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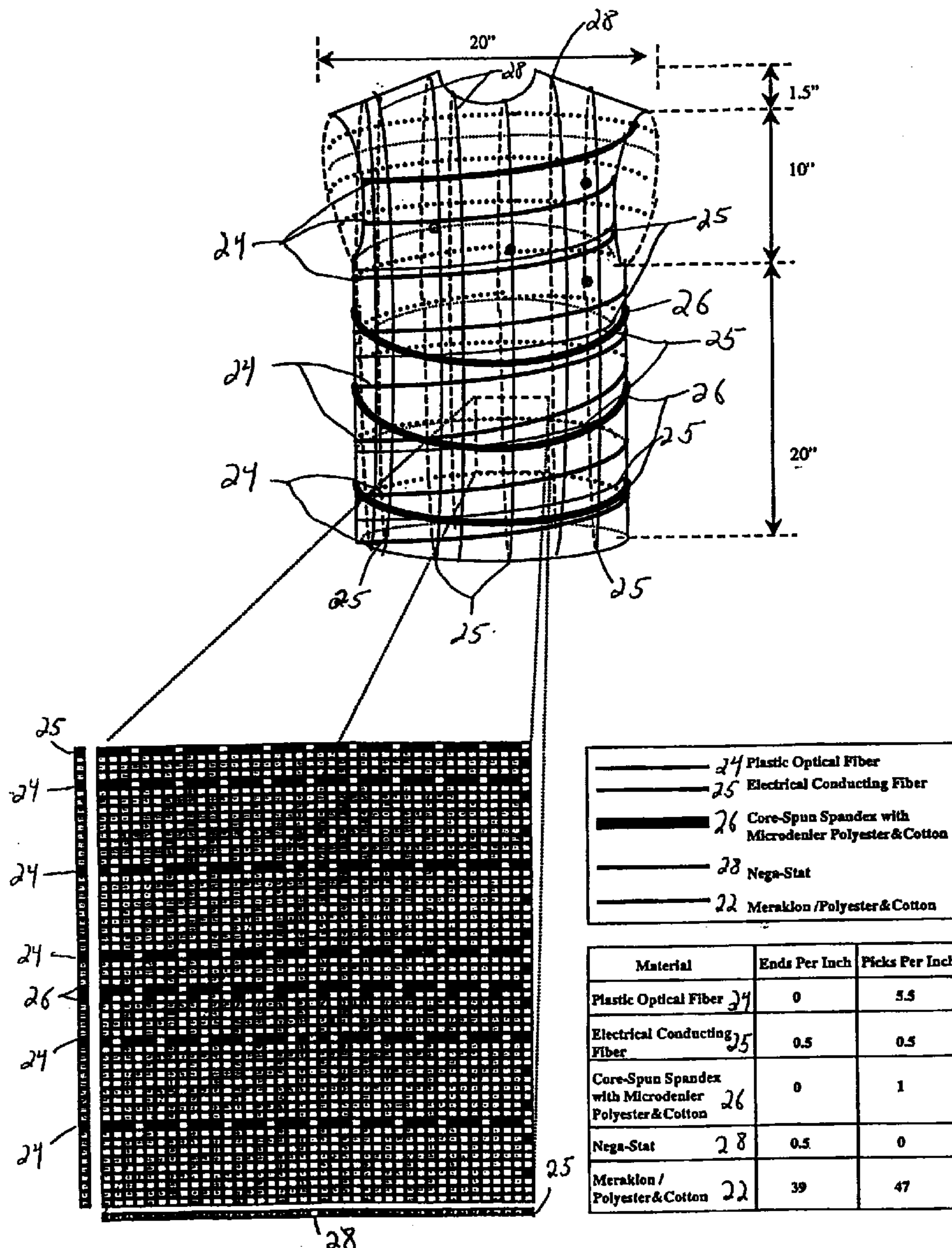
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(54) **TISSU OU VETEMENT COMPRENANT UNE
INFRASTRUCTURE D'INFORMATION FLEXIBLE
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(54) **FABRIC OR GARMENT WITH INTEGRATED FLEXIBLE
INFORMATION INFRASTRUCTURE**





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(57) L'invention concerne un tissu formé par tissage ou tricot ou un vêtement comprenant une infrastructure d'information flexible intégrée dans le tissu et permettant la collecte, le traitement, l'émission et la réception d'informations concernant notamment mais non exclusivement- la personne qui porte ce tissu. Ce tissu offre un nouveau procédé d'adaptation "sur mesure" des dispositifs de traitement à la personne qui porte le tissu, par l'intermédiaire de la sélection et de l'enfichage (ou du retrait) de puces/détecteurs dans le tissu de sorte à créer une infrastructure d'information mobile et pouvant être portée, et pouvant opérer en mode autonome ou en mode réseau. Ce tissu peut comprendre des détecteurs permettant de surveiller certaines caractéristiques physiques de la personne qui le porte, par exemple des signes vitaux tels que rythme cardiaque, ECG, pouls, rythme respiratoire, température, voix et réactions allergiques ainsi que la pénétration du tissu. Le tissu se compose d'un tissu de base ("composant de confort") et d'un composant infrastructure d'information qui peut être un composant de détection de pénétration ou un composant conducteur d'électricité, voire les deux. Le composant de détection de pénétration préféré est une fibre optique gainée. Le composant infrastructure d'information peut comprendre, outre un fil textile conducteur, un détecteur et un connecteur de détecteur. L'invention concerne en outre un procédé permettant d'établir une connexion électrique entre les fils conducteurs entrecroisés, ainsi qu'un procédé de gainage et de protection d'une fibre optique en plastique.

(57) A fabric, in the form of a woven or knitted fabric or garment, including a flexible information infrastructure integrated within the fabric for collecting, processing, transmitting and receiving information concerning - but not limited to - a wearer of the fabric. The fabric allows a new way to customize information processing devices to "fit" the wearer by selecting and plugging in (or removing) chips/sensors from the fabric thus creating a wearable, mobile information infrastructure that can operate in a stand-alone or networked mode. The fabric can be provided with sensors for monitoring physical aspects of the wearer, for example body vital signs, such as heart rate, EKG, pulse, respiration rate, temperature, voice, and allergic reactions, as well as penetration of the fabric. The fabric consists of a base fabric ("comfort component"), and an information infrastructure component which can consist of a penetration detection component, or an electrical conductive component, or both. The preferred penetration detection component is a sheathed optical fiber. The information infrastructure component can include, in addition to an electrically conductive textile yarn, a sensor or a connector for a sensor. A process is provided for making an electrical interconnection between intersecting electrically conductive yarns. Furthermore, a process is established for sheathing the plastic optical fiber and protecting it.

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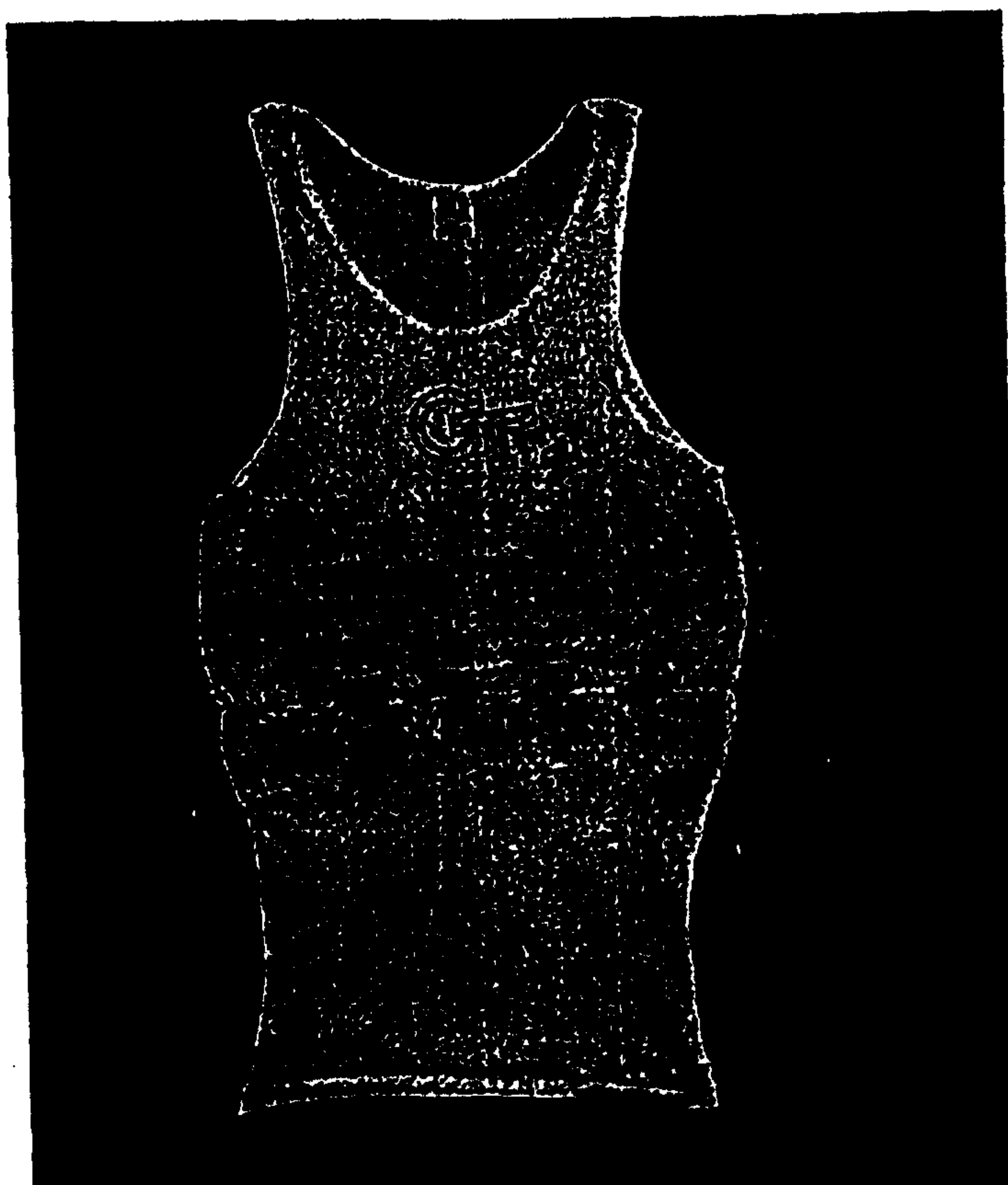
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(54) Title: FABRIC OR GARMENT WITH INTEGRATED FLEXIBLE INFORMATION INFRASTRUCTURE

(57) Abstract

A fabric, in the form of a woven or knitted fabric or garment, including a flexible information infrastructure integrated within the fabric for collecting, processing, transmitting and receiving information concerning – but not limited to – a wearer of the fabric. The fabric allows a new way to customize information processing devices to "fit" the wearer by selecting and plugging in (or removing) chips/sensors from the fabric thus creating a wearable, mobile information infrastructure that can operate in a stand-alone or networked mode. The fabric can be provided with sensors for monitoring physical aspects of the wearer, for example body vital signs, such as heart rate, EKG, pulse, respiration rate, temperature, voice, and allergic reactions, as well as penetration of the fabric. The fabric consists of a base fabric ("comfort component"), and an information infrastructure component which can consist of a penetration detection component, or an electrical conductive component, or both. The preferred penetration detection component is a sheathed optical fiber. The information infrastructure component can include, in addition to an electrically conductive textile yarn, a sensor or a connector for a sensor. A process is provided for making an electrical interconnection between intersecting electrically conductive yarns. Furthermore, a process is established for sheathing the plastic optical fiber and protecting it.



FABRIC OR GARMENT WITH INTEGRATED FLEXIBLE INFORMATION
INFRASTRUCTURE

This invention was made with government support under Contract No.
5 N66001-96-C-8639 awarded by the Department of the Navy. The government has
certain rights in this invention.

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates to a fabric or garment, and which includes an
10 integrated infrastructure for collecting, processing, transmitting and receiving
information.

2. Background of the Art

Efforts have been made previously to create fabrics and garments which
incorporate electrodes for monitoring a condition of the wearer, such as EKG, or
15 conductive fibers for electromagnetic screening. For example, U.S. Patents 4,668,545
to Lowe and 5,103,504 to Dordevic disclose fabrics including conductive fibers for
electromagnetic screening and for protecting a wearer from magnetic radiation.

U. S. Patent 4,580,572 to Granek et al. discloses a garment for delivering and
receiving electric impulses which can include a conductive medium knitted or woven
20 into the cloth, wires sewn onto the cloth or conducting cloth sewn onto non-
conducting cloth.

However, these patents fail to disclose either a woven or knitted fabric which
incorporates information infrastructure component in the form of a textile fiber which
can include a penetration detection component of the fabric for sensing penetration of
25 the fabric or an electrical conductive component of the fabric for collecting or
monitoring physical aspects of a wearer of the fabric and which may be worn and
hand washed in the same manner as conventional clothing.

A need, therefore, exists for a fabric having an integrated information
infrastructure which can be incorporated or fashioned into a wearable garment and
30 which includes a flexible infrastructure for collecting, processing, transmitting and

receiving information concerning a wearer of the garment. It is to the provision of such a fabric or garment with an integrated information infrastructure to which the present invention is one aspect directed.

SUMMARY OF THE INVENTION

5 It is, therefore, an object of the present invention to provide a fabric which can be incorporated or fashioned into a garment and which includes intelligence capability, such as the ability to monitor one or more physical conditions, for example body vital signs, and/or penetration of the fabric.

It is another object of the present invention to provide a wearable fabric which
10 includes a flexible information infrastructure for providing such intelligence capability.

It is an additional object of the present invention to be able to provide a full-fashioned garment which can include intelligence capability, such as the ability to monitor one or more body vital signs and/or penetration of the fabric, and a process
15 for making such a garment.

The fabric of the present invention is a tubular woven or knitted fabric, or a woven or knitted two-dimensional fabric, including a flexible infrastructure for collecting, processing, transmitting and receiving information. The fabric can be provided with information collection and processing means, for monitoring one or
20 more physical conditions of the wearer, as well as for monitoring penetration. The physical conditions can include body vital signs, such as heart rate or EKG, pulse and temperature, allergic reactions (such as an anaphylaxis reaction to a bee sting) and voice. The fabric consists of: a base fabric ("comfort component"), and at least one signal transmission component. In one embodiment, the signal transmission
25 component can be either a penetration detection component, or an electrical conductive material component, or both. The preferred penetration detection component is a sheathed plastic optical fiber (POF). The preferred electrical conductive component is a doped nylon fiber with conductive inorganic particles and insulated with PVC sheath, insulated stainless steel fiber, or a thin gauge copper wire
30 with polyethylene sheath. Preferably, the penetration detection component and the

electrical conductive component have the characteristics of a textile fiber. By a textile fiber, we mean a unit of matter characterized by flexibility, fineness, a high ratio of length to thickness, high temperature stability and a certain minimum strength and extensibility for textile applications. Optionally, the fabric can include a form-fitting component, such as Spandex fiber, or a static dissipating component, such as Nega-Stat, depending upon need and application. Each of these components can be integrated into the fabric of the present invention and thereby incorporated or fashioned into a wearable intelligent garment.

A "tubular" woven fabric can be produced using plastic optical fibers (POF) or electrical conducting fibers or both. The POF can, among others, serve the following two main functions: (i) It can help detect projectile penetration; and (ii) it can serve as a "data bus" or "motherboard" for transferring information or data to and from other devices that are in communication with it. These capabilities can be used together or individually. The electrical conducting fibers can help to carry information from sensors (mounted on the human/animal body or incorporated into the fabric structure) to monitoring devices to monitor heart rate, breathing rate, voice and/or any other desired body physical property. Thus, the present invention will create a flexible, wearable information infrastructure that will facilitate the "plugging" in of devices for gathering/processing information concerning its wearer utilizing the interconnection of electrical conductive fibers described below. Instead of both POF and conducting fibers, the fabric or garment can incorporate just conducting fibers and not the POF, or vice versa, depending on the desired end-use application. The number, length and pitch (thread spacing) of the POF can be varied to suit the desired end-use requirement. Similarly, the number, length and pitch (thread spacing) of the conducting fibers can be varied to suit the end-use requirement.

This fabric "tube" can be "integrated" into a garment structure such as a regular undershirt or T-shirt, by any appropriate joining technique, such as by sewing, gluing, or attachment by velcro, snaps, zippers, buttons, and the like. The interconnection technology described below can be used to attach connectors to the fabric. Sensors can be incorporated into the fabric and/or mounted on the human

being or animal and plugged into connectors incorporated into the fabric. The sensors can be used to monitor one or more body physical signs, such as vital signs. Thus, the fabric or garment of the present invention acts as a useful and flexible information infrastructure for information processing.

5 In another embodiment of this invention, the POF and/or conducting fibers can be used to knit a tube that can be similarly integrated into a regular knitted garment creating another variation of this infrastructure.

In yet another embodiment of this invention, the POF and/or conducting fibers can be either woven or knitted into a regular two-dimensional fabric. The fabric pieces
10 can then be "integrated" into a three-dimensional garment structure, for example, a T-shirt or undershirt, by any appropriate joining technique, such as sewing, gluing, attachment through velcro, buttons, zippers, and the like. By suitably tapping into the appropriate conducting fibers, the required monitoring capabilities will be created. Alternately, the POF can serve as the "data bus" in place of or in addition to the
15 conductive fibers for various applications.

It can be seen from the description herein of our invention that a fabric is provided which can be incorporated or fashioned into a wearable garment and which includes an integrated flexible infrastructure for collecting, transmitting, receiving and processing information concerning -- but not limited to -- a wearer of the garment,
20 thus serving as an information infrastructure or "wearable motherboard." These and other objects and advantages of the present invention will become apparent upon reading the following specification and claims in conjunction with the accompanying drawing figures.

BRIEF DESCRIPTION OF THE DRAWINGS

25 Fig. 1 is a front elevational view of a garment into which the wearable fabric with integrated information infrastructure of the present invention has been incorporated.

Fig. 2 is a front elevational view of another variation of a garment into which the integrated information infrastructure of the present invention has been
30 incorporated.

Fig. 3 illustrates a portion of a garment including the integrated information infrastructure according to one embodiment of the present invention;

Fig. 4 illustrates a portion of a garment including the integrated information infrastructure according to a second embodiment of the present invention;

5 Fig. 5 a portion of a garment including the integrated information infrastructure according to a third embodiment of the present invention;

Fig. 6 illustrates a portion of a garment including the integrated information infrastructure according to a fourth embodiment of the present invention;

10 Fig. 7 illustrates a further embodiment of the present invention including the information infrastructure fashioned into a wearable garment;

Fig. 8 illustrates the distribution of sensors in the garment of Fig. 7;

Fig. 9 illustrates another aspect of the present invention, namely, the interconnection of intersecting electrically conductive fibers in fabric of a preferred embodiment of the present invention;

15 Fig. 10 illustrates a garment incorporating the fabric of the present invention onto which a T-connector has been connected to electrically conductive fibers using the interconnection technology of Fig. 9 and to which an EKG sensor has been attached;

20 Fig. 11 illustrates a full-fashioned garment with a temperature sensor and microphone integrated using T-connectors according to the present invention;

Fig. 12 illustrates a detailed view of the results of using the interconnection technology of Fig. 9 of the present invention;

Fig. 13 illustrates an EKG trace taken from an EKG sensor incorporated into the garment of Fig. 10;

25 Fig. 14 illustrates a woven sample of the fabric of Fig. 7;

Fig. 15 illustrates the invention of Fig. 7 in the form of a printed elastic board;

Fig. 16 illustrates a woven fabric of the present invention integrated with sensors;

Fig. 17 illustrates a knitted sample of the present invention;

30 Fig. 18 illustrates an opened out illustration of the garment of Fig. 17;

Fig. 19 is a front view of a knitted fabric according to one embodiment of the present invention;

Fig. 20 illustrates one style of attachment for the invention of Fig. 19; and

Fig. 21 illustrates another style of attachment for the invention of Fig. 19.

5 **DETAILED DESCRIPTION OF THE ILLUSTRATIVE EMBODIMENTS**

Referring now to the above figures, wherein like reference numerals represent like parts throughout the several views, the fabric of the present invention having a multi-functional information infrastructure integrated within the fabric for information collection, processing, reception and transmission capability will be described in
10 detail.

The fabric of our present invention is wearable and, thus, provides a wearable information infrastructure integrated within the fabric that has hitherto been typically resident in a computer. When fitted with, or connected to, a data collector(s) such as, but not limited to, a sensor for monitoring body physical signs and connected to a data
15 transmitter or processing unit, as described in detail below, our wearable fabric provides information pathways that allow the sensor to provide information to the transmitter or processor, and vice versa. In this context, the information infrastructure of our fabric invention can manage the transfer of data between the sensor and the transmitter or processing unit. Since the sensor can be considered a “hardware
20 peripheral”, our wearable fabric, which can be fashioned into a garment, having an integrated information infrastructure can be conceived of as a “wearable motherboard.” When we use the term “wearable motherboard”, we are using the term in the context described immediately above.

25 **A. A Fabric Having An Integrated Flexible Information Infrastructure in Accordance With the Present Invention**

As illustrated generally in Figs. 1 and 2, the fabric of our present invention can be integrated or fashioned into a garment, for example a T-shirt or undershirt, by any appropriate joining technique, such as by sewing, gluing, attachment through velcro,
30 buttons, zipper, and the like. In the embodiments shown in these figures, the fabric is sewn into an undershirt and a T-shirt, respectively. The fabric provides an

infrastructure for a garment for collecting, monitoring, and/or tracking data regarding physical conditions of a wearer of the garment, such as body vital signs or voice, and transmitting such data to a remote location. The fabric can be provided with means in the form of sensors, or connectors for sensors to be worn on the body, for monitoring
5 body physical signs or atmospheric exposure, such as heart rate or EKG, pulse, voice and temperature, blood oxygen levels, chemical exposure levels for any desired chemicals, biological agent exposure levels for desired biological agents, atmospheric smoke levels, atmospheric oxygen levels, radiation exposure, etc. as well as for monitoring penetration. The specific physical or atmospheric quantities monitored
10 depend on the needs of the specific application in which the fabric is being used, e.g. military, medical, firefighting, driving, sports, mountaineering, space, etc.

The fabric with integrated information infrastructure consists of the following components: a base fabric or "comfort component," and an information infrastructure component. The base fabric can be either a tubular woven or knitted fabric, or a two-
15 dimensional woven or knitted fabric, into which the information infrastructure component is incorporated. Additionally, either or both a form-fitting component and a static dissipating component may be included, if desired.

The information infrastructure component can include any or all of the following, individually or in any combination, penetration detection components,
20 electrically conductive components, sensors, processors, or wireless transmission devices.

1. Woven Fabric

Fig. 3 illustrates one embodiment of the fabric of the present invention consisting of a woven comfort component of polyester/cotton yarn. A data/power bus
25 for carrying the sensor data or other information is integrated by weaving into the fabric twelve insulated conductive yarns spaced 5 mm apart on either side of the garment. In addition, one of the Respitrace Sensors is woven into the fabric as shown in Fig. 3. The signals from this chest level Respitrace sensor and another woven at the abdomen level are fed directly, or through a PSM (personal status monitor) described
30 in more detail below, to a monitoring device to measure the breathing rate of the

wearer. In the case of a temperature sensor, the type of sensor utilized is preferably a standard Thermistor Type Sensor. In the case of a voice sensor a lapel type microphone is preferably used. For EKG sensors, a standard type sensor used in conjunction with typical hospital equipment is preferably used.

- 5 Figs. 4 – 6 illustrate additional embodiments of our fabric consisting of woven designs for form fit. The warp and filling yarns for these designs are given below.

	Warp		Filling	
	Material	EPI	Material	PPI
Design I (Fig. 4)	Polyester/Cotton	30	Polyester/Cotton	10
			560 Denier Core-Spun Spandex	8
			Polyester/Cotton	10
Design II (Fig. 5)	Polyester/Cotton	30	Polyester/Cotton	14
			560 Denier Core-Spun Spandex	14
Design III (Fig. 6)	Polyester/Cotton	30	240 Denier Core-Spun Spandex	10
			560 Denier Core-Spun Spandex	8
			240 Denier Core-Spun Spandex	10

- 10 Fig. 7 shows another representative design of the fabric of the present invention. It consists of a single-piece garment woven similar to a regular sleeveless T-shirt. The legend in the figure denotes the relative distribution of yarns for the various structural components of the fabric in a 2" segment.

- The comfort component 22 is the base of the fabric and can in one
 15 embodiment be a standard fabric used as component of clothing. The comfort component will ordinarily be in immediate contact with the wearer's skin and will provide the necessary comfort properties for the fabric/garment. Therefore, the chosen material should preferably provide at least the same level of comfort and fit as compared to a typical fabric used for clothing, e.g., good fabric hand, air permeability,
 20 moisture absorption and stretchability.

The comfort component can consist of any yarn applicable to conventional woven fabrics. The choice of material for the yarn will ordinarily be determined by

the end use of the fabric and will be based on a review of the comfort, fit, fabric hand, air permeability, moisture absorption and structural characteristics of the yarn. Suitable yarns include, but are not limited to, cotton, polyester/cotton blends, microdenier polyester/cotton blends and polypropylene fibers such as Meraklon
5 (made by Dawtex Industries).

The fibers preferably suitable for use in the comfort component are Meraklon, and polyester/cotton blend. Meraklon is a polypropylene fiber modified to overcome some of the drawbacks associated with pure polypropylene fibers. Its key characteristics in light of the performance requirements are: (a) good wickability and
10 comfort; (b) bulk without weight; (c) quick drying; (d) good mechanical and color fastness properties; (e) non-allergenic and antibacterial characteristics; and (f) odor-free with protection against bacterial growth. Microdenier polyester/cotton blends are extremely versatile fibers and are characterized by: (a) good feel, i.e., handle; (b) good moisture absorption; (c) good mechanical properties and abrasion resistance; and
15 (d) ease of processing. It should be recognized that other fibers meeting such performance requirements are also suitable. Microdenier polyester/cotton blended fibers are available from Hamby Textile Research of North Carolina. Microdenier fibers for use in the blend are available from DuPont. Meraklon yarn is available from Dawtex, Inc., Toronto, Canada. In Fig. 7, Meraklon is shown in both the warp
20 and fill directions of the fabric.

The information infrastructure component of the fabric can include materials 24 for sensing penetration of the fabric 20, or materials 25 for sensing one or more body vital signs, or both. These materials are woven during the weaving of the comfort component of the fabric. After fashioning of the fabric into a garment is
25 completed, these materials can be connected to a monitor (referred to as a "personal status monitor" or "PSM") which will take readings from the sensing materials, monitor the readings and issue an alert depending upon the readings and desired settings for the monitor, as described in more detail below.

Materials suitable for providing penetration detection and alert include but are
30 not limited to: silica-based optical fibers, plastic optical fibers, and silicone rubber

optical fibers. Suitable optical fibers include those having a filler medium which have a bandwidth which can support the desired signal to be transmitted and required data streams. Silica-based optical fibers have been designed for use in high bandwidth, long distance applications. Their extremely small silica core and low numerical
5 aperture (NA) provide a large bandwidth (up to 500mhz*km) and low attenuation (as low as .5dB/km). However, such fibers are currently not preferred because of high labor costs of installation and the danger of splintering of the fibers.

Plastic optical fibers (POF) provide many of the same advantages that glass fibers do, but at a lower weight and cost. In certain fiber applications, as in some
10 sensors and medical applications, the fiber length used is so short (less than a few meters) that the fiber loss and fiber dispersion are of no concern. Instead, good optical transparency, adequate mechanical strength, and flexibility are the more important properties and plastic or polymer fibers are preferred. Moreover, plastic optical fibers do not splinter like glass fibers and, thus, can be more safely used in the fabric than
15 glass fibers.

For relatively short lengths, POFs have several inherent advantages over glass fibers. POFs exhibit relatively higher numerical aperture (N.A.), which contributes to their capability to deliver more power. In addition, the higher N.A. lowers the POF's susceptibility to light loss caused by bending and flexing of the fiber. Transmission in
20 the visible wavelengths range is relatively higher than anywhere else in the spectra. This is an advantage since in most medical sensors the transducers are actuated by wavelengths in the visible range of the optical spectra. Because of the nature of its optical transmission, POF offers similar high bandwidth capability and the same electromagnetic immunity as glass fiber. In addition to being relatively inexpensive,
25 POF can be terminated using a hot plate procedure which melts back the excess fiber to an optical quality end finish. This simple termination combined with the snap-lock design of the POF connection system allows for the termination of a node in under a minute. This translates into extremely low installation costs. Further, POFs can withstand a rougher mechanical treatment displayed in relatively unfriendly
30 environments. Applications demanding inexpensive and durable optical fibers for

conducting visible wavelengths over short distances are currently dominated by POFs made of either poly-methyl-methacrylate (PMMA) or styrene-based polymers.

Silicone rubber optical fibers (SROF), a third class of optical fibers, provide excellent bending properties and elastic recovery. However, they are relatively thick
5 (of the order of 5mm) and suffer from a high degree of signal attenuation. Also, they are affected by high humidity and are not yet commercially available. Hence, these fibers are not currently preferred for use in the fabric.

In Fig. 7, the POF 24 is shown in the filling direction of the fabric, though it need not be limited to only the filling direction. To incorporate the penetration
10 sensing component material into a tubular woven fabric, the material, preferably plastic optical fiber (POF), is spirally integrated into the structure during the full-fashioned weaving fabric production process as described in copending U.S. Patent Application Serial No. 09/157,607, which is incorporated herein in its entirety as if fully set forth herein. The POF continues throughout the fabric without any
15 discontinuities. This results in only one single integrated fabric and no seams are present in the garment. The preferred plastic optical fiber is from Toray Industries, New York, in particular product code PGS – FB250 optical fiber cord.

Alternatively, or additionally, the information infrastructure component may consist of either a high or a low conductivity fiber electrical conducting material
20 component (ECC) 25. The electrical conductive fiber preferably has a resistivity of from about 0.07×10^{-3} to 10 kohms/cm. The ECC 25 can be used to monitor one or more body vital signs including heart rate, pulse rate and temperature through sensors on the body and for linking to a personal status monitor (PSM). Suitable materials include the three classes of intrinsically conducting polymers, doped inorganic fibers
25 and metallic fibers, respectively.

Polymers that conduct electric currents without the addition of conductive (inorganic) substances are known as “intrinsically conductive polymers” (ICP). Electrically conducting polymers have a conjugated structure, i.e., alternating single and double bonds between the carbon atoms of the main chain. In the late 1970s, it
30 was discovered that polyacetylene could be prepared in a form with a high electrical

conductivity, and that the conductivity could be further increased by chemical oxidation. Thereafter, many other polymers with a conjugated (alternating single and double bonds) carbon main chain have shown the same behavior., e.g., polythiophene and polypyrrole. Initially, it was believed that the processability of traditional
5 polymers and the discovered electrical conductivity could be combined. However, it has been found that the conductive polymers are rather unstable in air, have poor mechanical properties and cannot be easily processed. Also, all intrinsically conductive polymers are insoluble in solvents and they possess a very high melting point and exhibit little other softening behavior. Consequently, they cannot be
10 processed in the same way as normal thermoplastic polymers and are usually processed using a variety of dispersion methods. Because of these shortcomings, fibers made up of fully conducting polymers with good mechanical properties are not yet commercially available and hence are not presently preferred for use in the fabric.

Yet another class of conducting fibers consists of those that are doped with
15 inorganic or metallic particles. The conductivity of these fibers is quite high if they are sufficiently doped with metal particles, but this would make the fibers less flexible. Such fibers can be used to carry information from the sensors to the monitoring unit if they are properly insulated.

Metallic fibers, such as copper and stainless steel insulated with polyethylene
20 or polyvinyl chloride, can also be used as the conducting fibers in the fabric. With their exceptional current carrying capacity, copper and stainless steel are more efficient than any doped polymeric fibers. Also, metallic fibers are strong and they resist stretching, neck-down, creep, nicks and breaks very well. Therefore, metallic fibers of very small diameter (of the order of 0.1mm) will be sufficient to carry
25 information from the sensors to the monitoring unit. Even with insulation, the fiber diameter will be less than 0.3 mm and hence these fibers will be very flexible and can be easily incorporated into the fabric. Also, the installation and connection of metallic fibers to the PSM unit will be simple and there will be no need for special connectors, tools, compounds and procedures. One example of a high conductive
30 yarn suitable for this purpose is Bekinox available from Bekaert Corporation,

Marietta, Georgia, a subsidiary of Bekintex NV, Wetteren, Belgium, which is made up of stainless steel fibers and has a resistivity of 60 ohm-meter. The bending rigidity of this yarn is comparable to that of the polyamide high-resistance yarns and can be easily incorporated into the information infrastructure in our present invention.

5 Thus, the preferred electrical conducting materials for the information infrastructure component for the fabric are: (i) doped nylon fibers with conductive inorganic particles and insulated with PVC sheath; (ii) insulated stainless steel fibers; and (iii) thin gauge copper wires with polyethylene sheath. All of these fibers can readily be incorporated into the fabric and can serve as elements of an elastic printed
10 circuit board, described below. An example of an available conducting fiber is X-Static coated nylon with PVC insulation (T66) from Sauquoit Industries, Scranton, Pennsylvania. An example of an available thin copper wire is 24 gauge insulated copper wire from Ack Electronics, Atlanta, Georgia.

 The electrical conducting component fibers 25 can be incorporated into the
15 woven fabric in two ways: (a) regularly spaced yarns acting as sensing elements; and (b) precisely positioned yarns for carrying signals from the sensors to the PSM. They can be distributed both in the warp and filling directions in the woven fabric. Additionally the fabric/garment including the information infrastructure can be knitted, as opposed to being woven, as shown in Figs. 17 and 18.

20 The form-fitting component (FFC) 26 provides form-fit to the wearer, if desired. More importantly, it keeps the sensors in place on the wearer's body during movement. Therefore, the material chosen should have a high degree of stretch to provide the required form-fit and at the same time, be compatible with the material chosen for the other components of the fabric. Any fiber meeting these requirements
25 is suitable. The preferred form-fitting component is Spandex fiber, a block polymer with urethane groups. Its elongation at break ranges from 500 to 600% and, thus, can provide the necessary form-fit to the garment. Its elastic recovery is also extremely high (99% recovery from 2-5% stretch) and its strength is in the 0.6-0.9 grams/denier range. It is resistant to chemicals and withstands repeated machine washings and the
30 action of perspiration. It is available in a range of linear densities.

The Spandex band 26 shown in the filling direction in Figs. 4 and 6 is the FFC for the tubular woven fabric providing the desired form-fit. These bands behave like "straps", but are unobtrusive and are well integrated into the fabric. There is no need for the wearer to tie something to ensure a good fit for the garment. Moreover, the
5 Spandex band will expand and contract as the wearer's chest expands and contracts during normal breathing.

The purpose of the static dissipating component (SDC) 28 is to quickly dissipate any built-up static charge during the usage of the fabric. Such a component may not always be necessary. However, under certain conditions, several thousand
10 volts may be generated which could damage the sensitive electronic components in the PSM Unit. Therefore, the material chosen must provide adequate electrostatic discharge protection (ESD) in the fabric.

Nega-Stat, a bicomponent fiber produced by DuPont is the preferred material for the static dissipating component (SDC). It has a trilobal shaped conductive core
15 that is sheathed by either polyester or nylon. This unique trilobal conductive core neutralizes the surface charge on the base material by induction and dissipates the charge by air ionization and conduction. The nonconductive polyester or nylon surface of Nega-Stat fiber controls the release of surface charges from the thread to provide effective static control of material in the grounded or ungrounded applications
20 according to specific end-use requirements. The outer shell of polyester or nylon ensures effective wear-life performance with high wash and wear durability and protection against acid and radiation. Other materials which can effectively dissipate the static charge and yet function as a component of a wearable, washable garment may also be used.

25 Referring again to Fig. 7, the Nega-Stat fiber 28 running along the height of the shirt, in the warp direction of the fabric, is the static dissipating component (SDC). The proposed spacing is adequate for the desired degree of static discharge. For the woven tubular garment, it will ordinarily, but not necessarily, be introduced in the warp direction of the fabric.

With reference to Fig. 8, connectors (not shown), such as T-connectors (similar to the "button clips" used in clothing), can be used to connect the body sensors 32 and/or microphone (not shown) to the conducting wires that go to the PSM. By modularizing the design of the fabric 20 (using these connectors), the sensors 32 themselves can be made independent of the fabric 20. This accommodates different body shapes. The connector makes it relatively easy to attach the sensors to the wires. This is illustrated in Fig. 11 where the microphone 33 is attached to the garment by snapping it into the T-Connectors 34. Fig. 11 also shows the thermistor sensor 32 "plugged" into the garment. Yet another advantage of separating the sensors themselves from the garment, is that they need not be subjected to laundering when the garment is laundered, thereby minimizing any damage to them. However, it should be recognized that the sensors 32 can also be woven into the structure.

The specification for the preferred materials to be used in the production of our fabric/garment are as follows:

Component	Materials	Count (CC)
Penetration Sensing (PSC)	Plastic Optical Fibers (POF)	PVC sheathed POF
Comfort (CC)	Meraklon; Microdenier Poly/Cotton Blend	18s Ne
Form-fitting (FFC)	Spandex	6s Ne Core-Spun from 560 denier Spandex yarn
Global and Random Conducting (ECC)	X-static Nylon with PVC insulation	6s Ne
	Stainless Steel	110 Tex
Static Dissipating (SDC)	Nega-Stat	18s Ne

The yarn counts have been chosen based on initial experimentation using yarn sizes that are typically used in undergarments. Other yarn counts can be used. Fig. 7 also shows the specifications for the tubular woven fabric. The weight of the fabric is around 8 oz/yd² or less. Fig. 16 shows the fabric of Fig. 7 with integrated sensors interconnected using the technology illustrated in Figs. 9 and 11.

2. Knitted Fabric

Parameter	Details
Knitting Machine	Flat Bed (Hand Operated)
Description	1x1 Rib
Gauge (Needles Per Inch)	5
Width	40 Inches
Plastic Optical Fiber	PGU-CD-501-10-E from Toray Industries, New York.
Electrical Conductive Fiber	X-Static Conducting Nylon fiber with insulated PVC Sheath from Sauquoit Industries, Pennsylvania
Meraklon	2/18s Ne Yarn from Dawtex, Inc., Canada

The above table shows the parameters used for producing the knitted fabric embodiment of our present invention having an information infrastructure integrated within the fabric. Fig. 17 shows the structure of the garment in which the Plastic Optical Fiber (POF) 24 is continuously inlaid throughout the structure. Thus, there is one single POF traversing the entire structure. The Electrical Conductive Yarn 25 is also inlaid in the structure. The comfort component, Meraklon 22 forms the 1x1 rib structure and serves as the base of the fabric. The electrical bus 50 in the structure is also shown. In this embodiment, the electrical bus 50 has been knitted separately and attached to the structure.

Fig. 18 shows an opened out image of the single piece integrated structure in Fig. 17. A front-view of the knitted fabric is shown in Fig. 19. A close-up view of the Velcro attachment used to bind the front and back of the garment is shown in Fig. 20. The use of zippers to bind the front and back of the garment is shown in Fig. 21. In the embodiments shown in Figs. 20 and 21, the electrical bus has been knitted separately and bound to the front and back of the garment. The embodiments of Figs. 20 and 21 can also be used for attachment of a woven garment as well as the knitted garment, in the same manner as described.

B. Protection of the Plastic Optical Fiber in the Fabric/Garment Having An Integrated Information Infrastructure

Some plastic optical fibers may be somewhat stiff allowing a limited bending radius and which may be more difficult to weave or knit into the fabric of our

invention. A preferred POF is one having polymethyl methacrylate as its core material and a core diameter of about 225 – 255 microns, a fluorinated polymer as its cladding material with a cladding diameter of about 235 – 265 microns. The preferred POF also has a numerical aperture of about 0.50 mm, a tensile strength (yield point) of about 0.30 kg, an allowable bending radius of about 9 mm and an attenuation of approximately 0.18 dB/m (650nm).

To protect the bare POF and to protect the wearer from the POF, a sheath for the POF is desirable. The preferred sheath material is one that is flexible and would not irritate the skin of the wearer when it comes into contact with the wearer. PVC is a suitable sheath material. The preferred sheath diameter is equal to the diameter of the POF plus 0.5 to 1.0 mm, providing a sheath thickness of 0.25 mm and an outer diameter of 1.5 mm. The sheath material may either be transparent or opaque. The advantages of a transparent sheath material include: points of damage along the POF caused during usage or manufacturing can be visually identified; the intensity of light transmitted throughout the POF can be monitored; and, if desired for certain applications, glowing of the POF can be viewed.

The sheath can be sleeved over the POF either continuously or intermittently, either manually or mechanically. It can also be sleeved in segments with the segment lengths varied.

20 C. Interconnection of Electrical Conductive Fibers

Interconnection of electrical conductive fibers incorporated into the fabric can be achieved by the following sequence of operations:

1. Softening and removal of the insulation of the electrical conductive fibers at the desired intersection zone;
- 25 2. Abrasion of insulation at the intersection zone;
3. Application of a conductive polymer paste at the intersection zone to establish the interconnection between the electrical conductive fibers;
4. Insulation of the interconnect zone to prevent undesirable short circuits; and
5. If desired, attachment of sensor or connector.

The potential for automation has been a key driving factor in the development of the interconnection process since automation is essential for large scale production of the fabric/garment. Also, automation is preferred for the reproducibility and repeatability of the various steps to create a uniform product on a continuous basis.

5 The details of the various steps are presently discussed.

1. Softening and Removal of Insulation

In order to make a connection of intersecting electrical conductive fibers, the insulation at the intersection must first be removed. This can be done by any one of a number of ways. Suitable removal techniques include chemical etching, mechanical
10 removal and any spot welding technique such as ultrasonic welding, laser light application or other localized heating technique. Preferably, the interconnection zone is chemically softened for the effective removal of the insulation, such as vinyl sheath. The process variables are: (i) the chemical used in the process; (ii) the concentration of the chemical; (iii) the amount of chemical applied; and (iv) duration of chemical
15 application. Acetone has been found to work quite well as a chemical-softening agent. A few drops of Acetone are applied. It is allowed to stand for about 10 seconds before the next step in the process. These processing conditions ensure that the conductive yarn itself is not damaged. Also since polyester, cotton and spandex do not interact with acetone, they are not damaged during this process. Where stainless
20 steel is used as the electrical conductive fiber, heat alone may be sufficient to achieve the desired softening and removal of insulation.

2. Abrasion of Insulation

The next step, if needed, is to abrade the insulation at the intersection zone that has been softened. A vibrating brush can be used, preferably one that oscillates at
25 3000 Hz. This effectively strips out the insulation at the interconnection zone as shown in Figure 9. The process variables are: (i) the frequency of oscillation of the brush; (ii) the pressure applied during abrasion; and (iii) duration of abrasion. By modifying these parameters, it would be possible to strip out different types of insulation without damaging the conductive yarns themselves. Depending on the
30 method used for removal of insulation, it may or may not be necessary to carry out

this step. Some methods of removal may result in removal of sufficient amount of insulation such that this abrasion step would not be needed.

3. Application of Conductive Paste

The interconnection between the conductive yarns where the insulation has
5 been removed can be established by applying a conductive paste to close the circuit
between the conductive yarns. The process variables are: (i) the properties of the
conductive paste used in the process; and (ii) the quantity of the paste applied to the
interconnect zone. The conductive paste should be chosen such that it offers only
minimum electrical resistance, adheres well to the conductive yarns, and does not
10 chemically react with the conductive yarn. Based on these requirements, Magnolia
3870, a silver-filled epoxy, room temperature curing paste, is a preferred conducting
paste. It has a shear strength of 2000 psi at 75°F and has a resistivity of 0.004 ohm-
cm at 75° F. It also cures well at room temperature and does not react with the
polyamide conductive yarn. It can be applied to the interconnect zone using a grease
15 gun or a similar device.

4. Insulation of the Interconnection Zone

The interconnection zone must be insulated to prevent it from shorting in the
presence of water. A polyester/urethane based resin can be used to insulate the
interconnection zone. The insulating layer should not chemically react with the
20 conductive paste, should adhere well to the paste and should offer adequate insulation.
It can be applied to the interconnection zone using a brush or other application means.

5. Attachment of a Sensor or Sensor Connector

Additionally, if desired, either a sensor or a sensor connector, such as a T-
connector, can be attached to the interconnection zone. Figs. 10, 11 and 12 show the
25 attachment of a T-connector 34 to the fabric for connecting a sensor, such as an EKG
sensor or a microphone 33 to the fabric. Fig. 13 shows an EKG trace taken from EKG
sensors attached to the garment of Fig. 11 worn by a person.

If desired, the interconnection technology and T-Connectors can be used to
mount antennas in a phased array formation on the garment. Groups of individuals

wearing the said garment with mounted antennas can form a large phased array to track moving objects such as aircraft.

Yet another modification is to provide a keyboard capability in the garment using either the conducting fibers themselves or through sensors mounted on the
5 conducting fibers using the interconnection technology so that the keyboard can serve as an input device for the information processing and monitoring devices plugged into the fabric of our present invention.

D. Core Spinning Technology

Core spinning is the process of sheathing a core yarn (e.g., POF or Spandex
10 yarns) with sheath fibers (e.g., Meraklon or Polyester/Cotton). It is not required in all situations for the present invention. It is desirable when the information infrastructure component, or other components other than the comfort component, do not possess the comfort properties that are desired for the garment. There are two ways to core spin yarns -- one using modified ring spinning machines and another by using a
15 friction-spinning machine. Ring spinning machines are very versatile and can be used for core spinning both fine and coarse count yarns. However, the productivity of the ring-spinning machine is low and the package sizes are very small. Friction spinning machines can be used only to produce coarse count yarns, but the production rates and the package sizes are much higher than ring spinning. Where the yarns that are used
20 are relatively coarse, friction-spinning technology is preferred for core spinning the yarns.

The preferred configuration of the friction-spinning machine for producing core spun yarns is as follows:

Parameter	Details
Machine Model	DREF3®
Machine Description	Friction Core Spinning Machine
Draft	200
Speed	170 m/min
Number of Doublings	5
Drafting Mechanism Type	3/3
Core-Sheath Ratio	50:50

Four full-scale prototypes of a garment fashioned from our fabric were produced on the AVL-Dobby loom. Additionally, two samples of a woven fabric were produced on a tabletop loom. The specifications for the samples are shown in Fig. 14. These samples were designed with high 42 and low 43 conductive electrical fibers spaced at regular intervals to act as an elastic circuit board 40. The circuit diagram of this board is illustrated in Fig. 15. The figure shows the interconnections between the power 44 and ground 46 wires and high 42 and low 43 conducting fibers. The data bus 47 for transferring data from the randomly positioned interconnection points 48 for the sensors to Personal Status Monitors 1 and 2 (PSM 1 and PSM 2) is also shown. The presently preferred PSM is a custom built PSM manufactured by the Sarcos Research Corporation of Salt Lake City, Utah.

The presently preferred PSM is a light weight device that is preferably located at the hip area of the user, i.e. at the bottom of the garment and at an end point of the data buses. The information obtained by the PSM is transmitted to the remote control center, e.g., the medical personnel in the case of military application, by Broadband-Code Division Multiplexing. The transmitter can be attached to the PSM or can be located externally on the outer garment of the user and coupled to the PSM using wire conductors.

Not expressly shown in Fig. 15, but to be included in the elastic board, are modular arrangements and connections for providing power to the electrical conducting material component and for providing a light source for the penetration detection component. The fabric in one form can be made with the sensing component(s) but without inclusion of such power and light sources, or the

transmitters 52 and receivers 54 illustrated, expecting such to be separately provided and subsequently connected to the fabric.

E. Operation of the Fabric With Integrated Information Infrastructure

The operation of our above-described fabric having an integrated information
5 infrastructure to illustrate its penetration alert and vital signs monitoring capabilities is now discussed.

Penetration Alert:

1. Precisely timed pulses are sent through the POF integrated into the garment.
- 10 2. If there is no rupture of the POF, the signal pulses are received by a transceiver and an "acknowledgment" is sent to the PSM Unit indicating that there is no penetration.
3. If the optical fibers are ruptured at any point due to penetration, the signal pulses bounce back to the first transmitter from the point of impact, i.e., the
15 rupture point. The time elapsed between the transmission and acknowledgment of the signal pulse indicates the length over which the signal has traveled until it reached the rupture point, thus identifying the exact point of penetration. The location of the actual penetration in the POF can be determined by an Optical Time Domain Reflectometer after the penetration is initially detected.
- 20 4. The PSM unit transmits a penetration alert via a transmitter specifying the location of the penetration.

Physical Signs Monitoring:

1. The signals from the sensors are sent to the PSM Unit or to a monitoring unit through the electrical conducting component (ECC) of the fabric.
- 25 2. If the signals from the sensors are within the normal range and if the PSM Unit has not received a penetration alert, the vital sign readings are recorded by the PSM Unit for later processing. Alternatively, the vital signs data may be transmitted continuously to remote monitoring units.

3. However, if the readings deviate from the normal, or if the PSM Unit has received a penetration alert, the vital sign readings are transmitted using the transmitter.

Thus, the fabric of our present invention is easy to deploy and meets all the functional requirements for monitoring vital signs and/or penetration.

Although the preceding description has been geared toward military applications the presently described fabric having an integrated information infrastructure can be adapted to many other applications. For instance, in medical applications the fabric can be utilized by doctors to either continuously or intermittently monitor desired vital signs of patients who are at remote locations. Further, persons who have known disorders can wear the garment and be under constant monitoring of their physical condition by medical personnel. These could include, but are not limited to, monitoring and treatment of: individuals including those in post-operative recovery (e.g., heart surgery); of geriatric patients, especially those in remote areas where the doctor-patient ratio is very small compared to urban areas; of mentally ill patients for a better understanding of diseases such as chronic depression; of children susceptible to SIDS (sudden infant death syndrome); and individuals prone to allergic reactions (e.g., anaphylaxis reaction from bee stings).

Just as the home security industry is a big business that monitors and protects homes, our fabric having an integrated information infrastructure has the potential to spawn a new industry for the reliable and effective monitoring of patients at home and thereby transform home healthcare delivery.

Additional applications can include police, fire fighting, mining and other public safety activities where it is desirable to maintain constant updates of information on the physical condition and location of personnel. By combining the physical sensors with GPS (Global Positioning System) the control center can monitor firefighter or police officers' location and physical signals at all times, thereby increasing the safety and ability of these personnel to operate in remote and/or hazardous conditions. Furthermore, the vital signs of drivers (auto, truck, etc.)

wearing the fabric/garment of our present invention can be monitored continuously and an alarm triggered if the driver becomes drowsy, thereby avoiding accidents.

Our fabric/garment can be used for monitoring astronauts in space in an unobtrusive manner and thereby enhance the knowledge to be gained from medical
5 experiments in space that will lead to new discoveries and the advancement of the understanding of space.

It can be used by athletes to monitor their vital signs and hence their performance. In team sports, the coach can track the vital signs and the performance of the player on the field and make desired changes in the players on the field
10 depending on the condition of the player.

It can also be used in various other settings (e.g., prisons, shops, high security areas, mountaineering/hiking expeditions, etc.) to monitor and track the movement of individuals and their vital signs.

Further, the fabric/garment can also transmit signals that are received by
15 receivers coupled to the data buses or the PSM. These signals can include video, positional signals, information on other members of a group, etc. The information can be transmitted utilizing B-CDMA or other communication protocols. For instance, the received signals can, be voice signals sent through the garment to an ear piece worn by the user. Video data can be supplied to a monitor that is coupled to garment
20 or flat screen display that is attached to the garment. The fabric/garment can utilize separate buses for transmitting and receiving signals if a certain bandwidth is needed for the received signals.

The advantages of incorporating the receive and transmit functions into the single garment include reduction in the amount of equipment the user must manage.
25 For example, a firefighter's microphone and radio can simultaneously communicate using one garment. This allows for a reduction in the number of pieces of equipment that need to be utilized, maintained and tracked. Other advantages include a lighter overall weight carried by the user since no external equipment with its associated casing is utilized.

In addition to transmitting the data of the wearer, the sensors can also act as receivers of external signals (e.g., from the PSM) through the databus in the fabric/garment. This feature can be used to modify the sensitivity of the sensors as needed. For example, the sensitivity of the microphone in the fabric/garment can be
5 changed remotely through the databus.

The fabric/garment allows a new way to customize information processing devices to "fit" the wearer by selecting and plugging in (or removing) chips/sensors from the garment, thus creating a wearable information infrastructure. This will lead to human networks of mobile information processors that interact with each other. For
10 example, the fabric/garment can be connected to the Internet and the wearer can search for information (e.g., on the world wide web), download information or upload information from the fabric/garment to the web, even when the wearer is mobile.

The fabric/garment can also be used to track valuable objects and hazardous substances (e.g., radioactive materials) whose movements must be monitored. For
15 instance, it can be used by banks to wrap money to facilitate their tracking (e.g., in the event of a bank robbery). Monitoring of vital signs of pets is among a myriad of such uses of the fabric.

The fabric/garment can be used to interact with the environment to modify the surroundings. For instance, depending on the wearer's mood reflected by the vital
20 signs, the ambience (e.g., lighting, music, climate, etc.) can be modified to suit the user's preferences. Thus, the fabric/garment pioneers the class of adaptive and responsive textile structures (ARTS). A related application of the fabric is to interact with Java™ or similarly enabled devices and appliances to carry out specific tasks such as turning on a coffeepot, a microwave, etc.

25 The vital signs of individuals involved in mission-critical or hazardous operations can be continuously monitored and appropriate action taken. For example, individuals operating mass transportation and/or cargo vehicles can be monitored on a regular basis to prevent or identify the causes for major disasters (e.g., plane crashes) brought on by the physical impairment of the human operator. Likewise, the vital

signs of scuba divers can be reliably monitored from the surface and they can be asked to take appropriate actions (e.g., return to the surface) to prevent injuries and fatalities.

While the invention has been disclosed in its preferred forms, it will be apparent to those skilled in the art that many modifications, additions, and deletions
5 can be made therein without departing from the spirit and scope of the invention and its equivalents as set forth in the following claims.

What is claimed:

1. A fabric comprising:
a comfort component serving as the base of the fabric; and
an information infrastructure component integrated within the comfort
5 component.
2. A fabric as defined in Claim 1, wherein the comfort component is a
yarn selected from the group consisting of fibers of cotton, cotton/polyester blends,
microdenier polyester/cotton blends, and polypropylene, and combinations thereof.
3. A fabric as defined in Claim 1, wherein the information infrastructure
10 component includes either a penetration detection component or an electrical
conductive component or both.
4. A fabric as defined in Claim 3, wherein the penetration detection
component is selected from the group consisting of silica-based optical fibers, plastic
optical fibers, and silicone rubber optical fibers, and combinations thereof.
- 15 5. A fabric as defined in Claim 3, wherein the electrical conductive
component is selected from the group consisting of insulated and intrinsically
conducting polymers, doped fibers, and metallic fibers, and combinations thereof.
6. A fabric as defined in Claim 1, wherein the comfort component is
selected from the group consisting of tubular woven and knitted fabrics and two-
20 dimensional woven and knitted fabrics.
7. A fabric as defined in Claim 1, further comprising a form-fitting
component.
8. A fabric as defined in Claim 7, wherein the form fitting component is
Spandex yarn.
- 25 9. A fabric as defined in Claim 4, wherein the penetration detection
component is a sheathed optical fiber having a core diameter of from 225 to 255
microns and a sheath diameter equal to the core diameter plus 0.5 to 1.0mm.
10. A fabric as defined in Claim 9, wherein the penetration sensing
component has a bending radius of at least 9 mm.

11. A fabric as defined in Claim 1, wherein said information infrastructure component further comprises means for monitoring a physical aspect selected from the group consisting of heart rate, EKG, pulse rate, temperature, respiration rate, allergic reactions, and voice, and combinations thereof.
- 5 12. A fabric as defined in Claim 1, wherein said fabric is fashioned into a garment.
13. A process for interconnecting intersecting electrical conductive textile fibers comprising the steps of:
- 10 softening and removing the insulation of the electrical conductive textile fibers at their intersecting point;
- applying a conductive paste to the intersecting point of the electrical conductive textile fibers; and
- insulating the intersecting point of the electrical conductive textile fibers.
- 15 14. A process as defined in Claim 13, wherein the removal of the insulation is done by chemical etching, mechanical removal, a spot welding technique, laser light, or localized heating.
15. A process as defined in Claim 14, wherein the conductive paste is a silver-filled epoxy conducting paste curing at room temperature.
- 20 16. A process as defined in Claim 13, further including the optional step of abrading the insulation to aid the removal of the insulation but before the step of applying a conductive paste.
17. A process as defined in Claim 13, wherein the material for insulating the intersection point is a polyester/urethane based resin.
- 25 18. A process as defined in Claim 13, further including the step of attaching a sensor or a sensor connector at the intersecting point of the electrical conducting fibers.
19. A process for creating a flexible protected optical fiber comprising the steps of:

providing an optical fiber having a core diameter of about 225 to 255 microns;

sheathing the optical fiber in a flexible sheathing material having a sheath diameter equal to the diameter of the optical fiber plus 0.5 to 1.0 mm.

5 20. A process as defined in Claim 19, wherein the sheathing material is PVC.

21. A fabric comprising:
a comfort component serving as a base of the fabric; and
a plurality of signal transmission paths integrated within the comfort
10 component.

22. A fabric as defined in Claim 21 wherein said plurality of signal transmission paths are woven into said comfort component.

23. A fabric as defined in Claim 21 wherein said plurality of signal transmission paths are knitted into said comfort component.

15 24. A fabric as defined in Claim 21 further comprising at least one sensor coupled with the at least one signal transmission path.

25. A fabric as defined in Claim 24 wherein said at least one sensor comprises a fabric penetration sensor.

20 26. A fabric as defined in Claim 24 wherein said at least one sensor comprises a sensor that monitors a physical condition of a wearer of the fabric.

27. A fabric as defined in Claim 21 further comprising a form fitting component.

28. A fabric as defined in Claim 27, wherein the form fitting component is Spandex yarn.

25 29. A fabric as defined in Claim 21 which can be used as a wearable, mobile and flexible information infrastructure and personal information processor operating in a stand-alone or networked mode.

30 30. A fabric as defined in Claim 21, wherein the comfort component is a yarn selected from the group consisting of fibers of cotton, cotton/polyester blends, microdenier polyester/cotton blends, and polypropylene, and combinations thereof.

31. A fabric as defined in Claim 21, wherein the plurality of signal transmission paths include either a penetration detection component or an electrical conductive component or both.

32. A fabric as defined in Claim 31, wherein the penetration detection
5 component is selected from the group consisting of silica-based optical fibers, plastic optical fibers, and silicone rubber optical fibers, and combinations thereof.

33. A fabric as defined in Claim 31, wherein the electrical conductive component is selected from the group consisting of insulated and intrinsically conducting polymers, doped fibers, and metallic fibers, and combinations thereof.

10 34. A fabric as defined in Claim 21, wherein the comfort component is selected from the group consisting of tubular woven and knitted fabrics and two-dimensional woven and knitted fabrics.

35. A fabric as defined in Claim 32, wherein the penetration detection component is a sheathed optical fiber having a core diameter of from 225 to 255
15 microns and a sheath diameter equal to the core diameter plus 0.5 to 1.0mm.

36. A fabric as defined in Claim 35, wherein the penetration detection component has a bending radius of at least 9 mm.

37. A fabric as defined in claim 21, wherein said fabric is fashioned into a garment.

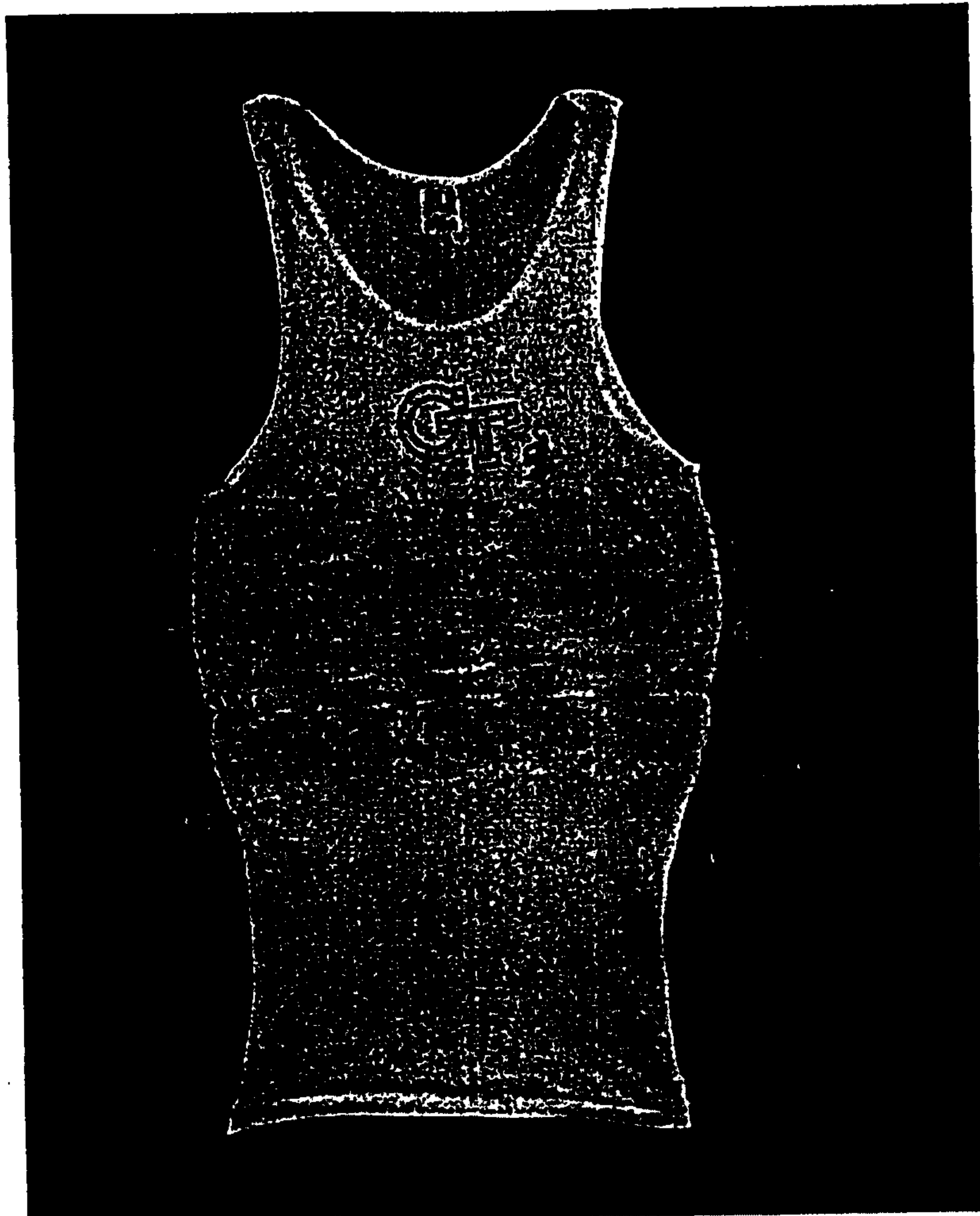


Fig.1

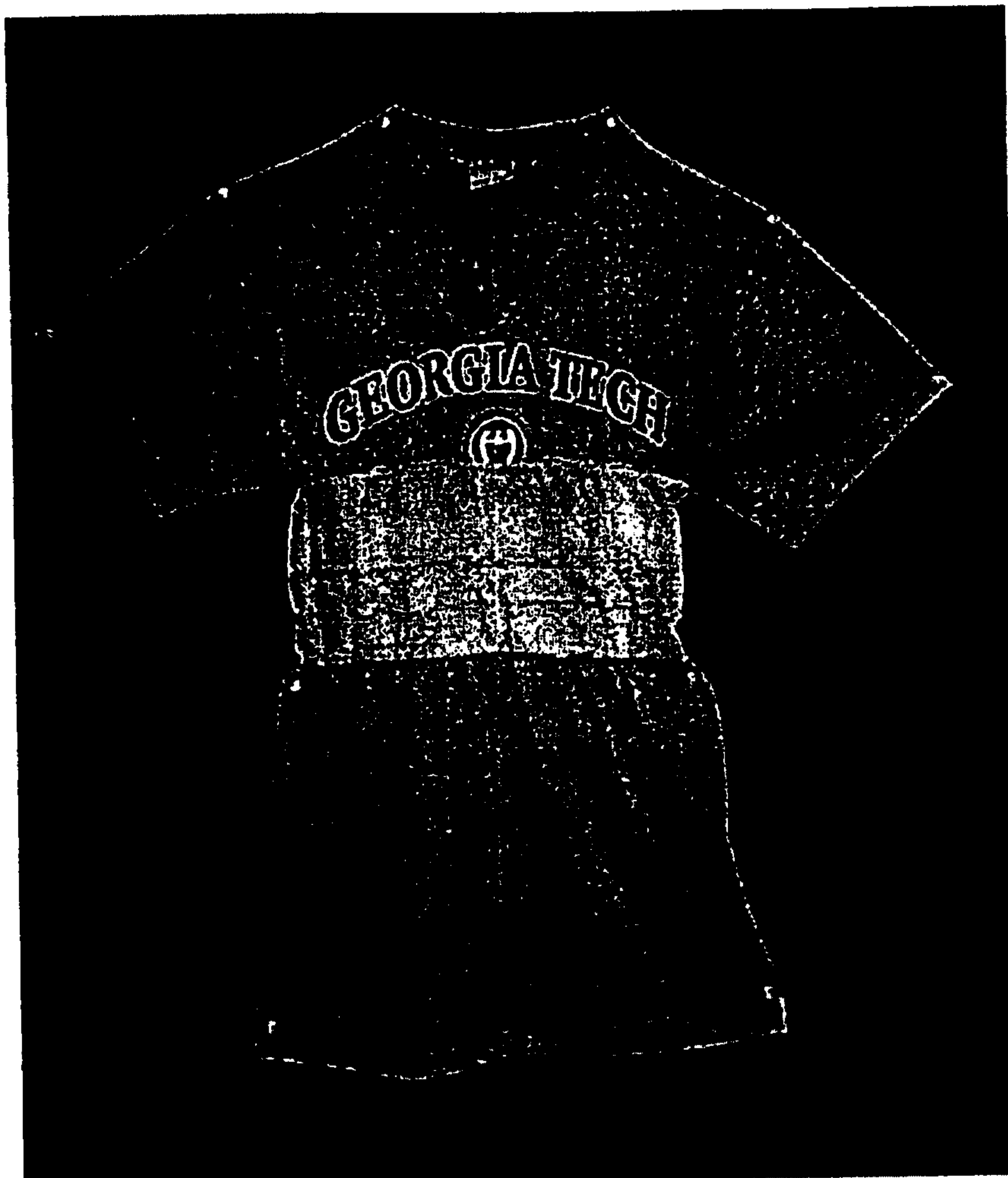


Fig.2

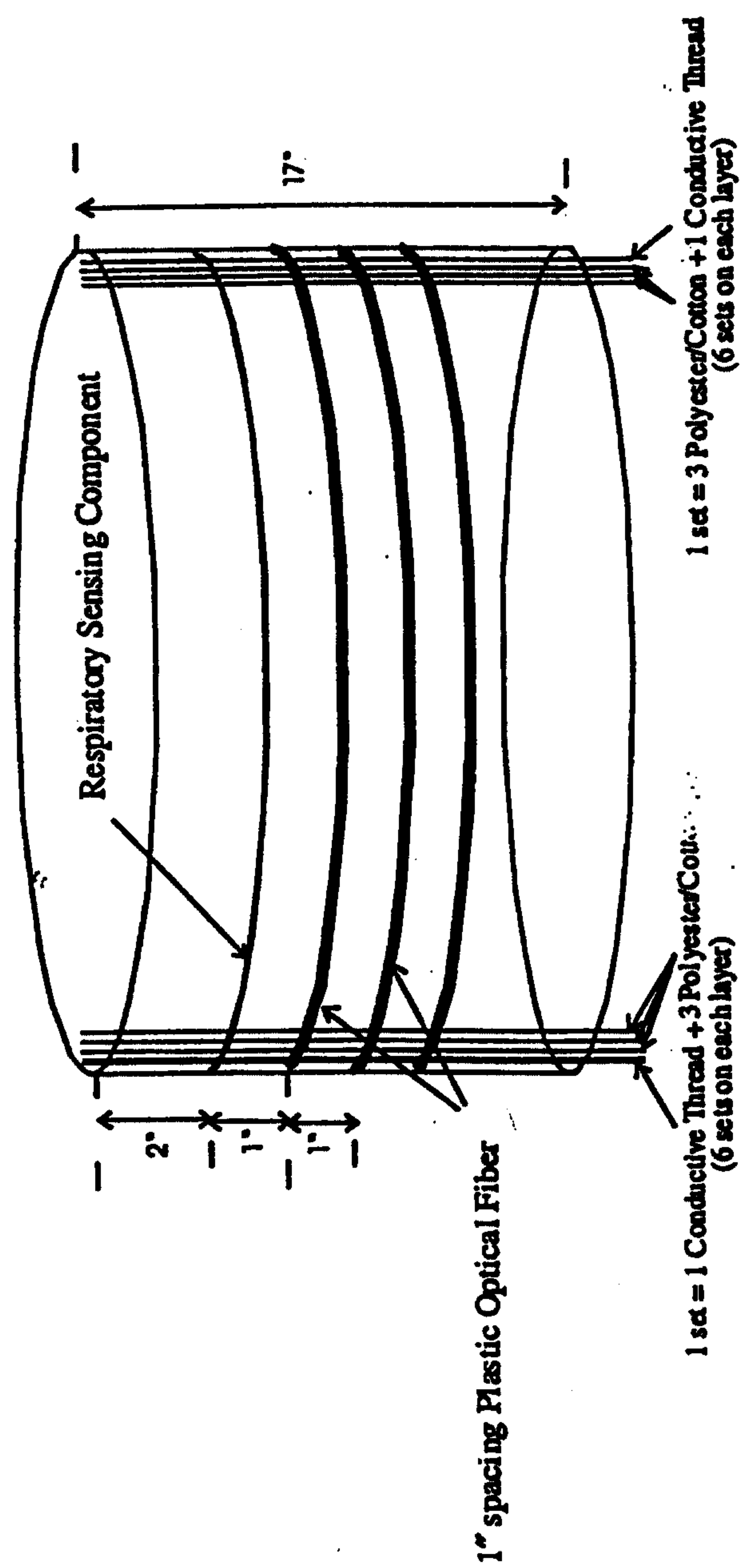
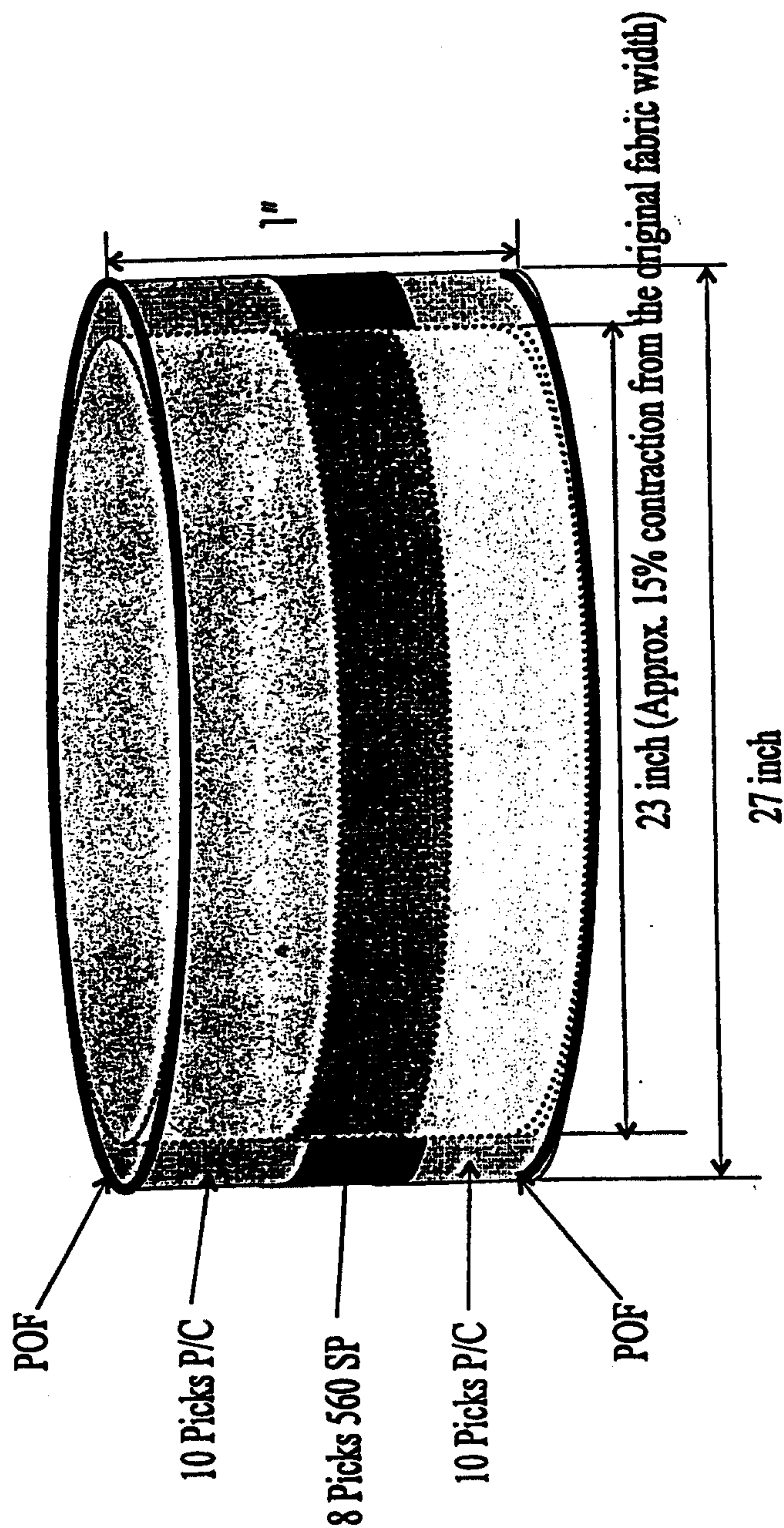
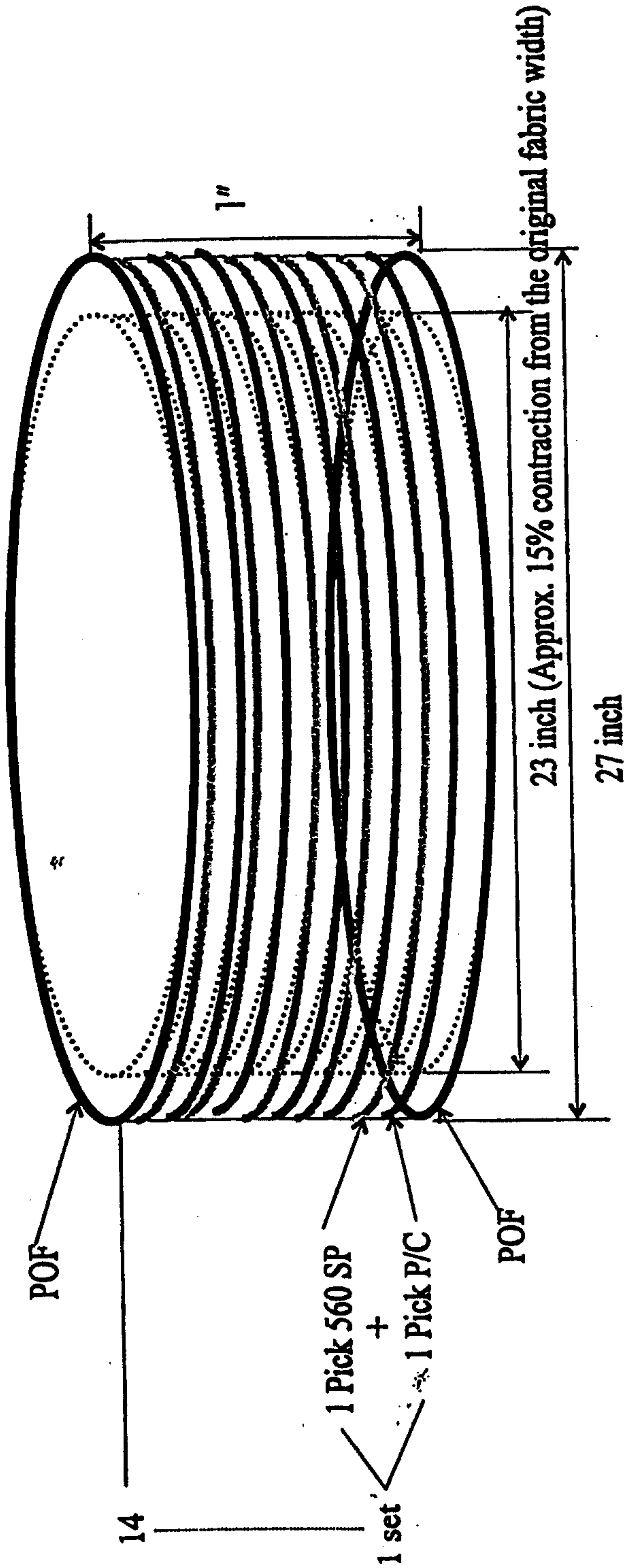


Fig. 3



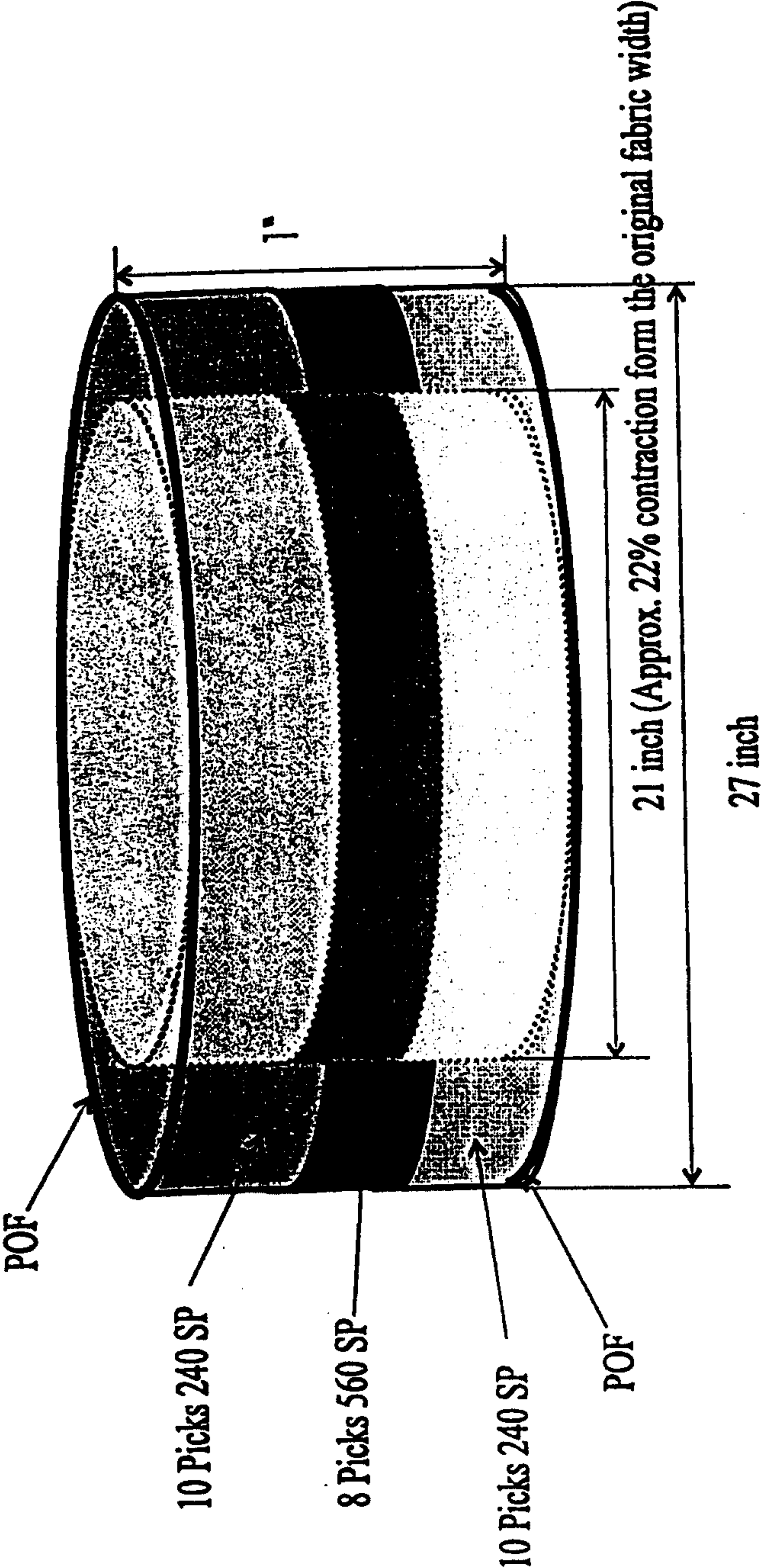
POF	Plastic Optical Fiber
560 SP	560 Denier Polyester/Cotton Core-Spun Spandex
P/C	50/50 Polyester/Cotton blended

Fig. 4



POF	Plastic Optical Fiber
560 SP	560 Denier Polyester/Cotton Core-Spun Spandex
P/C	50/50 Polyester/Cotton blended

Fig. 5



POF	Plastic Optical Fiber
240 SP	240 Denier Polyester/Cotton Core-Spun Spandex
560 SP	560 Denier Polyester/Cotton Core-Spun Spandex

Fig. 6

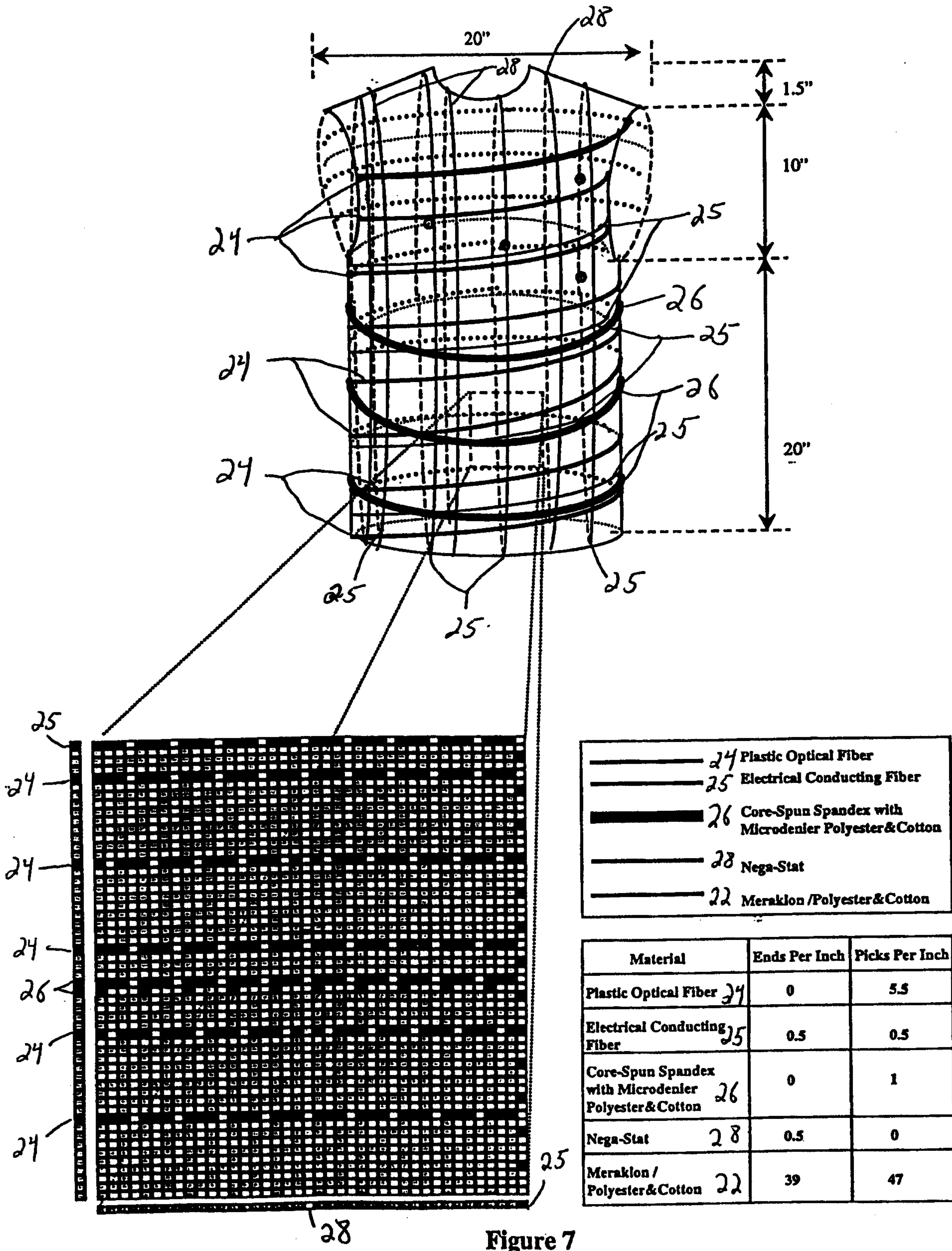


Figure 7

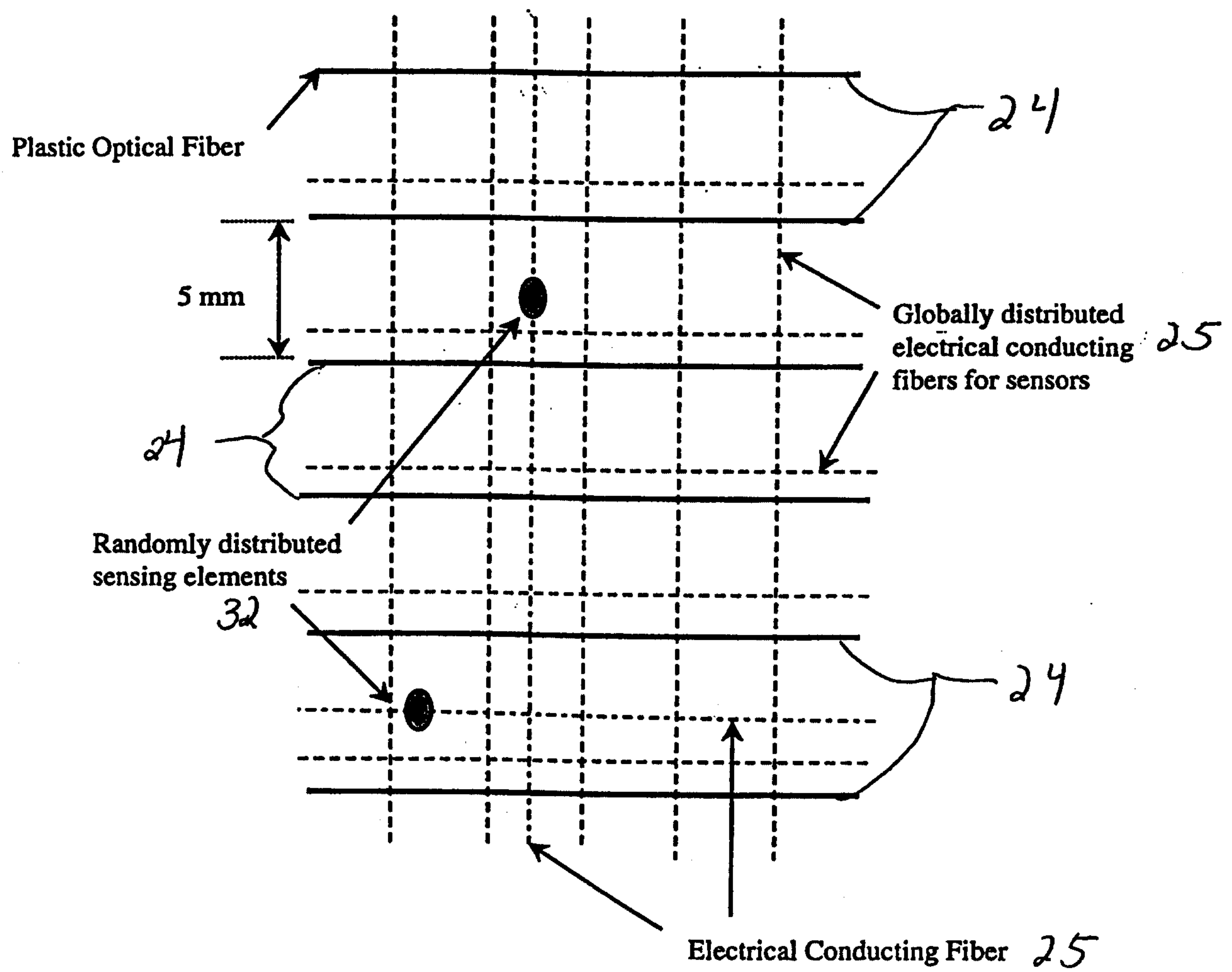


Figure 8

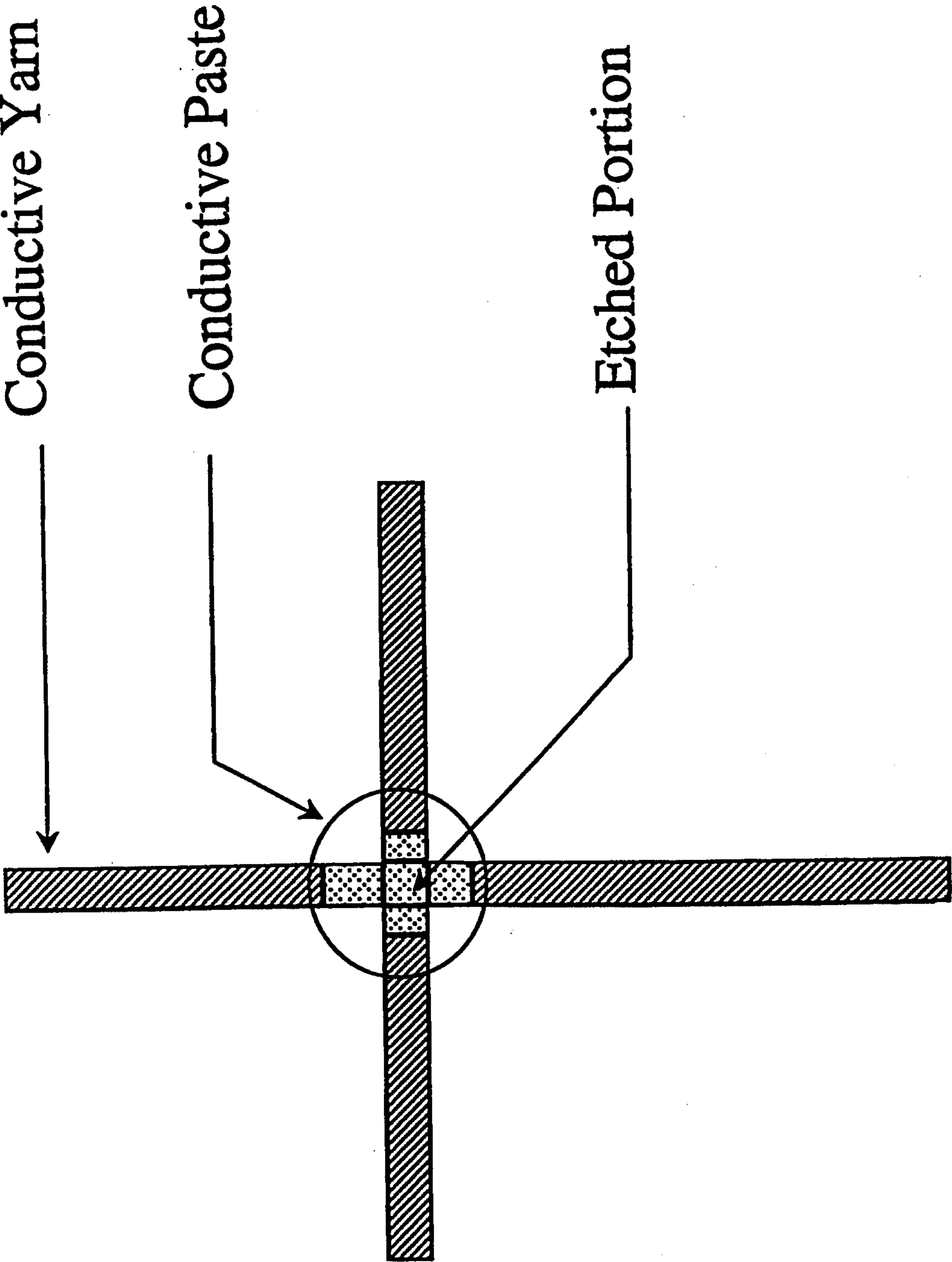


Fig. 9



Fig.10

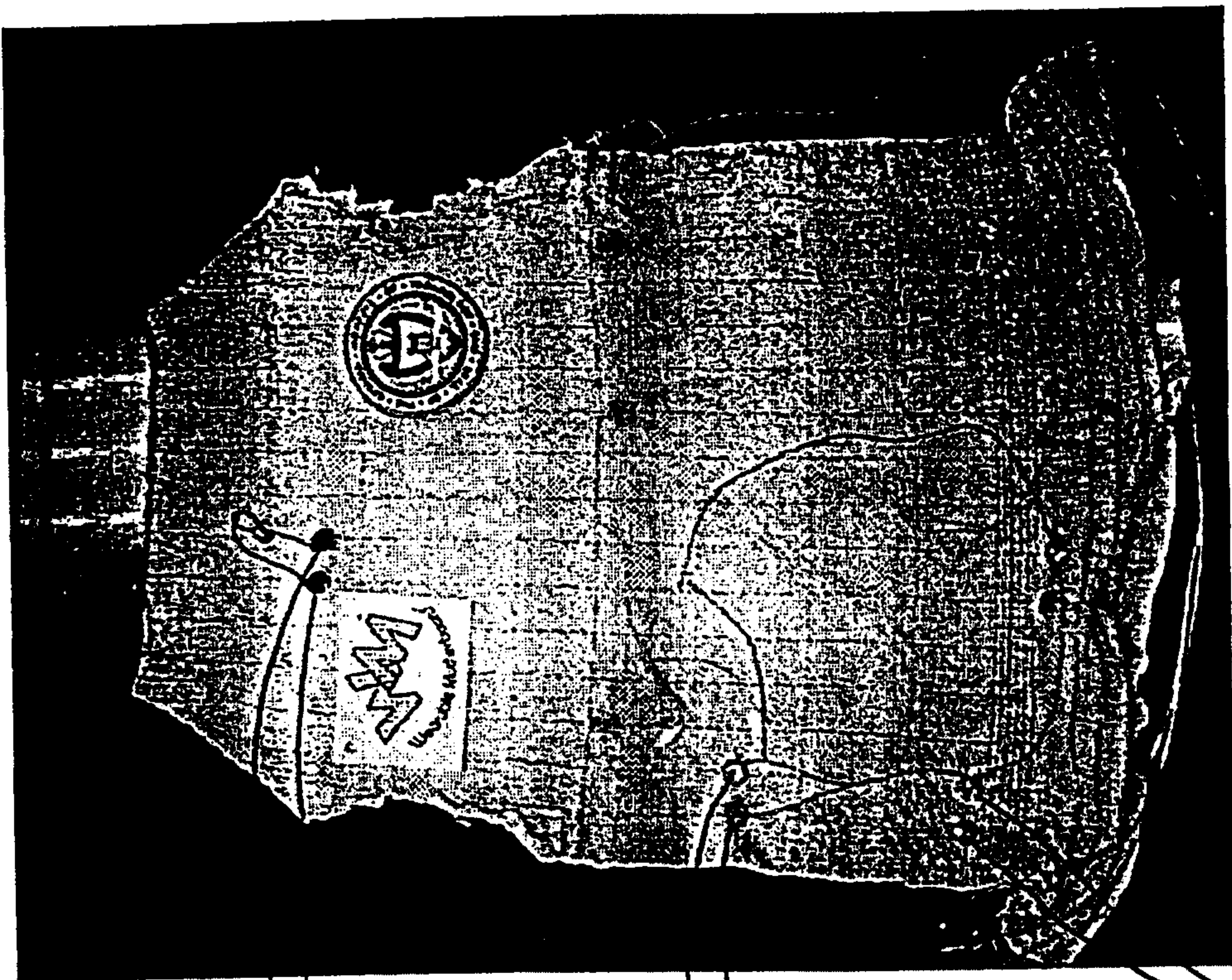


Fig. 11

33

32

34

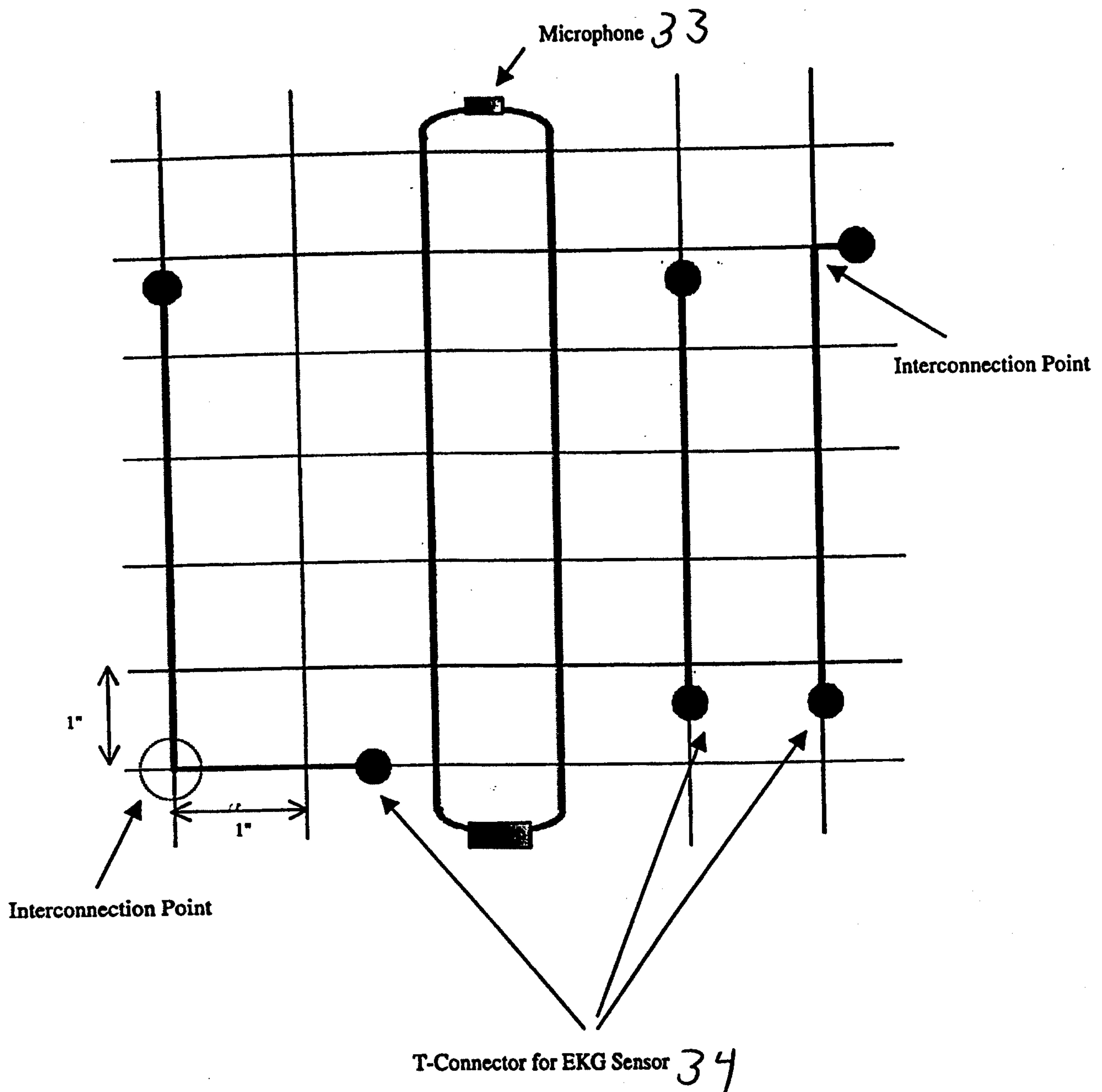


Fig. 12

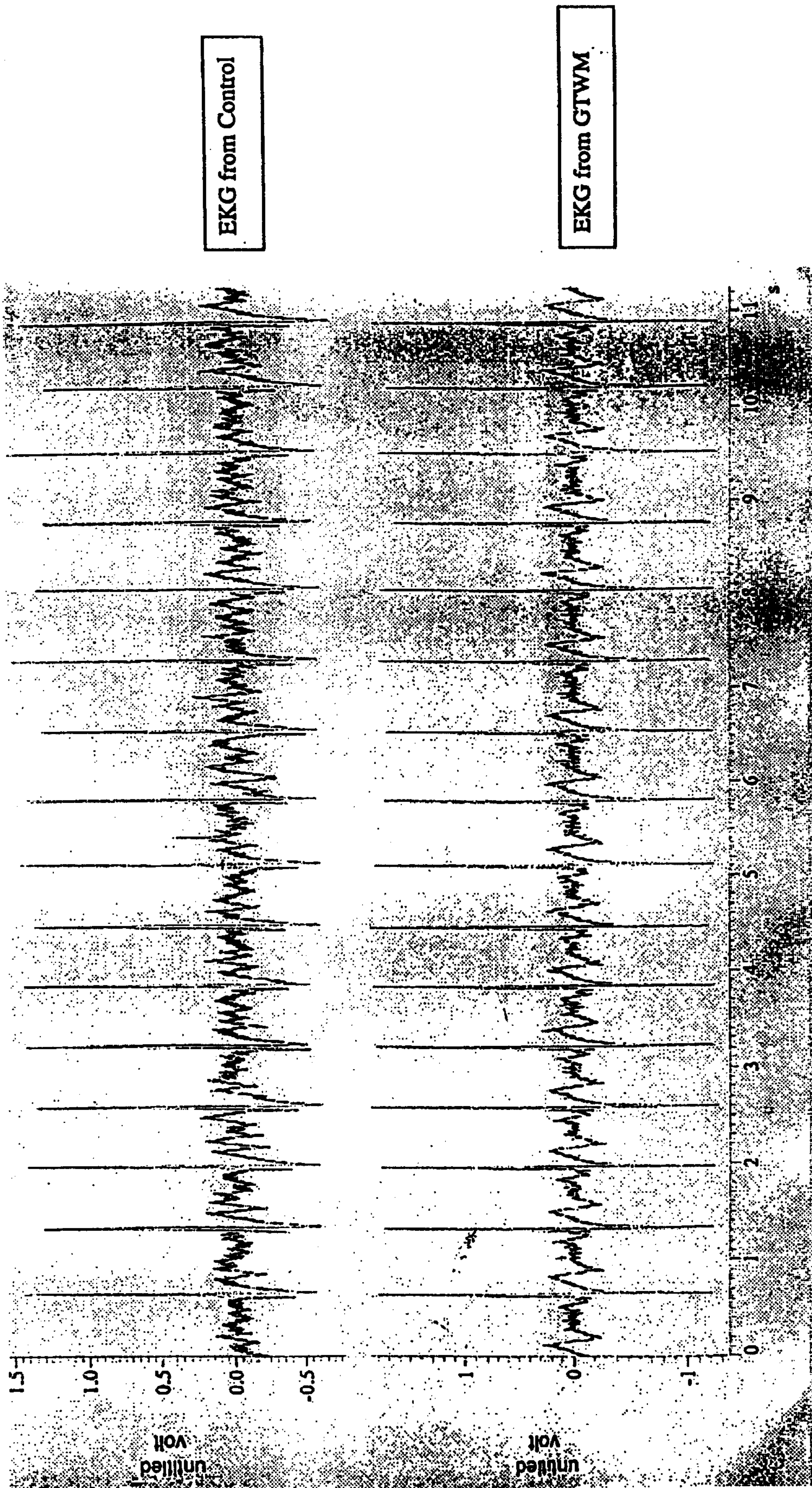
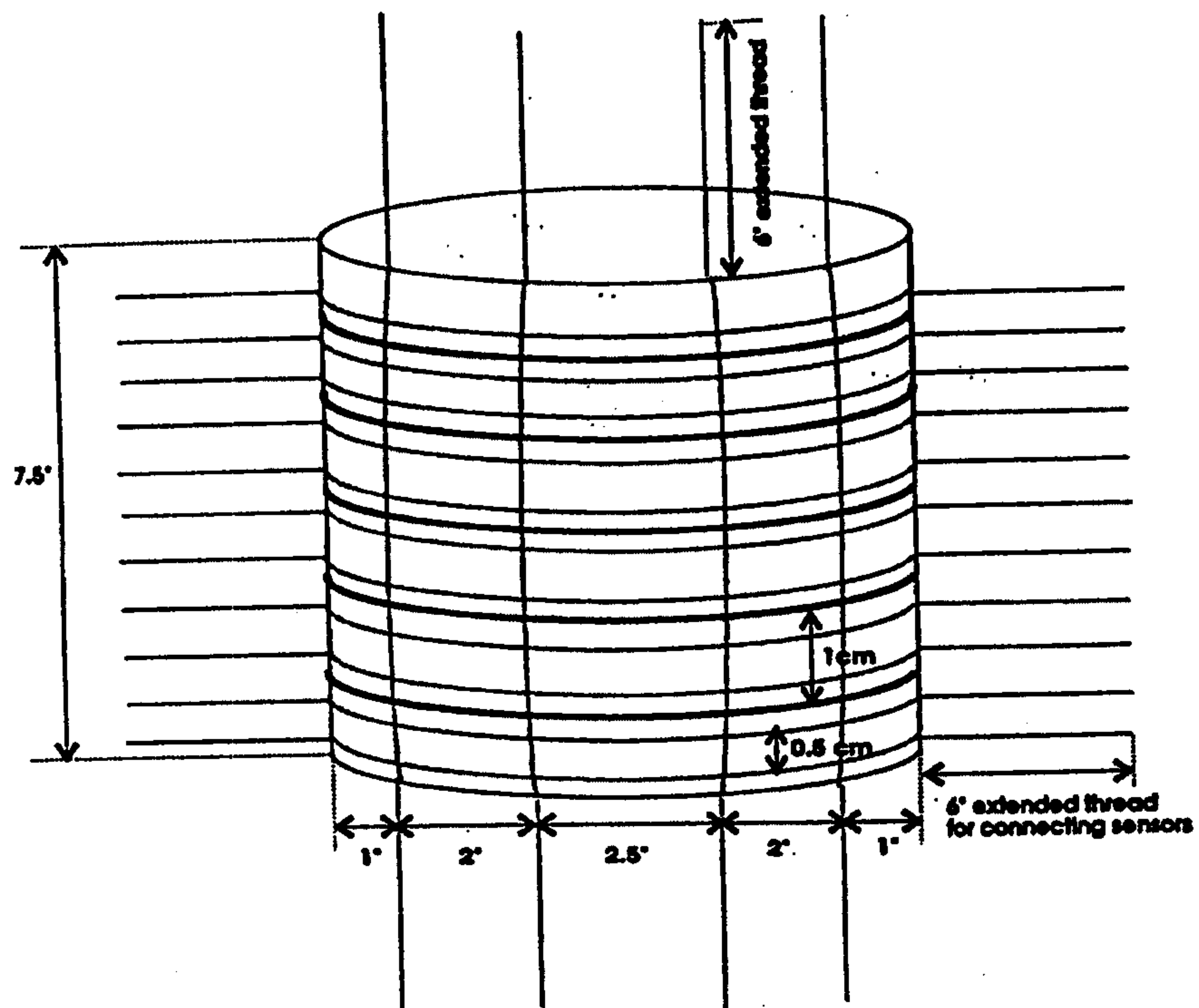


Fig. 13



- _____ 200 Denier X-Static Silver Coated Nylon Conductive Thread with PVC Sheath 25
 _____ Sheathed: Plastic Optical Fiber 24

Fig. 14

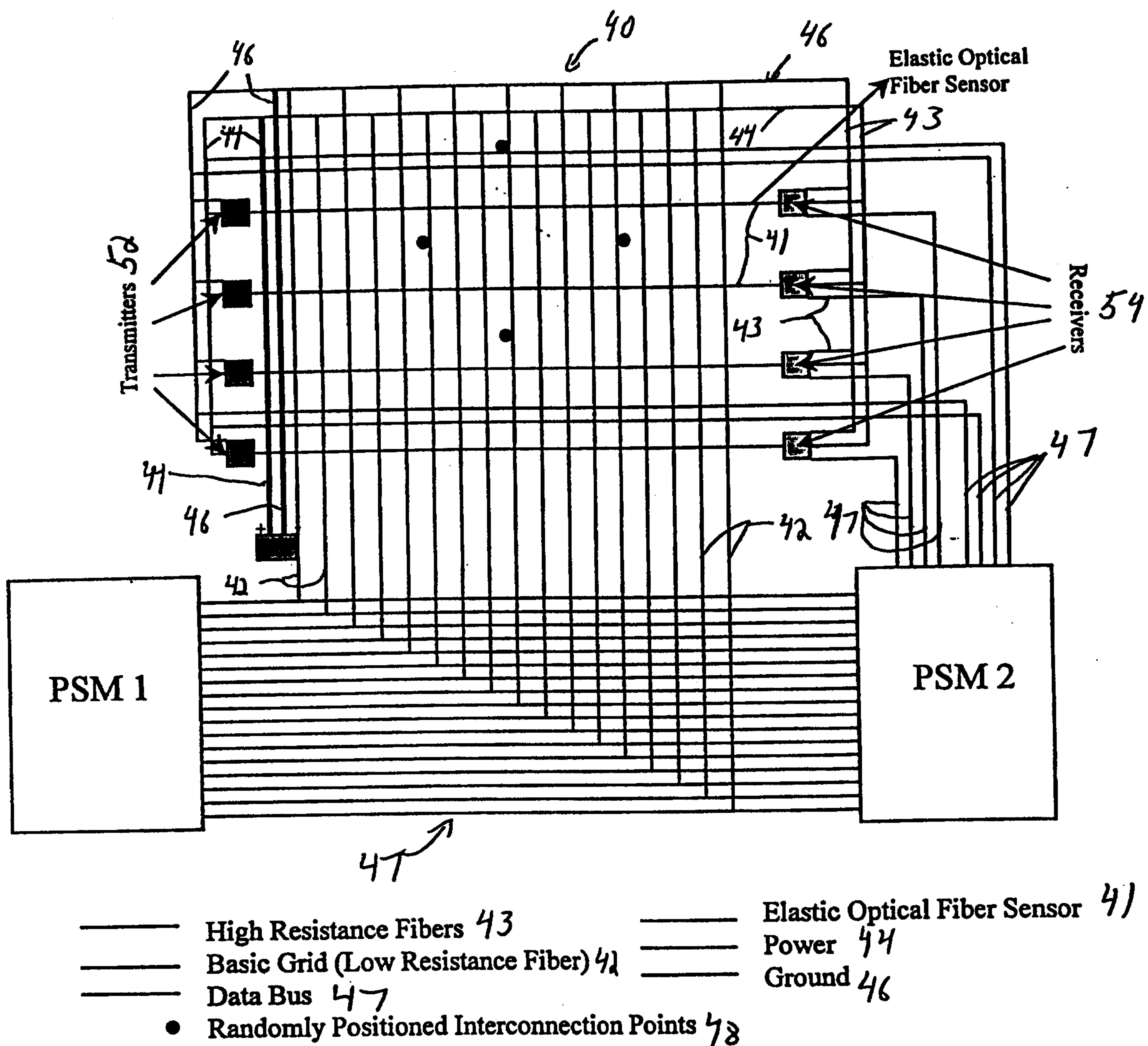


Fig. 15

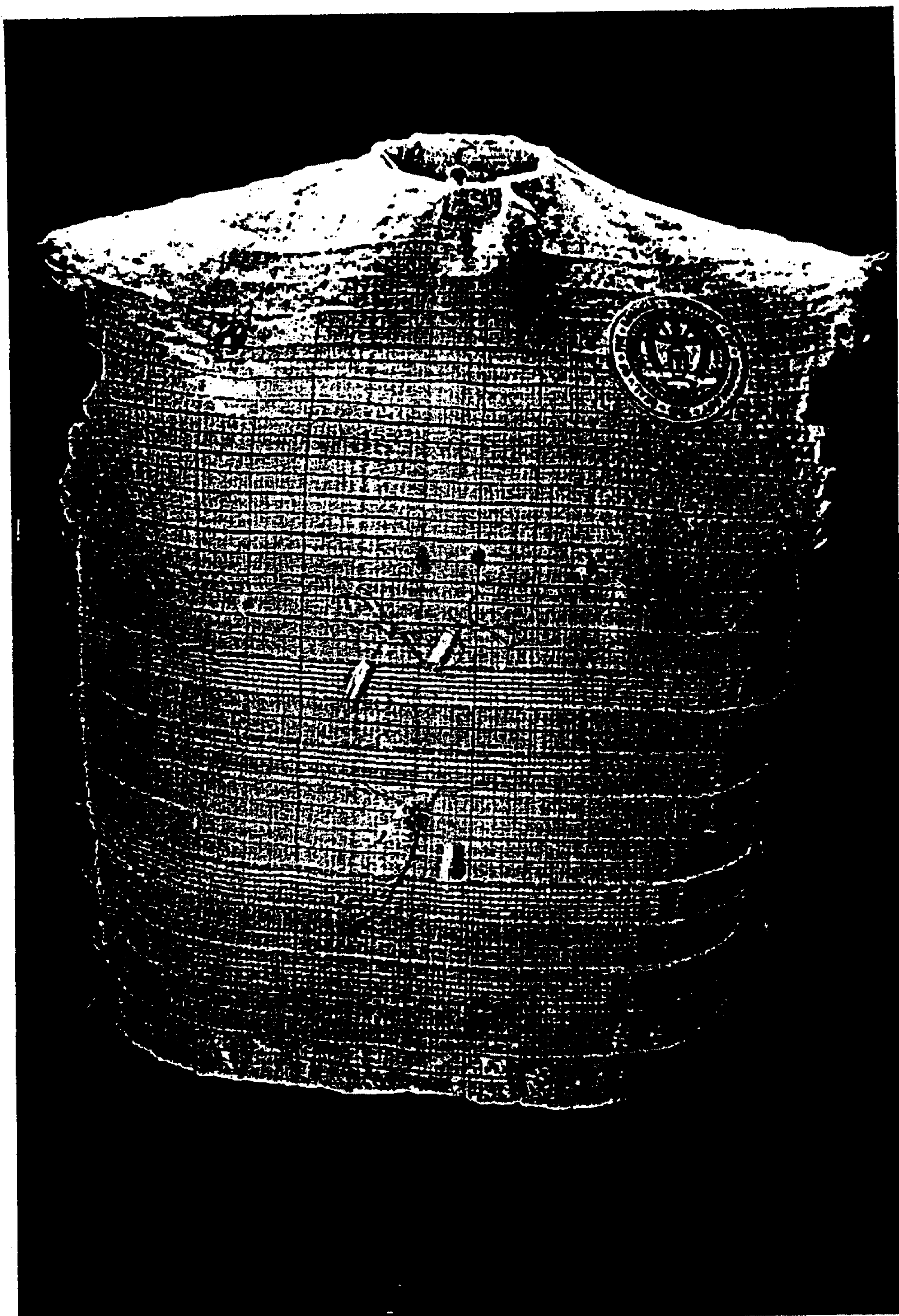


Fig. 16

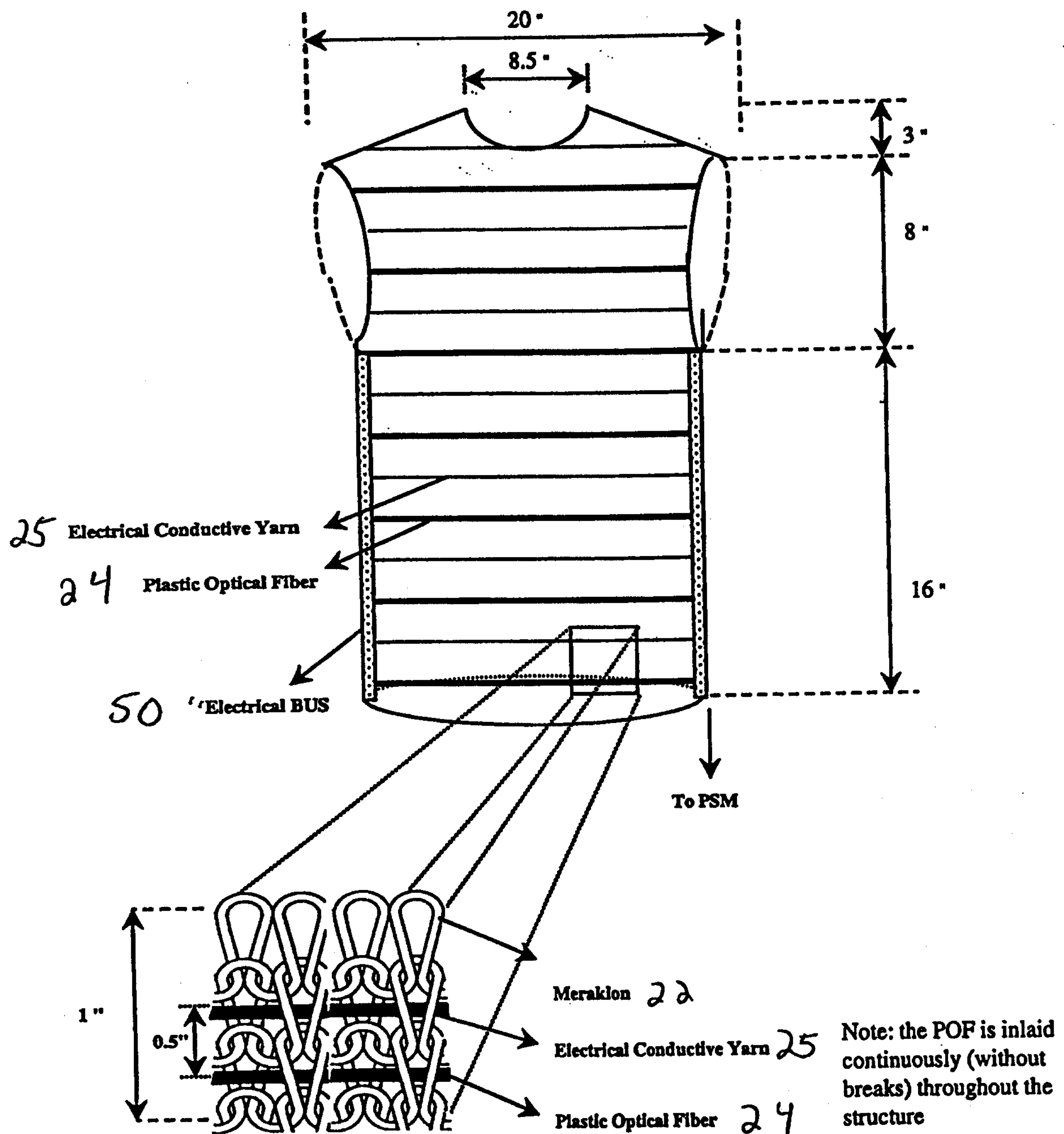


Fig. 17

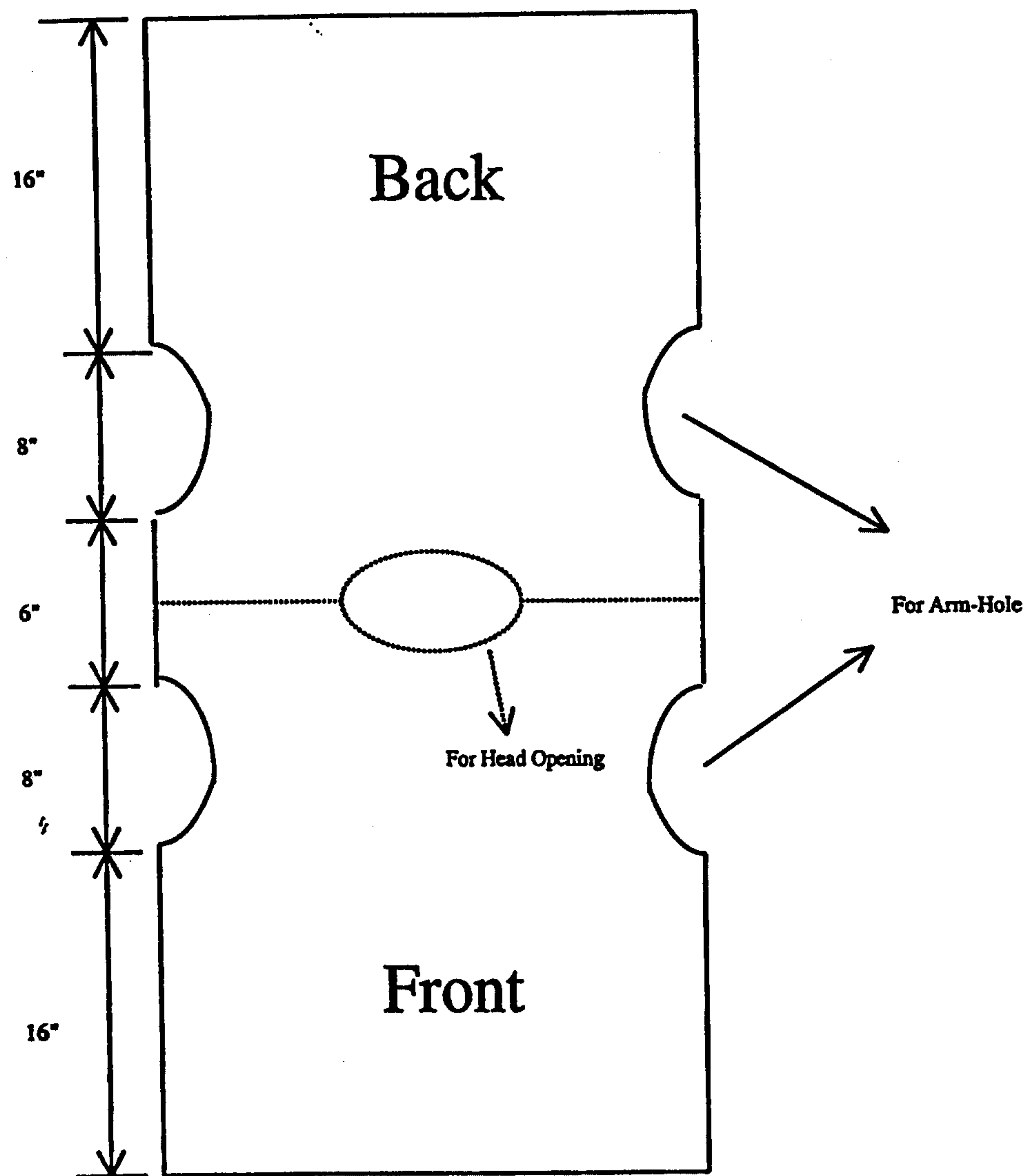


Fig. 18

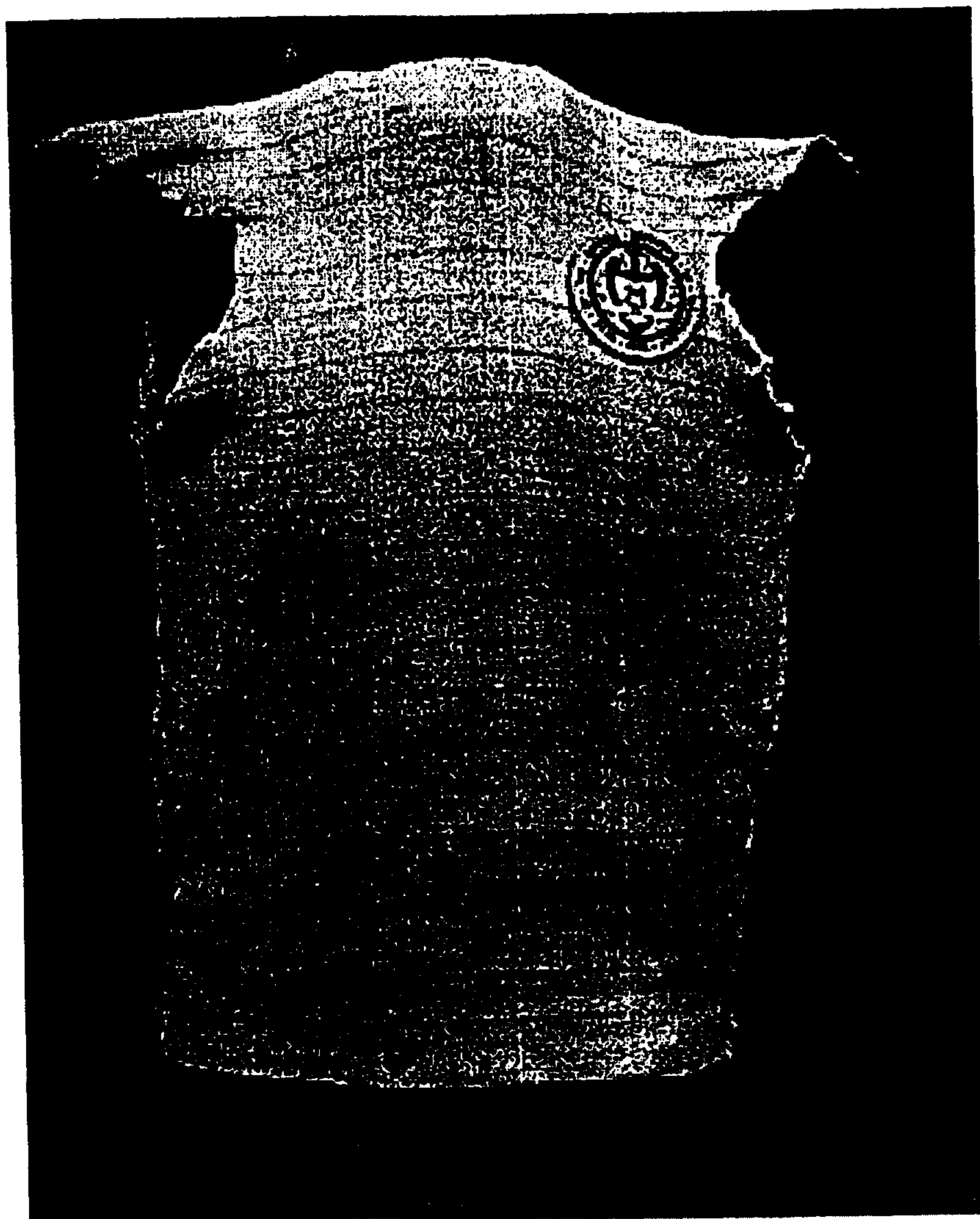


Fig. 19

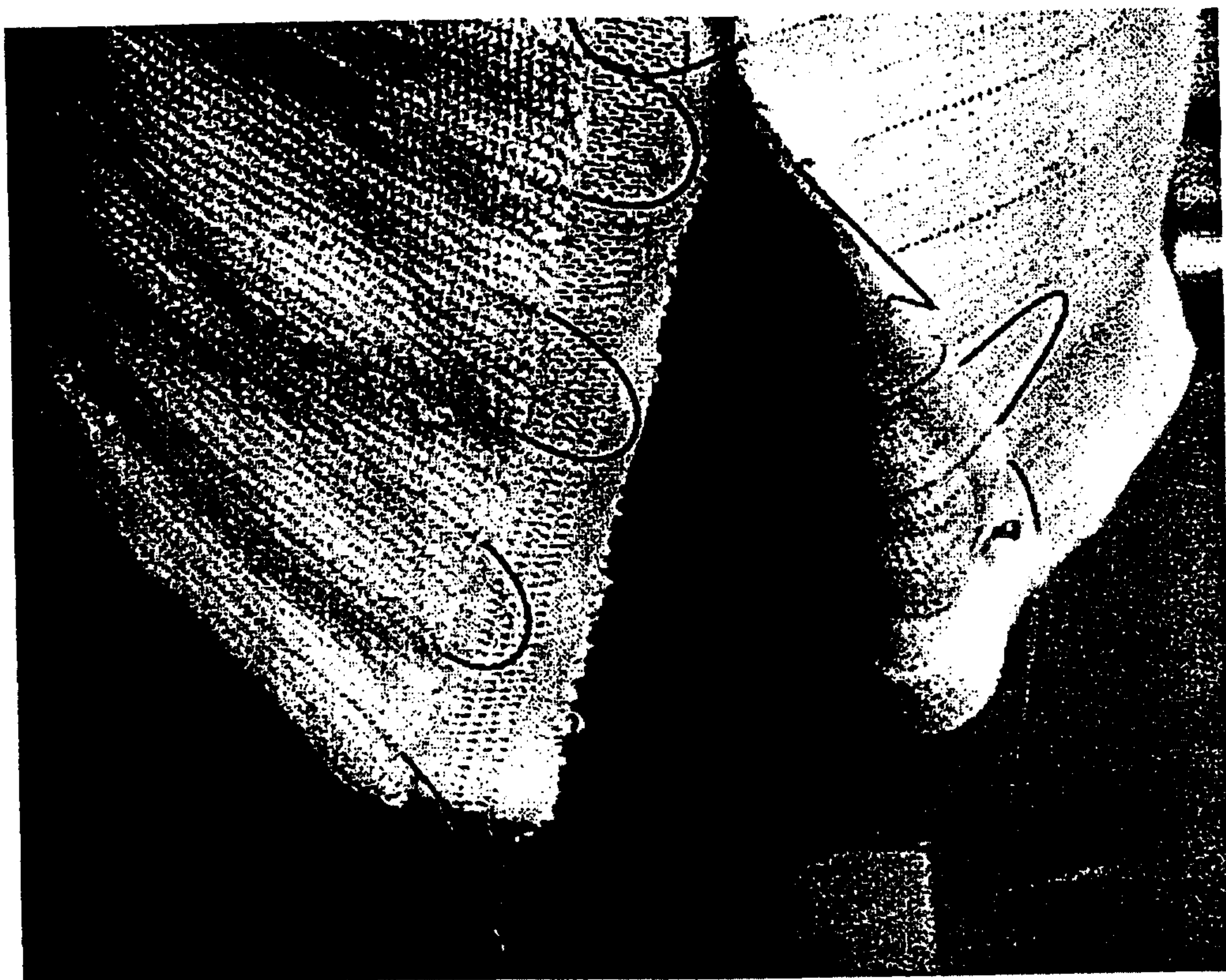


Fig. 20

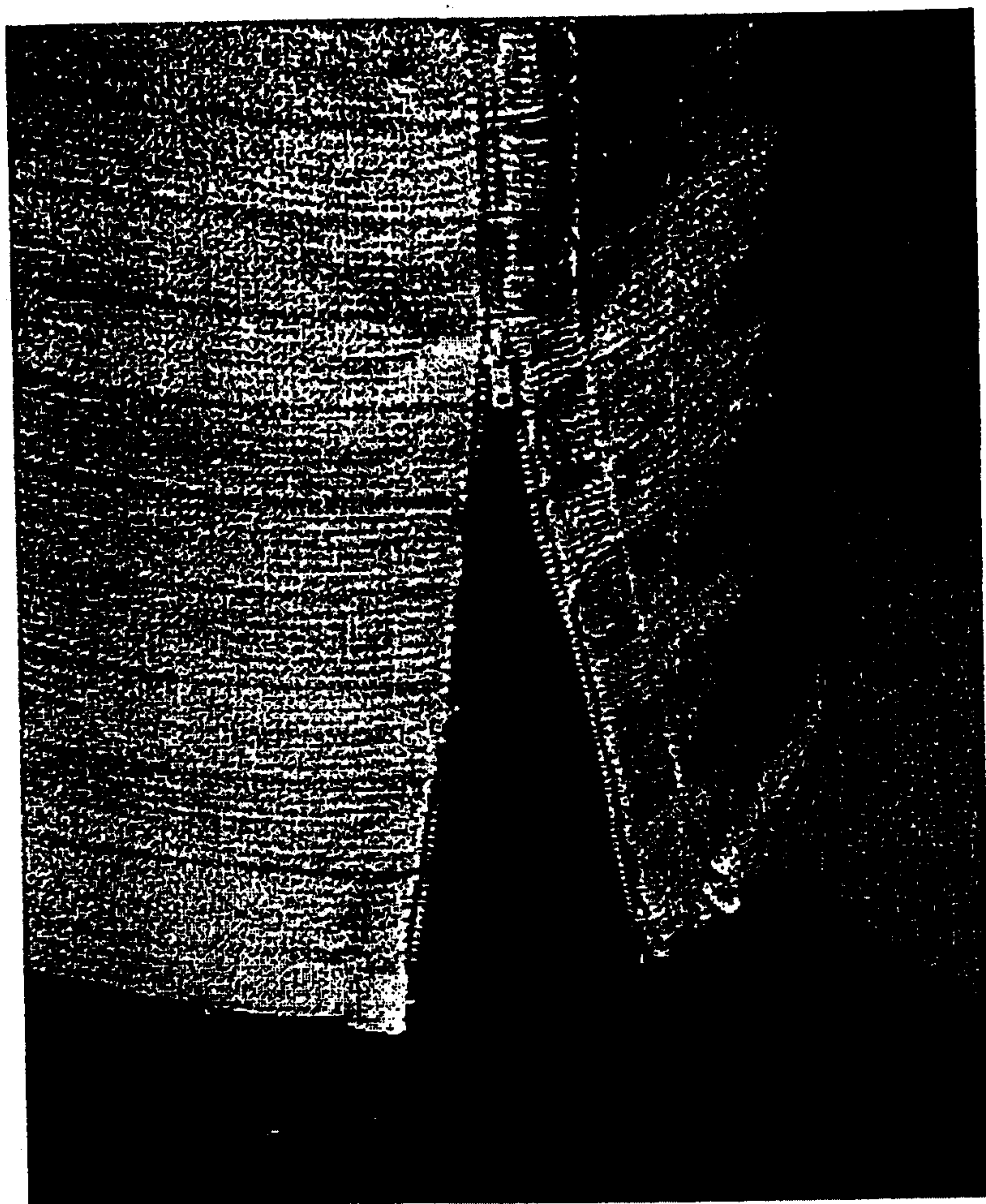


Fig. 21