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(71) Applicant (for all designated States except US): **TEMP-TIME CORPORATION** [US/US]; 116 American Road, Morris Plains, NJ 07950 (US).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **TAYLOR, Dene, H.** [US/US]; c/o Temptime Corporation, 116 American Road, Morris Plains, NJ 07950 (US). **PRUSIK, Thaddeus** [US/US]; c/o Temptime Corporation, 116 American Road, Morris Plains, NJ 07950 (US). **SMITH, Dawn** [GB/US]; c/o Temptime Corporation, 116 American Road, Morris Plains, NJ 07950 (US).

(74) Agent: **PITT, Roger**; KIRKPATRICK & LOCKHART NICHOLSON GRAHAM LLP, 599 Lexington Avenue, New York, NY 10022 (US).

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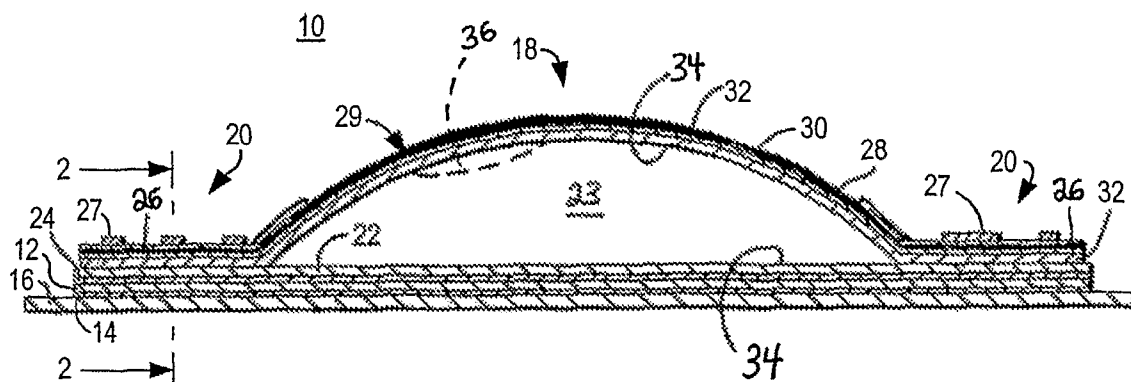
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(54) Title: FREEZE INDICATORS SUITABLE FOR MASS PRODUCTION



(57) Abstract: A freeze indicator employs, as active indicator element, dispersion of solid particles in a liquid medium which can be water or aqueous and which coagulates to provide an irreversible appearance change when subject to freezing. The liquid dispersion can be contained in an indicator volume around which extends a vapor block layer. The vapor block layer can prevent loss of liquid vapor from the dispersion and consequent drying out and dysfunctionality of the freeze indicator. For containing an aqueous medium, bilayer and trilayer laminate materials can be used which have a low water vapor transmission rate. The active indicator element can be a dilute colloidal dispersion of a metal such as gold or silver or other inorganic pigment material in water or an aqueous medium. Some embodiments avoid use of dispersants and the like and employ an active indicator element consisting of inorganic pigment particles, water and optionally an ice nucleating agent. Heavy water, or deuterated water can be components of the water, if desired.

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FREEZE INDICATORS SUITABLE FOR MASS PRODUCTION

TECHNICAL FIELD

The present invention relates to freeze indicators suitable for high-volume or mass production. More particularly, it relates to freeze indicators which can be employed to provide a reliable indication of the past exposure of a host product to a temperature of about, or below, the
5 freezing point of water. The invention includes embodiments of freeze indicators that can be embodied as small units suitable for attachment to small host products, for example, to vaccine vials or syringes.

BACKGROUND OF THE INVENTION

10 Many products of commerce are temperature sensitive and may spoil, deteriorate or lose quality if they suffer even brief exposure to a temperature near or below freezing. For example, bananas turn brown and become mushy. Some flowers, salad greens and herbs, such as basil, wilt, shrink and become dark colored, useless and/or unappealing when exposed to freezing or near-freezing temperatures. Such changes are well known and are largely caused by ice crystals
15 destroying the integrity of the botanical cells.

Many important commercial products, additional to the above, are susceptible to comparable freeze-induced damage, for example, other food and food products, certain pharmaceuticals including some drugs, sera and vaccines, as well as some industrial chemicals, and other
20 products, as will be known or apparent to those skilled in the art. Some examples of commercially significant freeze-sensitive products include freeze-sensitive liquid vaccines such as those employed in the World Health Organization ("WHO") Extended Program of Immunization.

25 One way of addressing this problem is to indicate irreversibly that an individual item, packet, syringe, vial, bottle or other volume container has been subjected to deleterious freezing conditions.

A variety of proposals are known for providing irreversible indications of freeze exposure. For
30 example, Ignacio, et al. United States Patent No. 5,239,942, discloses a freeze indicator comprising a frangible ampoule which is rupturable to release a dye that provides a color

change. Shahinpoor United States Patent No. 6,837,620, assigned to JP Labs, Inc., discloses a shape memory alloy temperature sensor having an alloy element that changes shape when exposed, even temporarily, to temperatures below a particular start temperature to provide a persistent indication of the temperature exposure. Also, Patel United States Patent No.

5 6,472,214 discloses a freeze monitoring device comprising a color changing indicator, which may be a partially polymerized diacetylene and can undergo an irreversible color change, e.g., from blue to red, when the activator mixture is frozen in the region of about 0 to -30 oC.

10 Hanlon et al. in U.S. Patent No. 4,148,748 ("Hanlon") disclose a nonreversible freeze-thaw indicator intended to detect whether an article has been subjected to freezing or thawing conditions. Hanlon's indicator employs a colloidal dispersion of organic solid particles of a polymeric resinous material, which may be in latex form, for example, styrene polymers. Various other styrene, vinyl and vinylidene polymers and copolymers are mentioned. Hanlon's colloidal dispersions are reported to become nonreversibly destabilized upon freezing,
15 transforming a translucent dispersion to a substantially opaque dispersion. Typically a latex dispersion may have the appearance of a low-fat milk. Once frozen and thawed the resultant product may have the appearance of frozen milk that has curdled or gelled.

Pursuant to the present invention, the indicator described by Hanlon is believed to lack adequate
20 shelf life for some applications and may respond inconsistently to temperatures in the freezing range, giving a poor or nonexistent visual signal.

Various freeze indicators are known that utilize the expansion of water on freezing to rupture a container. For example, Johnson United States Patent 4,191,125 discloses a a freeze indicator
25 which includes a frangible ampoule substantially filled with a mixture of water, a nucleating agent, and a surfactant. Upon reaching the freezing point of water, the water mixture freezes, fracturing the frangible ampoule. According to Johnson: a nucleating agent can be used to overcome what is called an undercooling effect; a dye-printed pad can be employed to show a color change; and deuterium oxide may be added to raise the freezing point.

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Emslander et al. U.S. Patent No. 4,846,095 discloses a freezing point indicating device comprising a microporous sheet which is wetted by a freeze-sensitive mixture of at least two liquids e.g. a water/butanol mixture. When the temperature of the liquid mixture reaches a critical value, such as the freezing point of water, the optical properties of the microporous sheet

are changed.

Pereyra United States Patent No. 5,964,181 discloses a critical temperature indicating device employing an indicating composition. The indicating composition is described as including: an
5 organic compound that has a freezing point above the critical temperature; a compound that has a freezing point below the critical temperature; and a wetting component that can wet out a microporous membrane at about the critical temperature upon solidification of a portion of the composition. According to Pereyra, the wetted membrane is rendered generally irreversibly transparent, translucent, or with colorant therein. The device can employ barrier materials to
10 provide a barrier to water vapor, environmental gases, etc., such that they do not contaminate the indicating composition in the device. Pereyra discloses that a change in opacity and/or color of the microporous membrane indicates that the temperature has dropped to, or below, the critical temperature to be indicated. Also described is that the indicator composition can be a solution or a gel. Furthermore, immobilizing agents such as thickeners and viscosifiers can be added to
15 the composition to control the rate of diffusion and/or build viscosity.

Patel United States Patent No. 6,472,214 discloses a device composed of a color changing indicator, an optional polymeric binder, that can have gel-forming capability, and a solvent mixture which induces a color change in the indicator when the device is frozen, in the region of
20 about 0 to -30 °C. The color-changing indicator can be a fine dispersion of a partially polymerized diacetylene dispersed in the solvent mixture. When the temperature of the device is lowered to the freezing point of water, an activator solvent phase separates out of the solvent mixture and induces a color change in the indicator.

25 Guisinger United States Patent 6,957,623 describes a critical temperature indicator which produces a visual, irreversible indication that the indicator has been exposed to a critical temperature such as a temperature near the freezing point of water. As described, Guisinger's critical temperature indicator includes a transparent housing and a temperature sensitive transformable material contained within the transparent housing. The transformable material includes mixture
30 of water, a nucleating agent, latex, and a stabilizer for the nucleating agent. The material is described as being translucent prior to exposure and as being transformed to be opaque. The latex is employed in an amount of from about 5 to 35% by weight and the nucleating agent is preferably an ice nucleating active (INA) microorganism.

SUMMARY OF THE INVENTION

The invention provides a freeze indicator suitable for volume production which is capable of a consistent response as between one production unit and another. In some embodiments, the invention provides freeze indicators having a good or extended shelf life which can provide a
5 consistent and irreversible response, as between one unit and another, after relatively long periods of storage.

Further embodiments of the invention comprise a freeze indicator suitable for low-cost production as small units that could, for example, be used on the cap or the side of a vaccine vial
10 or on a syringe, or other small host product.

In another general aspect, the invention provides a freeze indicator having a long shelf life and which can be mass produced as small units which can provide a clear visual signal of a past freeze exposure event. In some circumstances, the freeze exposure event could be ongoing.
15

The invention also provides, in some embodiments, a small freeze indicator suitable, for example, for attachment to a small volume vial such as a syringe, a vaccine vial or other small container, and which can be mass produced at low cost yet perform consistently.

20 In one aspect, the invention provides a freeze indicator comprising an indicator volume and an indicator dispersion of solid particles dispersed in a liquid medium. The indicator dispersion can be contained in the indicator volume and be capable of coagulating to provide an irreversible appearance change when subject to freezing. In this aspect, the invention also includes at least one vapor block member extending around the indicator volume to prevent loss of liquid vapor
25 from the indicator dispersion.

The at least one vapor block member can comprise a material having a low water vapor transmission rate, which can have a laminar construction with two or three or more layers, if desired.
30

The liquid medium can be an aqueous liquid and can, for example, comprise from about 10 percent to about 70 percent based on the weight of the liquid medium of deuterium oxide, deuterated water or both deuterium oxide and deuterated water. The dispersion, if aqueous, can comprise pigment particles dispersed in water and can optionally include an ice nucleating

agent. The invention includes embodiments that consist exclusively of or consist essentially of these ingredients. The aqueous dispersion can be devoid, or free, of organic liquid, if desired. Furthermore, the liquid medium can be a single phase before, during and after freeze exposure, if desired.

5

In small embodiments, the indicator volume can be in the range of from about 3 μL to about 50 μL . The concentration of pigment particles can be not more than about 0.05 percent by weight of the indicator dispersion.

10 One embodiment of the aqueous dispersion useful in the practice of the invention comprises a dispersion of latex particles.

In another aspect, the invention provides a freeze indicator comprising a dispersion of solid inorganic pigment particles in an aqueous dispersion medium. The dispersion exhibits an
15 irreversible appearance change in response to freezing of the dispersion. The indicator includes an indicator volume containing the inorganic pigment dispersion and a viewing window for viewing the dispersion. Optionally, the freeze indicator can comprise an attachment device for securing the freeze indicator to a host product to be monitored.

20 In a further aspect, the invention provides a freeze indicator comprising an indicator volume and an indicator dispersion of solid particles dispersed in a freezable liquid dispersion medium. The indicator dispersion is contained in the indicator volume and is capable of coagulating to provide an irreversible appearance change when subject to freezing. The freeze indicator also includes concentration-responsive coagulating agent dissolved in the dispersion medium. Freezing of the
25 dispersion medium increases the concentration of the coagulating agent and effects an appearance-changing coagulation of the dispersion medium.

If desired, a freeze indicator according to the invention can be associated with a host product to give a consistent and reliable indication of damaging exposure of the host product to a freezing
30 temperature.

Some embodiments of freeze indicator according to the invention are suitable for volume production and can give a consistent, reliable and irreversible indication of a previous temporary exposure to a temperature near or below about the freezing point of water. In one aspect of the

invention, the units of a given production batch of freeze indicators that pass quality control standards provide a similar appearance in response to a particular freeze exposure event.

In use, a freeze indicator according to the invention can have any of various chromatic or achromatic initial appearances and may be relatively clear and possibly colored. When frozen and then thawed, the stability of the dispersion is lost providing a distinct change in appearance. For example, after thawing, the particles of the dispersion may be flocculated or agglomerated into visible beads, lumps or aggregates between which clear liquid becomes visible. Various striking visual combinations can be used, for example a reflective background can be employed, to give the dispersion desired visual appearances before and after freezing.

In another aspect the invention provides a process for making a freeze indicator according to claim 1 comprising assembling a sheet or continuous web having a series of indicator volume-defining depressions in the sheet or continuous web charging the depressions with the liquid indicator dispersion applying a substrate layer over the liquid-charged depressions, sealing the substrate layer to the sheet or continuous web and separating individual freeze indicators from the sheet or web.

BRIEF DESCRIPTION OF THE SEVERAL VIEWS OF THE DRAWING

Some embodiments of the invention, and of making and using the invention, as well as the best mode contemplated of carrying out the invention, are described in detail below, by way of example, with reference to the accompanying drawings, in which like reference characters designate like elements throughout the several views, and in which:

Fig. 1 is a cross-sectional view of a freeze indicator suitable for monitoring the exposure of sensitive items to freeze-inducing temperatures, according to one embodiment of the invention;

Fig. 2 is an exploded view of the component layers visible on the line 2-2 of Fig. 1, not to scale, showing their descriptions; and

Fig. 3 is a schematic partial cross-sectional view on the line 2-2 of Fig. 1, scaled to show relative dimensions of the component layers in one exemplary embodiment of the freeze indicator there shown.

DETAILED DESCRIPTION OF THE INVENTION

The present invention provides freeze indicators employing an active indicator comprising a visually active dispersion of solid particles in a liquid medium which dispersion provides a distinct and irreversible appearance change indicative of freeze exposure. Some embodiments of the invention employ novel vapor sealing techniques to prolong the effective life of the freeze indicator. The invention includes embodiments employing novel dispersions including
5 dispersions of inorganic pigments, for example, metals or metal oxides, in water, aqueous media or other suitable dispersion media.

The invention includes useful embodiments which are small, low-cost freeze indicators that can be mass produced and provide a consistent response from one indicator to the next. Such small
10 freeze indicators according to the invention may have rather small indicator volumes measurable in, for example microliters or tens of microliters. Notwithstanding the shortness of the light path through the liquid medium, the invention provides active indicator elements which can give a good visual signal of freeze exposure, for example by exhibiting a pronounced change in
15 opacity, reflectivity, or both as a result of freeze exposure.

Further embodiments of the invention can provide a clear and irreversible visual signal in response to a defined freeze exposure event for example exposure to a particular temperature or temperature interval for a specific time interval. Desirably, most, if not all, of a production
20 batch of freeze indicators can respond to the defined temperature event providing a desired visual signal. For example, in the case of monitoring of the freezing point of water, the defined temperature event can be one hour at $-2\text{ }^{\circ}\text{C} \pm 0.2\text{ }^{\circ}\text{C}$. Other temperature events can of course be defined or selected to suit particular purposes. Desirable consistency can comprise a satisfactory visual response from at least about 90% of freeze indicator units in a batch or sample. Higher
25 consistencies, for example 99% or 99.9% can also be useful.

The invention provides a novel freeze indicator that is intended usually to be maintained at an ambient temperature which is above freezing and which can give a freeze indication. The freeze indication can be a clear, irreversible indication of current or past exposure of the indicator to a
30 temperature at or near the freezing point of water. It is contemplated that the indicated freezing or near-freezing temperature event will be exposure to a temperature within a few degrees of the freezing point of water for example in the range of from about $-10\text{ }^{\circ}\text{C}$ to about $5\text{ }^{\circ}\text{C}$. The duration of the exposure required to activate the indicator includes the time taken for the responsive component of the indicator to cool to the ambient temperature, as well as the time for

freezing to occur. This time may be as little as one or two minutes or as much as 30 or 60 minutes or other suitable time period, depending upon the construction of the indicator and a variety of other factors, as will be understood by those skilled in the art.

- 5 The terms "water" and "aqueous" are used in this specification to include not only hydrogen oxide, H_2O , but also deuterium oxide, D_2O , or heavy water, and partially deuterated water, DHO and mixtures of these materials. The concentration of deuterium oxide and/or partially deuterated water can be varied to control the freezing point of the water or aqueous phase.
- 10 Freeze indicators responsive to other temperatures than the freezing point or other exposure durations can also be provided, as will be apparent to those skilled in the art in light of this disclosure. Furthermore, in light of this disclosure, those skilled in the art can understand how to provide indicators responsive to other temperatures depressed below ambient, which other temperatures may or may not correspond with the freezing point of a particular material.

15

Some freeze indicator embodiments of the invention can be employed to indicate the actual historical exposure, or event associated with potential exposure, of a host product to a freezing temperature.

- 20 Depending upon the composition of the liquid dispersion medium employed, the freezing temperature indicated can be the freezing point of water, the freezing point of an aqueous solution or mixture or the freezing point of an organic, silicone or other solvent, liquid or liquid mixture, if such is employed in the inventive freeze indicator. Desirably, the liquid medium is a single phase before, during and after freeze exposure. Thus, the liquid medium can comprise a
- 25 single liquid, for example water, or a mixture of miscible liquids which do not separate one from the other or others before, during or after freezing, or after thawing. Other liquids, for example ethyl and other alcohols, toluene or hexane can also be used if desired.

- In one embodiment of the invention, active indicator element 23 is free of organic solvents or
- 30 other organic liquids.

The response temperature can be adjusted, if desired, for example by addition of solutes to depress the freezing point of the liquid medium. By way of example, the depressed temperature in the range of from about $-1^{\circ}C$ to about $-5^{\circ}C$.

In one non-limiting example, sodium chloride or other suitable solute is included in an appropriate concentration to provide a freeze indication below 0 °C for an aqueous host product having a depressed freezing point. Some examples of such host products include serum, blood,
5 or other bodily fluids and analogs thereof.

Pursuant to further embodiments of the invention, deuterium oxide or other suitable material can be added to raise the freezing point of water or other aqueous dispersion medium employed.

10 In some commercial situations the freeze indicator may freeze shortly before the host product itself freezes. This phenomenon may be helpful, in some cases, providing advance warning of imminent freezing of the host product. Advance warning may reduce the risk of a possible false positive or a failure to indicate that a potentially damaging exposure of the host product to freezing conditions has occurred. Thus, it will be understood that the inventive freeze indicator
15 indicates by its visual appearance, current or past freezing of the indicator itself rather than actual freezing of the host product, which may or may not have occurred.

The freeze indication provided by a freeze indicator according to the invention can be used in various ways, as will be apparent to those skilled in the art, in light of this disclosure. For
20 example, a host product bearing a freeze indicator giving a negative indication or a freeze exposure indication that renders the condition of the host product open to question, or otherwise undesirable may be handled in a number of different ways. It can be withheld or withdrawn from use, or discarded by a prospective end user, or screened out of a distribution channel or, possibly, remediated.

25

In some embodiments, freeze indicators according to the invention can comprise an indicator bubble or housing enclosing an indicator volume, which indicator volume contains an active indicator element or material. The indicator bubble may have any suitable configuration, for example a dome-like configuration or other appropriately contoured configuration. The indicator
30 bubble can be supported on, and project upwardly or outwardly from, an indicator substrate which is attachable to, or associatable with, a host product.

The inventive freeze indicator can be usefully embodied as a small visual indicator that can be applied to, or associated with, a wide variety of host products. Small freeze indicator

embodiments may be suitable for economical mass production. However, relatively large embodiments can be provided, if desired. Such larger embodiments can provide an indicator signal with greater visual impact and/or slower response time should these features be desired.

- 5 Some host products are freeze-sensitive perishable products, examples of which include vaccine vials and syringes containing perishable biologicals, or other freeze-sensitive products, food products, such as fruits, truffles, gourmet meats, fish and the like whose organoleptic qualities may be impaired by freezing.
- 10 Other possible host products can include maturing products such as cheeses and wines, as is described elsewhere herein. Still further possible host products will be known, or become known, to those skilled in the art.

Referring now to Figs. 1-2, the illustrated freeze indicator, referenced 10, comprises a carrier
15 substrate 12 which furnishes structural support for freeze indicator 10, an adhesive layer 14 coated on the underside of substrate 12 and a liner 16. Directional descriptions used herein (e.g. underside) reference the orientation of indicator 10 shown in Figs. 1 and 2. It will be understood that freeze indicator 10 can have any desired orientation in practice. Liner 16 functions as a release sheet and can be removed to permit freeze indicator 10 to be attached to a host product
20 (not shown) by means of adhesive 14 on liner 16, for which purpose adhesive 14 can be pressure-sensitive, if desired. Liner 16 is desirably flexible, but could be rigid, and can be formed of any suitable film or sheet material, for example, a polymeric, paper or metal film or sheet. Suitable materials for liner 16 and pressure-sensitive adhesives that may be employed are well known in the release sheet or other arts. Alternatively the freeze indicator can be attached
25 to a host product with a separately applied adhesive which can, if desired, be a pressure sensitive, hot melt or chemically reactive adhesive. The adhesive can be applied at the time of application to the host product.

Alternative means for mounting freeze indicator 10 on, or otherwise associating it with a host
30 product, will also be known, or become known, to those skilled in the art. Such alternative means, include, but are not limited to hook-and-loop fastener systems, mechanical projections such as skewers, or hooks, eyes, tape, ties and simple juxtaposition.

The upper surface of substrate 12 carries a transparent or translucent indicator bubble 18

exemplified as having a dome-like shape in the embodiment of the invention illustrated in Figs. 1-2. Some other possible shapes are described below. Indicator bubble 18 has a peripheral flange 20, which bears on substrate 12, desirably through a heat-sealing water barrier layer 22. Indicator bubble 18 contains an appearance-changing active indicator element 23 contained in an indicator volume 34. Indicator element 23 is the freeze-responsive component of the indicator and is described in more detail below.

Indicator bubble 18 desirably is sufficiently light-transmissive to enable the appearance change to be read at an appropriate viewing distance, for example from about 0.2 m to about 3 m, with the naked eye or other suitable instrument.

Many polymer films suitable for use in freeze indicators have significant vapor transmission rates. Excessive vapor loss during the life of a freeze indicator can lead to loss of liquid dispersion medium or drying out of the indicator. Thus, vapor loss can result in poor or lost performance of the indicator. To ameliorate this problem and enhance the utility of active indicator element 23, the invention provides vapor blocking means. Such means include a first vapor block member comprising vapor block layer 24, on substrate 12 beneath indicator bubble 18. A further vapor block member, to be described in more detail below, can be provided as a layer component of the wall of indicator bubble 18.

Both water barrier layer 22 and vapor block layer 24 are laminar sheets with planar configurations, as illustrated in Figs. 1-2. An opaque print-receiving peripheral ring 26 surrounds indicator bubble 18, overlying peripheral flange 20. Ring 26 can receive and display text, graphics and/or other printable indicia 27.

Alternatively, or additionally, display text, graphics and other printable indicia can be applied to water vapor layer 22 or to vapor block layer 24.

Ring 26 can be provided by an ink coating of suitable color, or by a separate structural element adhered to flange 20, if desired, for example, a polymeric, paper or metallic film or sheet element. In one embodiment of the invention, ring 26 is a reference ring, or other reference area proximate to active indicator element 23. For this purpose ring 26, or other suitable reference area, can have an appearance selected to match or suggest an end point or other appearance change point of the freeze indicator to help interpret the appearance of active indicator element

23. For example, reference ring 26 can approximately match or suggest the appearance of active indicator 23 after freezing. In one embodiment of the invention, reference ring 26 can provide a visual contrast with the appearance after freezing, for example, reference ring 26 can approximately match or suggest the appearance of active indicator element 23 before freezing.

5

For example reference ring 26 can have an appearance which is an approximate match to the appearance of active indicator element 23 after it has frozen so that the combined appearance is more or less uniform. This uniform appearance is notably different from the initial indicator appearance wherein indicator element 23 contrasts with surrounding reference ring 26.

10

Carrier substrate 12 can be fabricated from any suitable material that is expected to fulfill the objectives of the invention in light of this disclosure. Exemplary materials include polymeric material, paper, card or other fibrous or fabric material, laminate, metallic material and metallic composite material. Desirably carrier substrate 12 has strength and durability selected according to the intended end use and desired cost of the freeze indicator.

15

Carrier substrate 12 can be quite flexible, somewhat flexible or rigid, as may be desired, or appropriate, for a particular host product. Embodiments of freeze indicator 10 employing a flat, but rigid, carrier substrate 12 can be useful for mounting onto a flat top or other flat surface of a host product container such as a vaccine vial. A flexible flat substrate 12 can be employed for mounting on a curved surface such as the side surface of a cylindrical vaccine vial, a syringe, a syringe container or other container for pharmaceuticals or other host products. If desired, substrate 12 can be concavely shaped to conform to a convex container surface, for example a cylindrical or spherical surface.

20

Water barrier layer 22 can usefully be employed in embodiments of freeze indicator 10 which utilize an aqueous dispersion as an active element. Examples of suitable aqueous dispersions are described in more detail elsewhere herein. Desirably, the water barrier layer 22 is formed of a material, for example a hydrophobic synthetic polymer, that resists reaction with, or degradation by, active element 23 and especially by an aqueous component thereof, should such component be present. It will be understood that such resistance should be effective for the intended life of a particular freeze indicator which could be days, weeks, months or years. Other liquids if present in indicator 23, can be similarly contained by suitable materials.

25

30

An additional useful function that can be served by water barrier layer 22 is that of heat-sealing. When formed of a suitable material, water barrier layer 22 can be effectively sealed with another component or components of freeze indicator 10, in the vicinity of peripheral flange 20, or at another suitable location to provide a complete or partial sealed envelope around indicator
5 element 23. Suitable materials for water barrier layer 22 capable of performing both water resistant and heat sealing functions include heat-sealable materials such as, for example, polyolefins, amorphous polyesters and other materials that will be known or become known to those skilled in the art. Different active elements 23 may be utilized with different barrier layers 22 to perform corresponding functions, as will be apparent to those skilled in the art.

10

If desired, water barrier layer 22 can have an appearance which provides a contrasting visual background to active indicator element 23, facilitating viewing of the active element and reading of the indicator. For example, employing a relatively dark indicator element 23, such as a dispersion of particles of carbon black, water barrier layer 22 can be light or brightly colored.
15 Alternatively, water barrier layer 22 can present a relatively dark or deeply colored background to the visual appearance of indicator bubble 18, if desired.

20

To present another appearance option, an additional colored or otherwise visually active layer or coating can be provided on the "upper" viewer-oriented surface of water barrier layer 22.
Substrate vapor block layer 24 serves to prevent downward migration of vapor and consequent vapor loss from indicator bubble 18. Vapor block layer 24 can comprise a metallic foil or film, for example, of aluminum, or other suitable water-vapor blocking material. If desired, substrate vapor block layer 24 can be vapor deposited on substrate 12 or water barrier layer 22.
25 Alternatively, if desired, water barrier layer 22 can comprise a film or a coating, on a structural barrier layer or possibly on carrier substrate 12, of a suitable organic polymeric or silicone water sealing material, some examples of which are further described below. One such example is an aluminum layer or coating. Alternatively, a transparent vapor block material such as is described below in connection with indicator bubble 18 can be employed.

30

Substrate vapor block layer 24 can have any suitable construction, for example it can be a separate element that is assembled with substrate 12 and water barrier layer 22 or it can, as suggested, be a coating or film deposited on either the upper or lower surface of either component. Substrate vapor block layer 24 can, if desired, be a wall portion of an envelope or

pouch that also extends around indicator bubble 18, if desired.

If desired, substrate 12, water barrier layer 22 and substrate vapor block layer 24 can be preassembled as a laminate or composite material providing the desired functionality of the several individual layers, as a composite whole. Thus, for example, vapor block layer 24, can be a relatively sturdy aluminum layer which may be adhered to, and contribute structural stability to, carrier substrate 12.

In one useful embodiment of the invention water barrier layer 22 and vapor block layer 24 can be furnished as a composite, bi-layer or laminate material, for example a lidding foil comprising an aluminum foil layer or coating on a heat-sealable film. The aluminum layer or coating can provide the desired vapor blocking function and serve as vapor block layer 24. If desired, layers above the aluminum layer or coating can be transparent, so that the aluminum layer provides a reflective, silver background to active indicator 23.

Some useful examples of suitable materials for the heat-sealable film component of such a composite bi-layer film include polyvinyl chloride, polyvinylidene chloride, polyolefins, polyethylene, polypropylene and polyesters such as polyethylene terephthalate. Other examples will be known to those skilled in the art. If desired, one or both surfaces of the lidding foil can be lacquered. One supplier of lidding foils useful in the practice of the invention is Tekni-Plex, Inc., Somerville, New Jersey. An example of a useful aluminum lidding foil material available from Tekni-Plex Inc. TEKNILID (trademark) 1252 which is described by the supplier as an overlacquer/aluminum/heatseal-lacquer based on polyvinyl chloride, polyvinylidene chloride.

Again referring to Figs. 1-2, the embodiment of indicator bubble 18 shown has an upper structure comprising a clear, or partially clear, dome-shaped outer wall 29 which can be fabricated in multiple layers to serve a variety of functions.

In one embodiment of the invention, outer wall 29 has a multi-layer configuration comprising an outer layer 28, a thermoformable inner layer 32 and a further vapor block member in the form of a transparent vapor block layer 30. Outer layer 28 is exposed to the ambient environment of freeze indicator 10 while inner layer 32 defines, with substrate 12, indicator volume 34 within which active indicator 23 can be contained.

Transparent vapor block layer 30 can be sandwiched between inner layer 32 and outer layer 28,

if desired. Alternatively, transparent vapor block layer 30 can be disposed inside inner layer 32 or outside outermost layer 28. For example, transparent vapor block layer 30 can be formed as a film or coating on either outer layer 28 or on inner layer 32. The film or coating can be formed in any desired manner, for example by vapor deposition under vacuum or other suitable method.

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Desirably, outer wall 29 provides a viewing window for viewing active indicator 23 in indicator volume 34. Toward this end, the several layers constituting outer wall 29 can be light transmissive or can include a light-transmissive layer. Alternatively, the whole of the outer wall of indicator bubble 18 need not be light-transmissive. A light-transmitting window of smaller extent than the dome may be provided, with the remainder of the dome being opaque, if desired.

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Outer wall 29 desirably is sufficiently light-transmissive, for example, transparent or translucent, considering all of its layers together, to permit significant changes in the reflectivity of the interior of indicator bubble 18 to be monitored externally by the human eye or by an optical reader device. Such monitoring may, for example, be effected at distances of from about 0.2 m to about 3 m. However, freeze indicator 10 can have visual characteristics that permit closer or longer range monitoring, if desired.

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In one embodiment of the invention, active indicator 23 entirely fills indicator volume 34. In another embodiment, active indicator 23 does not entirely fill indicator volume 34 but a small visible air or other gaseous bubble 36 is provided in indicator volume 34. Bubble 36 will readily move to indicate the presence of a liquid medium in the dome. Such a bubble, which can for example have a diameter in the range of from about 5 to about 30% of the dome diameter or other large dimension, also serves as a freeze indicator, giving a clear indication, by movement of the host product, that the active indicator is solid when same is frozen. Such an indication can be useful for active indicators that provide a relatively subtle indication of freezing, which may become more pronounced on thawing.

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In another embodiment of the invention, freeze indicator 10 comprises an indicator bubble 18 having curved or domed portions formed, for example by molding, from a substrate material, which material may be opaque. Polyurethane foam or the like of suitable thickness, for example 2 mil (0.002 inches or about 0.05 mm), can be employed as the substrate material, if desired in which the curved portions of bubble 18 are formed as a depression. The curved or domed

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portions of bubble 18 can be covered by a flat or clear or other light-transmissive window, through which the freeze-indicating signal is viewed. The dome and flat clear window define between them an indicator volume within the dome for receiving an indicator dispersion. If desired, the indicator volume can be partially or entirely enveloped in a suitable vapor block material or materials, as described herein.

Embodiments of the invention employing aqueous dispersions that are free of organic liquids, and particularly of volatile organics as components of active indicator element 23 can be beneficial in facilitating choice of a suitable material or structure for vapor block layer 30.

If desired, the extent of transparent vapor block layer 30 can be confined to areas outside peripheral flange 20 to facilitate heat sealing of flange 20, as will be described in more detail below.

Thermoformable inner layer 32 can be a structural layer giving form to outer wall 29 of indicator bubble 18. Alternatively, such structural form can be provided by outer layer 28 and/or transparent vapor block layer 30. In one embodiment, inner layer 32 can comprise or be constituted by, a thermoformable material which can be heat sealed at peripheral flange 20 to water barrier layer 22, or other suitable layer. Inner layer 32 can maintain the desired shape, optionally with moderate flexibility, and can support any other layers of which outer wall 28 may be composed.

The outer surface of outer layer 28 can be scratch resistant or have a scratch-resistant coating to protect indicator bubble 18 from damage during normal handling and contact with other objects. In addition, or alternatively, the outer surface of outer layer 28 can be treated, or constituted, to be printable, which is to say capable of receiving and displaying printed matter.

In another embodiment, the invention employs known laminate or composite materials to fulfill several of the functions provided individually by outer layer 28, substrate vapor block layer 24 and an inner layer. For example, composite packaging films employed as vapor barrier packaging for medications formulated as pills, tablets or the like, may have suitable properties for employment in the practice of the invention as may be determined from the manufacturer's specifications, by simple experimentation, or by other suitable means.

In one embodiment of the invention, active indicator element 23 is entirely contained within a vapor blocking envelope to prevent water vapor loss. The vapor blocking envelope can be provided entirely, substantially entirely or partially by vapor block layer 24 and vapor block
5 layer 30. In another embodiment of the invention (not shown), the envelope is a self-contained, clear or transparent sealed sac of flexible or rigid vapor block material containing the indicator dispersion, in the manner of a small ampoule. If desired, such sacs or ampoules of indicator dispersion can be prefabricated and then assembled with substrate 12 and other desired components of freeze indicator 10.

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Pursuant to a further embodiment of the invention, a drop or aliquot of indicator dispersion is encapsulated in a clear, flexible sac of vapor block material. Usefully, a small air or gas bubble can be included in the sealed sac or ampoule to help indicate a liquid condition of the contents.

15 In a still further embodiment of the invention, the indicator dispersion can be microencapsulated to provide, for each freeze indicator unit, a flat array of miniature bubbles each containing a coagulatable dispersion. Such an indicator array can be curved to fit a host product, if desired and can be suitable for printing or for other continuous web or sheet fed mass production.

20 The liquids and liquid vapors contained by such measures may be water or aqueous liquids and vapors or derived therefrom. Other liquids or solvents and their vapors, if employed in active indicator element 23, can be similarly contained and retained, if desired, employing appropriate vapor blocking materials. The particular vapor blocking material employed can be selected according to the nature of the liquid and its vapor, to provide sufficient containment to avoid
25 poor performance during the intended useful life of the freeze indicator.

The shelf life before use of freeze indicator 10 can be prolonged as desired, to be for example, one year, two years, several years or an indefinite period, by sealing the indicator in a protective pouch or sheath of aluminum foil or other suitable material to prevent vapor loss. The protective
30 pouch or sheath can be removed prior to application of indicator 10 to a host product or association of indicator 10 therewith, or prior to the reading of the indicator response.

The material employed for vapor block layer 30 can be selected to avoid unsatisfactory loss of water or other dispersion phase components during the intended life of the freeze indicator. As

stated above, undue loss of the dispersion phase or medium may result in a poor quality signal or a confusing signal of a freeze exposure event, or even no signal. In one embodiment of the invention, vapor block layer 30 is a material, a laminate, a composite or the like, which permits a water vapor or moisture transmission rate of no more than about $1.0 \text{ g/m}^2/\text{day}$ at a temperature of 38°C (100°F) and a relative humidity of 90%. In another embodiment, the water vapor transmission rate at a temperature of 38°C (100°F) is no more than about $0.50 \text{ g/m}^2/\text{day}$ and a relative humidity of 90%. Materials that provide lower rates can be employed if desired, for example water vapor transmission rate of no more than about $0.1 \text{ g/m}^2/\text{day}$.

The vapor block material can be useful for many of the purposes of the invention if its vapor blocking properties are such that not more than about 20 percent by weight, or more desirably, 10 percent by weight of the water or other indicator liquid lost in one year of normal or standardized shelf life. Where a longer shelf life is desired, superior water vapor control may be utilized, for example so that not more than about 20 percent by weight or more desirably, 10 percent by weight of the water is lost in two, three or more years of normal or standardized shelf life. "Shelf life" references the indicator life while exposed to ambient conditions, for example, after attachment to a host product.

The invention includes embodiments wherein substrate vapor block layer 24 meets the foregoing vapor control requirements described for transparent vapor block layer 30. Since, for many embodiments of the invention, substrate vapor block layer 24 can be opaque, a suitably thick layer of aluminum or other opaque material can be employed for vapor block layer 24 to provide good control of vapor loss.

Many useful transparent vapor-blocking materials will be apparent to those skilled in the art in light of the teaching herein and include composite materials. Some suitable materials include, but are not limited to synthetic organic polymeric materials or silicone or organosilicone polymeric materials, as are known or as may become known to those skilled in the art. Monolayer films or multilayer laminates can be used. Useful multilayer laminates can comprise a structural synthetic polymer film and a vapor-blocking synthetic polymer film. In general, suitable multilayer materials may have lower water vapor transmission rates, but may be more expensive. Some examples of some useful transparent vapor-blocking materials include: clear water-sealing polyurethane, which can be applied as a coating, like a wood-floor sealing material, bilayer laminates of polyvinyl chloride and polychlorotrifluoroethylene, trilayer

laminates of polyvinyl chloride, polyethylene and polychlorotrifluoroethylene, glycolised polyethylene terephthalate ("PETG"), polychlorotrifluoroethylene ("PCTFE"), bilayer laminations of PETG and PCTFE and of polyvinyl chloride with PCTFE or with another suitable barrier film material, ethylene-vinyl alcohol copolymer ("EVOH") and trilayer
5 laminations of PETG, PCTFE and EVOH.

Some materials useful for fabricating transparent water vapor barrier 30 include rigid or flexible blister packaging moisture barrier films such as are available from Tekni-Plex, Inc. One example is a bilayer laminate of polyvinyl chloride and polychlorotrifluoroethylene such as
10 that supplied under the trademark ACLAR® 22, by Honeywell International Inc. Another example is TEKNIFLEX (trademark) VPA 760 supplied by Tekni-Plex, Somerville, NJ, and described as a laminate consisting of two layers, a 7.5 mil layer of PVC and a 0.6 mil layer of PCTFE. The moisture vapor transmission rate of this material is described by the supplier as 0.025 gram per 100 square inches per 24 hours. A further material, from the same supplier is
15 TEKNIFLEX (trademark) VPA 10300, described as a laminate consisting of 3 layers: a 10 mil layer of PVC, a 2 mil layer of PE and a 3 mil layer of PCTFE. The moisture vapor transmission rate of this material is described by the supplier as 0.005 gram per 100 square inches per 24 hours.

20 In some embodiments the invention can employ for mass production of freeze indicators, preformed arrays of blisters, for example of 15 mm diameter, such as are supplied by Tekni-Plex, Inc. for purposes such as lozenge or tablet packaging.

Some other suitable transparent water vapor barrier materials can include polymerizable
25 organosilicone monomers, for example, trimethoxy silanes, including alkyl and lower-alkyl substituted silanes, which provide tenacious hydrophobic coatings on curing. To this and the indicator fabrication process can, if desired, include a vapor block curing step at a moderate temperature of, for example, about 60-120 °C, in which case the substrate coating material is selected to withstand the moderate curing temperature, as may suitable polyesters.

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In some alternative embodiments of the invention, a thin deposited film of a metal or metals can serve as, or be components of transparent vapor block layer 30. The deposited metal can, for example, be aluminum or other suitable metal. The thickness of the deposited metal film can be selected to provide a balance between adequate blocking of water vapor or other liquid vapor for

the intended life of the freeze indicator and transmission of adequate light.

Other embodiments of the invention can employ other materials for transparent vapor block layer 30. For example, vapor block layer 30 can comprise a deposited, or other film, layer or coating of a transparent ceramic material, such as, indium tin oxide or silicon dioxide, or the like, or combinations or composites of such materials. Some useful ceramic layer products are available from Sheldahl, Northfield, Minnesota. Because ceramic materials may be brittle, if vapor block layer 30 has a curved or shaped configuration, a ceramic deposit, can be made on to a pre-shaped component, for example, on to a concave inner surface of outer layer 28 or on to the convex outer surface of an inner layer. In this way, possible post-shaping of a brittle ceramic layer can be avoided.

Referring now to Fig. 3, the various component layers of freeze indicator 10 may have any suitable dimensions appropriate for fulfilling the functions described herein. It will be understood that the dimensions may be varied according to a particular end product application, or host product to be monitored, and other factors. The X-Y dimensions of freeze indicator 10 in the horizontal plane perpendicular to the plane of the paper in Fig. 1 can largely be determined by the desired size and shape of a particular freeze indicator 10 which may in turn be determined by the intended application.

One example of possible Z-direction dimensions, perpendicular to the X-Y plane, or vertically on the page as illustrated in Fig. 3, will now be described. The to-be-described dimensions can be employed for a freeze indicator 10 having dimensions of for example 10 mm across and an indicator volume 34 of for example 10 or 20 μL and are given in units of mils, a mil being one-thousandth of an inch or about 0.025 mm. Reading upwardly in Fig. 3, releasable liner 16 can be from about 0.25 to about 25 mil thick, for example about 2.5 mil thick. Adhesive layer 14 can be from about 0.1 to about 10 mil thick, for example about 1 mil thick. Carrier substrate 12 can be from about 0.2 to about 20 mil thick, for example about 2 mil thick. Substrate vapor block layer 24 can be from about 0.002 to about 0.2 mil thick, for example about 0.02 mil thick. Water barrier layer 22 can be from about 0.1 to about 10 mil thick, for example about 1 mil thick.

Thermoformable inner layer 32 can be from about 0.6 to about 60 mil thick, for example about 6 mil thick. Transparent vapor block layer 30 can be from about 0.02 to about 2 mil thick, for

example about 0.2 mil thick. Outer layer 28 can be from about 0.03 to about 3 mil thick, for example about 0.3 mil thick. Peripheral ring 26 can be from about 0.03 to about 3 mil thick, for example about 0.3 mil thick. Other suitable dimensions will be, or will become, apparent in light of this disclosure. These various dimensions are merely illustrative. Other possible
5 dimensions will be apparent to those skilled in the art.

The various layers described can be clamped or pressed together in the vicinity of flange 20 to provide a water- and vapor-tight seal which desirably extends in a closed loop entirely around indicator volume 34. If desired, the seal can be effected by heat and/or use of an adhesive or by
10 other suitable means. For example, a pressure-sensitive adhesive can be employed to seal thermoformable inner layer 32 to water barrier layer 22.

The materials of the several layers of the indicator can be selected to be mutually adherent or heat sealable one to another, in the vicinity of flange 20 or adhesive may be employed to join
15 each layer to its vertical neighbor. Alternatively, or additionally, mechanical means such as clamps, rivets or the like may be employed to secure the several layers together. One or another of the foregoing, or a combination of same, may be employed to give freeze indicator 10 structural integrity.

Freeze indicator 10 can comprise or be constituted partially or entirely of commercially provided film materials that are available in roll or sheet stock, for low cost fabrication. Such a freeze
20 indicator can be embodied as a small unit which provides a distinct visual signal. The control of vapor loss provided by employment of substrate vapor block layer 24 and transparent vapor block layer 30 helps prevent drying out of the active indicator element, promoting consistency
25 and clarity of the visual signal provided by freeze indicator 10.

In vertical cross-section, as shown in Fig. 1, indicator bubble 18 defines an interior volume 34 comprising a segment of a circle. Outer wall 29 is essentially part-circular, while substrate 12, and the layers above it, provide a flat floor to indicator bubble 18. Other cross-sectional shapes
30 especially those naturally provided by fluid pressure within domes or other volumes of various configurations may also be utilized.

Indicator bubble 18 may have any desired peripheral shape in plan view for example circular, oval, angular, square, rectangular, triangular, polygonal, hexagonal and strip-like. Angular

shapes of indicator bubble 18 can be embodied in configurations having rounded or curved angles to accommodate construction of freeze indicators from unitary films, sheets or the like. The peripheral configuration of the freeze indicator, in plan view, can be similar to that of indicator bubble 18, or may be quite different. The illustrated embodiment of freeze indicator 5 10 will be further described with reference to the particular useful example of a circular plan shape of the freeze indicator and indicator bubble 18, with the understanding that other shapes may be employed, if desired.

Active element 23 can be any effective liquid composition, dispersion, or other element which 10 undergoes a distinct and irreversible change in appearance after being subjected to a freezing temperature followed by thawing. The appearance change may be brought about by crystallization of water or other liquid present in the active element, or in other suitable manner, and may be observed by a human observer or read optically.

15 As described above, a useful visual change can be provided by employing a dispersion of an opaque solid particulate material in a liquid medium, for example, an aqueous liquid medium. The visual change can be any change in an end product freeze indicator that can be detected without undue difficulty by the naked eye or by a suitable optical device. One example of a useful visual change is an optical density change of the indicator dispersion from an initial 20 colored or relatively dark optical density of 1.0 or higher to a colorless optical density of 0.1 or less at a selected wavelength appropriate for the particular indicator dispersion. If desired, the change may be from an optical density of 2.0 or higher to 0.01 or less.

The liquid medium usefully can consist only or essentially of water or an aqueous mixture as 25 the sole liquid component of the liquid medium. Solutes can also be present, as described herein or as will be apparent to those skilled in the art. The liquid medium can be free of organic liquids especially non-polar volatile liquids. However, in some cases, a polar organic solvent such as an alcohol, for example ethyl alcohol, optionally in an azeotropic mixture with water, may be employed to depress the freezing point, if desired. Liquids miscible with water 30 and which do not separate from the water or aqueous phase under the conditions of use of freeze indicator 10 can be employed. Some embodiments of the invention employ liquid aqueous mixtures which remain as a single phase before, during and after freezing.

Pursuant to the invention, a useful proportion of deuterium oxide and/or deuterated water can be

included in the water employed in the liquid medium. Deuterium oxide can be helpful in raising the freezing point of an aqueous liquid medium. Furthermore, deuterium oxide can be helpful in providing a faster response at a given freezing temperature. For example, a proportion of deuterium oxide in the water component of the liquid medium, if water is present, of from about
5 10 to about 70 percent by weight of the water can be employed. If desired the proportion can be from about 20 to about 50 percent by weight of the water component of the liquid medium.

One example of active element 23 comprises a stable aqueous dispersion of ink or other opaque particles in water, or other aqueous medium, optionally a colloidal dispersion. The dispersed
10 particles may have any suitable particle size and size distribution that can be stably dispersed. For example, the dispersed particles can have an average particle size of less than 10 micron, less than 1 micron or less than 100 nm.

The particles may comprise any suitable organic or inorganic pigment or lake, for example,
15 carbon black, iron oxide or ultramarine. Many others are known to those skilled in the art and may be employed.

The dispersed solid phase can comprise a quite small proportion of the dispersion, for example, not more than about 5 percent by volume. One embodiment of the invention employs a
20 proportion of pigment of not more than about 1 percent by volume. The proportion can be in the range of from about 0.1 to 1 percent by volume. If desired, higher proportions of solid particles up to about 10 percent by weight of the dispersion, or more, can be employed. Higher concentrations of solid can provide a more intense, or darker, visual appearance to freeze
indicator 10 before freezing. Lower concentrations of solid can, in some cases, provide a more
25 distinct visual change upon freezing.

If desired, a nucleating agent can be employed to help initiate coagulation of the dispersion and facilitate the obtaining of a consistent response to a defined temperature event. Water, for example, exhibits a precise melting point under standard conditions of 0 °C. However, the
30 freezing point in any given circumstance may be several degrees below zero owing to the well-known phenomenon of supercooling. Other liquids may behave similarly, to a greater or lesser degree. Use of a nucleating agent, for an aqueous liquid dispersion medium, an ice nucleating agent can help control the freezing point to be closer to the melting point of the liquid.

One embodiment of the invention utilizing an aqueous indicator dispersion employs a nucleating agent known to initiate freezing of water at a temperature near its freezing. Some examples of suitable nucleating agents include silver iodide crystals, cold-precipitated silver iodide/silver bromide mixtures, copper sulfide, ice-nucleating proteinaceous materials and other suitable ice
5 or other nucleating agents, as known or as will become known to those skilled in the art. One example of an ice-nucleating proteinaceous material is a snow inducer product derived from the ice-nucleating active microorganisms *Pseudomonas syringae* under the trademark SNOMAX from York Snow (Victor, New York).

10 The nucleating agent can be added in any effective nucleating quantity or proportion, for example in a proportion of from about 0.01 percent by weight of the indicator dispersion to about 1 percent by weight of the indicator dispersion for example from about 0.05 to about 0.1 percent by weight nucleating agent. As is known in the art, a given quantity of nucleating agent can seed different volumes of liquid. If desired, the amount of nucleating agent to be employed
15 can be determined by routine experimentation.

If desired, freeze indicator 10 can include an ultraviolet-blocking layer or coating that is transparent to visible light overlying one or more of the transparent outer surfaces of freeze indicator 10. Such ultraviolet-blocking means can be useful to protect ultraviolet-sensitive
20 components of freeze indicator 10 from possible damage or degradation, by ultraviolet light. Some examples of suitable ultraviolet-blocker technology can be found in U. S. Patent Application Publication No. 2004/0253733 and the documents cited therein, the entire disclosure of which patent application publication is incorporated by reference.

25 Another example of a useful active element comprises a colloidal dispersion of an unreactive metal, or other unreactive inorganic mineral or material for example colloidal gold, colloidal silver, colloidal selenium or the like. Usefully, the dispersed material does not display reactivity adverse to the performance of the freeze indicator during the useful life of the freeze indicator.

30 Some further examples of materials that can be employed in particulate form include particles of a material selected from the group consisting of pigments, ink pigments, minerals, unreactive metals, noble metals, precious metals, gold, silver, aluminum, iridium, platinum, zinc, selenium, carbon black, sulfur, ferric oxide, kaolinite, montmorillonite, talc, halloysite, calcite (calcium carbonate), dolomite (calcium carbonate, magnesium carbonate), rutile titanium dioxide,

gibbsite (aluminum hydroxide), zincite (zinc oxide), barite (barium sulfate) crystalline silica, amorphous silica, hydrated silica, fluorite (calcium fluoride), hydroxyapatite, white and colored polystyrene beads, white and colored plastic and synthetic polymeric particles, or a combination of any two or more of the foregoing materials comprising a coating of one material upon the
5 other.

The dispersed inorganic pigment material is selected to be one providing an appearance change after freezing and thawing. A distinct appearance change is desirable. For example, 10 nm colloidal gold available from BB International Ltd, Cardiff, United Kingdom changes from red
10 to blue-black on freezing and thawing and may be employed. Other colloidal gold sizes, for example 20, 50 and 200 nm can also exhibit distinct appearance changes, for example, from red to clear, and can be employed, if desired.

The colloidal solids can be generally spherical particles. In one embodiment, the colloidal solids
15 can have a narrow particle size distribution with 90% or more of the particles having diameters within 10% of the average particle size.

Quite low concentrations of such colloidal minerals or other solids can be employed which may be in the range of from about 1 to about 500 or 1,000 parts per million ("ppm") which is to say
20 about 0.0001 to about 0.05 or 0.1 percent, by weight. For example a concentration or proportion of solids in the colloid in the range of from about 10 to about 100 ppm by weight can be employed. The dispersions may be relatively pure dispersions of the elemental or other inorganic material in more or less pure water. In one embodiment of the invention, no other ingredients are present. Active indicator element 23 can consist of, or consist essentially of
25 colloidal inorganic particles, for example gold particles, dispersed in water.

If desired, one or more dispersants, or dispersant aids may be employed to facilitate and maintain the stability of the dispersion, such as are known in the art. One example is hexametaphosphate. Generally, a solution of dispersant having a strength that is not more than
30 about 0.1 molar will be satisfactory.

Some embodiments of the freeze indicator dispersion comprise, consist of, or consist essentially of, pigment, water and dispersant. Colorant, such as a dye, can be added to the aqueous dispersion medium. To facilitate control of vapor loss, organic solvents can be excluded, if

desired.

In use, some embodiments of freeze indicator 10 can have an initial appearance such as an opaque gray, black, white, red, blue, yellow, green or other desired color which can be determined by suitable choice of pigment used in the dispersion. When frozen and then thawed, the stability of the dispersion is lost. The particles of the dispersion flocculate or agglomerate into visible beads, lumps or aggregates between which clear liquid becomes visible. Depending upon the optical characteristics of the liquid, a background may also become visible through the clear liquid. In such cases, the clear liquid appearance is provided by a subtractive color effect. For example, a blue background viewed through a yellow liquid can yield a green appearance to the viewer. Various useful visual combinations that can be employed will be apparent to those skilled in the art in light of this disclosure.

For example, a dispersion of carbon black in water and a white background layer provide a freeze indicator which initially has a continuous black appearance. Upon freezing, the carbon black particles coagulate into small black areas between which the white of the barrier layer shows through to a viewer as a pronounced mottling or mosaicking. Alternatively, a barrier layer or a background layer can be provided in a bright warning color such as red, orange or yellow which would command attention when viewed between the coagulated black particles.

A further striking color shift can be provided by employing a dispersion of blue particles in water made yellow through the use of one or more additives, the concentrations of colorant being selected to provide an initially uniform green appearance. Coagulation on freezing can yield a quite different appearance comprising curds of blue mottled with yellow.

In some cases, the intensity of the visual response is related to the concentration of solid pigment or other material in the dispersion, which consideration provides a further parameter that can be varied, selected or adjusted to provide a desired visual effect.

Thus, the invention can provide a freeze indicator with a flexible range of visual signaling options. The appearance change provided on freezing can be managed by appropriate selection of the respective appearances provided by the colors and reflectivities or absorptivities, of the pigment component of active element 23, of the aqueous or other liquid phase of an active element and of the background appearance provided by a water barrier layer or an additional

background color layer on or behind the water barrier layer, should same be employed.

Some non-limiting examples of the practice of the invention will now be described.

5 Example 1: Colloids Changing Appearance on Freezing

Duplicate aliquots of approximately 0.5 ml each of five samples, numbered 1-5, of various colloidal mixtures, are placed into separate cups. The cups are thermoformed from clear 250 μ m polymer film and each cup has a volume of about 0.8 ml. The cups are sealed with clear polymer tape. A small bubble is intentionally present in each sealed cup. One aliquot of each sample is
10 placed into a freezer at
-29 °C. The other aliquot is left at room temperature. After the one aliquot of each sample has completely frozen it is removed, thawed and is visually compared with the other, duplicate aliquot that has remained at room temperature and never been frozen.

15 Colloidal mixtures having the following compositions are employed in preparing Samples 1-5:

Sample 1: Genflo 9771 latex (ca. 40% solids w/w), available from Omnova Performance Chemicals, Green Bay, WI.

Sample 2: Aquaseal AS510G latex (ca. 40% solids w/w), available from Hunt Corp., Philadelphia, PA

20 Sample 3: 10 nm gold sol available from Ted Pella Inc., Redding, CA.

Sample 4: 50 nm gold sol available from Ted Pella Inc., Redding, CA.

Sample 5: 200 nm gold sol available from Ted Pella Inc., Redding, CA.

Some observations obtainable are shown in Table 1 below:

25

Table 1: Comparison of Never Frozen Colloid Samples with Frozen-and-Thawed Colloid Samples		
<u>Sample No</u>	<u>Never frozen</u>	<u>Frozen/Thawed</u>
1	Creamy white liquid	White solid
2	Slightly yellow creamy liquid	Slightly brown solid
3	Pale red liquid	Pale blue-black liquid
4	Pale red liquid	Pale violet - colorless clear liquid
5	Slightly cloudy pale orange liquid	Colorless clear liquid

In each case a distinct visual change occurs as a result of freezing and thawing. Colloidal compositions 1-5 are each suitable for incorporation as an active element in the inventive freeze indicator, for example, as active indicator element 23. Gold samples 3-5 provide a surprisingly distinct appearance change and demonstrate that gold colloids can be beneficially employed in a variety of different freeze indicators 10 with or without vapor block layers 24 and 30 or other vapor loss prevention means. Thus, gold colloids can be usefully employed in freeze indicators whose anticipated life is relatively short and also in freeze indicators that are expected to have a relatively long life including both shelf life and life associated with a host product.

Example 2: Latex Colloids

A high solids (ca. 40% w/w) latex dispersion (Genflo 9771 latex obtained from Omnova Performance Chemicals, Green Bay, WI) is diluted to various levels with tap water to provide a number of test samples. Unfiltered, hard tap water from New Hope, PA, believed to contain dissolved calcium salts, is utilized.

Duplicate aliquots of approximately 0.5 ml each of each sample of the diluted latex dispersion, are placed into separate cups. The cups are thermoformed from clear 250 μ m polymer film and each cup has a volume of about 0.8 ml. The cups are sealed with clear polymer tape. A small bubble is intentionally present in each sealed cup. One aliquot of each sample is placed into a freezer at -20°C . The other aliquot is left at room temperature. After the one aliquot of each sample has completely frozen it is removed, thawed and is visually compared with the other, duplicate aliquot that has remained at room temperature and never been frozen.

Some results obtainable are shown in Table 2, below:

Table 2: Comparison of Never Frozen with Frozen-and-Thawed Diluted Latex Samples		
<u>Latex Content (% w/w)</u>	<u>Never frozen</u>	<u>Frozen/Thawed</u>
40	Creamy white liquid	White solid
12	Creamy white liquid	White solid
4.0	Milky white liquid	White solid
1.6	Cloudy white liquid	White curds in clear liquid
0.4	Cloudy white liquid	White curds in clear liquid

In all cases there is a distinct difference between the frozen/thawed and the never frozen

materials. Even at relatively low concentrations, for latex, of 1.6% or less, a distinct appearance change is obtained. The presence of clear liquid in the frozen-and-then thawed product can provide a useful means of displaying a distinctive, for example, highly colored background. The colloids of Example 2 can be employed as active elements in the freeze indicators of the invention.

The experimental procedures described in the following Control Examples C3-C5 and Examples 6-11 are intended to provide a meaningful simulation of the moisture loss performance of various indicator dispersions sealed into commercial blister packages, fabricated from a variety of barrier film materials.

Control Example C3:

Monolayer Polyvinylchloride Barrier Film/Distilled Water

A series of holes slightly greater than 15 mm in diameter is bored about 5 mm into a wooden block of dimensions 30 cm long by 10 cm wide by 2 cm deep. Individual blisters are cut from pre-formed arrays of 15 mm diameter blisters supplied by Tekni-Plex, Inc., using the wooden block as a support. The blister material employed in this control example is a 10 mil monolayer polyvinylchloride barrier film supplied by Tekni-Plex, Inc., under the trademark TEKNIFLEX VM 100. The moisture vapor transmission rate of the film is described by the supplier as 0.18 gram per 100 square inches per 24 hours. In cutting the blisters, care is taken to ensure there is at least 3 mm of flat film stock around the perimeter of each blister cavity. Indicator dispersions, described below, are added to each blister cavity. An aluminum lidding foil, available from Tekni-Plex, Inc., under the trademark TEKNILID 1252, and which is described by the manufacturer as an overlacquer/aluminum/-heatseal-lacquer based on polyvinyl chloride and polyvinylidene chloride is cut into 25 x 35 mm rectangles. One rectangle each is placed, heat seal side down, on the top of each blister.

A cylindrical aluminum block 25 mm tall and 19 mm in diameter, with a 15 mm diameter hole bored about 7 mm deep in one end, is heated with the hole end down on a laboratory stirrer hot plate set to have a surface temperature of approximately 170°C. The heated block is grasped with vise-grips, and aligned over the center of each supported blister and held in contact with the lidding foil, with modest manual pressure, for about 3 seconds. The aluminum block generates enough heat to seal the lidding foil to the blister, while the presence of the hole in the aluminum block prevents the contents of the blister from becoming overheated. The efficacy of the heat

seal between the lidding foil and the blister is confirmed visually and then by pressing gently on the blister foil. The aluminum block is re-heated as necessary.

Three samples are prepared by adding 200 μ L by volume of distilled water supplied by ACME Markets (www.acmemarkets.com) to each blister before sealing with lidding foil.

Control Example C4:

Monolayer Polyvinylchloride Barrier Film/Gold Colloid

Control Example C3 is repeated with the difference that the three samples are prepared by adding 1.0 mg by weight of silver iodide powder nucleating agent to the blister, using a spatula, and then dispensing 200 μ L by volume of indicator dispersion into the blister. The indicator dispersion employed is an aqueous gold colloid derived from gold chloride and supplied under product code EM.GC40 by British BioCell International, (www.bbigold.com). This gold colloid product is an intense red color, as received and has a particle size of 40 nm, an optical density of 4.8 at 520 nm, and a gold colloid concentration of 0.04% by weight based on the weight of the gold as gold chloride, according to the supplier. The silver iodide employed is supplied by Sigma-Aldrich under product code 226823-25G.

Control Example C5:

Monolayer Polyvinylchloride Barrier Film/Latex Dispersion

Control Example C4 is repeated with the difference that the indicator dispersion employed is OMNOVA 5176 latex supplied by OMNOVA Solutions Inc., (www.omnova.com), which is added to the blisters by pipette. The latex dispersion, as supplied, is diluted to a concentration of 3% with a solution containing 0.07% calcium chloride in distilled water (Acme Markets). The latex dispersion, as supplied by the manufacturer, is nominally 50% solids, so that the resultant dispersion has a solids content of about 1.5% by weight. It has a white to light tan color. Concentrations are by weight based on the weight of the dispersion.

Examples 6-8:

Three-layer Laminate Film

Control Examples C3-C5 are repeated with the difference that the blister arrays, supplied by Tekni-Films USA, are fabricated from a three-layer laminate film, product code Tekniflex™ VPA 10300, consisting of a 10 mil layer of polyvinyl chloride, a 2 mil layer of polyethylene and a 3 mil layer of polychlorotetrafluorethylene. The moisture vapor transmission rate of the film,

as described by the supplier, is 0.005 gram per 100 square inches per 24 hours.

Examples 7-9:

Two-layer Laminate Film

- 5 Examples 7-9 are repeated with the difference that the laminate film, is a two-layer film, product code Tekniflex™ VPA 760, consisting of a 7.5 mil layer of polyvinyl chloride and a 0.6 mil layer of polychlorotetrafluoroethylene. The moisture vapor transmission rate of the film, as described by the supplier, is 0.025 gram per 100 square inches per 24 hours.

10 Aging Test

The twenty-seven test samples prepared in Examples C3-C5 and Examples 6-11, three samples per example, are subjected to an aging test conducted at an elevated temperature to simulate possible water loss from the products that may occur during long-term storage at room or ambient temperatures, as a result of water vapor migration through the blister. Each of the freeze indicator blister samples is weighed to determine its weight in grams to 5 decimal places and then placed in an oven held at 65°C for a period of six weeks. Heating above room temperature provides an accelerated aging process permitting testing to be performed within a shorter time frame than the desired shelf life which may be measured in months, for example 12 or 24 months or more. The samples are periodically removed from the oven re-weighed to assess water loss and replaced in the oven. Moisture loss is determined by subtraction. In each case, the starting weight of water is about 200 mg. Some results obtainable are shown in Table 3 below. In addition to determining weight loss, the samples are observed daily, recording changes in the appearance of the indicator dispersion such as a color change or an increase in viscosity.

25

Table 3: Aging Results

Example	Film	Water loss from blister in mg Averages from triplicate samples					
		Initial	1 Day	1 Week	2 Week	3 Week	6 weeks
C3	VM100	0	9	75	122	199	Dry ¹
C4	VM100	0	10	88	147	191	Dry ¹
C5	VM100	0	9	77	126	196	Dry ¹
6	VPA 10300	0	1	5	9	19	36
7	VPA 10300	0	1	6	9	21	43
8	VPA 10300	0	1	5	9	20	35

9	VPA 760	0	3	20	32	66	112
10	VPA 760	0	2	19	31	65	110
11	VPA 760	0	2	19	31	65	108

¹ As samples are dried out after 24 days, no further measurements are taken.

As may be seen from an inspection of the data in Table 3, the tested samples lose water at different rates when aged at 65°C.

5

A comparison of the blister samples of Examples 6 and 9, which only contain water, with those of Control Example C3, which also only contain water, shows the superior water vapor barrier characteristics, in this test system, of the tri-layer VPA 10300 film and the bi-layer VPA 760 film over the monolayer VM 100 control film. The samples of Control Example C3 lose water significantly more rapidly than do those of Examples 6 and 9. Thus, after 2 weeks about 60% of the water had been lost from the C3 samples compared to about a 4-5% loss from the samples of Example 6 and about a 16% loss from the samples of Example 9. These results are consistent with the relative moisture vapor transmission rates quoted above: VPA 10300 had the lowest quoted moisture vapor transmission rate and the lowest actual water loss in this experiment.

15

A comparison of the blister samples of Examples 7 and 10, which contain EM.GC40 gold colloid, with those of Control Example C4, which also contains the EM.GC40 gold colloid, shows the superior water vapor barrier characteristics, in this test system, of the tri-layer VPA 10300 film and the bi-layer VPA 760 film over the monolayer VM 100 control film as materials for freeze indicators containing a gold colloid. With regard to appearance, (not described in Table 3), during the first 9 days at 65°C no changes in appearance are noticed for any of the gold colloid samples. After 12 days at 65°C, the contents of C4 samples had changed from red to colorless liquid while samples from Examples 7 and 10 had not changed color. Comparison of sample weights showed that the total loss of color of C4 samples coincided with about 60% loss of water. As the test continued, samples of Examples 7 and 10 retained color long after the control samples C4 had failed. Eventually the samples of Examples 7 and 10 began to fade: after 24 days at 65°C the samples of Example 7 are light pink in color while the samples of Example 10 are light purple in color. The water loss at this stage is about 10% for Example 5 samples and about 30% for Example 8 samples. It appears that the superior moisture barrier provided by films VPA 10300 and VPA 760 contributes to the retention of color by the samples of Examples 7 and 10 compared to the samples of Control Example C4 that fail after 12 days.

30

A comparison of the blister samples of Examples 8 and 11, which contain 3.0% OMNOVA 5176 latex, with those of Control Example C5, which also contain 3.0% OMNOVA 5176 latex, shows the superior water vapor barrier characteristics, in this test system, of the tri-layer VPA 10300 film and the bi-layer VPA 760 film over the monolayer VM 100 control film as materials for freeze indicators containing a latex dispersion. With regard to appearance, during the first 12 days at 65°C there is merely a slight darkening in color of all samples from white or a light tan color to a medium tan color. While the control samples C5 lose water faster than the samples of Examples 5 and 8, all samples remain as free-flowing liquids. At 24 days the samples of Control Example C5 lose almost all their water and become dark tan-colored viscous semi-solids, while the samples of Examples 8 and 11 are still free-flowing, tan-colored liquids. After 6 weeks when the test terminates, the samples of Examples 8 and 11 are still free-flowing tan-colored liquids of similar appearance to the starting samples, while the control blisters of Example C5 contain no liquid and merely have a yellow-brown residue. It appears that the superior moisture barrier of films VPA 10300 and VPA 760 is responsible for the retention of physical appearance long after the control sample dries out.

Example 12: Gold Colloid and Deuterium Oxide

Using a spatula, 0.0002g of silver iodide powder, corresponding to a concentration of 0.05% by weight based on the resultant colloid, is added to each of ten 0.2 ml lidded plastic vials ("Thermowell tubes", Catalog Number 6571: Corning Inc.). 26.4 μ L of intense red 40 nm gold colloid product code EM.GC40 as used in Control Example C4, and 13.6 μ L of deuterium oxide (Sigma-Aldrich, www.sigmaaldrich.com) are added by pipette to each vial. Each of the resultant ten samples is sonicated for five seconds using a Bransonic 200 Ultrasonic Cleaner. After dilution with deuterium oxide, the red color of the gold colloid is slightly reduced but is still vividly apparent to the naked eye. The samples are placed in a propylene glycol/water bath at -2°C and checked periodically for color change.

The samples all freeze within 10 minutes to form ice. The frozen sample vials all have a white to clear appearance. After returning the sample vials to room temperature, all are colorless. The difference in appearance between indicators before freezing (red) and after freezing (colorless) is striking.

Example 12 illustrates a useful embodiment of the invention wherein the gold colloid employed

provides a strong visual color change. A rapid freezing response is obtained using a combination of 0.05% silver iodide as nucleating agent to increase the freezing rate, and 34% deuterium oxide to increase the freezing point compared to pure water. Percentages are by weight based on the weight of the colloid.

5

Examples 13-16 Gold Colloid and Deuterium Oxide at Different Concentrations

Example 12 is repeated with the difference that the gold colloid employed is the material supplied under product code EM. GC20 (British BioCell International, www.bbigold.com) having a particle size of 20 nm, an optical density of 2.2, and a gold colloid concentration 0.02% based on the weight as gold chloride. Also, the gold colloid and deuterium oxide are added by pipette to the sample vials at different ratios to give deuterium concentrations of 0%, 20%, 34% and 45% by volume, for Examples 13, 14, 15 and 16 respectively. In each case, the total sample volume is 40 μ L. The examples are run in triplicate, 30 samples per example, as necessary and selectively tested at three different temperatures, as described below.

15

As shown in Table 4, groups of ten samples of selected ones of Examples 13-16 are immersed in a propylene glycol/water bath set at the three temperatures, namely 0 °C, -1 °C and -2 °C, i.e. at the melting point of water and at temperatures just below that. The samples are examined periodically. The samples designated "Change" freeze to give a white/clear solid at the test temperature and in all cases are colorless liquids after being removed from the bath and returned to room temperature. The samples designated "No Change" remained as pink/red liquids at the test temperature and after being returned to room temperature. Table 4 shows the number of samples observed to be in each category.

25 Table 4: Effect of Deuterium Oxide on Freezing Behavior of Samples from Examples 13-16

Example	Concentration Deuterium Oxide	Time	-2°C		-1°C		0°C	
			Change	No Change	Change	No Change	Change	No Change
13	0%	10 Minutes	0	10	0	10	0	10
		1 Hour	7	3	0	10	0	10
		2 Hour	10	0	0	10	0	10
		6 Hours	NT	NT	0	10	0	10
		3 Days	NT	NT	NT	NT	0	10
14	20%	10 Min	10	0	2	8	0	10
		45 Min	NT	NT	5	5	0	10
		1 Hour	NT	NT	7	3	0	10
		1.5 Hours	NT	NT	10	0	0	10

		5.0 Days	NT	NT	NT	NT	0	10
15	34%	10 Min	10	0	7	3	0	10
		17 Min	NT	NT	10	0	0	10
		60 Min	NT	NT	NT	NT	0	10
		90 Min	NT	NT	NT	NT	1	9
		120 Min	NT	NT	NT	NT	4	6
		150 Min	NT	NT	NT	NT	7	3
16	45%	10 Min	NT	NT	NT	NT	0	10
		15 Min	NT	NT	NT	NT	4	6
		20 Min	NT	NT	NT	NT	5	5
		30 Min	NT	NT	NT	NT	7	3
		55 Min	NT	NT	NT	NT	10	0

NT = Not Tested

- Table 4 shows that the time required for the tested gold colloid to respond to freezing temperatures, with visible color change attributable to coagulation of the sample, decreases with increasing concentrations of deuterium oxide. Example 13 contained no deuterium oxide and serves as a control. The Example 13 samples all show a relatively long response time of about 2 hours, even at -2°C before they freeze. At -1°C none of the Example 13 samples is frozen even after 6 hours and at 0°C the Example 13 samples remain unfrozen after 3 days.
- In contrast, the samples from Example 14, containing 20% deuterium oxide display significantly shorter response times: all ten samples change color after 10 minutes at -2°C ; at -1°C half the samples freeze after 45 minutes and all are frozen after 1.5 hours. However, at 0°C none of the samples freezes, even after 5.0 days exposure.
- The samples from Example 15, containing 34% deuterium oxide also all change color after 10 minutes at -2°C . At -1°C seven out of ten of these samples displays a freeze-indicating color change after only 10 minutes, and at 17 minutes all samples change color. At 0°C some of the samples give a freeze indication after 120 minutes and seven out of ten of the samples has changed color after 150 minutes.
- The samples from Example 16, containing 45% deuterium oxide all change color after only 55 minutes at 0°C and are not tested at lower temperatures where it is to be expected, in light of the data shown in Table 4, that they will change color in just a few minutes at -1°C or -2°C .

The Table 4 results show that the presence of deuterium oxide sensitizes the samples to freezing temperatures.

Example 17: GC40 Gold Colloid Alone

5 40 μ L of EM. GC40 gold colloid having an optical density of 4.8 is added by pipette to each of ten sample vials of the type described in Example 12. The EM.GC40 colloid is a deep red color at room temperature. The vials are placed in a freezer for 30 minutes at -25°C .

The EM. GC40 gold colloid samples all freeze to form ice of a white-to-clear appearance and
10 after being returned to room temperature all samples are colorless.

Example 18: GC20 Gold Colloid Alone

Example 17 is repeated employing EM.GC20 gold colloid having an optical density of 2.2 in place of the EM. GC40 gold colloid used in Example 17. The EM.GC20 colloid is a pink/red
15 color before freezing. A similar result is obtained.

Example 19: Silver Colloid (Hot Tub(trademark))

Example 17 is repeated employing an aqueous silver colloid, Hot Tub Silver supplied by Purest Colloids Inc (www.purestcolloids.com) in place of the EM. GC40 gold colloid used in Example
20 17. The aqueous silver colloid employed is a gray color before freezing. A substantially similar result is obtained with the difference that the samples after being returned to room temperature are almost colorless, with a faint gray tint.

Example 20: Silver Colloid (MesoSilver (trademark))

25 Example 17 is repeated employing an aqueous silver colloid, MesoSilver (trademark) supplied by Purest Colloids Inc (www.purestcolloids.com) in place of the EM. GC40 gold colloid used in Example 17. The aqueous silver colloid employed is a light gray color before freezing. Similar results are obtained.

Example 21: Gold Colloid (MesoGold (trademark))

30 Example 17 is repeated employing an aqueous gold colloid, MesoGold (trademark) supplied by

Purest Colloids Inc (www.purestcolloids.com) in place of the EM. GC40 gold colloid used in Example 17. The aqueous gold colloid employed is a light pink color before freezing. A similar result is obtained.

5 Examples 17-21 compare the behavior in the test system of the gold colloids sourced from British BioCell International (Examples 17 and 18) to other commercially available metal colloid products. Examples 19-21 show that Hot Tub Silver, MesoSilver, and MesoGold all give an irreversible and distinct color change, visible to the naked eye, upon freezing. Accordingly, each appears suitable for use as a visually active colloidal indicator component of a freeze
10 indicator according to the invention. The British BioCell International gold colloids, EM. GC40 and EM. GC20, employed in Examples 17 and 18, provide a particularly dramatic color change. The more subtle colors available from other colloids of relatively inert or noble metals, such as those employed in Examples 19-21, extend the range of visual options available. All these low-concentration metal colloids may be employed with white backgrounds, or backgrounds of other
15 colors to provide one or more of a variety of different visual effects.

Example 22: MesoSilver Silver Colloid and Deuterium Oxide

26.4 μ L of MesoSilver silver colloid and 13.6 μ L of deuterium oxide are added by pipette to each of ten Thermowell sample vials. Each sample is sonicated for five seconds using a Bransonic
20 200 ultrasonic cleaner. After dilution with deuterium oxide, the gray color of the silver colloid becomes lighter but is still apparent to the naked eye. The samples are placed in a water bath at -2°C and checked periodically for color change.

After 18 hours the samples are not frozen and no color change is apparent. The sample vials are
25 then placed in a freezer for 30 minutes at -25°C . The samples all freeze to form ice of a white-to-clear appearance, and after being returned to room temperature all are colorless.

Example 23: MesoGold Gold Colloid and Deuterium Oxide

Example 22 is repeated except that MesoGold gold colloid is used in place of MesoSilver silver
30 colloid. After dilution with deuterium oxide, the pink color is lighter but is still apparent to the naked eye. Similar results are obtained.

Example 24: MesoSilver Silver Colloid, Deuterium Oxide and Silver Iodide

Example 22 is repeated except that 0.0002g of silver iodide powder is also added to each sample vial. In this case, all ten samples freeze within ten minutes of exposure at -2°C , and after being returned to room temperature, all are colorless.

5

Example 25: MesoGold, Gold Colloid Deuterium Oxide and Silver Iodide

Example 23 is repeated except that 0.0002g of silver iodide powder is also added to each sample vial. In this case, all ten samples freeze within ten minutes of exposure at -2°C , and after being returned to room temperature, all are colorless.

10

Examples 22-25 illustrate that MesoGold gold colloid and MesoSilver silver colloid can also be formulated with deuterium oxide and, optionally, silver iodide, to provide quicker responses to freeze exposure than the colloid alone.

15 Pursuant to a further aspect of the invention, a freeze indicator dispersion suitable for use as active indicator 23 can employ a finely dispersed surface-charged pigment such as ferric oxide or other metal oxides or the like, by employing source of multivalent counter-ions to reduce the surface charge and thus reduce the stability of the dispersion. Example 26, below illustrates this aspect of the invention.

20

Example 26: Preparation of ferric oxide dispersion

23.0 g of distilled water is added to 0.25 g of dry ferric oxide powder, iron (III) oxide, 99% purity, average particle size 20-50 nm, obtained from Alpha Aesar, Ward Hill, Massachusetts) in a glass vessel. 2.0 g of about 10% ammonia solution is added and the vessel closed. The
25 mixture is shaken vigorously, placed in an ultrasonic bath for 10 minutes, and then left to sit. It immediately coagulated. Some months later it is opened, a strong ammonia smell is noted, and the supernatant is poured off. It is replaced with a like volume of distilled water, the vessel closed and put into an ultrasonic bath for 5 minutes. The mix no longer coagulated. It had a mild ammonia odor. After sitting over night a small amount of material had settled out but the
30 supernatant remained well dispersed. This is Dispersion I.

An aliquot of dispersion I is diluted to a concentration of about 1.0 g/l with distilled water. It is well dispersed and does not coagulate on freezing. It is then heated to 65°C for about 20 minutes while being exposed to air. On cooling there is no odor of ammonia. On freezing at —

3.0°C partial coagulation is visible. This is Dispersion II.

Aliquots of dispersion 1 are taken and small quantities of 0.20% or 0.020% calcium chloride solution in distilled water are added. The samples are mixed and allowed to sit. Samples
5 prepared at 0.004% calcium chloride or greater coagulate but those at 0.002% or less do not. A larger sample of the dispersion is prepared at 0.002% calcium chloride. The sample remained dispersed overnight. This is Dispersion III.

Each sample of dispersions I-III is prepared for freeze testing in the following way: about 0.5
10 µg of silver iodide powder, an ice nucleating agent, is placed in the bottom of a 150 µl polyvinyl chloride blister and about 100 µl of dispersion added. The blister is sealed with 3M 3850 pressure sensitive adhesive tape. Freeze testing is conducted by immersion in an anti-freeze solution at -3.0° for 5 minutes. All samples are prepared and tested in triplicate.

15 It is seen that all samples freeze within 5 minutes. There is no apparent poisoning of the silver iodide that would cause it to become dysfunctional.

The appearances of the blisters containing samples without calcium chloride are slightly changed upon freezing in that they acquire a frozen look. However, the rust color of the oxide is
20 still dispersed more or less uniformly through the blister. On thawing the mixture is well dispersed and indistinguishable from a comparable unfrozen blister. There is insufficient appearance change to be useful as an indicator and the change is not irreversible. Thus, the tested dispersion, without calcium chloride, is not suitable for use in a freeze indicator pursuant to the invention.

25 The appearances of the samples containing 0.002% calcium chloride is distinctly changed upon freezing. The intensity of the color is reduced and is concentrated in clusters toward the center of the blister. On thawing the colloid is coagulated and rapidly settles leaving a clear supernatant. These samples appear useful as the active component of a freeze indicator according to the
30 invention. It is expected that similar results can be obtained with other multivalent cations or other insoluble inorganic powders.

As can be understood from Example 26, freeze indicator active element can employ finely dispersed ferric oxide by making the dispersion marginally stable with respect to the

concentration of a source of multivalent counter-ions, in this case calcium ions, when this is included in the dispersion. Upon freezing, the concentration of counter ions increases, further neutralizing the surface charge on the dispersed particles, causing the dispersion to lose stability and coagulate.

5

It will be understood that, in addition to ferric oxide, many minerals and other particles, with simple ionizable surfaces when suspended in water can be similarly employed in the practice of the invention, using a suitable source of counter ions to partially neutralize the surface charge on the particles and provide a marginally stable dispersion.

10

The surface charge of the suspension can be adjusted to be relatively low so that it is not highly dispersed. This can be adjusted with an acid or base depending upon the nature of the surface charge. In example 26 ammonium hydroxide is used first to give the ferric oxide particles a high charge so that they can be well dispersed, and then by its removal to lower the charge.

15

In another aspect of the invention, a further experiment, such as is described in Example 27, can be performed to determine whether a heat-sealing step at elevated temperature can be avoided by employing a pressure-sensitive adhesive to bond a transparent indicator dome or bubble to a substrate layer.

20

Example 27: Use of Pressure Sensitive Adhesive to Seal a Blister-Pack Freeze Indicator

100 µl aliquots of gold colloid (BBI EM GC40) and 50 µl aliquots of a suspension of about 1% silver iodide (Sigma Aldrich) in distilled water are dispensed into 450 µl polyvinyl chloride blisters. One set of blister samples is heat sealed with TEKNILID (trademark) 1252 foil, which includes a heat-seal adhesive. Another set of blister samples is cold sealed using a pressure-sensitive adhesive tape, 3M Corp. product code 3280. The freezing characteristics of the two types of sample are compared by immersion in a chilled bath operating at -3.0°C. Both sets of samples freeze within 10 minutes and in all cases the contents change from pink to clear. When the samples are thawed and returned to room temperature, they remain clear. The test is repeated on samples maintained for one day at room temperature. Similar results are obtained. All samples show a good visual change upon freezing and the change is irreversible. They all appear useful as freeze indicator dispersions in the practice of the invention. The pressure sensitive adhesive employed does not appear to have contaminated the dispersion, in an undesirable manner, in this test.

30

If desired, miscible organics, organic mixtures, or silicone fluids or silicone fluid mixtures or other liquids or liquid mixtures can be used in place of water and can be selected to provide responses and indications of other desired temperature exposures. Suitable vapor barriers can
5 be selected accordingly.

Various methods can be employed to mass produce freeze indicators according to the invention. For example, sheets or a web assembly of the upper layers of the indicator can be provided with the domes inverted and filled or partially filled with a liquid dispersion of an active element.
10 The substrate layers can then be applied on top and clamped shut. Individual freeze indicators are then pressure- or heat-sealed in the vicinity of their peripheral flanges and cut or stamped from the sheet or web.

As may be understood from the foregoing description, the invention can provide, inter alia, a
15 small, economical freeze indicator having a good shelf life, of for example at least six months, one year, two years or possibly even more. Toward such ends the invention can employ a high quality, well-controlled aqueous dispersion which responds consistently to given freeze conditions, providing a visual change of good intensity and/or contrast which is readily observed or read optically. Useful features which can be helpful in providing small units include use of a
20 dilute aqueous dispersion, employment of vapor-loss control measures, and employment of active element that provides a good optical response to a freezing event.

Freeze indicator 10 can be employed to monitor the exposure to freezing of any of wide variety of host products. A freeze indicator according to the invention can be associated with or
25 attached to the host product to monitor its exposure. Some examples of possible host products include freeze-sensitive vaccines, foodstuffs, dairy products, vegetables, plants, flowers, bulbs, biologicals, cultures, human or animal organs, pharmaceuticals, medicaments, chemicals, water-based chemicals, paints, and water-based adhesives.

30 Some further examples of possible freeze-perishable host products include: fruit, vegetables, dairy products, for example milk, cream, yogurt and cheese; eggs and egg-containing products; baked products, for example, breads, cakes, cookies, biscuits, pastries and pies; fresh, cooked, cured or smoked meats and fish; and roasts, steaks, chops, and whole and split carcasses of beef, veal pork, lamb, goat, game, domesticated meat, wild meat and other meat;

food service products, for example restaurant service foods, fresh cut foods, fruits, salads and the like;

mail order supplied or public carrier delivery products for example gourmet and other fruits, chocolates, cheeses, fresh and cured meats, chicken, fowl, game, and the like, and ready-to-eat

5 or ready-to-cook meals ordered by phone, mail or Internet and delivered to a residence or business;

freeze-perishable animal foods for example pet foods and foods for agricultural, zoological or other animals;

cut and uncut flowers;

10 water-containing cosmetics, and cosmetics containing biologicals or other labile ingredients; biological materials for industrial or therapeutic uses, for example cultures, organs and other human or animal body parts, blood and perishable blood products;

diagnostic devices, kits and ingredients containing freeze-perishables;

freeze-perishable health care products, for example vaccines, drugs, medicaments,

15 pharmaceuticals, medical devices and prophylactics;

freeze-perishable chemical or biological agent detection kits useful for detecting exposure to nerve agents, blood agents, blister agents, or other toxic agents;

freeze-perishable chemicals and industrial supplies, for example water-containing products; and other freeze-perishable products as will be apparent to those skilled in the art.

20

Embodiments of the freeze indicator of the invention can also usefully be employed to monitor the possible freeze exposure of a wide range of maturable products, including for example:

one or more maturing consumable products selected from the group consisting of: fruits; apples; pears; kiwis; melons; grapes; grapefruit; bananas; peaches; nectarines; plums; pineapples;

25 mangoes; guavas; dates; papayas; plantain; avocados; peppers; tomatoes; cheeses; soft cheese; brie cheese; camembert cheese; hard cheese; cheddar cheese; aging beef; aging steak; other aging meats and meat products; aging gourmet meats; gourmet hams; pheasant; gourmet game products; aging sausages; wines; Bordeaux wine, burgundy wine; claret; champagne; port; whisky; cognac; and other beverages that can benefit from maturation.

30

The invention furthermore includes quality assured maturable or maturing products comprising any of the herein described maturable host products provided with a quality assurance system according to the invention described herein.

The freeze indicator can be applied to the host product at a suitable point in the production, packaging or distribution of same, for example, when assembled into final package, inspect same at selected points prior to use. At a suitable point prior to use, freeze indicator 10 is inspected and if it signals that exposure to freezing has occurred, the host product can be
5 discarded.

Disclosures Incorporated. The entire disclosure of each and every United States patent and patent application, each foreign and international patent publication, of each other publication and of each unpublished patent application that is specifically referenced in this specification is
10 hereby incorporated by reference herein, in its entirety.

Throughout the description, where compositions are described as having, including, or comprising specific components, or where processes are described as having, including, or comprising specific process steps, it is contemplated that compositions of the present invention
15 can also consist essentially of, or consist of, the recited components, and that the processes of the present invention can also consist essentially of, or consist of, the recited processing steps. It should be understood that the order of steps or order for performing certain actions is immaterial so long as the invention remains operable. Moreover, two or more steps or actions may be conducted simultaneously. In addition, all proportions recited herein are to be understood to be
20 proportions by weight, based upon the weight of the relevant composition, unless the context indicates otherwise.

Furthermore, where a structure is illustrated as employing two material layers, the invention contemplates alternative embodiments fulfilling the functions of the two layers in a single layer.
25

The foregoing detailed description is to be read in light of and in combination with the preceding background and invention summary descriptions wherein partial or complete information regarding the best mode of practicing the invention, or regarding modifications, alternatives or useful embodiments of the invention may also be set forth or suggested, as will be apparent to
30 one skilled in the art. Should there appear to be conflict between the meaning of a term as used in the written description of the invention in this specification and the usage in material incorporated by reference from another document, the meaning as used herein is intended to prevail.

While illustrative embodiments of the invention have been described above, it is, of course, understood that many and various modifications will be apparent to those of ordinary skill in the relevant art, or may become apparent as the art develops. Such modifications are contemplated as being within the spirit and scope of the invention or inventions disclosed in this specification
5 and as claimed.

Claims:

1. A freeze indicator comprising:
 - (a) an indicator volume;
 - (b) an indicator dispersion of solid particles dispersed in a liquid medium, the indicator dispersion being contained in the indicator volume and being capable of coagulating to provide an irreversible appearance change when subject to freezing; and
 - (c) at least one vapor block member extending around the indicator volume to prevent loss of liquid vapor from the indicator dispersion.
2. A freeze indicator according to claim 1 wherein the liquid medium is an aqueous liquid and optionally comprises from about 10 percent to about 70 percent based on the weight of the liquid medium of deuterium oxide, deuterated water or both deuterium oxide and deuterated water.
3. A freeze indicator according to claim 2 wherein the aqueous dispersion consists of, consists essentially of, or comprises pigment particles dispersed in water and, optionally, an ice nucleating agent.
4. A freeze indicator according to claim 2 wherein the liquid medium is a single phase before, during and after freeze exposure.
5. A freeze indicator according to claim 2 wherein the aqueous dispersion comprises a dispersion of latex particles.
6. A freeze indicator according to claim 2 wherein the pigment particles comprise a material selected from the group consisting of pigments, ink pigments, minerals, unreactive metals, noble metals, precious metals, gold, silver, aluminum, iridium, platinum, zinc, selenium or carbon black, sulfur, ferric oxide, kaolinite, montmorillonite, talc, halloysite, calcite, dolomite, rutile titanium dioxide, gibbsite, zincite, barite, crystalline silica, amorphous silica, hydrated silica, fluorite, hydroxyapatite, white and colored polystyrene beads, white and colored plastic and synthetic polymeric particles, and a combination of any two or more of the foregoing materials the combination comprising a coating of one material upon the other material.
7. A freeze indicator according to claim 3 wherein the indicator volume is in the range of from about 3 μL to about 50 μL .

8. A freeze indicator according to claim 1 wherein the concentration of pigment particles is not more than about 0.05 percent by weight of the indicator dispersion.
- 5 9. A freeze indicator according to claim 1 wherein the indicator dispersion is opaque before freezing and visibly light-transmissive after freezing of the indicator dispersion or the indicator dispersion is colored before freezing and is substantially colorless after freezing of the indicator dispersion.
- 10 10. A freeze indicator according to claim 1 comprising a substrate attachable to a host product to support the indicator wherein the at least one vapor block member comprises a curved transparent member permitting viewing of the indicator volume and a substrate-disposed vapor block member.
- 15 11. A freeze indicator according to claim 10 wherein the curved transparent member comprises a layer of synthetic organic polymeric material and the substrate-disposed member comprise a metallic film.
13. A freeze indicator according to claim 9 comprising a dome-shaped transparent structural
20 member defining the indicator volume and supported on the substrate.
14. A freeze indicator according to claim 1 wherein the at least one vapor block member comprises an envelope entirely enclosing the indicator volume.
- 25 15. A freeze indicator according to claim 1 wherein the at least one vapor block member comprises a material selected from the group consisting of metallic foil, metallic film, aluminum foil, aluminum film, synthetic organic polymeric material, silicones, organosilicone polymeric materials, silicone water-vapor sealing material, water-vapor blocking material, organic
30 polymeric water sealing material, clear water-sealing polyurethane, transparent polymerizable organosilicone monomers, trimethoxy silanes, alkyl and lower-alkyl substituted alkoxysilanes, composite materials, blister packaging moisture barrier film material, multilayer laminates of structural synthetic polymer film and vapor-blocking synthetic polymer film, bilayer laminates of polyvinyl chloride and polychlorotrifluoroethylene, trilayer laminates of polyvinyl chloride, polyethylene and polychlorotrifluoroethylene, glycolised polyethylene terephthalate,

polychlorotrifluoroethylene, bilayer laminations of glycolised polyethylene terephthalate and polychlorotrifluoroethylene and of polyvinyl chloride with polychlorotrifluoroethylene or with another suitable barrier film material, ethylene-vinyl alcohol copolymer and trilayer laminations of glycolised polyethylene terephthalate, polychlorotrifluoroethylene and ethylene-vinyl alcohol
5 copolymer, ceramic coating material, indium tin oxide, and silicon dioxide coating material.

16. A freeze indicator according to claim 1 wherein the at least one vapor block member has a water vapor transmission rate of no more than about $1.0 \text{ g/m}^2/\text{day}$ at a temperature of 38°C and a relative humidity of 90%.

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17. A freeze indicator according to claim 1 wherein the proportion of dispersed solid phase comprises a proportion selected from the group consisting of: a proportion of not more than about 5 percent by volume of the dispersion; a proportion of not more than about 5 percent by weight of the dispersion; a proportion of not more than about 1 percent by volume of the
15 dispersion; a proportion of less than about 0.1 percent by weight of the dispersion; and a proportion of less than about 0.05 percent by weight of the dispersion.

18. A freeze indicator according to claim 1 wherein the indicator dispersion comprises a visible gaseous bubble in the liquid medium.

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19. A freeze indicator according to claim 1 wherein the indicator dispersion comprises a reference area proximate to the indicator volume, the reference area having an appearance similar to the appearance of the indicator dispersion either before freezing or when frozen.

20. A freeze indicator according to claim 1 wherein the freeze indicator includes at least one transparent outer surface for viewing the indicator dispersion and an ultraviolet-blocking layer wherein the ultraviolet-blocking layer overlies one or more of the transparent outer surfaces of the freeze indicator and is transparent to visible light.

21. A freeze indicator comprising a dispersion of solid inorganic pigment particles in an aqueous dispersion medium, the dispersion exhibiting an irreversible appearance change in response to freezing of the dispersion, an indicator volume containing the inorganic pigment dispersion and a viewing window for viewing the dispersion, the freeze indicator optionally comprising an attachment device for securing the indicator to a host product to be monitored.

22. A freeze indicator according to claim 21 wherein the pigment particles comprise a material selected from the group consisting of pigments, ink pigments, minerals, unreactive metals, noble metals, precious metals, gold, silver, aluminum, iridium, platinum, zinc, selenium or carbon
5 black, sulfur, ferric oxide, kaolinite, montmorillonite, talc, halloysite, calcite, dolomite, rutile titanium dioxide, gibbsite, zincite, barite, crystalline silica, amorphous silica, hydrated silica, fluorite, hydroxyapatite, and a combination of any two or more of the foregoing materials the combination comprising a coating of one material upon the other material.
- 10 23. A freeze indicator according to claim 22 wherein the indicator volume is in the range of from about 5 μ L to about 50 μ L, the concentration of pigment particles is not more than about 0.05 percent by weight, the indicator dispersion is opaque before freezing and visibly light-transmissive after freezing of the dispersion or the indicator dispersion is colored before freezing and is substantially colorless after freezing of the dispersion.
- 15 24. A freeze indicator comprising:
- (a) an indicator volume;
 - (b) an indicator dispersion of solid particles dispersed in a freezable liquid dispersion medium, the indicator dispersion being contained in the indicator volume and being
20 capable of coagulating to provide an irreversible appearance change when subject to freezing; and
 - (c) a concentration-responsive coagulating agent dissolved in the dispersion medium;
- wherein freezing of the dispersion medium increases the concentration of the coagulating agent and effects an appearance-changing coagulation of the dispersion medium.
- 25 25. A freeze indicator according to claim 23 wherein the solid particles are inorganic pigment particles having a surface charge and the coagulating agent comprises from about 0.001 to about 0.01 percent by weight of the indicator dispersion of a counter ion substance to reduce the surface charge on the inorganic pigment particles.
- 30 26. A process for making a freeze indicator according to claim 1, the process comprising: assembling a sheet or continuous web having a series of indicator volume-defining depressions in the sheet or continuous web; charging the depressions with the liquid indicator dispersion applying a substrate layer over the

liquid-charged depressions;

sealing the substrate layer to the sheet or continuous web;

and separating individual freeze indicators from the sheet or web.

5 27. A host product and a freeze indicator according to claim 1 wherein the freeze indicator is associated with or attached to the host product to indicate past exposure of the host product to a potentially freezing temperature.

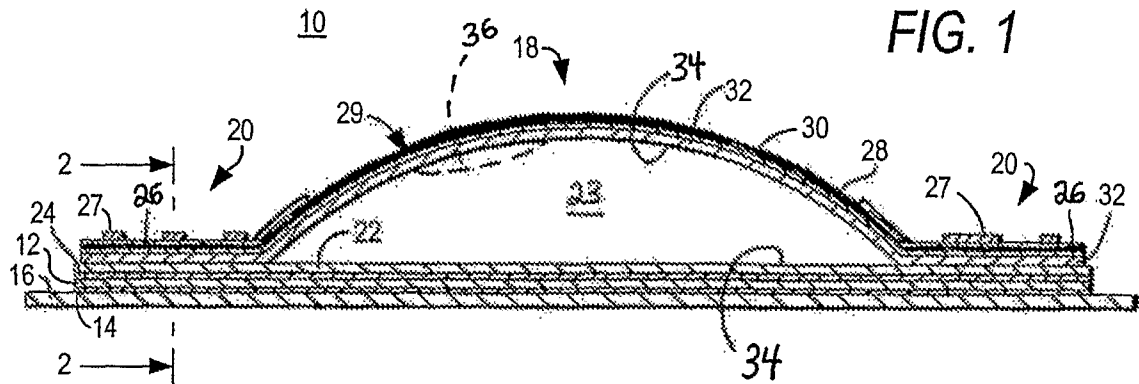
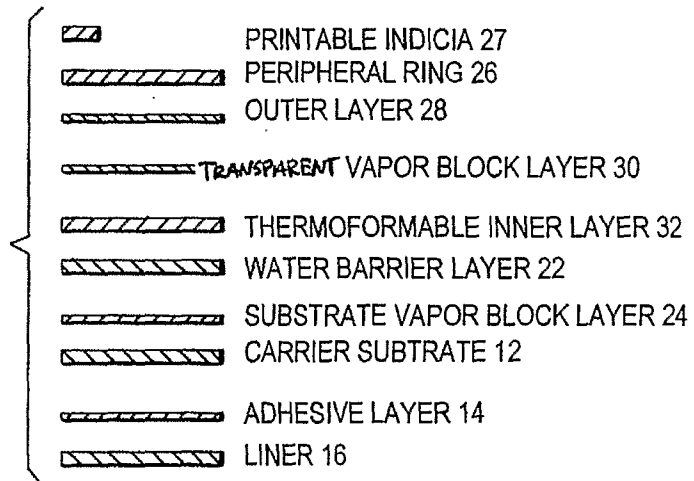
28. A freeze indicator according to claim 1 wherein the liquid medium is a non-aqueous liquid.

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29. A freeze indicator according to claim 28 wherein the indicator dispersion consists of, consists essentially of, or comprises pigment particles dispersed in a non-aqueous liquid.

30. A freeze indicator according to claim 29 wherein the liquid medium is a single phase before,
15 during and after freeze exposure

31. A freeze indicator according to claim 28 wherein the dispersion comprises a dispersion of ink pigment particles.

**FIG. 2****FIG. 3**