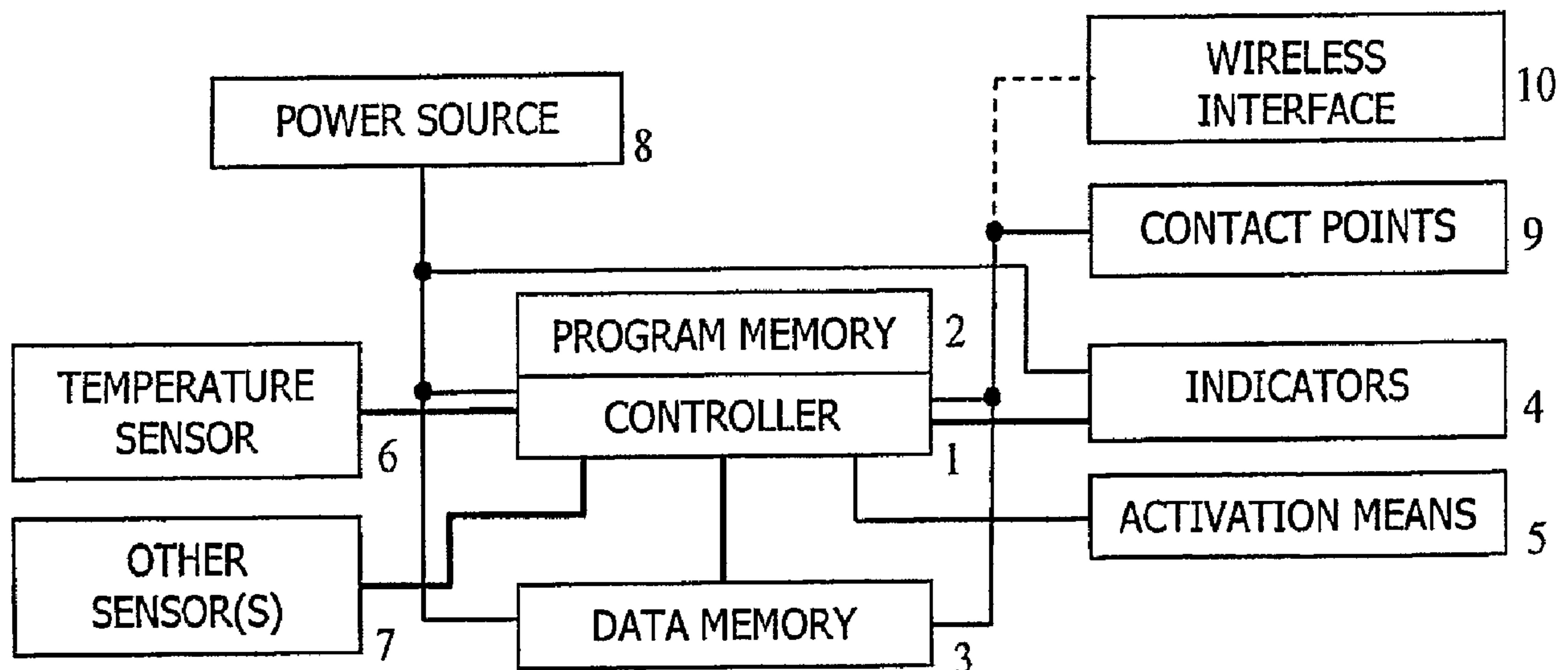




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(57) **Abstrégé/Abstract:**

One apparatus embodiment includes an electronics assembly including an environmental sensor, memory that provides data storage, a logic circuit, an indicator component, and a power source for providing power to at least one of the logic circuit and the memory. The logic circuit can be designed to perform a time measurement, perform an environmental measurement with the environmental sensor, and/or initiate an alarm status when a calculated alarm event time occurs based upon the environmental measurement. The indicator component can be connected to the logic circuit for displaying the alarm status.



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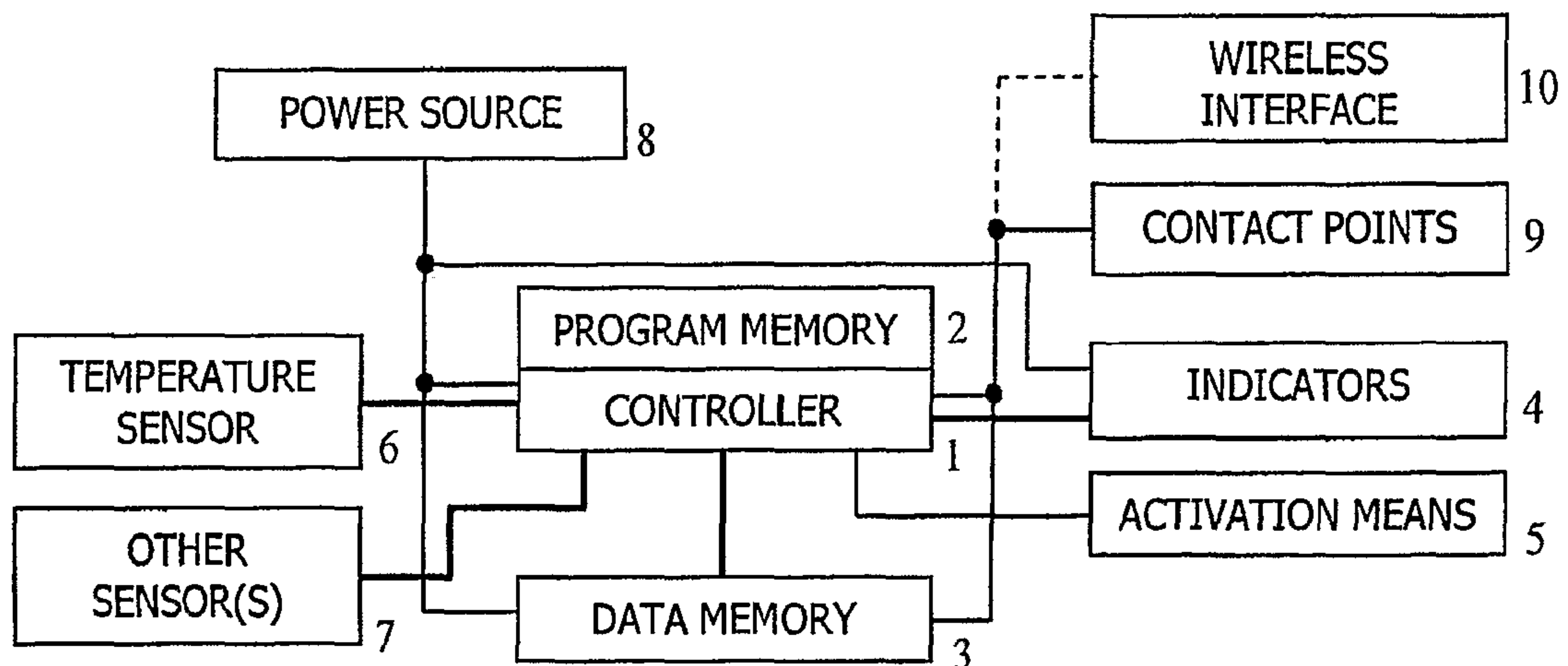
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ENVIRONMENTAL SENSING

5

BACKGROUND

Embodiments of the present disclosure relate generally to sensing environment conditions, converting and processing sensed data, as well as storing derived information and conveying derived information in order to inform users as to conditions that exist. Aspects of the present disclosure also
10 relate to methods for constructing, applying, using, and evaluating such data.

SUMMARY

Producers, distributors, warehouseurs, and quality personnel, among others, especially those in charge of perishable, spoilable, or high-value items
15 that are, for example, moving through a logistics supply chain, typically have to know the condition of items for which their operation is accountable. Also, the customer perception of quality may be of value in some industries and, therefore, the monitoring of products through the supply chain may be used to indicate such quality to a customer base.

20 Further, some entities may be interested in lowering insurance premium costs and the monitoring of products through the supply chain may be one way to reduce such costs. Monitoring the environment of products as they travel is a way of gaining such efficiencies, increasing traceability, and/or of providing for the quality and safety of products which can influence one or more of the above
25 factors, among other benefits.

Embodiments of the present disclosure can be utilized to provide a simple to use, low-cost, accurate, disposable, and/or re-usable devices as an element of a monitoring system. Device embodiments, for example, can be a tag, label, or an assembly that is built into a package.

In such embodiments, the device can include a circuit assembly (e.g., printed circuitry) containing a sensor or sensors, a power source, and/or other electronic circuitry. Embodiments of the present disclosure can include rigid and/or flexible circuit components.

5 In various embodiments, the device can be as small as about 1.5 inches square by about 0.1 inches high, which can, for example, be fit into larger materials. Some embodiments utilize a transparent, semi-transparent or opaque pouch that forms an outer layer over the circuit assembly. Such pouches can be designed to meet industry standards, such as food safety standards. In this way, 10 if the pouch is sealed, the pouch may be approved for use (e.g., as safe for placement adjacent to food) while the contents do not have to be approved. This case saves significant time and money since the manufacturer does not have to gain approval of the apparatus to be placed within the pouch, in some instances, among other benefits.

15 In some embodiments, a portion of or all of an environmental sensing assembly and/or an electronics assembly can be manufactured from one or more materials that meet a food safety standard. As defined herein a food safety standard can be any standard created by an entity (e.g., the U.S. Food and Drug Administration) to regulate usage with food.

20 Various methods of manufacturing and using such monitoring devices are described in the present disclosure. Further, the present disclosure provides method embodiments for communicating with such devices and conveying their data in ways that fit the applications that the devices are intended to address.

25 These and other embodiments of the present disclosure will be discussed more fully in the detailed description. The features, functions, and/or advantages can be achieved independently in various embodiments of the present disclosure, or may be combined in yet other embodiments.

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is a schematic block diagram of a circuit of an embodiment of the present disclosure.

Figure 2 is a top view of a labeled circuit assembly of an embodiment of the present disclosure, providing detail of graphical features.

Figure 3 is a top view of a pouched monitoring device of an embodiment of the present disclosure.

Figure 4 is a partially exploded view of a monitoring device of an embodiment of the present disclosure.

Figure 5 is a partially exploded view of a monitoring device of an embodiment of the present disclosure.

Figure 6 is a cover detail of a monitoring device of an embodiment of the present disclosure.

Figure 7 is a schematic block diagram showing connectivity of elements of a system embodiment of the present disclosure.

Figure 8 is a schematic block diagram showing connectivity of elements of a system embodiment of the present disclosure.

Figure 9 is a flowchart of the connectivity schema of tags, packages, and labels in a monitoring system embodiment of the present disclosure.

Figure 10 is a process flow diagram for a portion of a manufacturing process embodiment of the present disclosure.

Figure 11 is a process flow diagram for a portion of manufacturing process embodiment of the present disclosure.

Figure 12 is an outline of a printed circuit board of an embodiment of the present disclosure.

DETAILED DESCRIPTION

The present disclosure describes a number of device, system, and method embodiments. For example, in some device embodiments, the device includes an electronic circuit and associated executable instructions (e.g., software,

firmware, etc.), enclosed in a label, tag, or package, that monitors environmental conditions.

The various embodiments of the present disclosure can include a number of different features and functionalities. For example, some device embodiments
5 can be read through use of a reader that penetrates an outer coating of the device to touch a number of contacts therein.

In some embodiments, the contacts are located on the outside of the device and therefore the reader does not penetrate the device. In various embodiments, the reader can be wireless and can receive information from the
10 device without contacting the device.

Some wireless embodiments of the device and reader, can be usable a short range and/or at long range. For example, some such embodiments can utilize portable device communication formats (e.g., GSM, ANSI, etc.) to communication information to and/or from the device.

15 The present disclosure also includes embodiments that can be activated by a variety of different mechanisms. For example, some embodiments can be activated by snapping, breaking, or bending a portion of the device, among other mechanisms. Similarly, some embodiments can be activated by one or more radio frequency (RF) signals.

20 In some embodiments, the display of the device can also be provided in various forms. For example, a number of LED's can be used, in some embodiments.

Various embodiments can utilize a chemical change to provide a portion of or the entire display functionality of the device. For example, an electro-
25 chemical component can be used to provide at least some display functionality, in some embodiments.

Some embodiments can have different physical characteristics. For example, various device embodiments can be designed to be folded, laminated, or pouched, and/or reusable or disposable.

Embodiments can include memory to store various data that is accumulated by the device, such as time and environmental condition data. In some embodiments, this information can be provided to a database that is not contained within the device (e.g., a database on a server with a web portal for
5 access by a number of clients).

Embodiments can also be designed to take time and temperature measurements rather than a number of times that a sensor has exceeded a threshold or the amount of the time the sensor was over the threshold. This can be important in some instances, particularly in instances where not only the
10 amount of time over the threshold is important, but where the amount that the environmental condition was over the threshold is also important (e.g., in food safety situations where the higher the temperature to which a product is exposed, the more quickly it will perish).

The present disclosure also includes embodiments that incorporate
15 memory compression techniques that allow the device to store more information. For example, a device embodiment can include a variation limit data compression mechanism that can discard data points if there is no change, or if the change is not outside a variation limit.

Data points can be averaged, in some embodiments, if the data points are
20 within a particular range that is deemed acceptable (e.g., although data is taken every minute, some data points can be averaged and that point can be stored, since all data averaged is within an acceptable range). In some embodiments, such variation limits, thresholds, and/or averaging parameters can be set and/or adjusted by the user, seller, or manufacturer based, for example, upon the type of
25 product with which the device is to be used.

In some embodiments, executable instructions can be provided that are executable by a logic circuit to take an environmental measurement at a predetermined time interval. In various embodiments executable instructions can be provided that are executable by the logic circuit to take an average of a

number of such environmental measurements. These averages can, for example, be calculated through use of a number of sets of environmental measurements.

As discussed above, executable instructions can be provided, in some embodiments, that are executable by the logic circuit to store an environmental measurement if it is within a predetermined range of values and/or within a
5 predetermined range of value variations. For example, if a temperature is between 40 and 70 degrees F (in such embodiments, a range can be one threshold, such as 40 degrees, and no second limit, thereby making the range, for example, 40 degrees and above), the temperature can be recorded.

10 With respect to value variations, as used herein, a value variation is a variation from a particular value. The value can be preset, based upon an average as described above, based upon a last stored value or a last measured value, among other values that can be utilized to measure a variation therefrom.

Embodiments of the present disclosure can be fabricated from a variety
15 of materials. For example, device embodiments can be fabricated with rigid or flexible circuit components and in some embodiments, these components can be printed circuit components. These and other features and functionalities of the various embodiments of the present disclosure are discussed in more detail below.

20 In some embodiments, the embodiment can have the ability for the label, tag, or package to convey its information to users in one of a variety of ways. For example, as shown in the embodiment of Figure 1, a circuit of the label, tag, or package may include a controller, such as a microcontroller and/or other logic circuitry (e.g., state machine, hard wired logic, etc.) 1, a program memory 2 (e.g.,
25 read-only, read-writable), a data memory 3, a display and/or indicators 4, an activation mechanism 5, a one or more environmental sensors 6 (e.g., temperature sensor), one or more optional other sensors 7, such as humidity, shock, tilt, vibration, pressure, light, chemical, or others, and/or a power source 8.

Activation mechanism 5 can be provided by a number of possible circuits and constructions, including ones that include a breakaway tab switch, a pull-tab switch, an infrared switch, a magnetic switch, an electromagnetic switch, or a radio frequency resonant switch, among other mechanism types. For example, with respect to a breakaway tab switch or a pull-tab switch, activation can be accomplished by a user physically activating the circuit. In some embodiments, a transmitting device can be used to remotely accomplish the activation.

A communications mechanism can be incorporated into the circuit, such as, for example, a set of target contact points 9, suitable for contacting with an external probe device can be utilized and can be located within the device or can be positioned for contact without penetration into the device. As discussed above, a wireless interface 10, such as infrared or radio frequency modulation circuit can be utilized in some embodiments. Some purposes of the hardware described above, for example, can be to provide mechanisms for sensing environmental variables, performing storage of measured data, performing processing of the measured data (e.g., under embedded software control), providing display indications, and/or providing download and/or offload capability of processed data.

In some embodiments, a flexible or rigid printed circuit assembly can serve as a substrate or mounting surface for the electronics. For example, the electronic components can be provided as surface mounted components. Some embodiments, such as that illustrated in Figure 1, incorporate power source 8 (e.g., a tab-mounted coin-cell type power source) into the circuit assembly.

Also present in the embodiment of Figure 1, are a number of indicating Light Emitting Diodes (LEDs) as indicators 4. Such indicators can, for example, be arranged to indicate an upper yellow, a middle green, and a lower yellow light as indicators 4. As discussed herein, other display indicators can be used in various embodiments.

In some embodiments, a label graphic can be constructed (e.g., from plastic and/or paper film, etc.), as is shown in the embodiment of Figure 2. A

cover, for example including the label graphic, can be used to cover the circuit assembly. In such embodiments, the cover can include printed features on its surface.

In some embodiments, a cover can also be made larger such that it can be folded to cover both the front and the back of the Printed Circuit Assembly (PCA). In various embodiments, an area of the cover can be printed with legend information (e.g., text and/or symbols) that identifies what the one or more indicators signify. The label can be fabricated from any suitable material including translucent or opaque materials and can be provided as a clear material with overprinting thereon, in some embodiments.

In some embodiments, the label graphic and the printed circuit assembly can be integrated such that a portion of, or the entire, printed circuit is part of, or attached to, the label material. In some such embodiments, the label may be designed such that the graphic, or portions thereof, may be applied before the printed circuit is created. In some embodiments, the label may be designed such that the graphic, or portions thereof, may be applied after the printed circuit is created.

In embodiments that utilize one or more illuminating indicators, such as LEDs, the indicators can illuminate printed lenses 11, for example, from behind. The legend information associated with the indicators (e.g., adjacent to the lenses 11 in Figure 2), can be modified to suit the measurement and/or alert parameters that are programmed.

Various embodiments can use plastic films that accept inks that can be printed by ink-jet, laser, flexographic, and/or other suitable printing processes. Some embodiments may be capable of utilizing the high-resolution and/or deep color saturations possible using off-the-shelf printers, such as those available from Hewlett Packard, Canon, or Primera.

Embodiments can also include other graphic elements such as a logo, target product identification area 12, an activation break point graphic 13, and/or a temperature limit graphic 14, as illustrated in the embodiment of Figure 2. The

logo and target product identification area 12, as well as the temperature limit graphic 14 can be used, for example, to provide a package, tag, or label to be supplied with a unique graphic that is matched to the parameters that are programmed into a controller's program memory 2 and/or data memory 3.

5 For instance, features 12 and 13 can provide identification of the target product and its parameters. The activation break-point graphic 13, the embodiment of Figure 2, is placed over an area of the printed circuit assembly that has a breakaway corner, to indicate to the user where the circuit can be activated when it is time for monitoring to commence. In some embodiments, 10 such as in some flex circuit embodiments, this activation mechanism can be a tear off or snap corner as such activation mechanisms are understood in the art.

In some embodiments, a circuit assembly (e.g., printed circuit with a cover label 15), as depicted in Figure 3, can be inserted into a pouch 16. The pouch can be of any suitable material and can be sealed permanently or 15 resealably in any suitable manner. For instance the pouch can be heat-sealed, glued, or have a physical sealing structure formed from the pouch material.

As stated above, in some embodiments, the pouch can be fabricated of a material that meets one or more requirements within a particular field. For example, in the field of food transportation, the material may be a material 20 deemed safe to be placed near or in contact with food.

Examples, of such materials include, but are not limited to materials including plastics, vinyls, polystyrenes, and other such materials. For instance, polyethylene terephthalate (PET) is one suitable plastic material for use with food. In some embodiments, the exterior of the pouch can meet such a 25 requirement, while the interior may or may not meet a requirement.

In various embodiments, such as that depicted in Figure 4, a circuit assembly can be inserted into a hole 21 (e.g., die-cut) into a piece of material, such as in a piece of foam (e.g., closed-cell) or plastic 18, which can then be laminated on its top and/or bottom surfaces (e.g., with printed plastic film 30 covers, 17 and 19). In some embodiments, the film can be heat sealed to the

foam or can be adhered with adhesive to the foam. Embodiments having such a laminated assembly can include graphic information and/or lenses 20 as part of a top film cover 17, which, for example, may comprise translucent or clear material with overprinting, or can have lenses.

5 In various embodiments, the tag or label device may also be inserted into a packaging material. In such embodiments, the tag or label may be built into or added to a larger label or a larger pouch that can be adhered to a package or inserted into a package.

Figure 5 depicts an embodiment of a tag or label that comprises a top
10 cover 22 and a bottom cover 23 that cover the top and bottom of printed circuit assembly 24. Such an embodiment can also have graphic information and lenses as part of the top film cover 22, which may, in some embodiments, comprise translucent or clear material with overprinting, and/or can have openings with lenses built in as separate materials.

15 Figure 6 depicts an embodiment, having a top label graphic cover 22 and a bottom cover 23 that are the same piece of material (e.g., folded or cut in half or other dimensions/shapes). The printed circuit assembly 24 is illustrated mounted underneath the top half of the cover, and aligned with lenses 25.

If an adhesive is used to bond the covers 22 and 23 to printed circuit
20 assembly 24 and/or to each other, then the assembly can be utilized as a covered electronic assembly with label surfaces on both sides, and with lenses for the light transmission of the indicators. In various embodiments, the assemblies of Figures 5 and/or 6 can be inserted into the pouch as discussed with respect to Figure 3.

25 Various label, tag, or package-based device embodiments can be provided that process and/or store data. Embodiments can facilitate communication of the data to reader devices. In such embodiments, reader devices can communicate by way of any suitable direct connection (e.g., via the use of probe pins) or any suitable wireless connection type. Suitable types of
30 wireless connections include infrared, LEDs (e.g., in data transmission mode,

can emit pulsed visible light), and/or radio frequency modulation among many other connection types known to those in the art.

With respect to embodiments utilizing a radio frequency communication connection, radio frequency based readers utilize a one-way (transmit only) or a two-way radio mechanism to be associated with the tag, label, or reader device. Likewise, a one-way (receive only) or two-way radio connection can be used by the reader device to match the tag, label, or package device with which it will be communicating.

These data radio mechanisms can be based upon established standards, such as IEEE 802.11b, or based upon other proprietary radio technologies. The radio mechanisms associated with the tag, label or package devices may also participate in a networked (e.g., mesh network) or similar interface scheme to communicate with the reader. These types of networks may fall within IEEE 802.15.4 standards development, among others.

As readers gather the data from their respective tags, labels, or packages, the readers, in turn, can communicate the data or files to databases or other storage locations. In some embodiments, this can be accomplished via another type of data device. For example, such devices can include a standalone gateway, hub, router, or other type of computing device, such as a personal computer, portable computing device, or server type computing device.

These devices can communicate with tag, label, or package readers by way of wired or wireless interfaces, including Internet or other connection types. Through these connections, data can be forwarded to one or more databases for storage and/or analysis, among other functions. If a gateway or hub device communicates wirelessly to a database, then it can be autonomous with respect to its immediate environment.

In such embodiments, a gateway or hub device can be situated, for example, in a warehouse, on a pier, or in an industrial area and perform its function without utilizing additional local information technology infrastructure.

This can represent added value, for example, for users who do not wish to upgrade their existing computer and IT equipment.

Figure 7 is a schematic block diagram showing a wireless reader 27 and a wireless hub 28 in communication with a tag, package, or label device 26. As depicted, each device has its own logic circuitry, 29, 34, and 40, respectively. In such embodiments, these logic circuits can utilize a microcontroller or microprocessor device in communication with program memory and data memory, a state machine functionality, logic circuitry utilizing a number of flip flops, or other such logic components. Such controllers can control the operation of the other devices in each respective circuit.

The embodiment of Figure 7 includes a number of different communication links in various formats. Communication links can be in any suitable format. For example, in the embodiment of Figure 7, an electromagnetic (EM) communication transmitter 35 is employed in reader device 27 to form a communication link to send a pulse or series of pulses to EM receiver 30 via an antenna (e.g., a coil type antenna) 31 thereby utilizing an EM channel. The transmitting or receiving functionality of a communication link can be provided by one or more transmitters, receivers, and/or transceivers. Although designated as EM and RF transmitters and receivers in the embodiment of Figure 7, it is to be understood that any suitable wireless or wired communication mechanisms can be utilized in various embodiments of the present disclosure.

An EM channel typically operates at close range and can be used to initiate an upload of data, for example, telling the tag, package, or label device 26 to wake-up and begin transmitting data via a transmitter 32 and antenna 33 over to wireless reader's 27 receiver 36 via its antenna 37. In such embodiments, the wireless reader can receive and process the data using its controller. Devices can also be designed to transmit processed data to wireless hub 28 via transmitter 38, via antenna 39 to hub 28 to transceiver 41 via antenna 42. Hub 28 can also be utilized to transmit signals containing commands and data to reader receiver 36 via its antenna 37, in some embodiments.

In various embodiments, a wireless reader can transmit data from a label directly via a communication link over a wired or wireless network 47 to a remote location (e.g., to a remote device such as a hub or computing device) or directly to a computing device 76 for storage and/or analysis. Such
5 communications can, for example, be accomplished via a data modem 74 and a communication link (e.g., a communication interface) 75. A wireless reader can be beneficial in some fields of use since the products being shipped may not be near a fixed power source and/or fixed computing device.

The wireless reader can transfer data via a RF modem and a network such
10 as by global system for mobile (GSM) communication. The wireless reader may also transfer data over a wired connection, such as via universal serial bus (USB), to a hub or other network device (e.g., a computing device) for storage and/or analysis. Such hubs and computing devices may also transfer the data via
15 wired or wireless communications to a remote location for storage and/or analysis.

The schematic block diagram shown in Figure 8 illustrates another embodiment with a similar communication technique to the one described for Figure 7. In this embodiment, all of the communications for the tag, package, or label device 26, wireless reader device 27 and wireless hub device 28 are
20 implemented using transceivers 38, 41, and 43, which are present in each respective device, along with antennae 33, 37, and 42.

The transceivers allow the same or similar communication capabilities as for the system depicted in Figure 7. Transceivers can have various standard protocols, including 13 MHz or UHF forms of Radio-Frequency Identification
25 (RFID) transceivers, IEEE 802.11, IEEE 802.15.4 type devices, and non-standard and proprietary protocol devices, among others.

As is the case for the embodiment depicted in Figure 7, each device shown in Figure 8 has its own logic circuitry, 34, 40, and 44. Again, these controller circuits can utilize a microcontroller or microprocessor device, among

other logic types, in communication with program memory and data memory. Each tag, package, or label device 26 also includes sensing circuitry 45.

The wireless hub communicates to databases by wired or wirelessly through interface 46 via the Internet 47 or other media conduit. Similar to the
5 embodiment of Figure 7, the wireless reader 27 of Figure 8 may also transfer data to a remote location by wired or wireless communications. This may be accomplished, for example, via a communication interface 96. Such embodiments may utilize the Internet or mobile communications networks for transferring data.

10 Figure 9 is a connectivity diagram, depicting an example of how tags 48, packages 49, and labels 50 can all be connected in locations distant from one another using different types of readers 51 into a database 56. Readers can be fixed (e.g., mounted on portals to buildings 52) or portable 54.

Readers can communicate in a wired and/or wireless manner 53. In
15 various embodiments, each reader can be in communication with a hub 55 that is in its locality, among other locations. Each hub can be configured to connect to a database 56 or multiple databases.

In some embodiments, a reader can also provide the functionality of a hub or be a hub network device. In such embodiments, the system may not
20 utilize independent hub devices, but rather, one or more of the readers can provide such functionality to the systems. In some embodiments, hubs and readers can be used to provide such functionality. In the tag, label, or package device of the present disclosure, executable instructions can be loaded and executed by a controller or other control logic of the device.

25 The executable instructions (e.g., loaded or embedded software/firmware) can implement a variety of methods of data compression. In various embodiments, the sensor readings can be compared to past readings and decisions can be made, based, for example, upon programmed, settable parameters and/or upon the value of the new data. For instance, if a new reading
30 is within one or more settable window limits as compared to the last reading,

then the new reading is not stored, and if outside of the limits, then the reading is stored.

In some embodiments, data compression can be provided by storing the difference between two values (e.g., adjacent values in time, adjacent values as
5 stored, difference from a reference value, etc.)

Another storage condition can be used, such that if a settable period of time has passed since the last storage of a reading, then a new reading will also be stored. Such criteria (e.g., limits and periods of time) can be designed to be pre-programmed and/or programmable in the field, in various embodiments.

10 In some embodiments, in order for circuit assemblies for tags, labels, and packages, as described above, to be manufactured in volume, it may be advantageous that they be loaded, during manufacture, with tuning parameters that allow application specific, and/or custom tuned, functionality to suit different user's monitoring desires. An example method that can be employed to
15 accomplish tuning at the end of the manufacturing process is called late-stage customization.

This method involves building the printed circuit assemblies (PCA's) to be generic. With such embodiments, it may be possible for PCAs to be inventoried as generic units until an order is placed for some quantity of tag,
20 package, label, or reader products and is to be filled.

The order may contain information that can be used to customize the generic assemblies. For example, at the point where an order is to be filled, the generic board can then receive its executable instructions and data. Once such programming is accomplished, a power source 8 can be connected to the circuit.
25 In some embodiments, the generic assembly may have the power source attached prior to programming of main or customized executable instructions. In some such embodiments, the device can be designed such that the program can provide a power-on self-test procedure and then go to sleep, waiting for activation by a user to occur.

In some embodiments, the executable instructions, upon powering up, after the power source (e.g., a battery) is installed, can set up a number of variables, read setpoint and alert data from the EEPROM, and then put the controller into a sleep mode. In sleep mode, the controller can, for example, still
5 be powered but not execute instructions, and therefore draw very low power levels, in order to preserve the life of power source 8, among other benefits.

Some embodiments can employ and make use of specific parameters, previously stored in the EEPROM array contained within the tag or label circuit, for example, to establish the personality of a tag, label, or package, among other
10 uses. The executable instructions, for instance, read these personality parameters upon activation, allowing for executable instructions to then behave according to loaded parameters.

The parameters can be data that allow configuration setpoints of, for example, limits for over-temperature, under-temperature, or time-temperature
15 integration thresholds. Other parameters can include serial numbers, model numbers, times, locations, and/or data sample rates, among others. This information can allow for indication and alert modes to be stored, retrieved, and utilized to set specific desired operations, among other functions.

Various embodiments include the incorporation of printed information
20 onto the front and/or back surfaces of the package, tag, or label, which can, for example, be printed during manufacturing. Executable instructions, including, for example, specific compiled or assembled program code and/or parametric or personality data, as described above, can be written (e.g., via a programming fixture) to the program and/or one or more data memory components of a generic
25 PCA that is to be finalized into a tag, label, or package.

In the process flow diagram depicted in Figure 10, a previously manufactured PCA 57 is brought in contact with a fixture 58 where electrical
contact is made to one or more test pads 59 via one or more test probes 60. The program and test fixture 58, through such contact between pads 59 and probes
30 60, programs one or more of the memories and tests the function of the

assembly. The programming and test function can be accomplished through use of an off-the-shelf personal computer (PC) 61.

Computer 61 can contain specific object files 62, and/or device information such as a record of serial numbers, which can be managed and/or
5 kept in a database file 63. Serial numbers and, in some embodiments, real-time date and time stamp, can be loaded into data memory. The serial numbers can be incremented with each successive PCA that moves through the process, in some embodiments.

As each PCA 57 is programmed and tested, the serial number
10 information can be printed onto a label by printer 64, along with other desired text, bar coding, and/or other graphical information that is to be displayed on the surface of the tag, label, or package. As used herein graphical material can include symbols, including numbers and letters, graphs, and other graphical representations of results and/or information. The printing and testing can be
15 accomplished simultaneously in some embodiments. In various embodiments, a printer 64 can be fed with printable material 65 (e.g., roll or sheet form label stock), and the printer 64 can emit a serialized label 68 upon control of computer 61 each time a PCA is programmed and tested. Note that label 68 can contain lenses for indicators or display elements to show through. The lenses can be
20 previously fabricated onto the label stock material 65, and/or the label stock can be clear or translucent. The lenses can become a printed feature, with many ink, patterning, and material choices available to create lenses, viewing windows, etc.

In the embodiment of Figure 9, once a PCA 57 is completed and/or has passed testing, it can proceed to attachment fixture 66. Power source 67 can be
25 associated with the electrical circuit of the PCA 57 and powered-up if desired. In some embodiments, the power source can be affixed and associated with the PCA prior to programming of the PCA.

PCA 57 can receive the printed label 68 via applicator 69 while in a powered-up condition. Note that a combination of the aforementioned program,
30 test, installation of power source, and application of label, among other functions

can be accomplished in a single process location, and can be automated using pneumatic controls, actuators, and/or machined fixturing.

In some embodiments, a completed, labeled PCA 70 can be inserted into a pouch (e.g., formed from roll-stock clear web material 71). Pouches can be
5 constructed from any suitable material. For example, packaging materials, such as SnackWeb or other Rapid-Roll products from Avery Dennison, can be used.

In the embodiment of Figure 10, the two components, 70 and 71 are fed into a pouching machine 72, such as a Go-Packer 3000 machine from Phoenix Engineering, Inc, or other suitable pouching device or process. Such pouching
10 techniques can be used to enclose a labeled PCA 70 into a pouch 72 and thereby provide a pouched, activatable, safe for contact with food, and/or water-resistant product 73 that can be inserted into other packaging, labeling, or over-packaging. In some embodiments, the assembly can be made more flexible by utilizing a flexible PCA 57.

15 Post-printing of a label graphic, at a late-stage in manufacturing, can provide a benefit in that the product can be built to order using a set of components that can be used with respect to each product's bill of material. In some embodiments of a post-printed product, it is also possible to print directly on the web material 71 used for pouching, on the inside and/or the outside
20 surface of the material.

Rather than printing a separate label material 65 that is internal to the pouch or, alternately, affixed to the outside, direct printing on the web material 71 results in fewer steps and a simpler product, among other benefits. Post-printing can be accomplished on any suitable rolled web material, such as
25 materials that are clear, translucent, opaque, and/or materials having multiple areas of different opacity.

Materials can have one or more lens features and/or window features. For example, an opaque foil laminate or plastic laminate material can be used and can be fabricated having one or more lenses and/or windows.

In the following process method embodiment, addressing the flow diagram depicted in Figure 11, a manufactured PCA 77 can be brought in contact with a fixture 78 where electrical contact can be made to test one or more pads 79 via one or more test probes 80. The program and test fixture 78, through such contact between pads 79 and probes 80, can be used to program the one or more memories and test the function of the assembly.

In various embodiments including those illustrated in Figures 10 and 11, a PCA with a pre-programmed processor can be used. In some such embodiments, such programming can allow for certain instructions and or personality information to be transferred and/or programmed into the PCA using wireless and/or non-contact communications, among others.

The programming and test functions can be accomplished, for example, through use of an off-the-shelf personal computer (PC) 81. Computer 81 can contain specific object files 82, and one or more records of serial numbers, which are managed and kept in a number of serial number database files 83. Serial numbers and a real-time date and time stamp can be loaded into data memory and such device can include executable instructions to increment the serial number to be used with each successive PCA 77 that moves through the process.

As each PCA 77 is programmed and tested, a simultaneous event occurs, in which the serial number information is printed onto a label by printer 84, along with other desired text, bar coding, and/or other graphical information that is to be displayed on the surface of the final product. Printer 84 is fed with roll form top cover material 85, and the printer 84 emits a top cover 88 upon control of computer 81 each time a PCA 77 is programmed and tested.

In some embodiments, it should be noted that top cover 88 can contain lenses and/or windows for indicators or display elements to show through. The lenses can be previously fabricated onto the label stock material 85, or the label stock can be clear or translucent, and the lenses become a printed feature, with many ink, patterning and material choices available to create workable lenses.

Once a PCA 77 is completed and has passed testing, it proceeds to attachment fixture 86, where power source 87 is attached to the electrical circuit of the PCA 77. Once the circuit is powered-up, PCA 77 can be inserted into a punched hole in spacer 90, and they together form positioning structure 91. In some embodiments, the power source can be attached prior to final programming and/or testing of the PCA.

The spacer material can be any suitable type of material. For example, the spacer can be a type of foam, elastomer, plastic, cotton based, or wood based material, among others. The spacer material can be of any suitable thickness, and may, for example, be the same height as the PCA. Such an arrangement provides protection and accessibility to the PCA, among other benefits. It can be provided as die-cut parts loaded onto reels. Note that a combination of the steps described can be automated using pneumatic controls and actuators and machined fixturing.

In various embodiments, the positioning structure 91 can be inserted, along with top cover 88 and bottom cover 93 into a laminating machine 92. For example, the bottom cover material can be fed from rolls or in sheets into the laminating machine 92.

In some embodiments, the resultant tag, label, or package device 94 has two film-like covers over a positioning structure of a consistent height. The positioning structure 91 can be made more flexible by making PCA 77 a flexible PCA. The resultant device 94 is water resistant and can be inserted into other packaging, labeling, or over-packaging, as desired.

In some embodiments, the environmental sensing assembly can include an inner portion including the environmental sensor, memory, logic circuit, indicator component, and the power source, among other assembly components. An outer portion can include an encapsulating material that encapsulates the inner portion. In such embodiments, the outer portion can be formed from any suitable material, such as plastic, vinyl, paper, and/or polystyrene materials, among others.

In some embodiments, the outer portion can be formed from a number of pieces (e.g., a top cover and bottom cover) that can be adjoined to encapsulate the inner portion. In some such embodiments, an outer layer (e.g., a pouch) can be placed around the outer layer. The outer layer can be a transparent, opaque, or
5 semi-transparent layer, in various embodiments.

With regard to different methods of attaching this monitoring device onto other items, some approaches include using adhesive backing, use of a mounting tab or a hole for attaching, tying, or hanging on to an item's container, or attaching directly on an item to be monitored. Device embodiments can be built
10 directly into cardboard or plastic packaging, or into totes, bins, or other product containers or assemblies.

The monitoring devices described herein can be built to a specification established by quality assurance personnel. The unused tag, label, or package monitoring device is first installed in its monitoring situation and is activated at
15 the desired time. The device can also be programmed for a delayed activation, such that it begins recording after a programmed delay and/or the occurrence of an event, such as a temperature and/or moisture threshold being met or exceeded.

In some embodiments, the device can be programmed for a delay in monitoring for alerts. In such embodiments, the device can be designed to begin
20 collecting data once activated, but to not act on that data for a set period of time.

In some embodiments, as depicted in the representation of the printed circuit board 95 shown in Figure 12, a corner tab can be pre-cut into the printed circuit board upon fabrication. This tab or a portion thereof can be a thin section that forms a break-off activation switch. In various embodiments, the corner
25 may be scored to facilitate weakening the corner and creating a uniform mechanism for activating the device.

When activation is desired, the user snaps the corner; it opens a circuit trace that runs across the break boundary, which in turn wakes up the processor so that it can begin monitoring. Once activated, the indicators of this

embodiment will acknowledge that the device has activated (e.g., flash a number of times).

In operation, the LEDs of the embodiment illustrated in Figure 1, are constructed to indicate an upper yellow, a middle green, and a lower yellow light
5 on the surface of the device, when shining through the lens areas. In this configuration, the upper yellow indicator can serve as an over limit status indicator, the lower yellow indicator as an under limit status indicator, and the center green indicator can serve as an OK status indicator.

In such embodiments, the LED indicators can, for example, flash once
10 every few seconds, and can also perform double, triple, or coded flashes to signify different status conditions, again as programmed to suit particular applications. An aspect of having indicators that are able to respond to programmatic settings and to indicate derived parameters is that they can provide a summary of events that occur over time. In effect, the one or more indicators
15 can provide a compressed form of data to the viewer.

In various embodiments, the environmental sensing apparatus can be designed to be customized in late stage manufacture or by the customer. For example, in some embodiments, the formation of the environmental sensing component, logic circuit, power source, and encapsulating material can be
20 accomplished to form an environmental sensing assembly, and then one or more customer specific items can be added to the environmental sensing assembly.

Adding a customer specific item to the environmental sensing assembly can, for example, be accomplished by printing a customer specific item on an outer surface of the encapsulating material, by providing an item of data to be
25 used by the logic circuit in determining whether an action should be taken based upon the received sensing information, by configuring the logic circuit with a customer specific configuration to be used in determining whether an action should be taken based upon the received sensing information, and/or other customer specific information, among other items. Such items can include

customer specific logos, identifiers (e.g., customer name or other identifier), unit specific identification numbering, threshold information, sampling periods, etc.

In some such embodiments, the addition of these items can be accomplished wirelessly, which may allow the manufacture of the assembly to be
5 completed or substantially completed before the customization is accomplished. Such embodiments can be particularly beneficial where a customer may do the customization since the assemblies can be sent to the customer with just the customization left to be accomplished.

In some embodiments, the encapsulation may not yet have been
10 accomplished when the customization is undertaken. Such embodiments can be beneficial where the assembly is to have printed information thereon that is to be applied just prior to shipping to a customer or to be print by a customer thereon. In some such embodiments, printed items and/or data items can be added, for example.

15 Although specific embodiments have been illustrated and described herein, those of ordinary skill in the art will appreciate that any arrangement calculated to achieve the same techniques can be substituted for the specific embodiments shown. This disclosure is intended to cover adaptations or variations of various embodiments of the disclosure. It is to be understood that
20 the above description has been made in an illustrative fashion, and not a restrictive one.

Combination of the above embodiments, and other embodiments not specifically described herein will be apparent to those of ordinary skill in the art upon reviewing the above description. The scope of the various embodiments of
25 the disclosure includes various other applications in which the above structures and methods are used. Therefore, the scope of various embodiments of the disclosure should be determined with reference to the appended claims, along with the full range of equivalents to which such claims are entitled.

Additionally, in reading this disclosure and claims, it should be noted that
30 the indefinite article “a” or “an”, as it is used herein, is not intended to limit the

number of elements to one. Accordingly, the terms “a” and “an” should be viewed as meaning one or more unless such limitation is expressly stated or such meaning would be illogical based upon the arrangement of elements formed by such meaning. Further, the term “a number of” should be interpreted as meaning
5 one or more.

In the foregoing Detailed Description, various features are grouped together in a single embodiment for the purpose of streamlining the disclosure. This method of disclosure is not to be interpreted as reflecting an intention that the embodiments of the disclosure require more features than are expressly
10 recited in each claim.

Rather, as the following claims reflect, inventive subject matter may lie in less than all features of a single disclosed embodiment.

WHAT IS CLAIMED IS:

1. A method, comprising:
 - forming an environmental sensing component;
 - forming a logic circuit that receives environmental sensing information from the environmental sensing component and determines whether an action should be taken based upon the received sensing information;
 - providing a power source to provide power to at least one of the sensing component and the logic circuit;
 - encapsulating the environmental sensing component, the logic circuit, and the power source to form an environmental sensing assembly with an encapsulating material;
 - and
 - wirelessly configuring the logic circuit with a customer specific configuration to be used in determining whether an action should be taken based upon the received sensing information.
2. The method of claim 1, wherein configuring the logic circuit is accomplished by providing an item of data.
3. The method of claim 2, wherein providing an item of data includes data to be used by the logic circuit in determining whether an action should be taken based upon the received sensing information.
4. The method of claim 1, wherein configuring the logic circuit with a customer specific configuration to be used in determining whether an action should be taken based upon the received sensing information comprises configuring the logic circuit with threshold information or a sampling period.

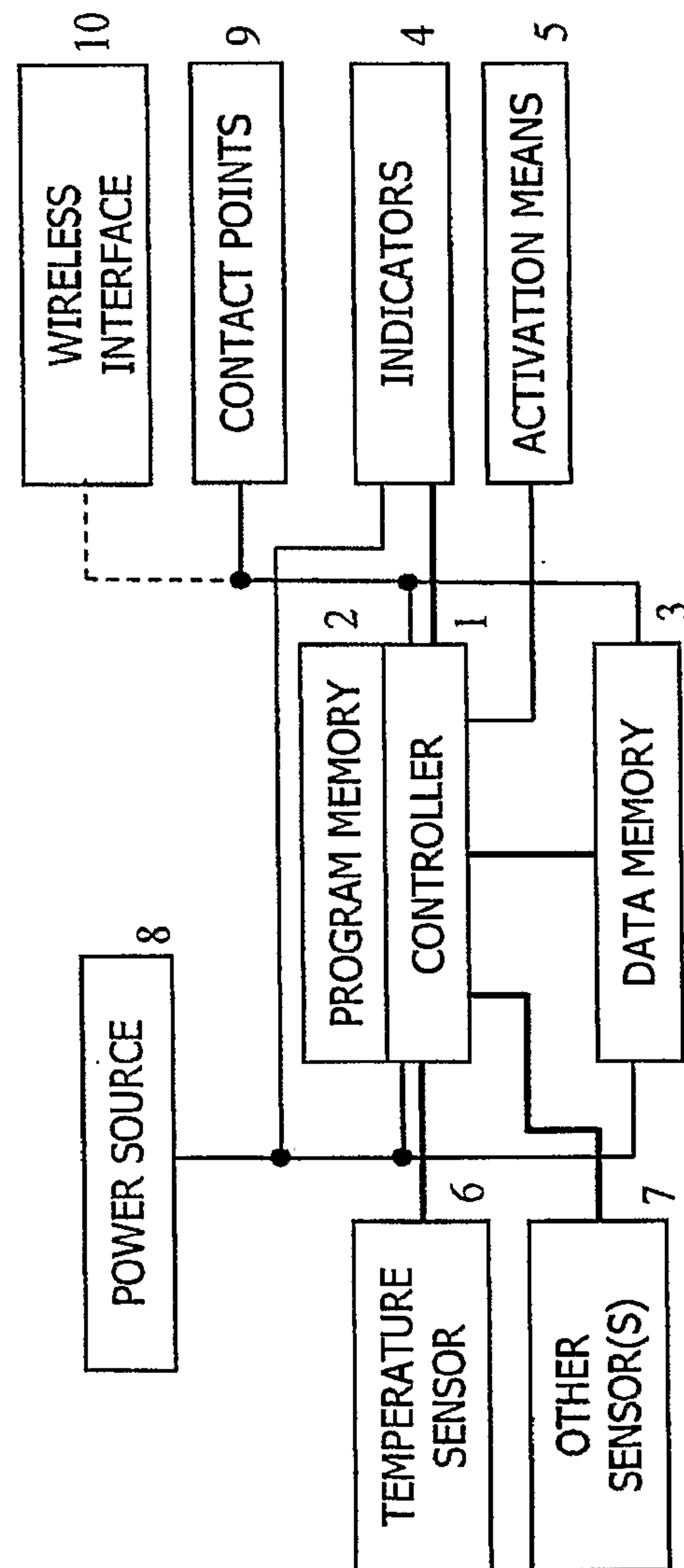


FIGURE 1

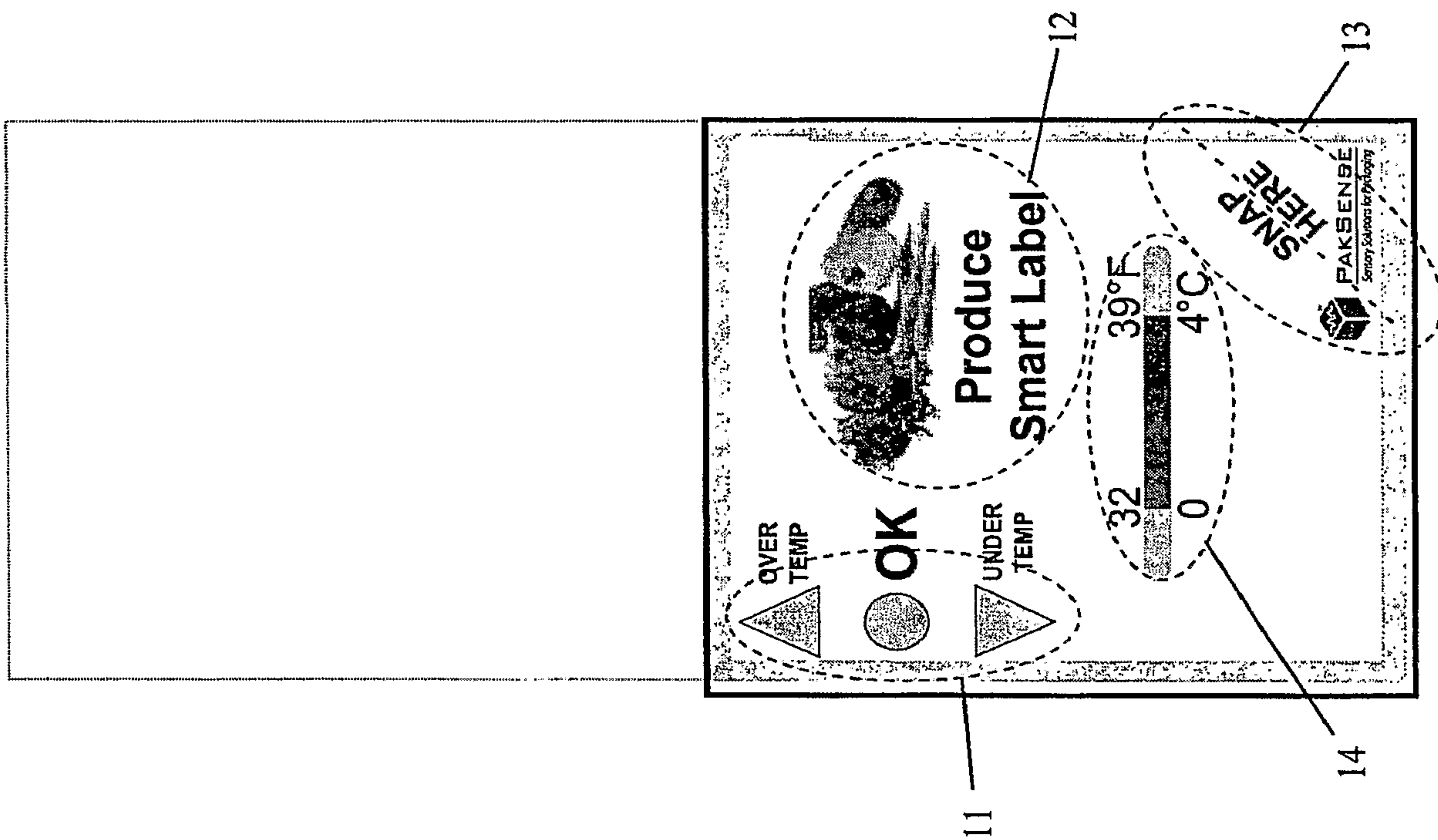


FIGURE 2

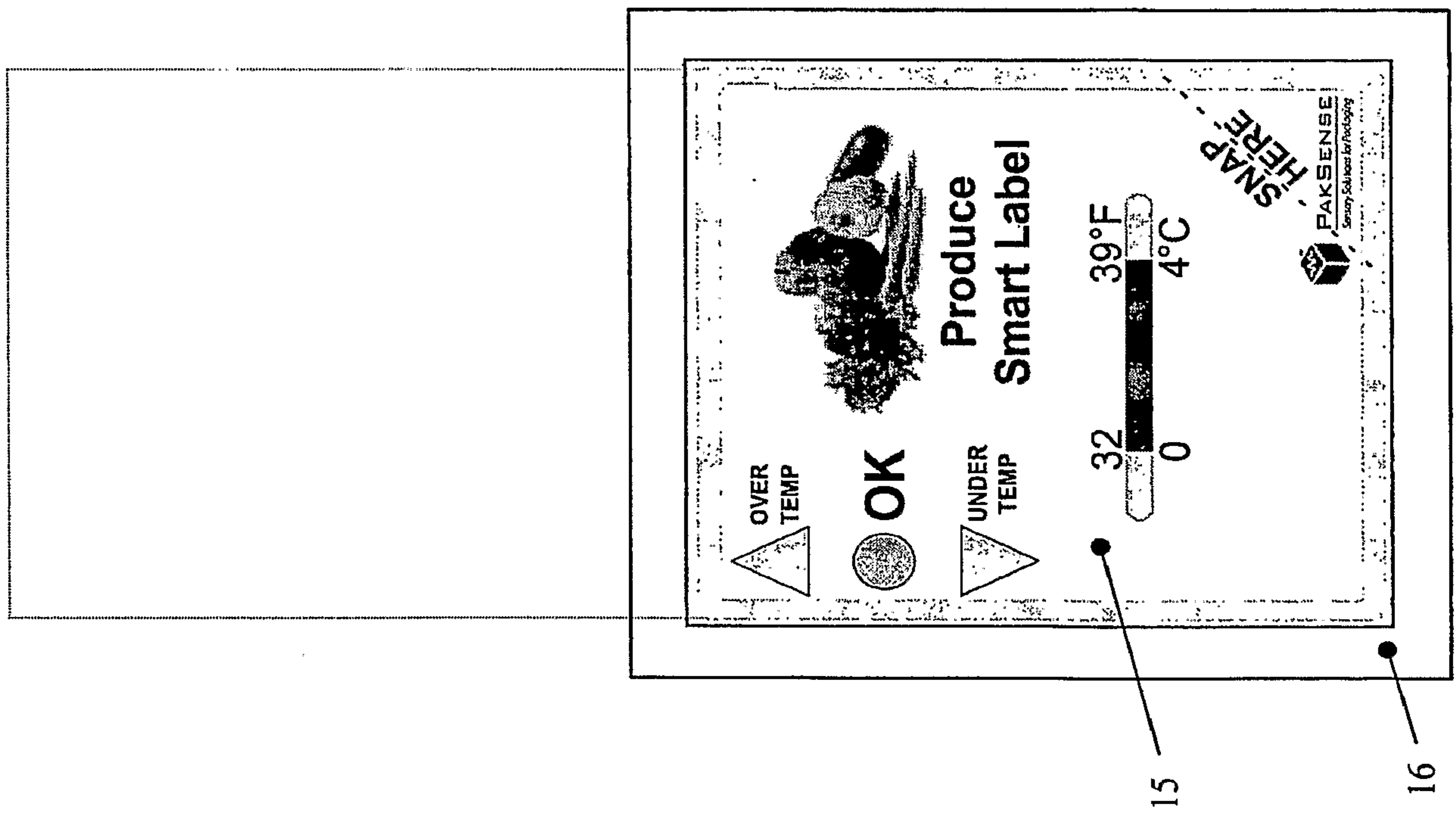


FIGURE 3

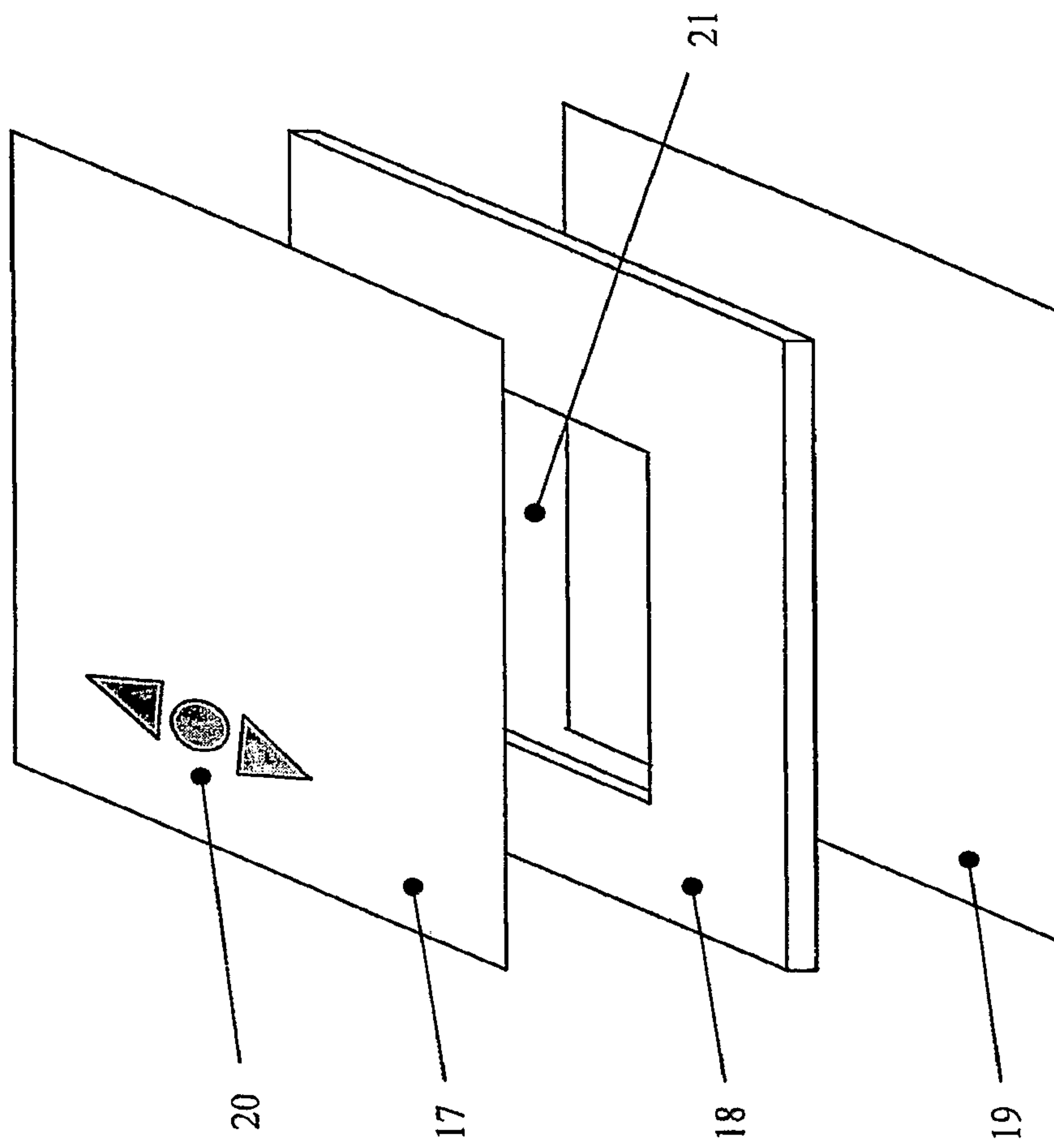


FIGURE 4

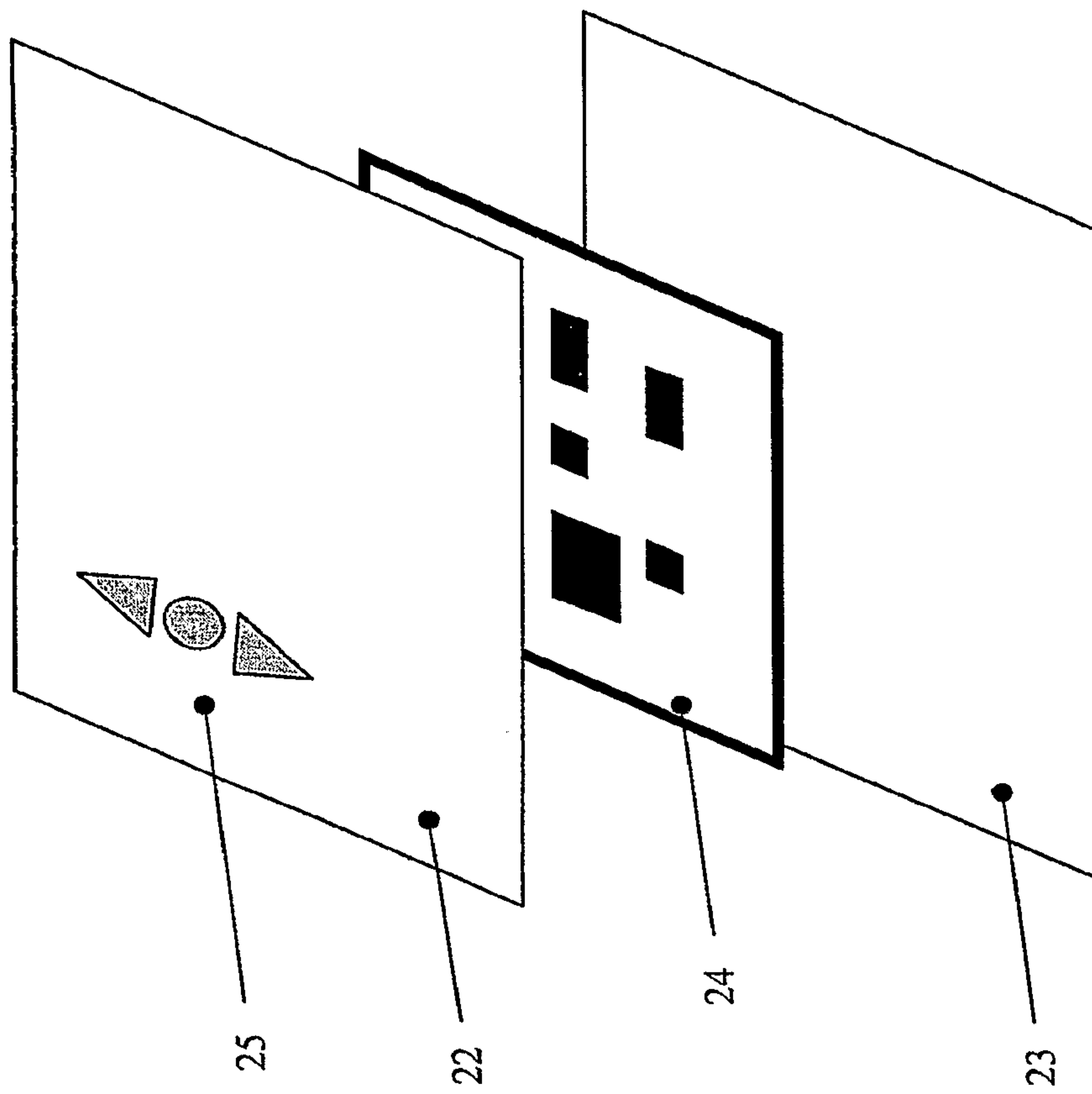


FIGURE 5

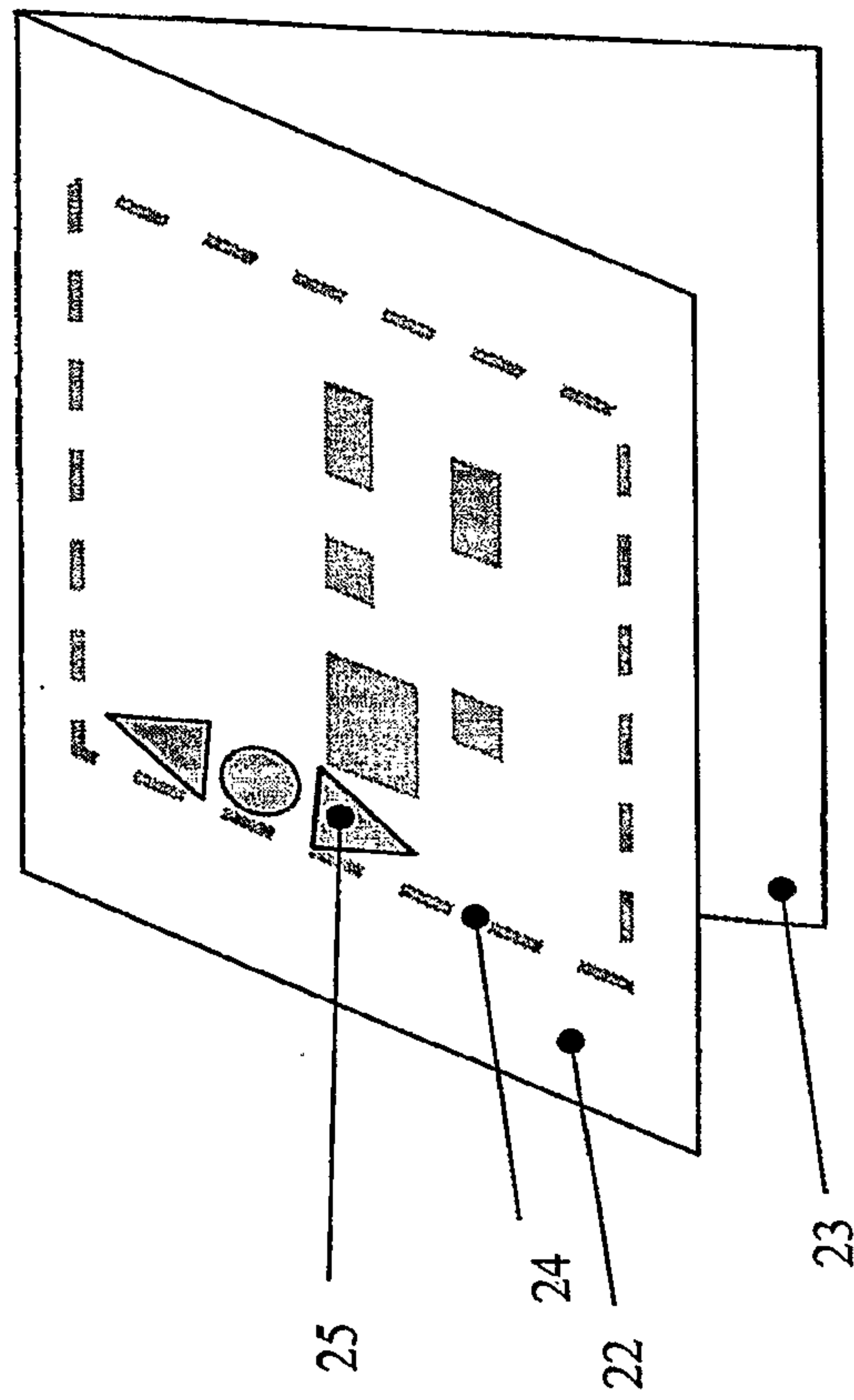


FIGURE 6

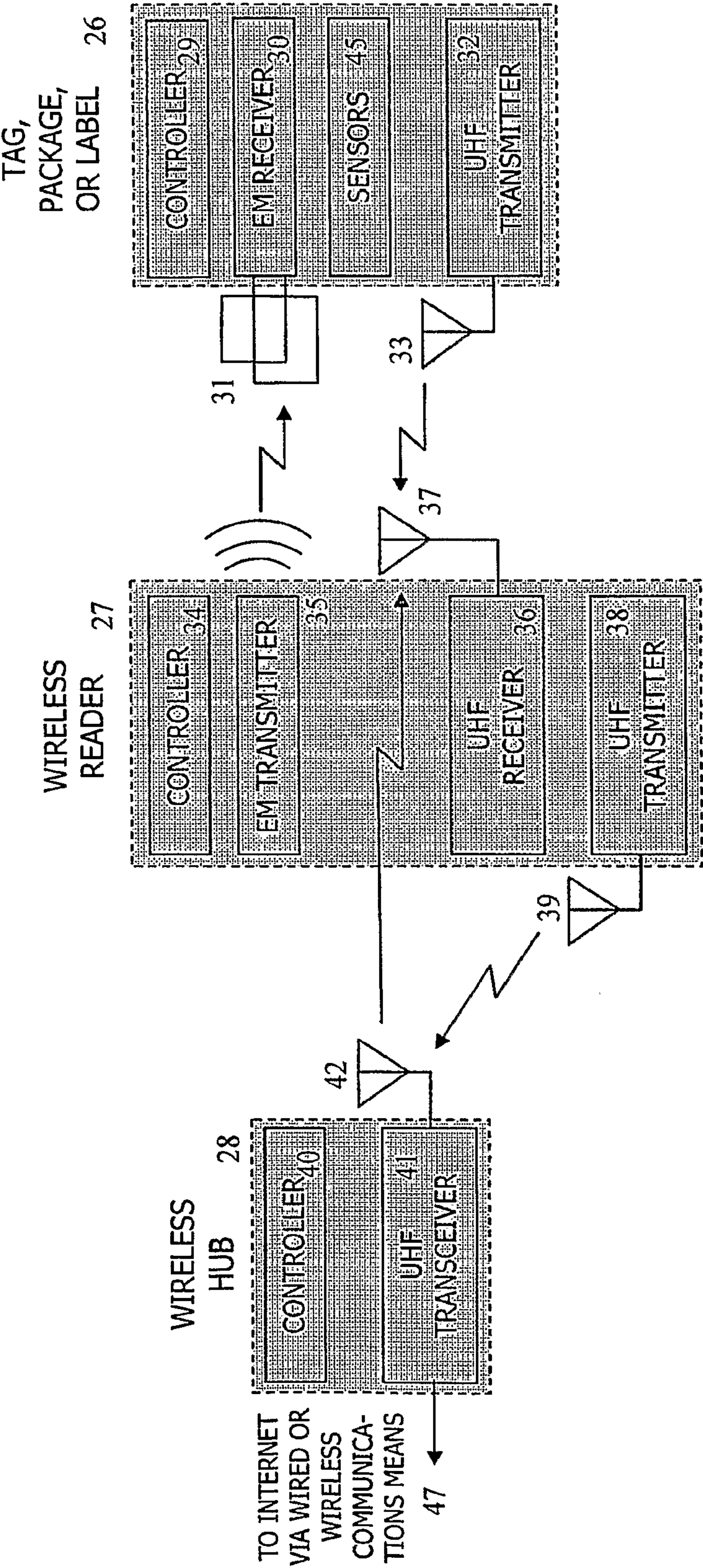


FIGURE 7

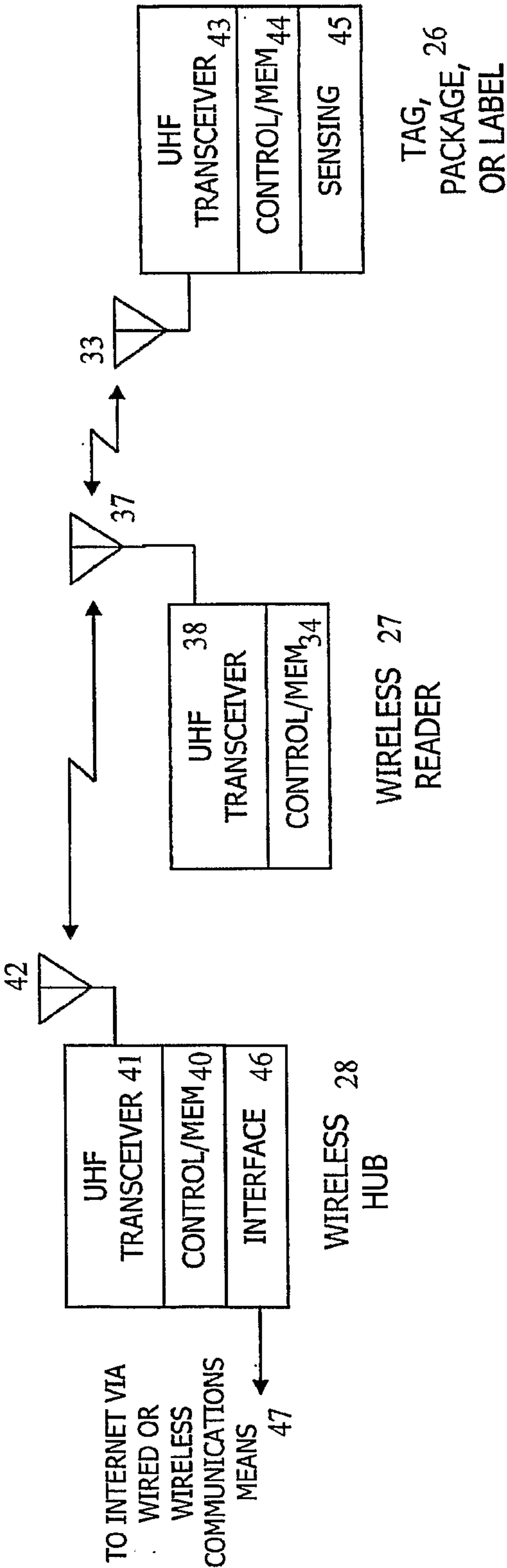


FIGURE 8

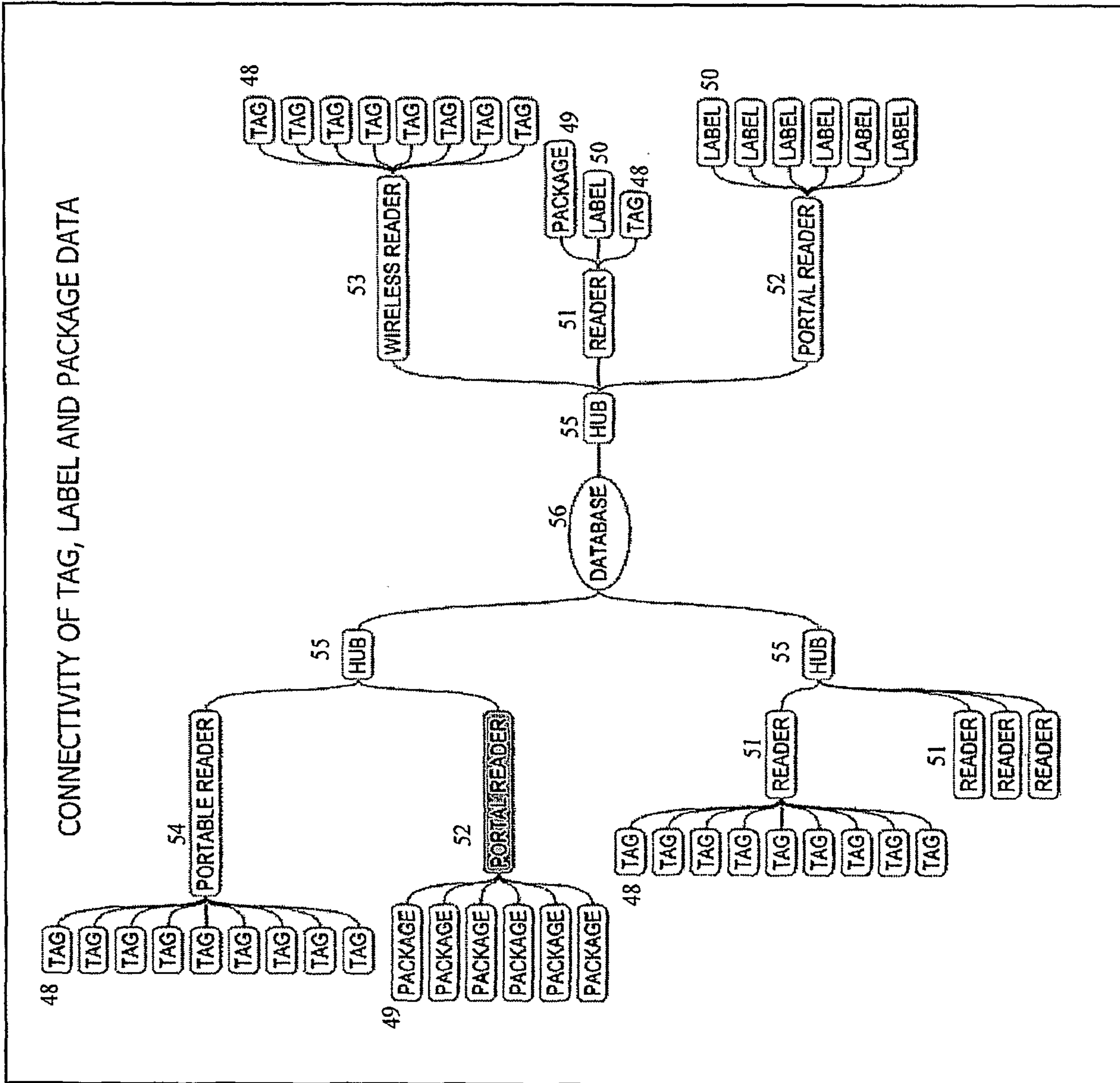


FIGURE 9

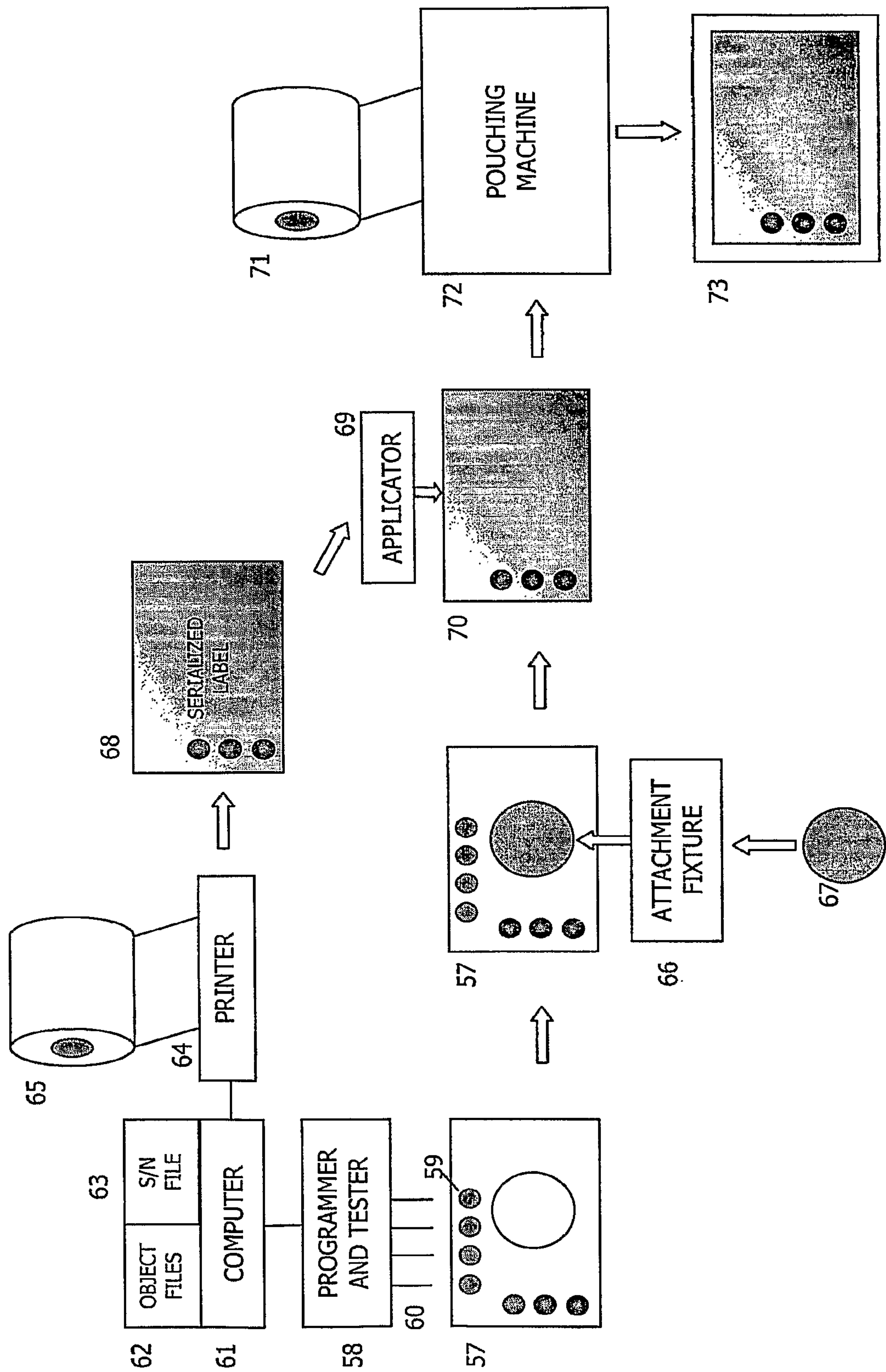


FIGURE 10

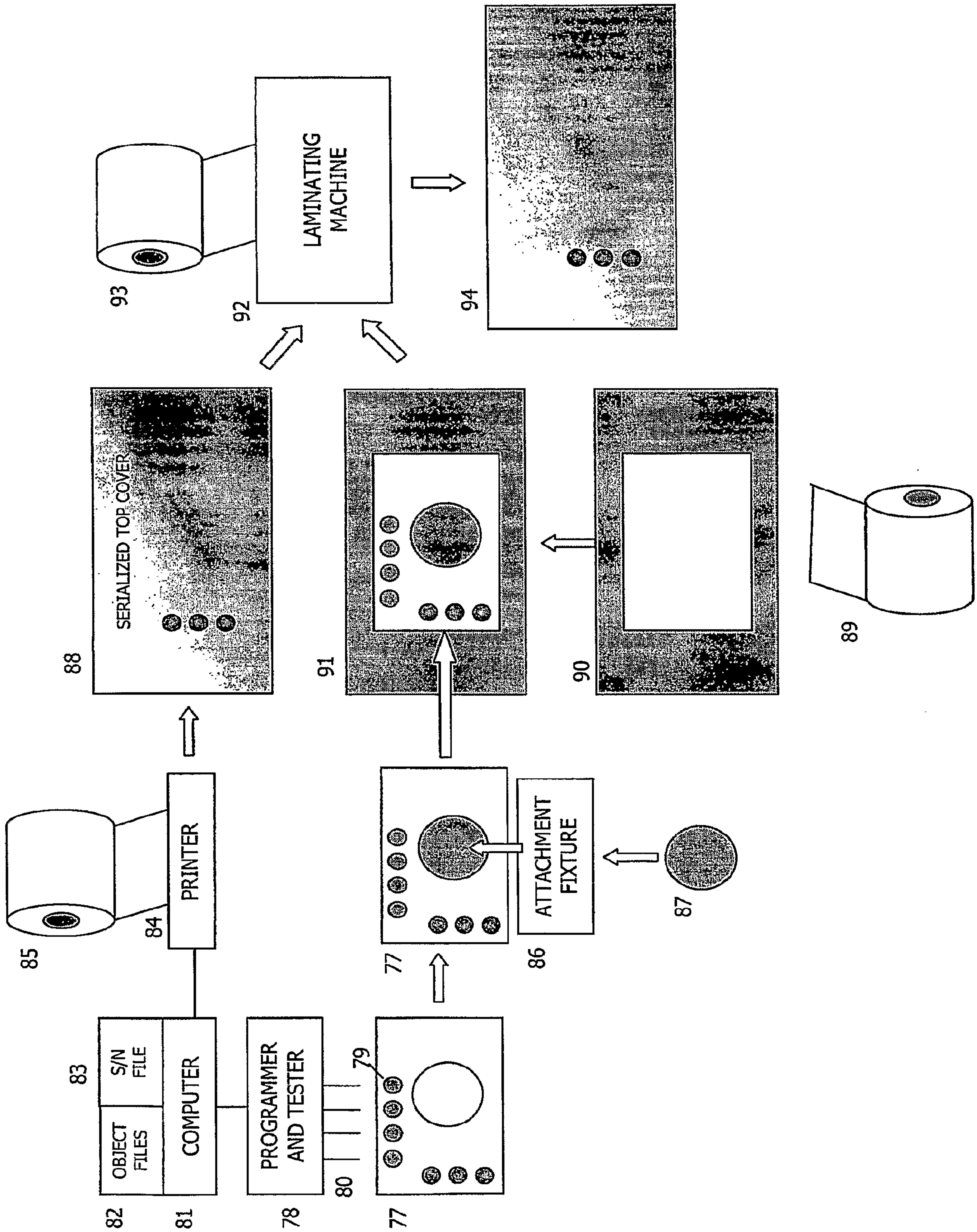


FIGURE 11

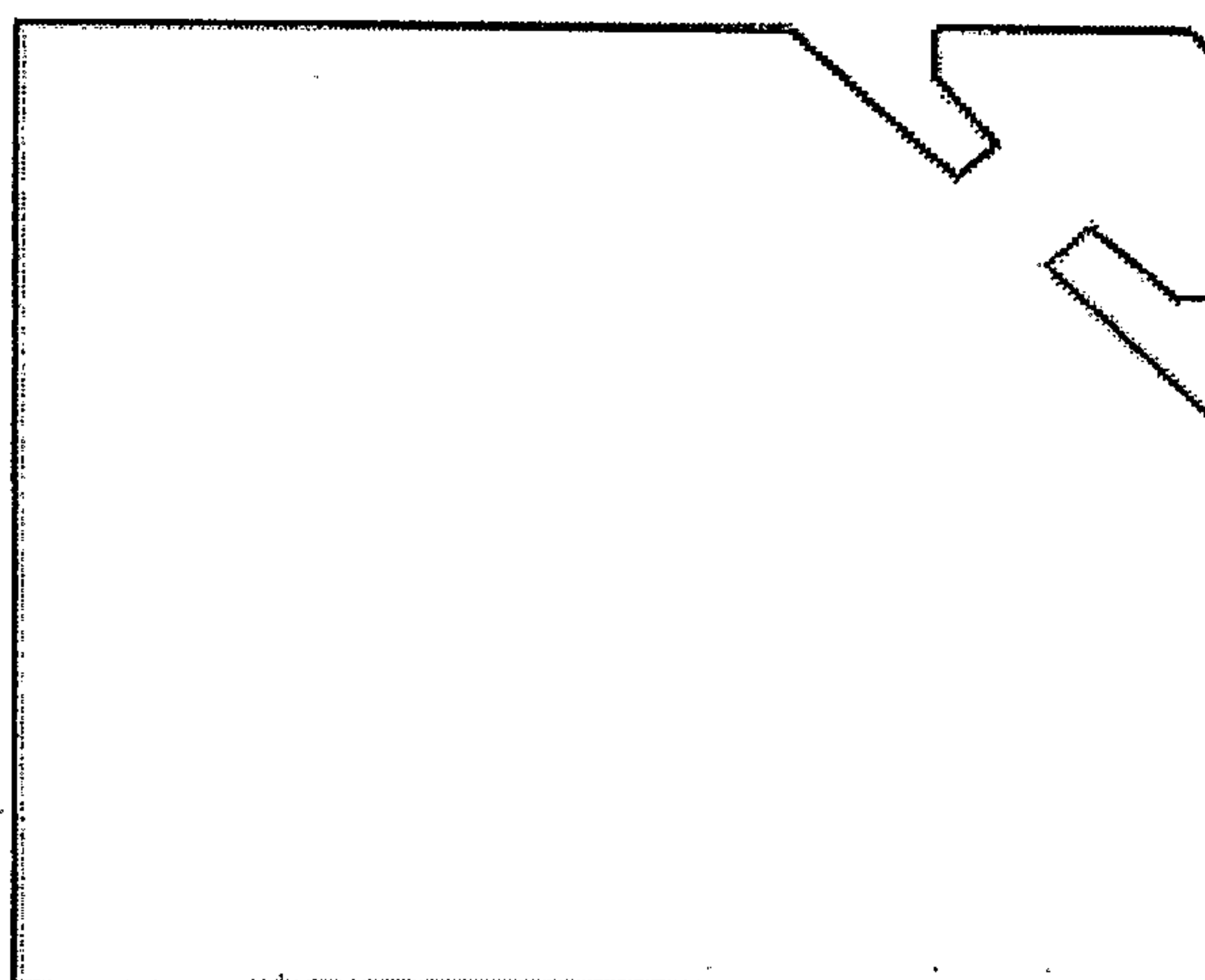


FIGURE 12

