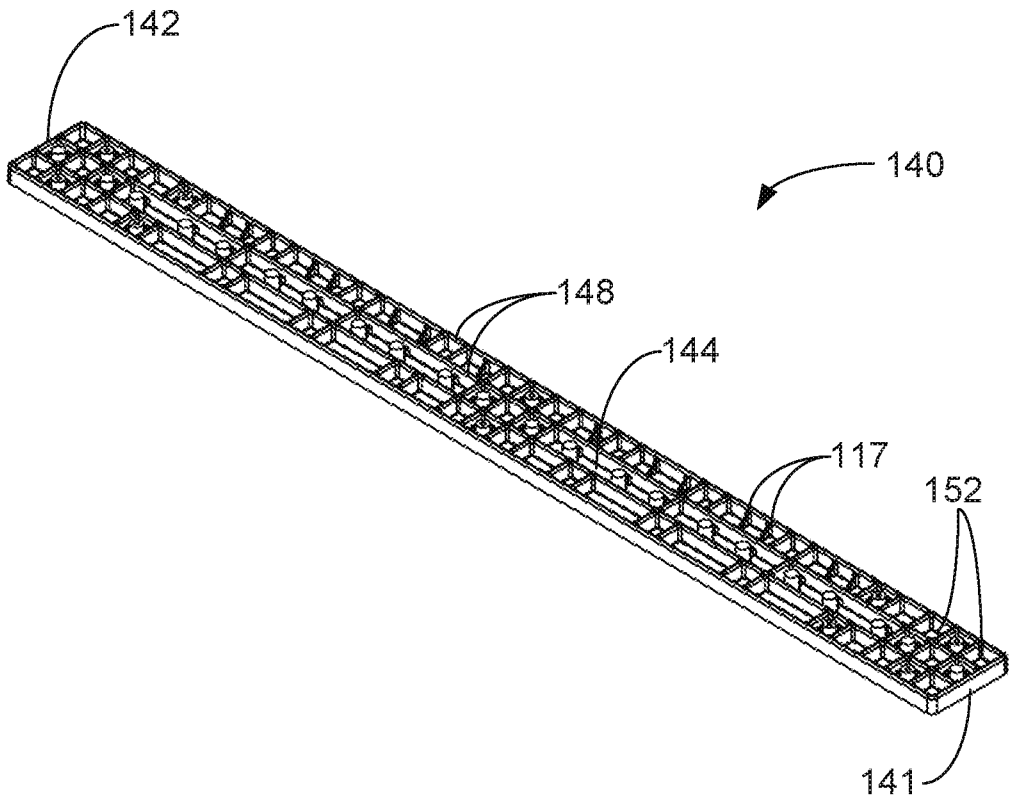


FIG. 3C

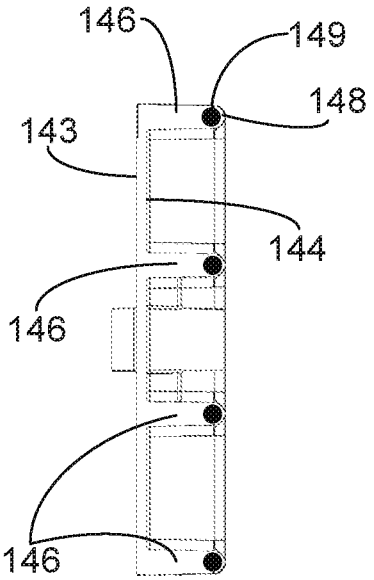


FIG. 3D

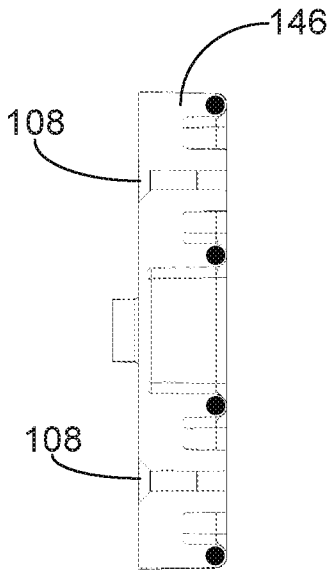


FIG. 3E

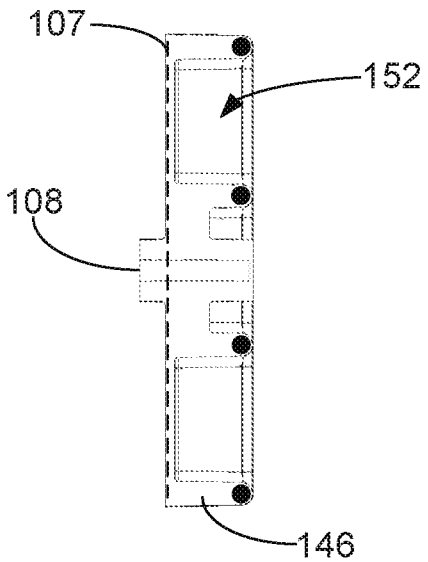


FIG. 3F

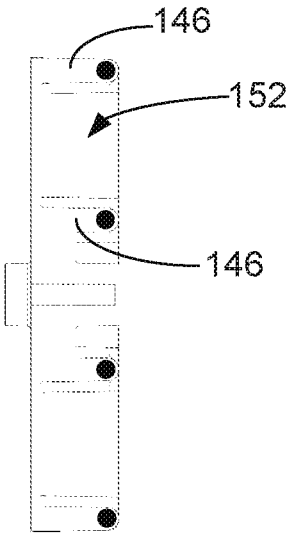


FIG. 3G

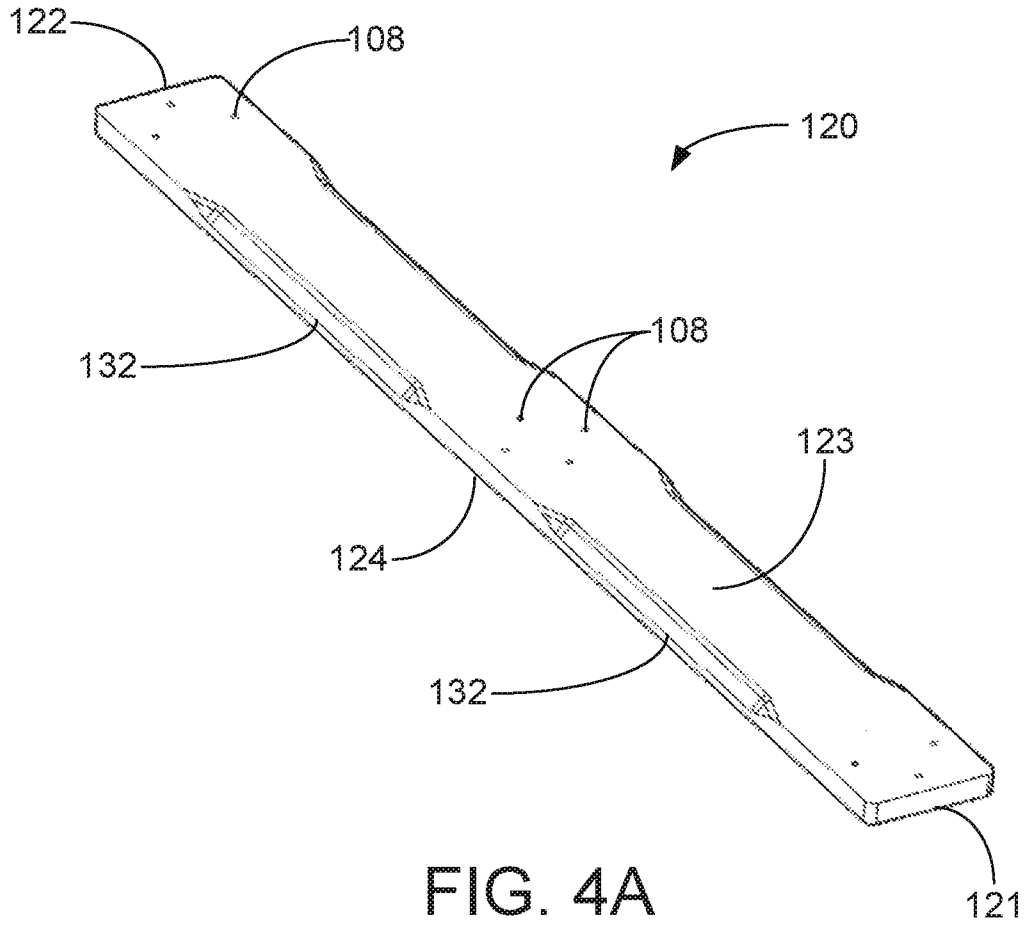


FIG. 4A

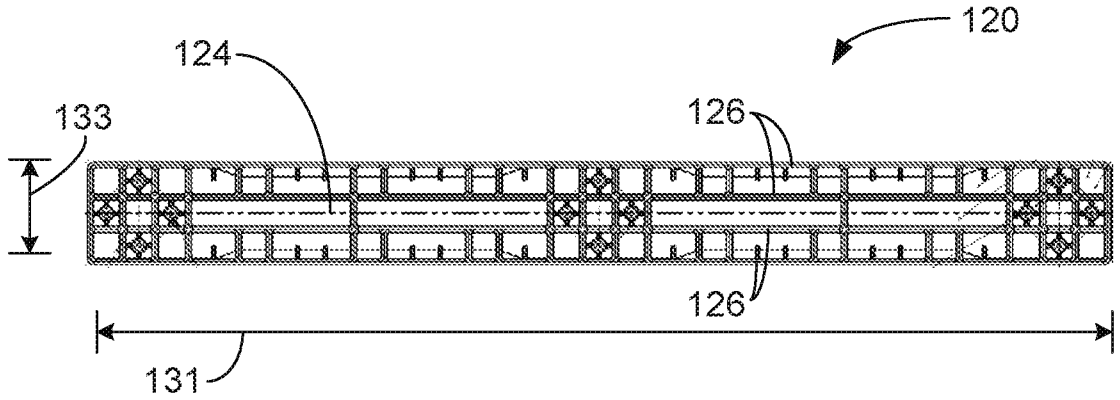


FIG. 4B

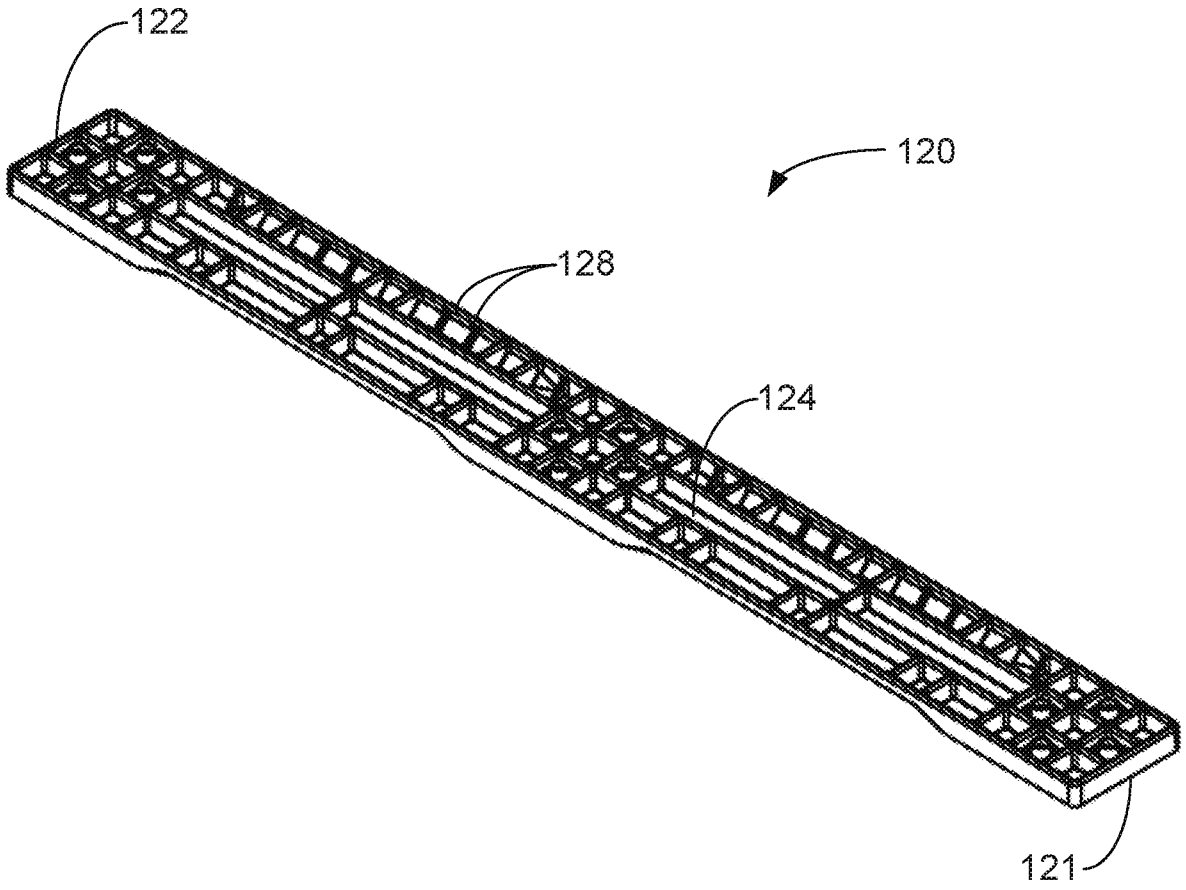


FIG. 4C

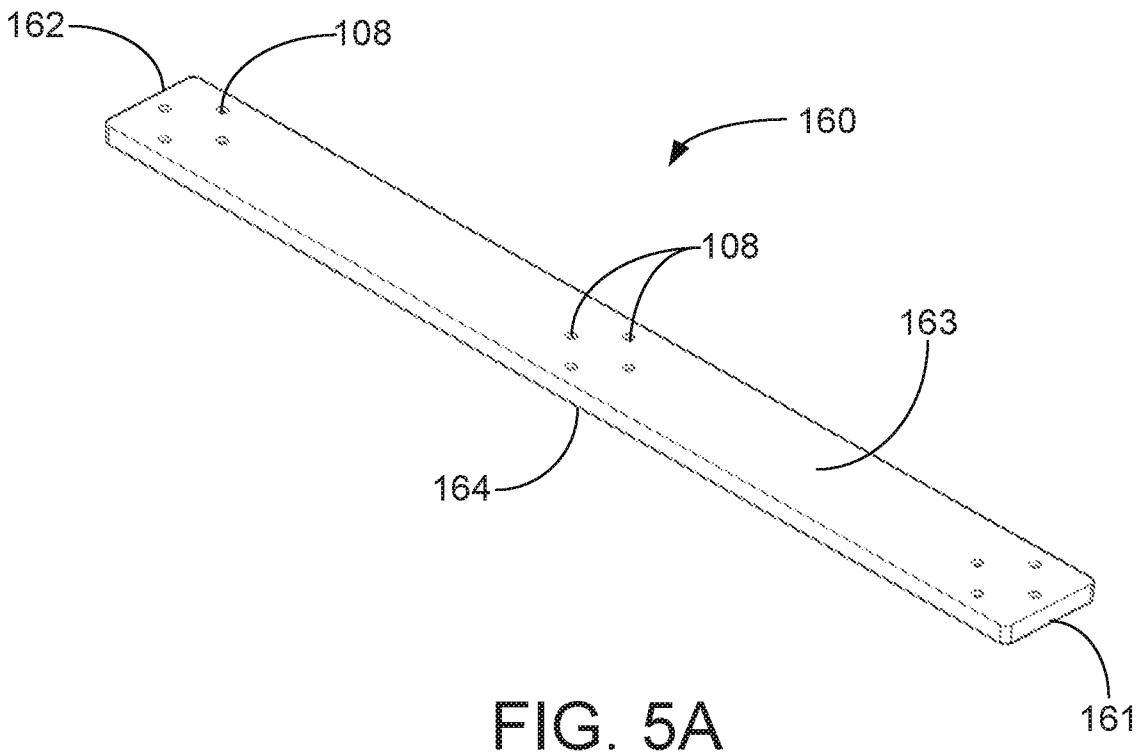


FIG. 5A

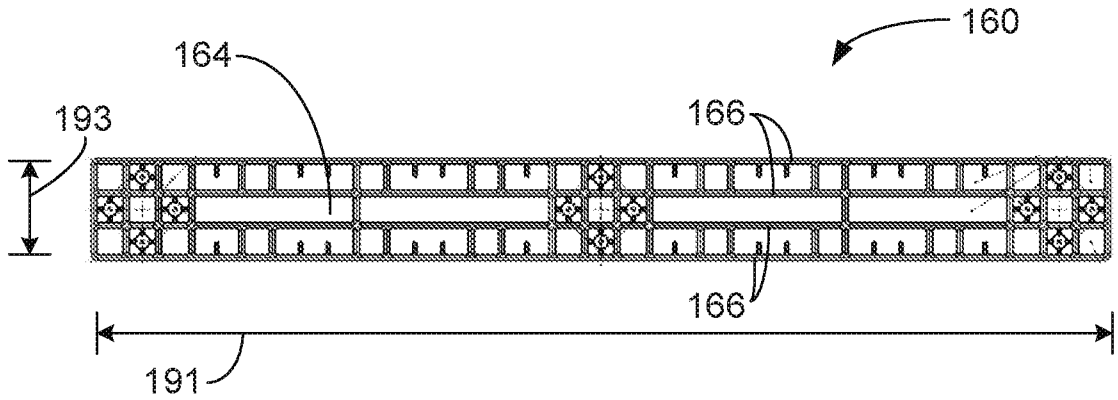


FIG. 5B

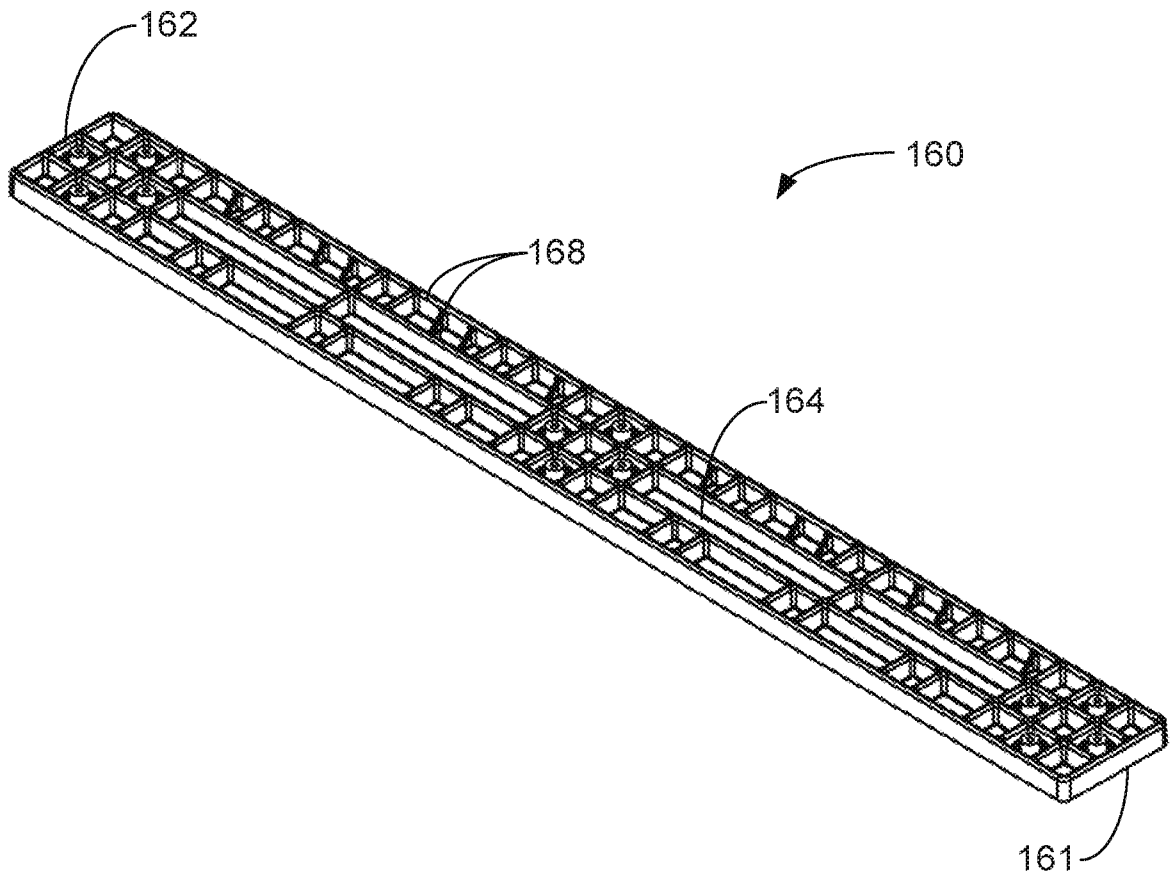


FIG. 5C

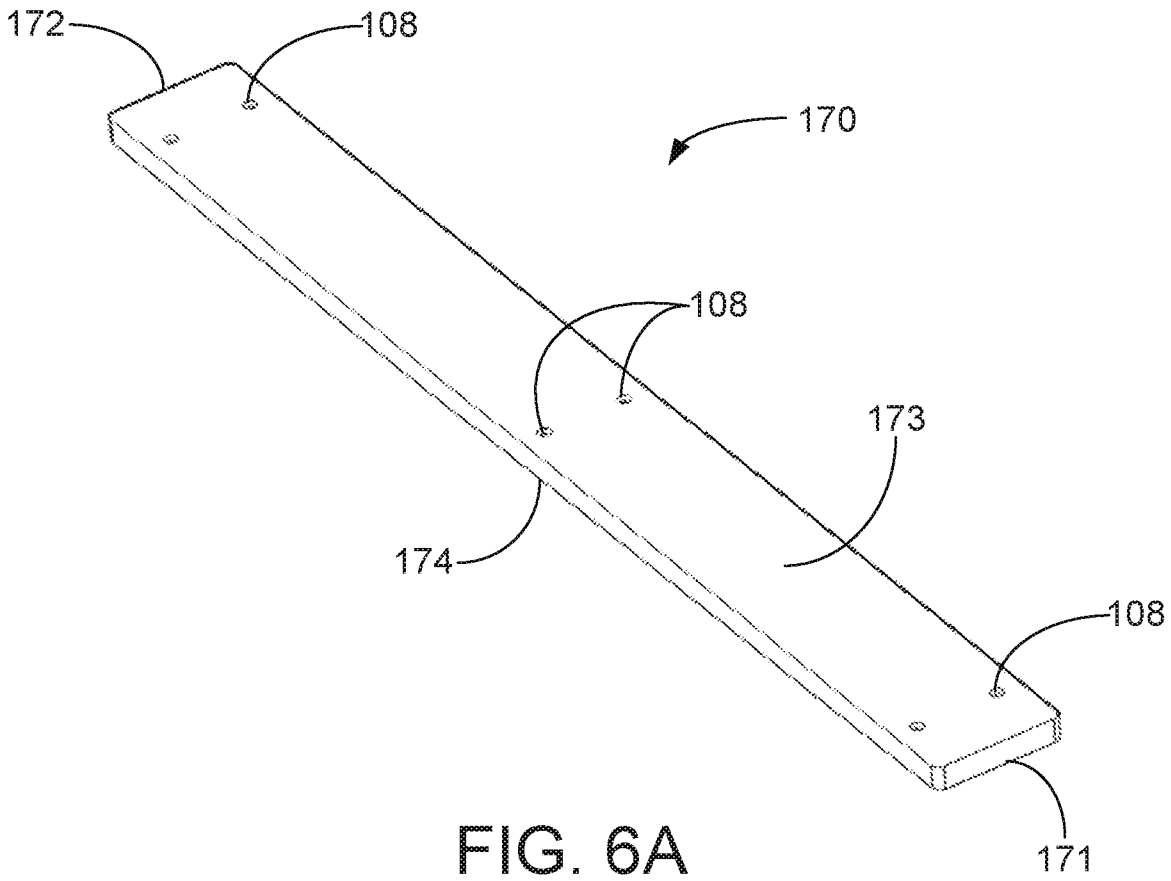


FIG. 6A

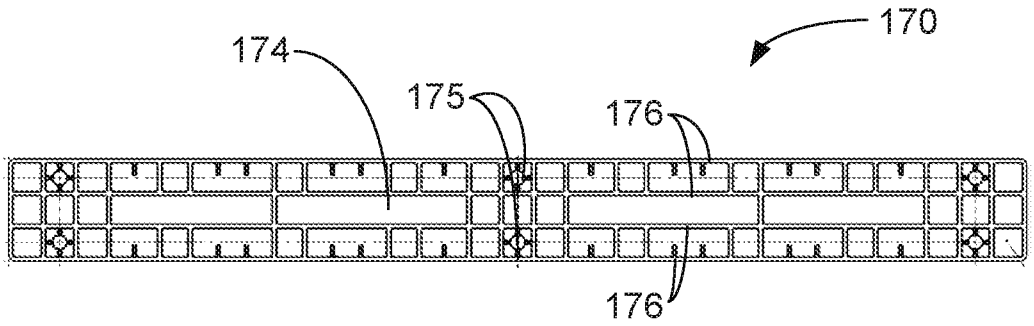


FIG. 6B

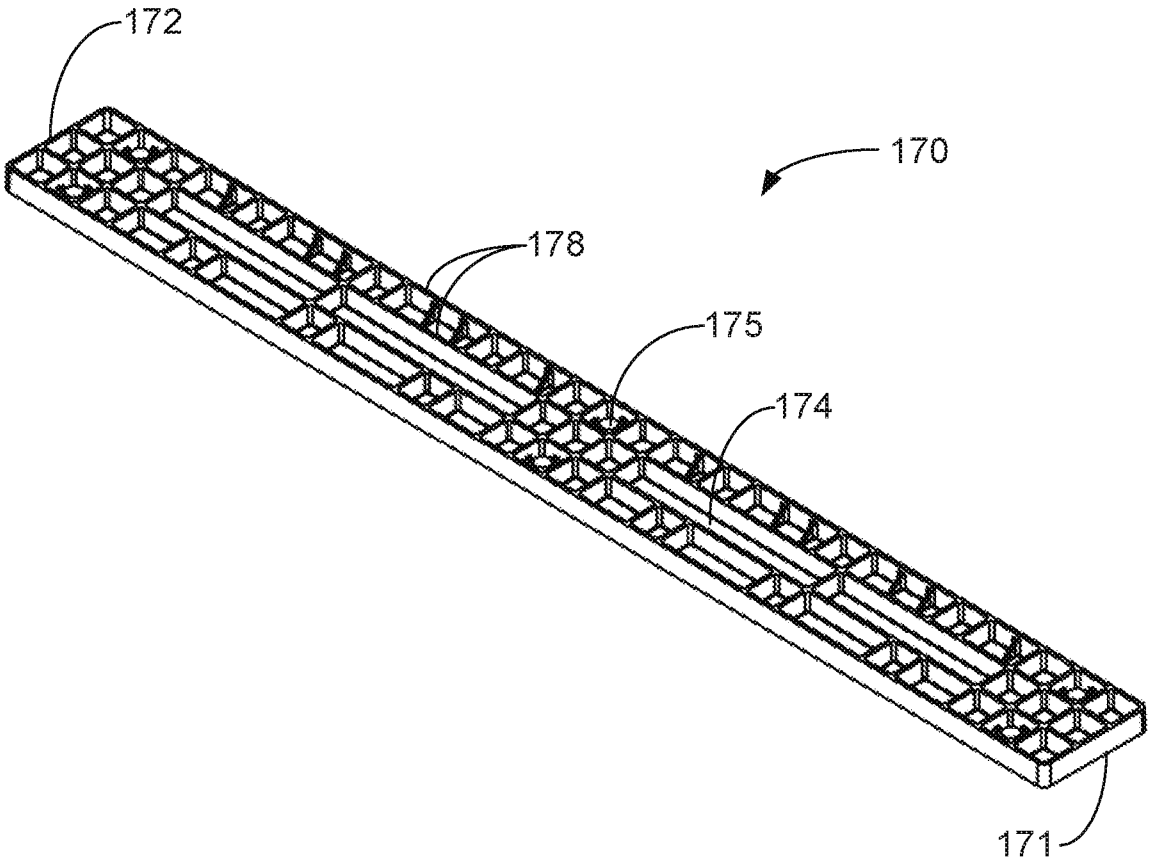


FIG. 6C

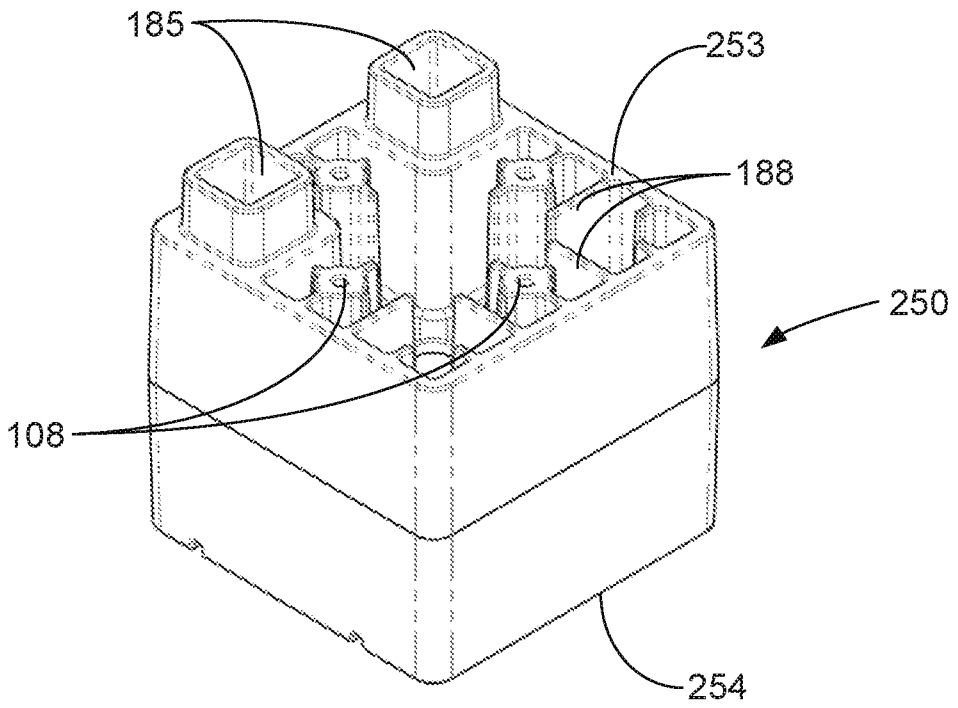


FIG. 7

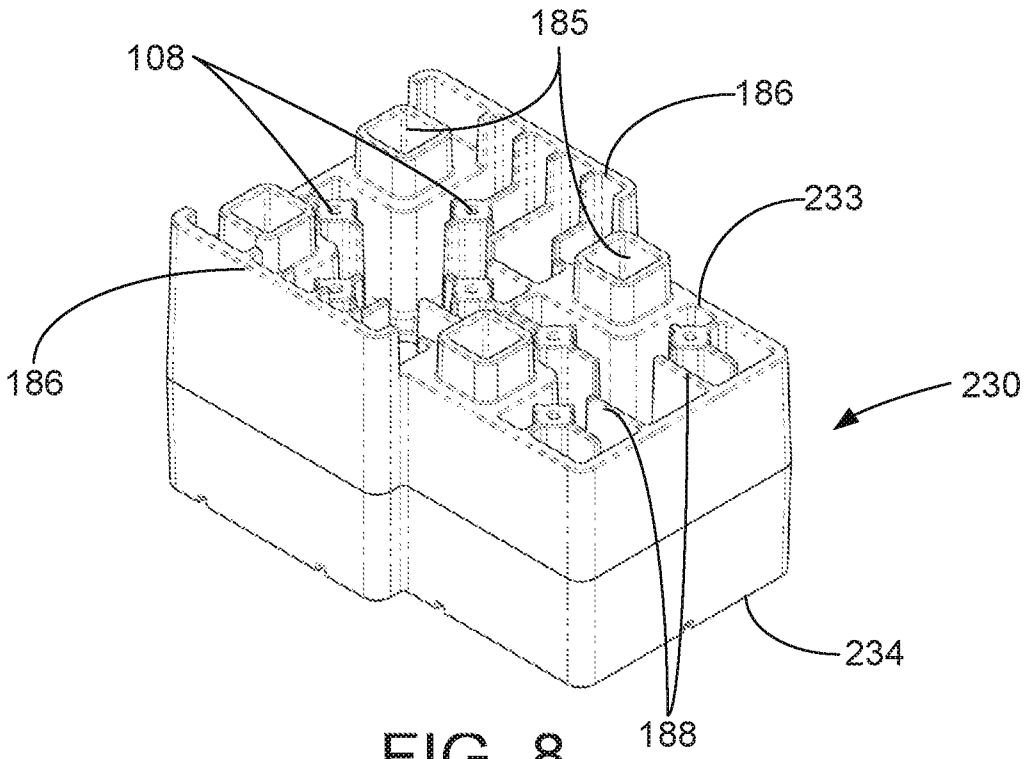


FIG. 8

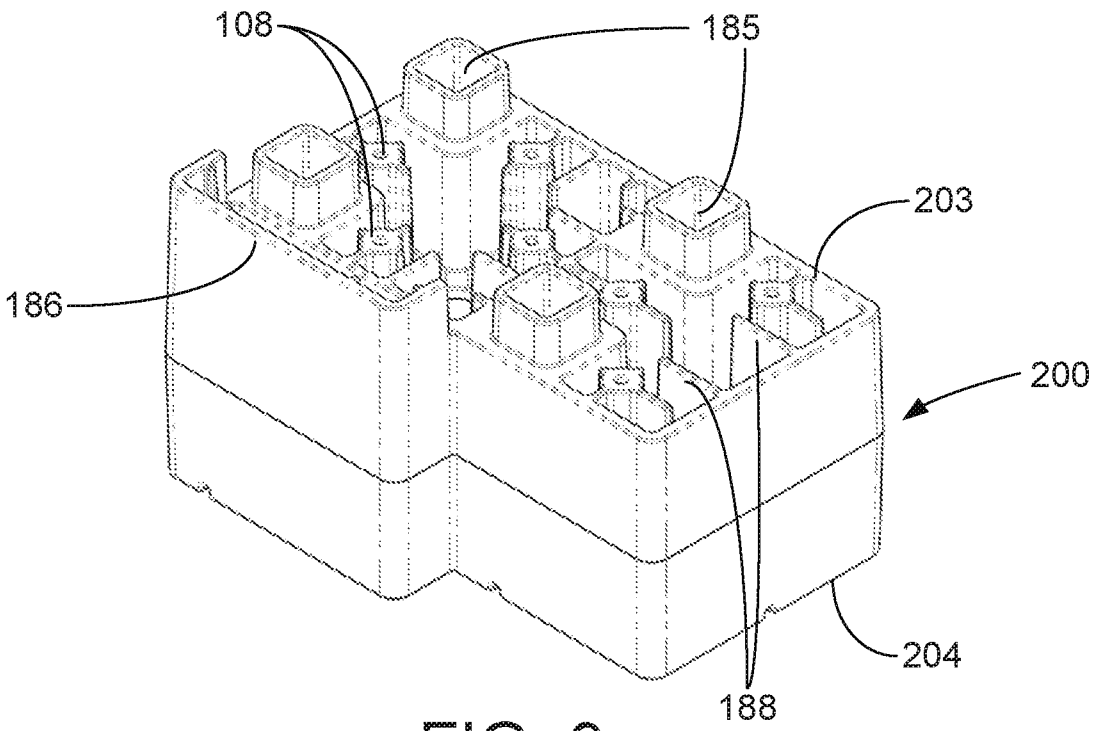


FIG. 9

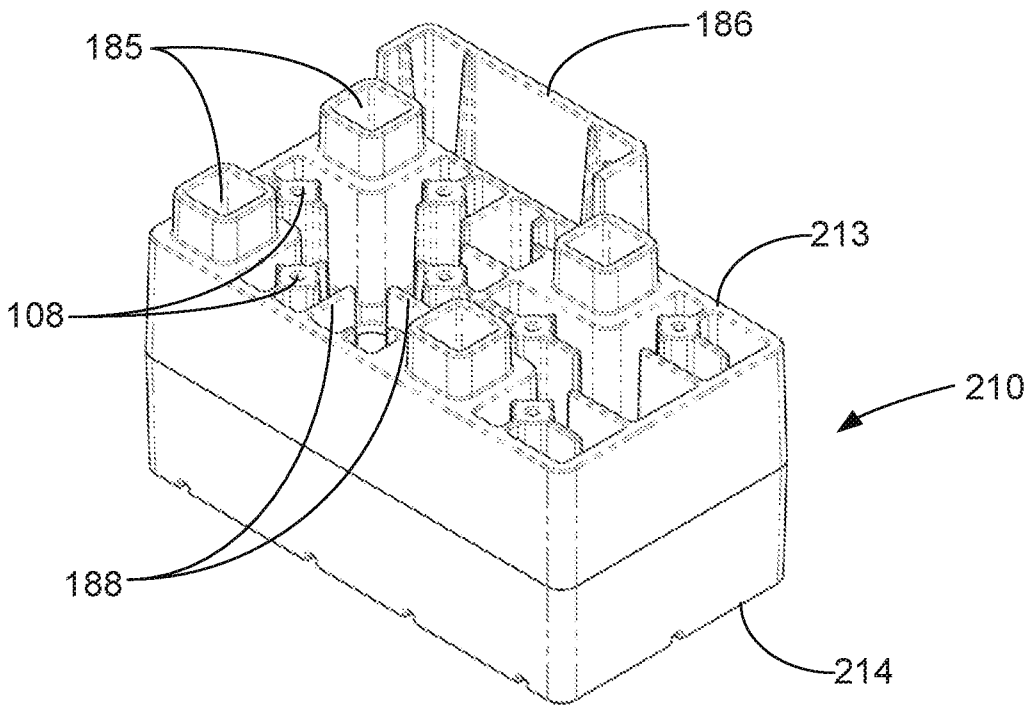
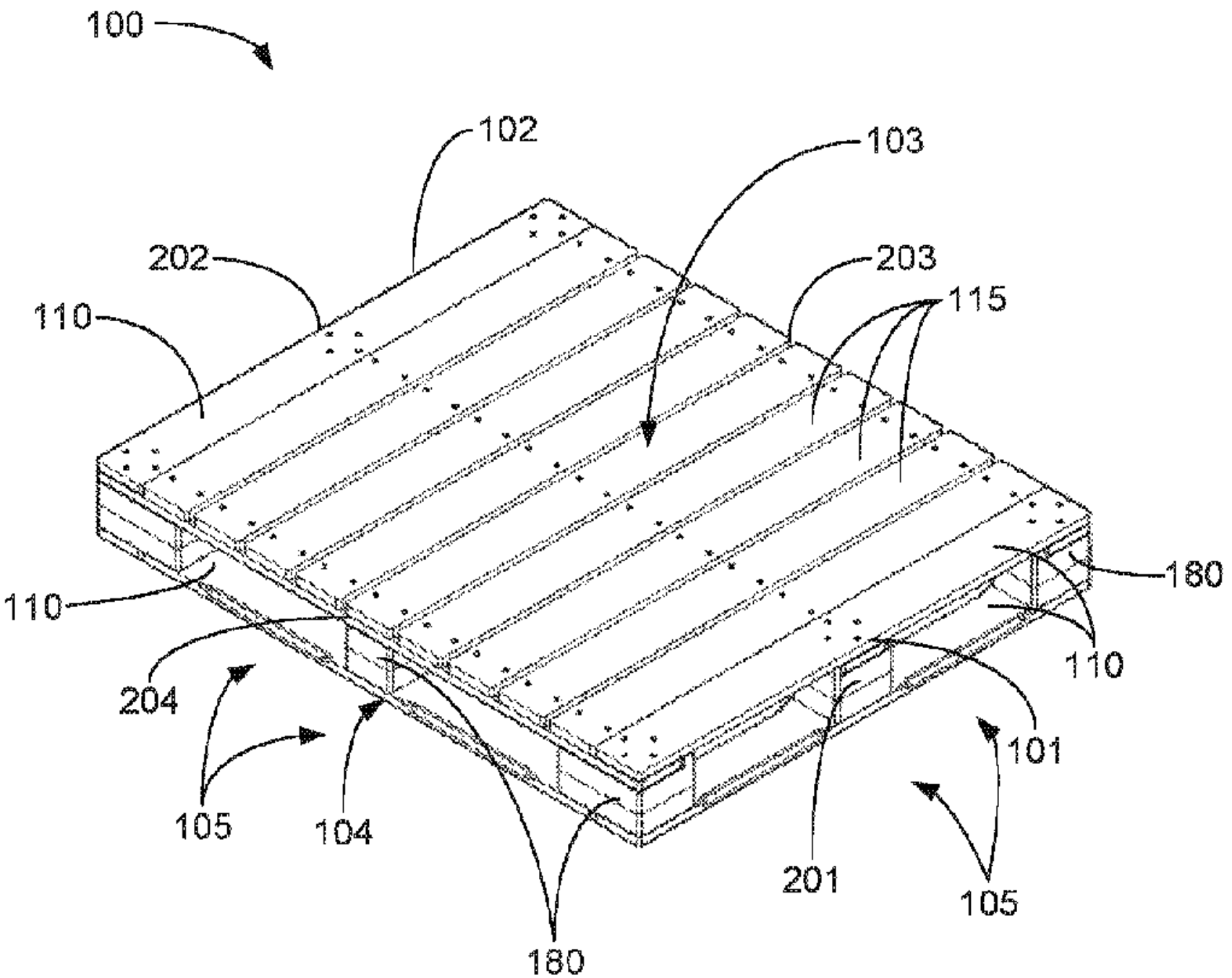


FIG. 10


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