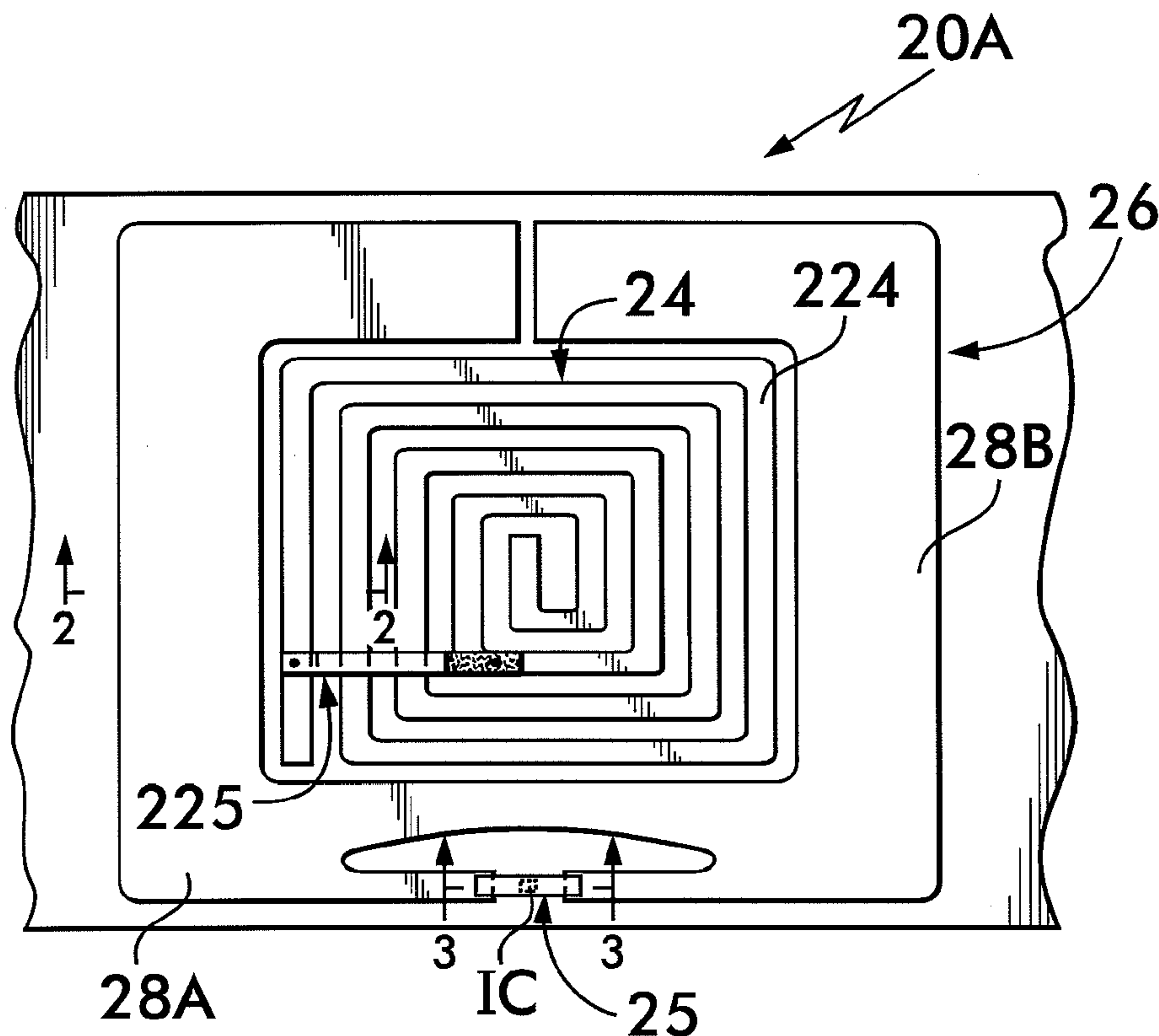




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(54) Titre : ETIQUETTE COMBINANT UN ELEMENT DE SURVEILLANCE D'ARTICLE ELECTRONIQUE (EAS) ET UN
ELEMENT A ULTRAHAUTE FREQUENCE (UHF)
(54) Title: EAS AND UHF COMBINATION TAG



(57) **Abrégé/Abstract:**

A combination EAS and UHF security tag that adds the ability to add item level UHF functionality to a retail tag and maintain the integrity of the EAS systems installed in the business and whereby the EAS and UHF security elements are substantially formed from a common conductive layer. This combination tag also includes the ability to change a tag from a "far-field read" tag to a "near-field read" tag.



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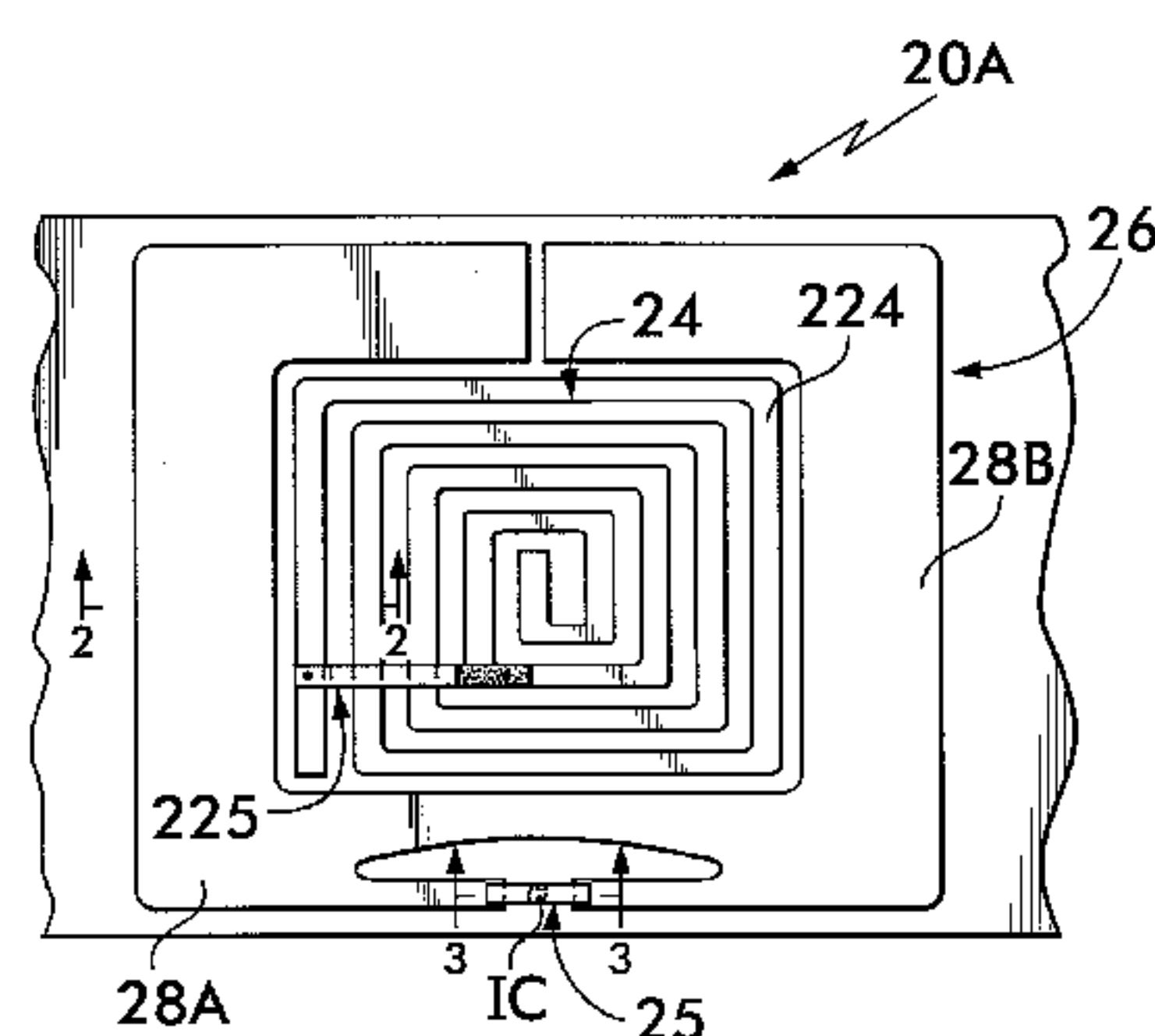
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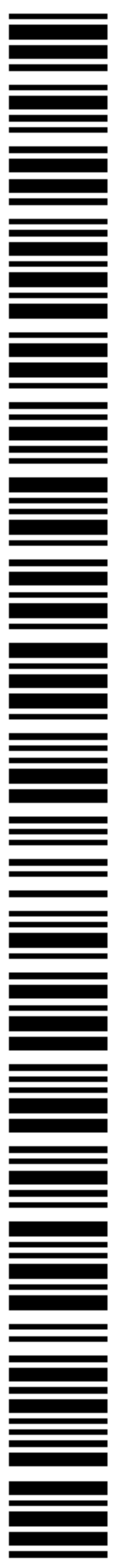
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EAS AND UHF COMBINATION TAG SPECIFICATION

CROSS-REFERENCE TO RELATED APPLICATIONS

This PCT application claims the benefit of both U.S. Utility Application Serial No. 11/955,917 filed on December 13, 2007 and U.S. Provisional Application Serial No. 60/871,016 filed on December 20, 2006 both of which are entitled EAS AND UHF COMBINATION TAG and both of whose entire disclosures are incorporated by reference herein.

BACKGROUND OF THE INVENTION

1. FIELD OF INVENTION

The current invention relates to security tags and more particularly, discloses a combination electronic article surveillance and ultrahigh frequency tag, and method of making the same.

2. DESCRIPTION OF RELATED ART

Tracking or detecting the presence or removal of retail items from an inventory or retail establishment comes under the venue of electronic article surveillance (EAS), which also now includes radio frequency identification (RFID). EAS or RFID detection is typically achieved by applying an EAS or RFID element as part of a security tag to the item or its packaging and when these security tags are exposed to a predetermined electromagnetic field (e.g., pedestals located at a retail establishment exit), they activate to provide some type of alert and/or supply data to a receiver or other detector.

It has become desirable to include two elements on, or in, a single security tag wherein each security element responds to a different interrogator/reader system. By way of example only, two EAS elements, or two RFID elements or an EAS element and an RFID element may be positioned on or in a single security tag. See U.S. Patent Nos. 5,510,769 (Kajfez, et al.); 5,517,195 (Narlow, et al.); and 7,109,867 (Forster). Thus, it may be desirable to read the RFID element of a tag attached to an article for inventory purposes while interrogating the EAS element if the tagged article should be removed from a store exit without having been purchased. Other variations of providing loop/antenna configurations on a single substrate are exemplified by Texas Instrument's Dallas Inlay or Impinj's Propellor.

Commonly-owned U.S. Pat. No. 7,129,843 (Piccoli, et al.) entitled "LC Resonant Circuit with Amplification Device" discloses an amplification shield that surrounds an EAS circuit. Commonly-owned U.S. Application Serial No. 11/540,000 filed Oct. 10, 2006 entitled "Security

Tag for Cigarette Pack” (U.S. Patent Application Publication No. 2007/0146142) discloses a security tag formed from the metal liner of a cigarette pack whereby a security element is surrounded by a metal path. Both of these references are incorporated by reference herein.

However, there remains a need for manufacturing a combined security element that combines EAS with UHF characteristics using the same conductive material, as well providing an enhanced EAS response signal. Furthermore, there remains a need to deactivate the far-field reading capability of a security tag while maintaining a near-field read capability.

All references cited herein are incorporated herein by reference in their entireties.

BRIEF SUMMARY OF THE INVENTION

A security tag comprising an electronic article surveillance (EAS) element and an ultrahigh frequency (UHF) element including an RFID integrated circuit. The UHF element is positioned adjacent the EAS element wherein the UHF element substantially surrounds the EAS element.

A security tag comprising an electronic article surveillance (EAS) element and an ultrahigh frequency (UHF) element having portions that are formed from a common conductive layer.

A method of producing a security tag comprising an electronic article surveillance (EAS) element and an ultrahigh frequency (UHF) element including an RFID integrated circuit. The method comprises: providing a substrate; applying an adhesive to the substrate in a pattern corresponding to the EAS element and to the UHF element; applying a conductive layer to the adhesive; cutting the conductive layer to form a portion of the EAS element and a portion of the UHF element; applying an RFID chip strap to the UHF element and a capacitor strap or a capacitor plate to the EAS element; and electrically coupling the RFID chip strap to the UHF element and the capacitor strap or the capacitor plate to the EAS element.

BRIEF DESCRIPTION OF SEVERAL VIEWS OF THE DRAWINGS

The invention will be described in conjunction with the following drawings in which like reference numerals designate like elements and wherein:

Fig. 1 is a plan view of a first embodiment of a combination EAS/UHF tag that exhibits enhanced EAS response signal characteristics and which shows an EAS security element using a capacitor strap substantially surrounded by an RFID UHF security element;

Fig. 2 is a cross-sectional view of the first embodiment taken along line 2-2 of Fig. 1;

Fig. 3 is a cross-sectional view of the first embodiment taken along line 3-3 of Fig. 1;

Fig. 4 is a plan view of a second embodiment of a combination EAS/UHF tag that is formed to have an integrated dipole configuration with the coil portion of the EAS element;

Fig. 5 is a cross-sectional view of the second embodiment taken along line 5-5 of Fig. 4;

Fig. 6 is a cross-sectional view of the second embodiment taken along line 6-6 of Fig. 4;

Fig. 7 is an equivalent circuit of the combination EAS/UHF tag of Fig. 1;

Fig. 8 is an equivalent circuit of the combination EAS/UHF tag of Fig. 2;

Fig. 8A is an alternative equivalent circuit of the combination EAS/UHF tag of Fig. 4;

Fig. 9 depicts an isometric view of a patterned adhesive applied to a substrate where the patterned adhesive is in the form of combination EAS/UHF tag of Fig. 2;

Fig. 10 depicts a layer of conductive material (e.g., aluminum) that is applied on top of the patterned adhesive to form a laminate;

Fig. 11 is a cross-sectional view of the laminate of Fig. 10 taken along line 11-11 of Fig. 10;

Fig. 12 depicts the layer of conductive material being cut in the form of the patterned adhesive;

Fig. 13 depicts the layer of conductive material that is adhesively secured to the substrate while the portions of the layer of conductive material that are not adhesively secured to the substrate have been removed;

Fig. 14 depicts a laminate comprising a releasably secured upper capacitor plate that is registered for application on top of the formed coil;

Fig. 15 is side view of an application station depicting how the upper capacitor plate is applied to the coil;

Fig. 16 depicts how the upper capacitor plate is crimped in place to form an electrical connection with the coil;

Fig. 17 depicts a laminate comprising a releasably secured chip strap is registered for application on top of the loop antenna;

Fig. 18 is a cross-sectional view taken along line 18-18 of Fig. 17 showing the RFID chip strap positioned on the loop antenna;

Fig. 19 is a cross-sectional view of the RFID chip strap showing it electrically coupled to the loop antenna;

Fig. 20 is a transmitter/receiver system for the combination EAS/UHF tag of Fig. 1;

Fig. 21 is a transmitter/receiver system for the combination EAS/UHF tag of Fig. 2;

Fig. 22 is a third embodiment, which is an alternative version of the second embodiment, of a combination EAS/UHF tag that is formed to have an integrated dipole configuration with the coil portion of the EAS element along with an RFID loop directly coupled to the EAS element;

Fig. 23 is an equivalent circuit of the combination EAS/UHF tag of Fig. 22;

Fig. 24 is a fourth embodiment of a combination EAS/UHF tag that includes an RFID loop directly coupled to an EAS element and also includes a dipole connected to the EAS element via a deactivation element for providing the combination EAS/UHF tag with a far field and near field read capability; and

Fig. 25 is an equivalent circuit of the combination EAS/UHF tag of Fig. 24.

DETAILED DESCRIPTION OF THE INVENTION

The present invention involves the combination of an EAS security element along with an RFID UHF (ultrahigh frequency) security element. The present invention adds the ability to add item level UHF functionality to a retail tag and maintain the integrity of the EAS systems installed in the business. In the past, the goal has been to discard the EAS system and EAS tags and replace these with an entire RFID system and RFID tags. In a first embodiment 20A of the present invention, the close proximity of the RFID UHF security element enhances the response signal of the EAS security element. In a second embodiment 20B of the present invention, an EAS security element, using a coil and capacitor configuration, is augmented by integral dipole antenna elements and substantially surrounds an RFID UHF security element. In both embodiments, the majority of these dual security elements are formed from a common conductive layer, thereby making the production of these dual security elements cost effective.

Conventional EAS security elements include a resonant circuit formed of a capacitor and multi-turn coil which are electrically coupled and are usually tuned to approximately an 8.2 MHz frequency range. RFID security elements include an RFID IC electrically coupled to an antenna tuned to a 13.56 MHz frequency or higher. As the frequency increases, the distance at which a security tag can be detected (also referred to as a "read distance") also increases. Thus, it is desirable to operate the EAS and RFID security elements at higher frequencies, especially at ultrahigh frequencies, UHF, (e.g., 850 MHz - 1200 MHz). Typically the EAS security element and the RFID security element are formed using two independent processes.

Fig. 1 is plan view of a combination EAS/UHF tag 20A that exhibits enhanced EAS response signal characteristics. Fig. 7 is an equivalent circuit of the EAS/UHF tag 20A. In

particular, the tag 20A includes an EAS security element 24 and a UHF security element 26. The EAS security element comprises a coil 224 and capacitor. By way of example only, the capacitor may comprise a capacitor strap 225 that can be electrically connected to the coil 224 to form a resonant circuit; the details of a capacitor strap are disclosed in A.S.N. 11/539,995 filed on October 10, 2006 entitled "Capacitor Strap" and whose entire disclosure is incorporated by reference herein and which is also owned by the same Assignee as the present application, namely, Checkpoint Systems, Inc. Thus, by applying the capacitor strap 225 to the coil 224, the EAS security element is then tuned to a particular frequency range that responds with a characteristic response signal to a corresponding interrogator or reader; by way of example only, the EAS security element 24 may be tuned to approximately 8.2 MHz. The UHF security element 26 includes an RFID integrated circuit (IC), which is implemented as a "chip strap," 25 which is electrically coupled to an antenna, typically a dipole antenna (formed by dipole elements 28A and 28B). Recently, the attachment of the IC has been accomplished by electrically-coupling conductive flanges to respective IC contacts to form the chip strap 25. See for example U.S. Patent Nos. 6,940,408 (Ferguson, et al.); 6,665,193 (Chung, et al.); 6,181,287 (Beigel); and 6,100,804 (Brady, et al.), as well as U.S. A.S.N. 11/539,995, and all of which are incorporated by reference herein.

However, as part of the invention 20A of the present application, it has been determined that by positioning the UHF security element 26 to substantially surround the EAS security element 24 to form the "combination tag", the EAS security element response signal is enhanced and thus can be read or "seen" at a significantly greater distance as compared to the EAS security element response signal without the close proximity of the UHF security element 26. It is believed that the close proximity of the surrounding UHF security element 26 increases the electromagnetic flux applied to the EAS security element 24. Moreover, the surrounding UHF security element 24 acts as static electricity protection to the EAS security element 24 in that static charge tends to discharge through the UHF security element 26, rather than through the EAS security element 24.

In particular, Fig. 20 depicts an EAS transmitter 2 and EAS receiver 4. When the EAS transmitter 2 emits an interrogation signal 6, the EAS/UHF tag response signal 100 can be detected at a much greater distance than a conventional EAS tag. Table 1 sets forth the response data of the EAS security element 24 by itself ("EAS Alone"), the EAS security element 24 with the closely-adjacent UHF security element 26 ("EAS w/Dipole") and the UHF security element

26 by itself (“UHF”). As can be seen from the data, the amplitude of the EAS w/Dipole was increased as compared to the amplitude of the EAS alone. This is manifested in being able to read the EAS security element 24 at a greater distance beyond the near field (e.g., 3-5 feet). Moreover, when compared to the response signal of Checkpoint System Inc.’s “gold standard” (GST), which is Checkpoint’s Series 410 tag, the GST rating of 1 or better was achieved using the combination tag.

Table 1

	EAS Alone				EAS w/Dipole				UHF	
	Freq	Amp	Q	GST	Freq	Amp	Q	GST	Freq	Read Dist
1	8.19	0.36	62.53	0.85	8.21	0.42	59.63	1.00	1150.00	<1 ft
2	8.10	0.40	67.00	0.95	8.14	0.47	69.40	1.13	1150.00	N/R
3	8.03	0.39	68.50	0.95	8.07	0.46	69.90	1.11	1150.00	N/R
4	8.21	0.36	63.34	0.86	8.24	0.42	62.56	1.01	1140.00	<1 ft

Figs. 2-3 depict the construction of the combination tag 20A. As can be seen from Fig. 2, the tag 20A is supported on a carrier or substrate 23 to which the EAS security element 24 is attached. Similarly, the dipole elements 28A/28B of the UHF security element 26 are also secured to the carrier or substrate 23. Fig. 3 shows how the chip strap 25 is coupled across a gap G between the dipole elements 28A and 28B. It should be understood that the formation of the EAS security element 24 and UHF security element 26 of the combination tag 20A is similar to the formation of the combination EAS/UHF tag 20B to be discussed next. In addition, the formation of the EAS security element 24 individually and the UHF security element 26 individually are shown in A.S.N.11/400,932 filed on April 10, 2006 entitled “Transfer Tape Strap Process” and whose entire disclosure is incorporated by reference herein.

It should be noted that the advantage of the combination tag 20A over commonly-owned U.S. Patent No. 7,129,843 (Piccoli, et al.) and U.S. Patent Application Publication No. 2007/0146142 (both mentioned previously) is, among other things, the creation of two security elements (e.g., an RFID dipole and EAS resonant circuit) from common layers while effecting the enhancement of the EAS circuit response signal. As mentioned previously, this provides a large benefit to customers by making the overall security tag adaptable for different detection systems.

Fig. 4 depicts a combination EAS/UHF tag 20B whereby an EAS security element 124, using a coil 126 and capacitor 128 configuration, is augmented by integral dipole antenna elements 125A and 125B, and all of which are formed from a common conductive layer. Unlike the first embodiment 20A where enhancement of the EAS circuit response signal is one of the

key features of that embodiment, the important feature of the EAS/UHF tag 20B is the construction of a dual tag (EAS and RFID) using common layers of material. Fig. 8 is an equivalent circuit of the EAS/UHF tag 20B. In particular, the dipole elements 125A/125B are integrally-formed with a coil 126. The capacitor 128 is formed by one of the dipole elements 125A and an additional capacitor plate 128A which is positioned over the dipole element 125A with a dielectric disposed between dipole element 125A and the plate 128A. An RFID IC is electrically coupled to a loop antenna 130 that is also positioned closely adjacent the EAS security element 124 inside an area 133 defined by end portions of the elements 125A/125B and the coil 126. By itself, the loop antenna 130 is tuned to a first UHF frequency (e.g., 700 MHz). However, by positioning the EAS security element 124 closely adjacent the loop antenna 130, the RFID signal emitted by the loop antenna 130 is enhanced (e.g., the loop antenna 130 is tuned to a higher frequency, e.g., 860 – 950 MHz range), thereby being readable at a farther distance. Fig. 21 depicts an EAS transmitter 3 and EAS receiver 5. When the EAS transmitter 2 emits an interrogation signal 7, the EAS security element 124 responds to the tuned frequency by emitting response signal 9. When an RFID reader signal 11 is emitted, the UHF security element provides a response signal 13 to the RFID reader. Table 2 depicts the characteristic of this embodiment 20B.

Table 2

	EAS				UHF		
	Freq	Amp	Q	QSI	Freq	Read Dist	Read on Parch
1	8.1115	0.35	52.3	0.86	884	11	16
2	8.49	0.35	50.2	0.86	901	15	20
3	8.194	0.35	54.3	0.85	899	18	20
					Free Air	Parchment Box	
						Dist in feet	

Figs. 5-6 depict the construction of the combination tag 20B. As can be seen from Fig. 5, the tag 20B is supported on a carrier or substrate 123 to which the EAS security element 124 is attached. Similarly, the loop antenna 130 is also secured to the carrier or substrate 123. Fig. 6 shows how the chip strap 25 is coupled across a gap G between the loop antenna ends 131A and 131B.

Fig. 8A is an equivalent circuit of another similar embodiment.

The formation of the combination EAS/UHF tag 20B is shown in Figs. 9-19. In particular, a patterned adhesive 300 (Fig. 9) is initially applied to the substrate layer 123. Next, as shown in Figs. 10-11, a conductive layer 302 (e.g., aluminum) is applied on top of the

patterned adhesive 300. As shown in Fig. 12, the conductive layer 302 is cut into the shape of the patterned adhesive 300. The portion of the conductive layer 302 under which there is no patterned adhesive 300 is removed, thereby leaving the desired coil 126 and partial capacitor 128 configuration, augmented by the integral dipole antenna elements 125A and 125B, as shown in Fig. 13. To complete the combination tag 20B is to position the upper capacitor plate 128 over a portion of the dipole element 125A and to couple the chip strap 25 to the loop antenna 130. Fig. 14 depicts a web 304 comprising a plurality (only one of which is shown) of capacitor plates 128A. The web 304 is positioned such that one capacitor plate 128 is registered properly with a portion of the dipole antenna element 125A. It should be noted that the capacitor plate 128A comprises a first adhesive layer 306, a conductive layer 308 and a second adhesive layer 310. The first adhesive layer 306 makes direct contact with the portion of the dipole antenna 125A and acts as the dielectric layer of the capacitor 128. The conductive layer 308 forms the actual "other plate" of the capacitor 128. The second adhesive layer 310 releasably secures the capacitor plate 128A to the web 300 prior to its application to the portion of the dipole antenna 125A.

As can be seen in Fig. 15, a roller 312 (rotating counterclockwise) applies pressure against the back side of the web 300 to release the capacitor plate 128A from the web 300 and to apply it to the dipole portion 125A. Because the first adhesive layer 306 comprises a stronger adhesive than the second adhesive layer 310, upon application of pressure by the roller 312, the capacitor plate 128A disengages from the web 300. At this point, one end of the conductive layer 308 needs to be electrically coupled to the coil 126. To that end, as shown in Fig. 16, a crimp (or hot stamp, etc.) is applied to form an electrical connection between one end 314 (Fig. 14) of the capacitor plate 128A and a conductive terminal 316 (also Fig. 14) on the coil 126. As a result, the capacitor 128 is formed.

The remaining step is to couple the chip strap 25 to the loop antenna 130. As shown in Fig. 17, a web 318 comprising a plurality (only one of which is shown) of chip straps 25 is positioned such that one chip strap 25 is registered properly with loop antenna ends 131A/131B. It should be noted that the chip strap 25 comprises a first adhesive layer 320 (as shown most clearly in Fig. 19), conductive elements 322A/322B and a second adhesive layer 324. The first adhesive layer 320 makes direct contact with the loop antenna ends 131A/131B. The conductive elements 322A/322B form the conductive extensions of the IC of the chip strap 25. The second

adhesive layer 310 releasably secures chip strap 25 to the web 318 prior to its application to the loop antenna ends 131A/131B.

As can be seen in Fig. 18, a roller 326 (rotating counterclockwise) applies pressure against the back side of the web 318 to release the chip strap 25 from the web 318 and to apply it to the loop antenna ends 131A/131B. Because the first adhesive layer 320 comprises a stronger adhesive than the second adhesive layer 324, upon application of pressure by the roller 326, the chip strap 25 disengages from the web 318. At this point, the conductive elements 322A/322B need to be electrically coupled to the loop antenna ends 131A/131B, respectively. To that end, as shown in Fig. 19, a hot weld/crimp is applied to form an electrical connection between the respective conductive element (322A and 322B) and its corresponding loop antenna end (131A and 131B). As a result, the RFID loop antenna 130 is formed.

Fig. 22 depicts a third embodiment which is an alternative version 20B' of the combination EAS/UHF tag 20B whereby an EAS security element 124, using a coil 126 and capacitor 128 configuration, is augmented by integral dipole antenna elements 125A and 125B, and the RFID loop 130 and all of which are formed from a common conductive layer. Fig. 23 is an equivalent circuit of the EAS/UHF tag 20B'. Every aspect of the alternative version 20B' is the same with regard to the second embodiment 20B, as described previously. The only difference is that the loop antenna 130 is directly coupled with the coil 126 via bridges 402 and 403. In addition, the formation of the alternative version 20B' would include the bridges 402/403 in Figs. 9-10 and 12-13.

It should be understood that the order in which the capacitor plate 128 and the chip strap 25 are applied does not limit the method of the present invention; either one could be applied first or substantially simultaneously.

Figs. 24-25 depict a fourth embodiment 20C whereby a security tag is deactivatable from a far-field configuration to a near field configuration. This provides a large advantage to customers in that an item returned to a store should not set off security alarms but should provide the return desk with item/pricing information when the tag is scanned at the return desk. Thus, by deactivating the far field mechanism, the security tag prevents alarms from going off but still allows the tag to be interrogated for its item ID and pricing.

In particular, as shown in Fig. 24, the fourth embodiment 20C has some similarity to the third embodiment in that it comprises an RFID loop 530, an EAS security element 524 (having a coil 526 and a capacitor formed from plates 528 and 528A) and dipole elements 525A and

525B. However, unlike the third embodiment 20B', the dipole elements 525A and 525B are not integrally formed with the EAS security element coil 526; instead, a deactivation element 527 (e.g., a fuse, a dimple, or any other type of mechanism that can operate to disconnect) forms a portion of the EAS security element coil 526 that connects to the dipole elements 525A/525B. During normal operation when the combination EAS/UHF tag 20C is exposed to the interrogation field (UHF frequency range), the response signal including the RFID content can be read 3-4 meters (approximately 15-20 ft) away which is considered "far-field". However, if the tag should be exposed to a deactivation field such the deactivation element 527 is operative, the dipole elements 525A and 525B are removed from the response signal transmission, thereby relying simply on the EAS security element 524 to transmit the response signal. The read distance via the EAS security element including the RFID content is approximately 1 foot which is considered the "near field."

While the invention has been described in detail and with reference to specific examples thereof, it will be apparent to one skilled in the art that various changes and modifications can be made therein without departing from the spirit and scope thereof.

CLAIMS

WHAT IS CLAIMED IS:

1. A security tag comprising an electronic article surveillance (EAS) element and an ultrahigh frequency (UHF) element including a radio frequency identification (RFID) integrated circuit, said UHF element being positioned adjacent said EAS element wherein said UHF element substantially surrounds said EAS element.
2. The security tag of Claim 1 wherein said UHF element comprises two dipole antenna elements, said dipole antenna elements being positioned to be substantially contiguous around said EAS element.
3. The security tag of Claim 2 wherein said EAS element comprises a coil and a capacitor configuration.
4. The security tag of Claim 2 wherein said EAS element comprises a rectangular shape and wherein said dipole elements are configured to correspond to said rectangular shape.
5. A security tag comprising an electronic article surveillance (EAS) element and an ultrahigh frequency (UHF) element having portions that are formed from a common conductive layer.
6. The security tag of Claim 5 wherein said EAS element comprises a coil and a capacitor circuit having dipole antenna elements integrated with said coil portion and wherein said UHF element comprises a loop antenna including a radio frequency identification (RFID) integrated circuit, said UHF element being positioned closely adjacent said coil.
7. The security tag of Claim 6 wherein said dipole antenna elements comprise end portions that face each other and, along with said coil, define an area in which said UHF element is positioned closely adjacent said coil.
8. The security tag of Claim 5 wherein said UHF element is connected to said coil.
9. The security tag of Claim 5 wherein said EAS element comprises a coil and a capacitor circuit having dipole antenna elements connected to said coil portion via a deactivation element and wherein said UHF element comprises a loop antenna including a radio frequency identification (RFID) integrated circuit, said UHF element being connected to said coil.
10. The security tag of Claim 9 wherein said deactivation element is a fuse.
11. A method of producing a security tag comprising an electronic article surveillance (EAS) element and an ultrahigh frequency (UHF) element including an RFID integrated circuit, said method comprising:

providing a substrate;
applying an adhesive to said substrate in a pattern corresponding to the EAS element and to the UHF element;
applying a conductive layer to said adhesive;
cutting said conductive layer to form a portion of said EAS element and a portion of said UHF element;
applying an RFID chip strap to said UHF element and a capacitor strap or a capacitor plate to said EAS element; and
electrically coupling said RFID chip strap to said UHF element and said capacitor strap or said capacitor plate to said EAS element.

12. The method of Claim 11 wherein said portion of said EAS element comprises a coil to which said capacitor strap is electrically coupled.

13. The method of Claim 12 wherein said portion of said UHF element comprises dipole elements that are electrically coupled to said RFID chip strap.

14. The method of Claim 11 wherein said portion of said EAS element comprises a coil having integrated dipole elements, said capacitor plate being electrically coupled to said coil.

15. The method of Claim 14 wherein said portion of said UHF element comprises a loop having a pair of open ends, said ends being electrically coupled to said RFID chip strap.

16. The method of Claim 11 wherein said step of applying an adhesive to said substrate in a pattern corresponding to the EAS element and to the UHF element comprises applying said adhesive such that said UHF element is closely adjacent said EAS element.

17. The method of Claim 14 wherein said step of applying an adhesive to said substrate in a pattern corresponding to the EAS element and to the UHF element comprises applying said adhesive in the form of open ended extensions to form said integrated dipole elements.

18. The method of Claim 17 wherein said coil and said open ended extensions define an area in which said UHF element is positioned.

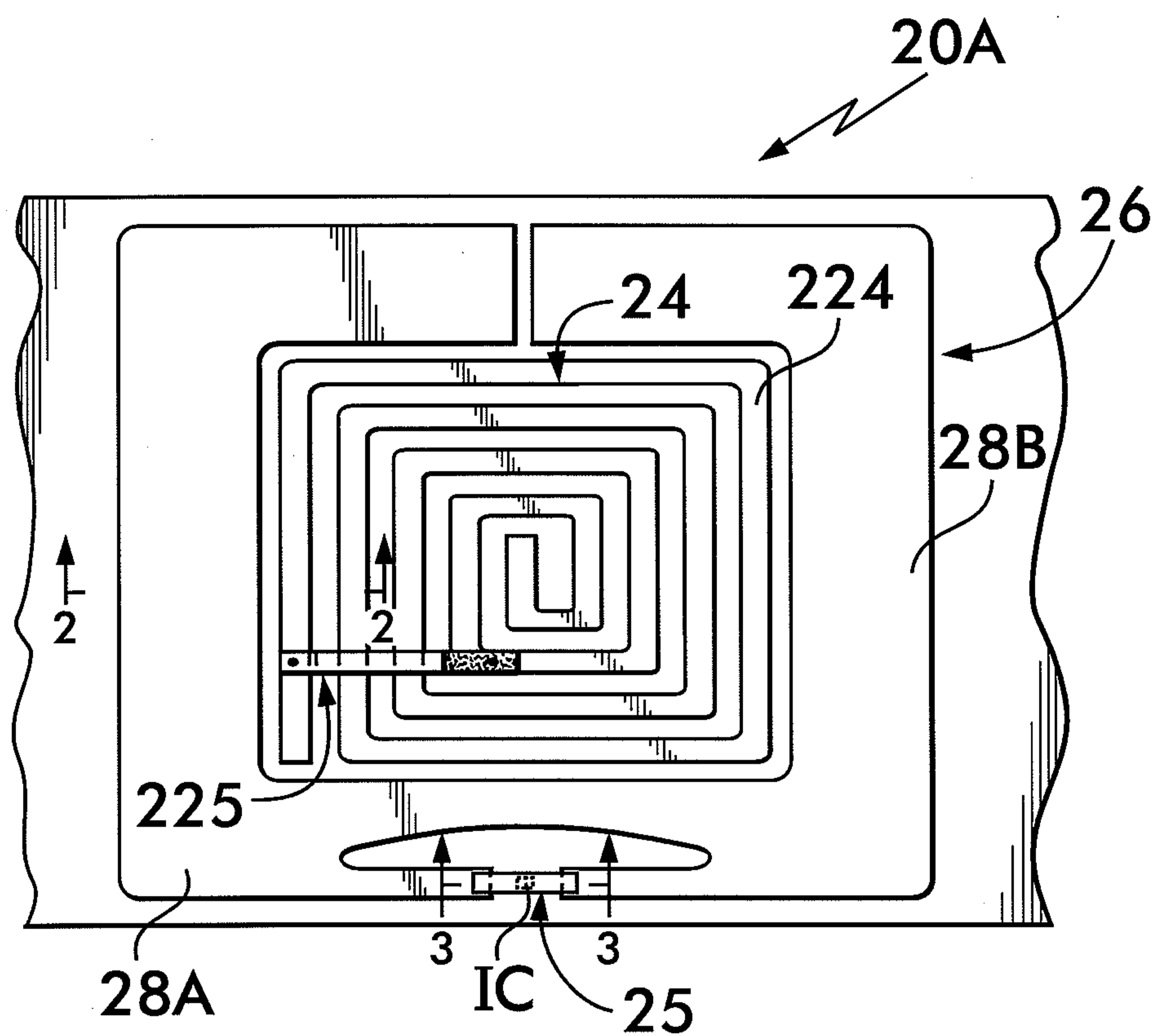
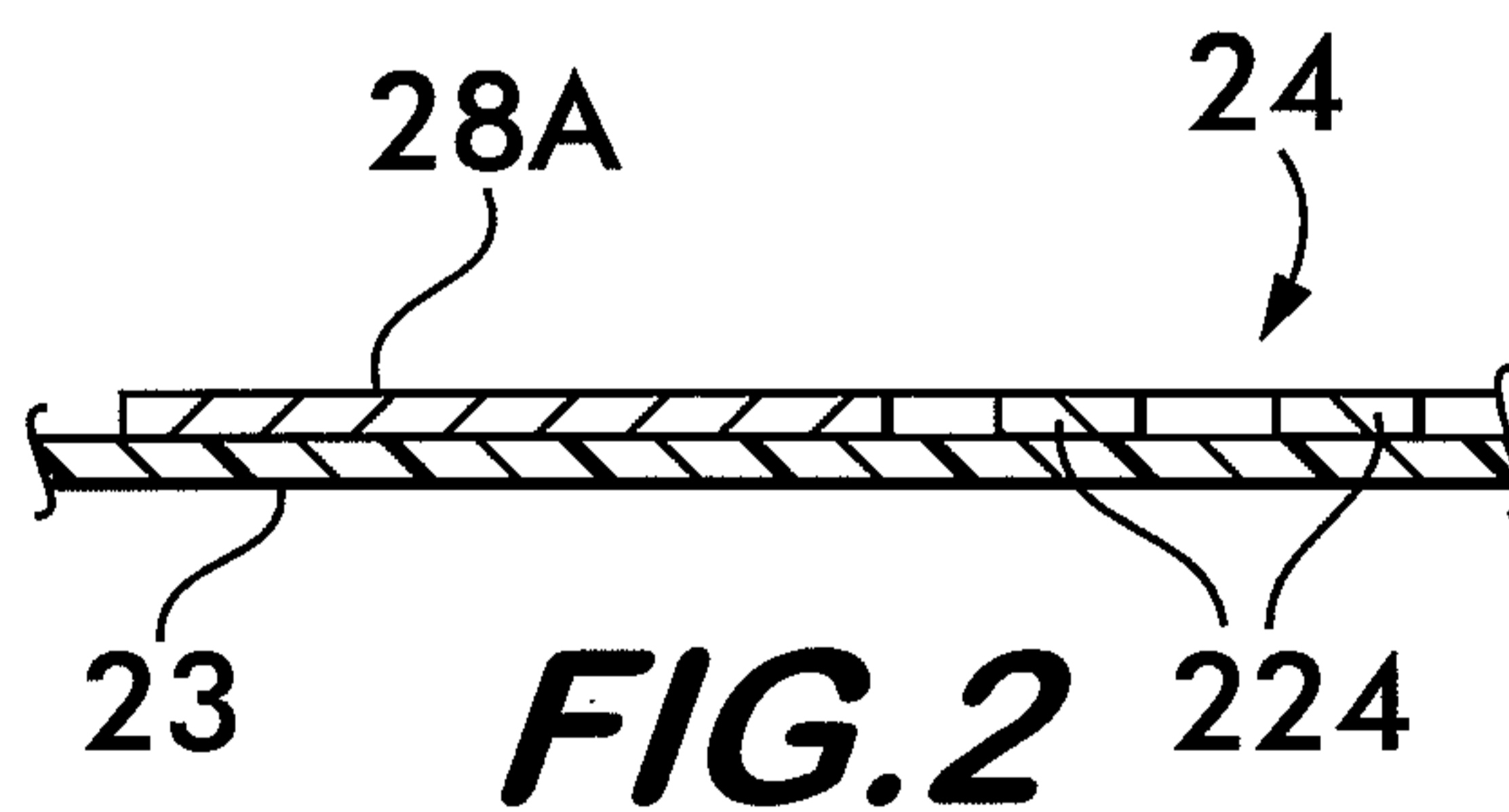
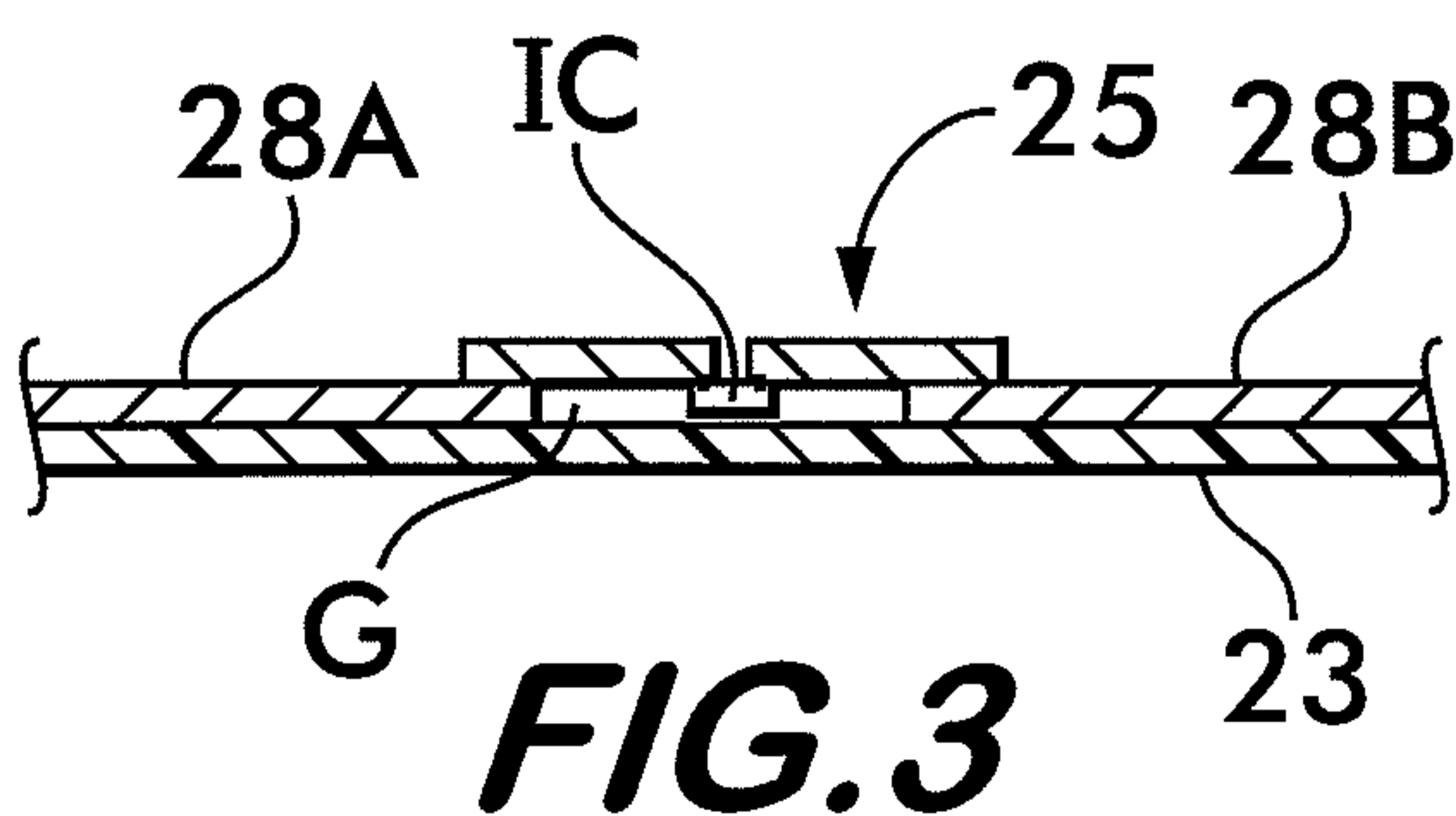
19. The method of Claim 11 wherein said step of applying an adhesive to said substrate in a pattern corresponding to the EAS element and to the UHF element comprises applying said adhesive in the form of a coil and in the form of a band that substantially surrounds said adhesive in the form of said coil.

20. The method of Claim 11 wherein said step of applying an adhesive to said substrate in a pattern corresponding to the EAS element and to the UHF element comprises applying said adhesive such that said UHF element is connected to said EAS element.

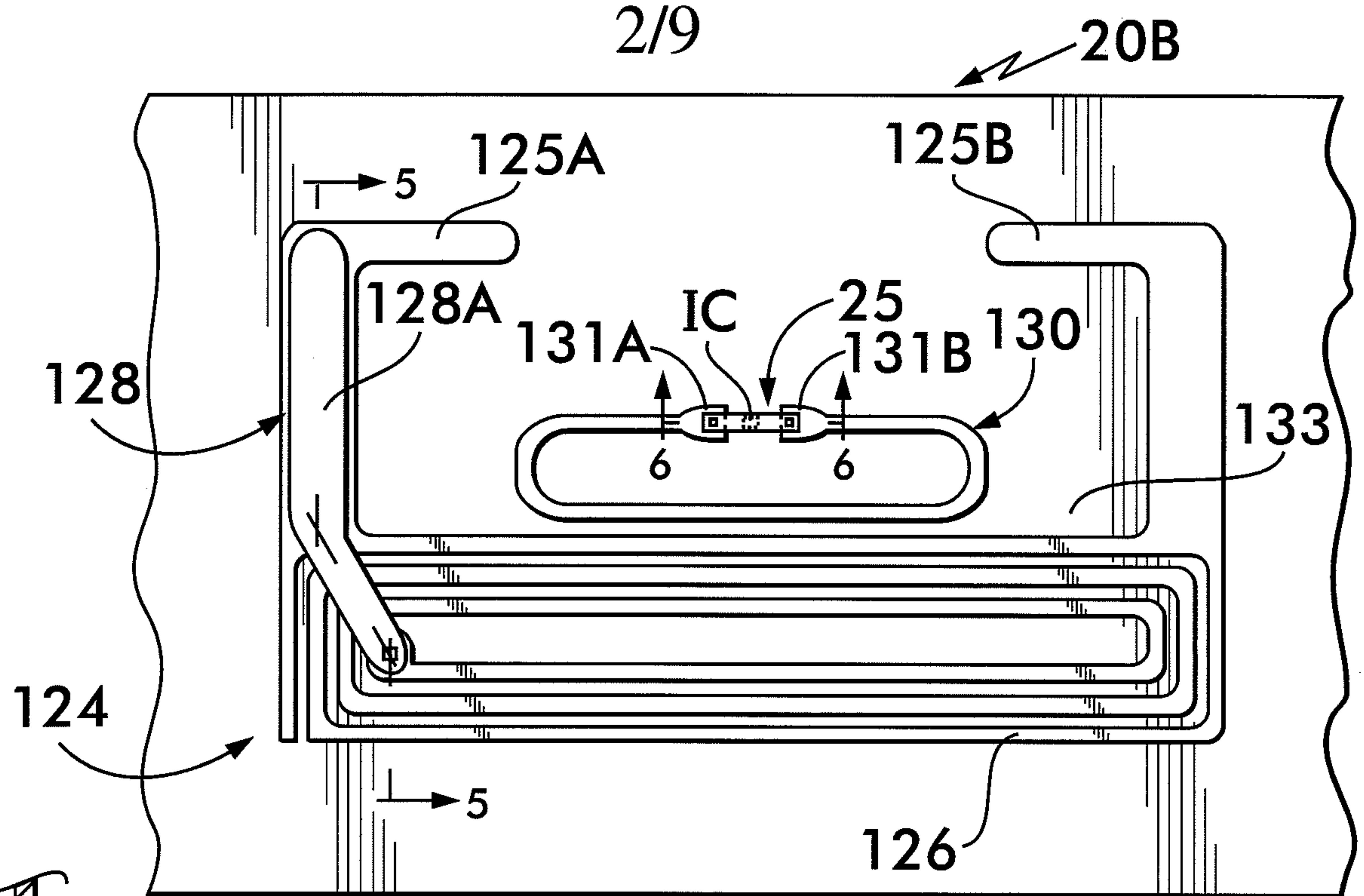
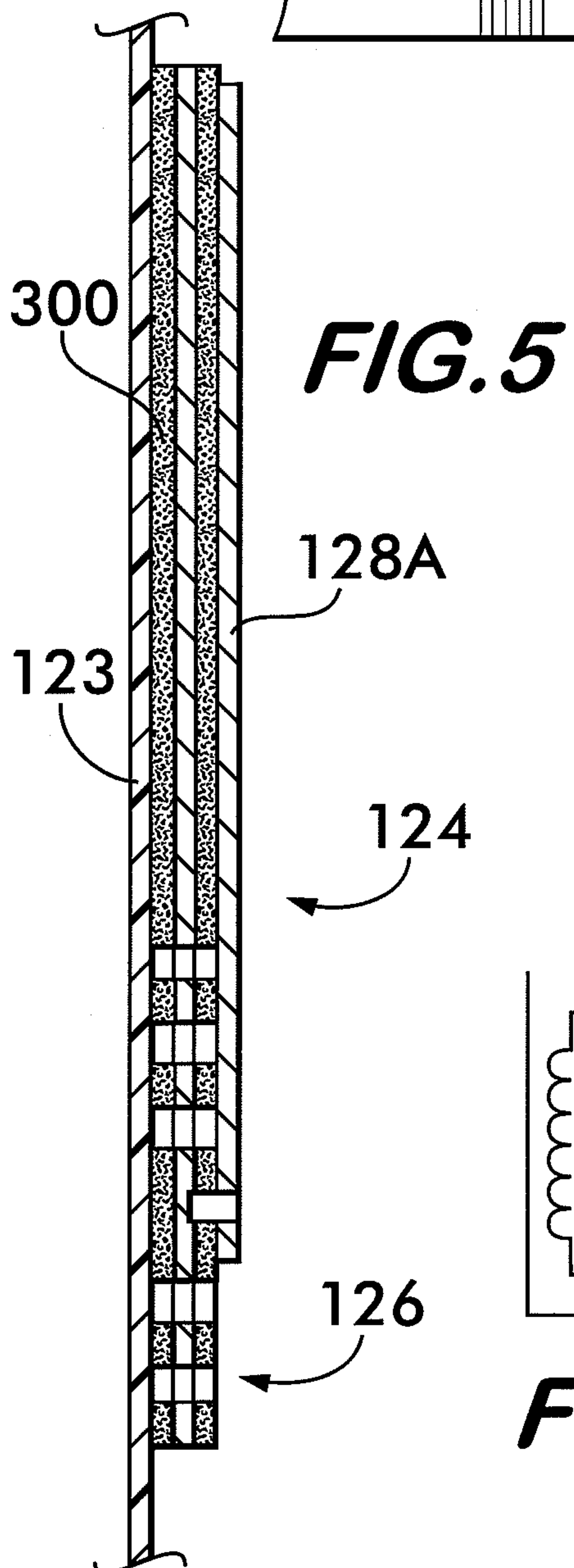
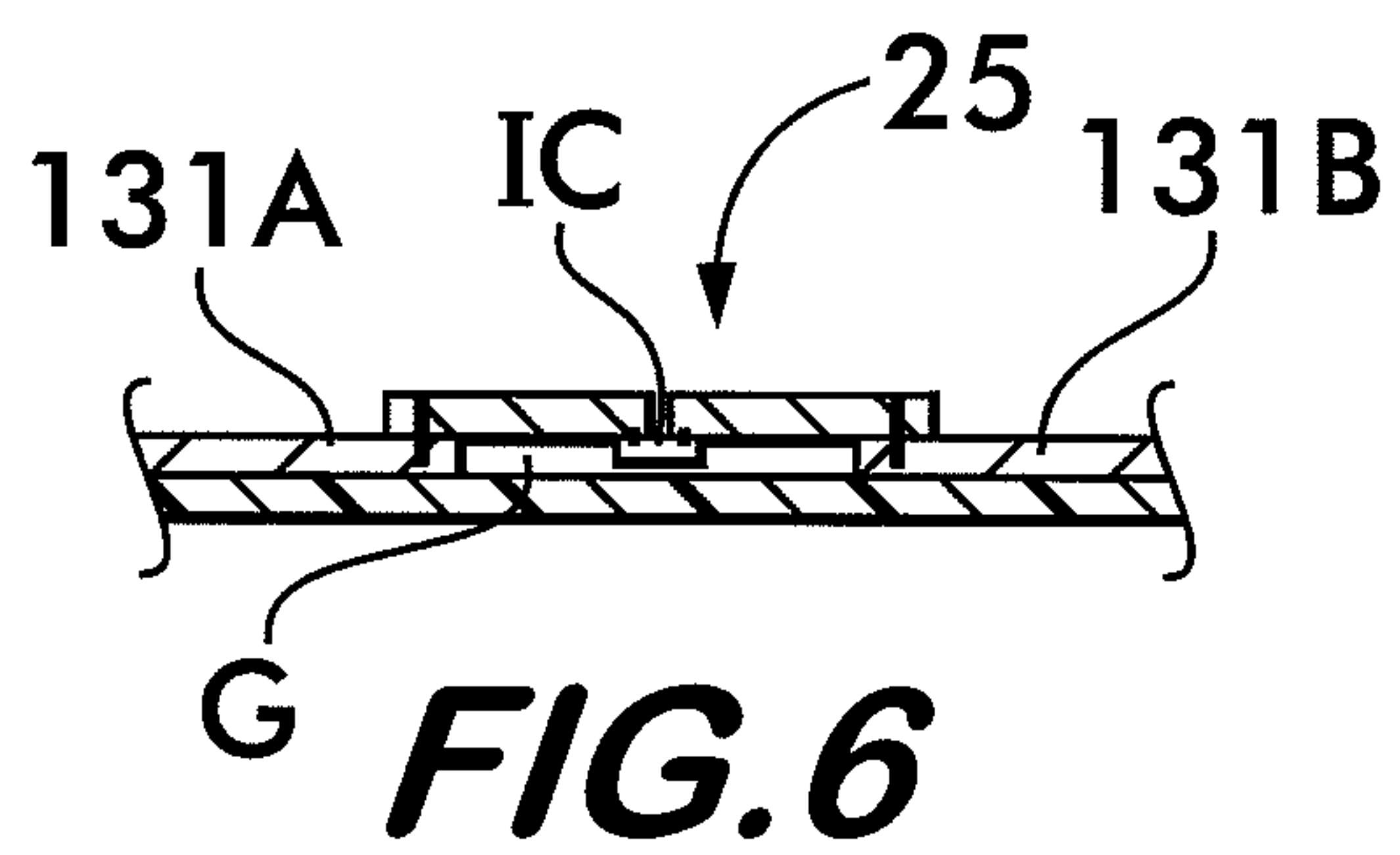
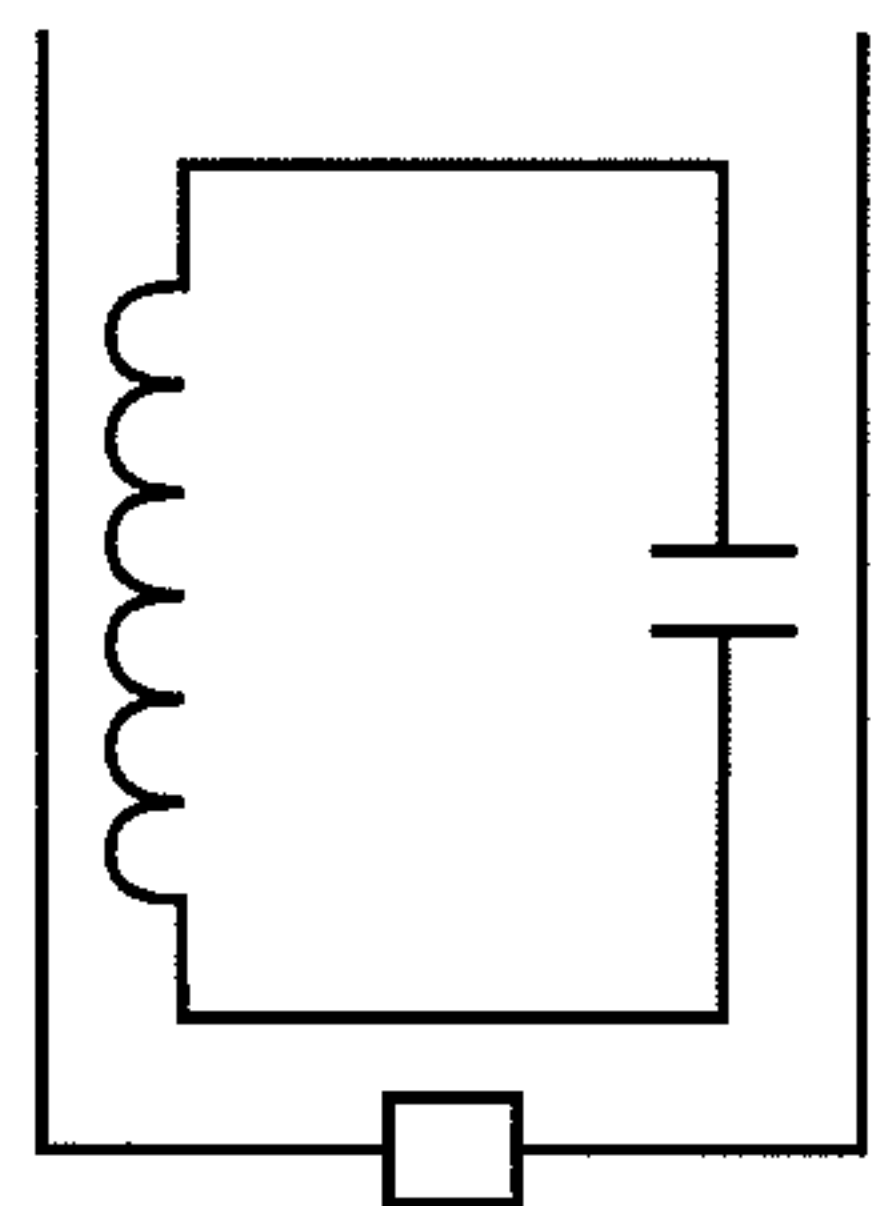
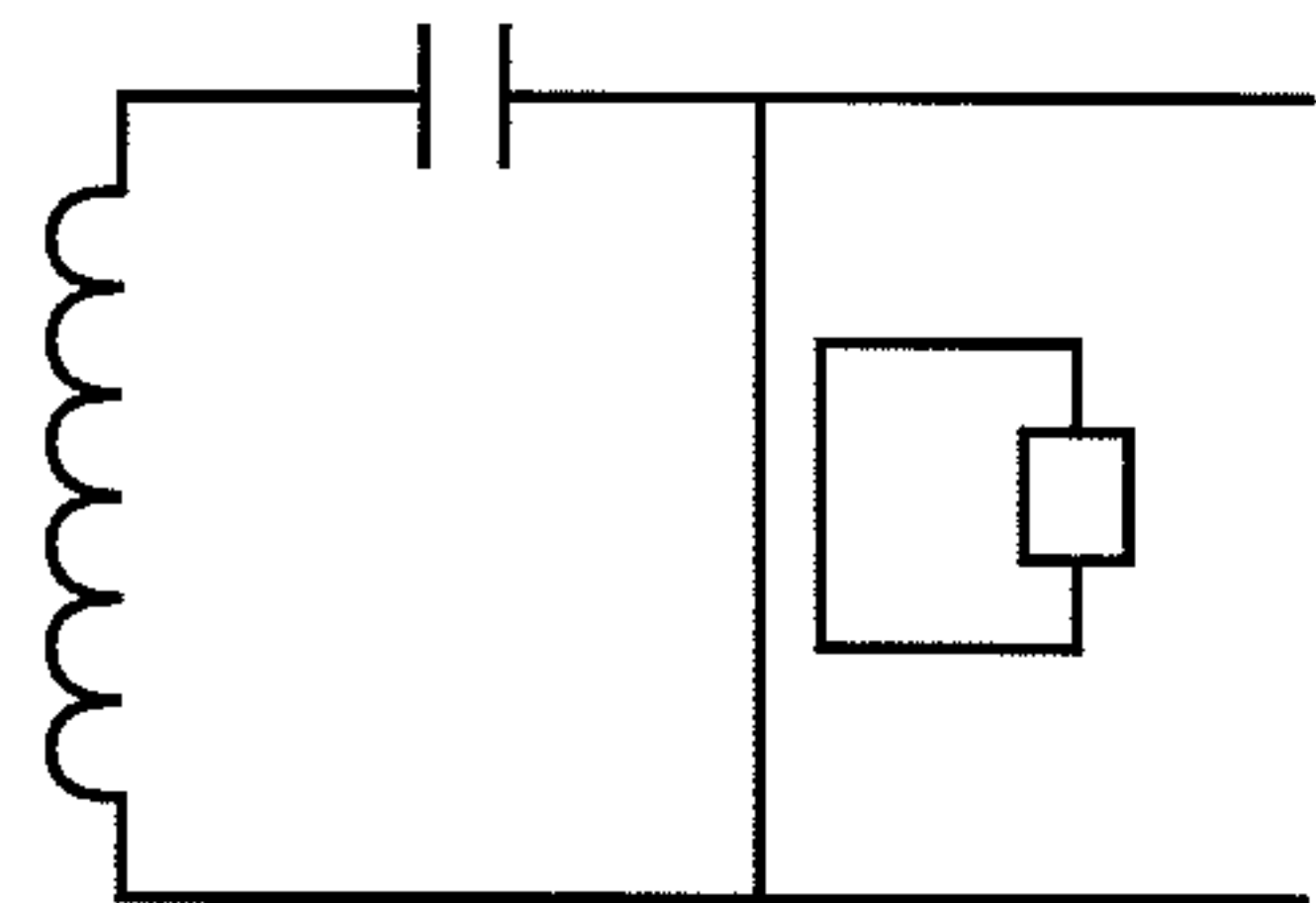
21. The method of Claim 11 wherein said step of cutting said conductive layer to form a portion of said EAS elements comprises including a deactivation element in said EAS element.

22. The method Claim 21 wherein said EAS element comprises a coil and wherein said deactivation element is a fuse.

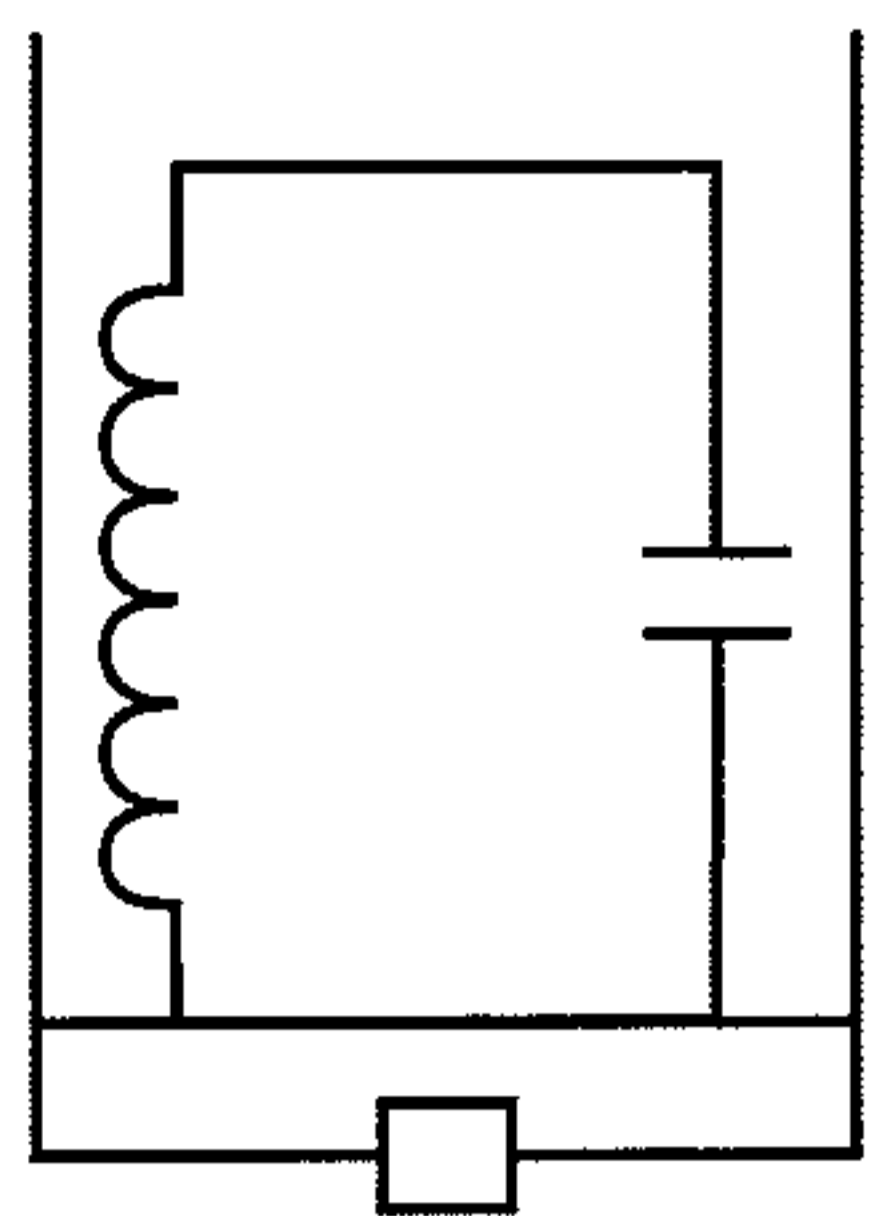
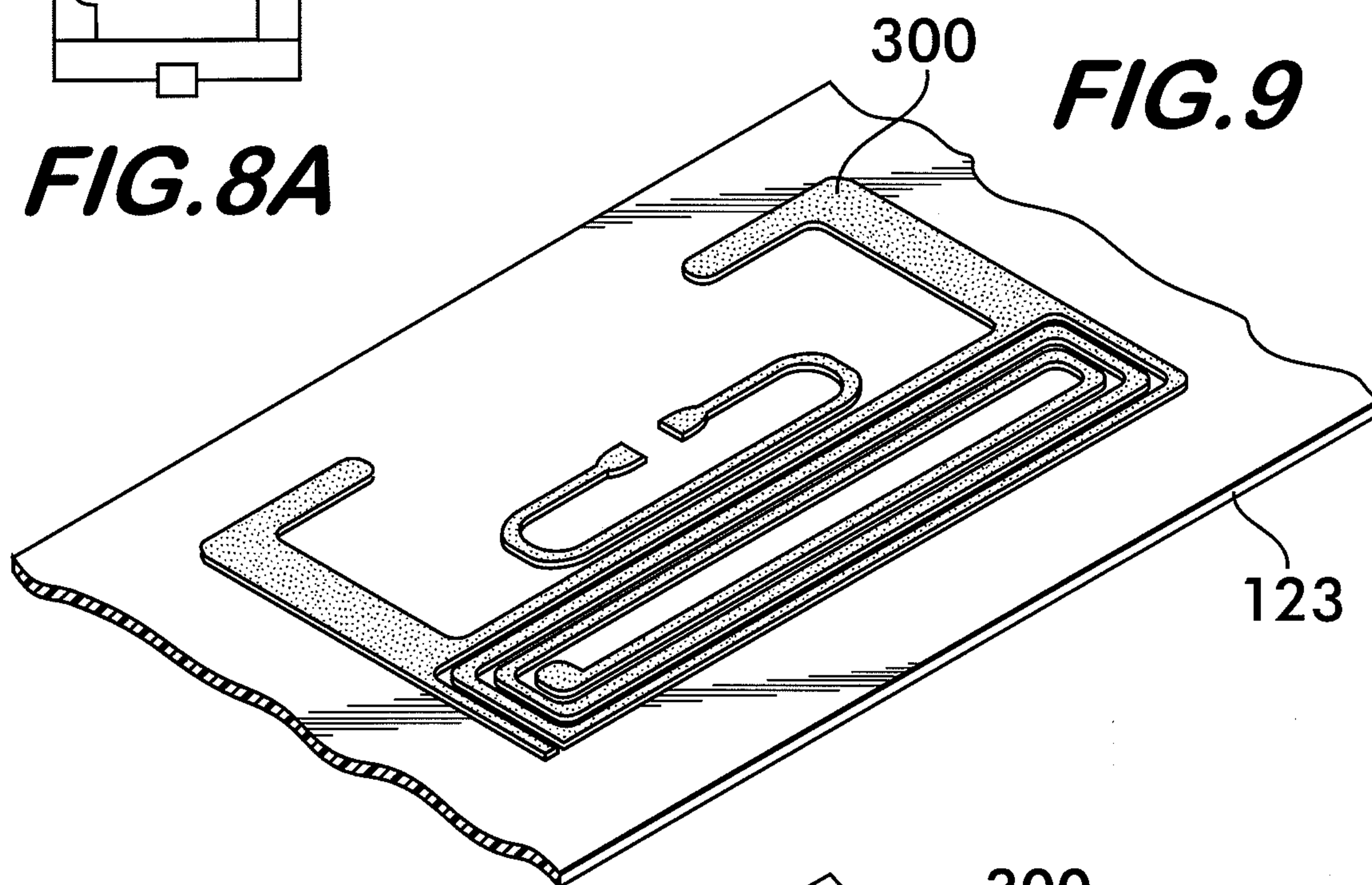
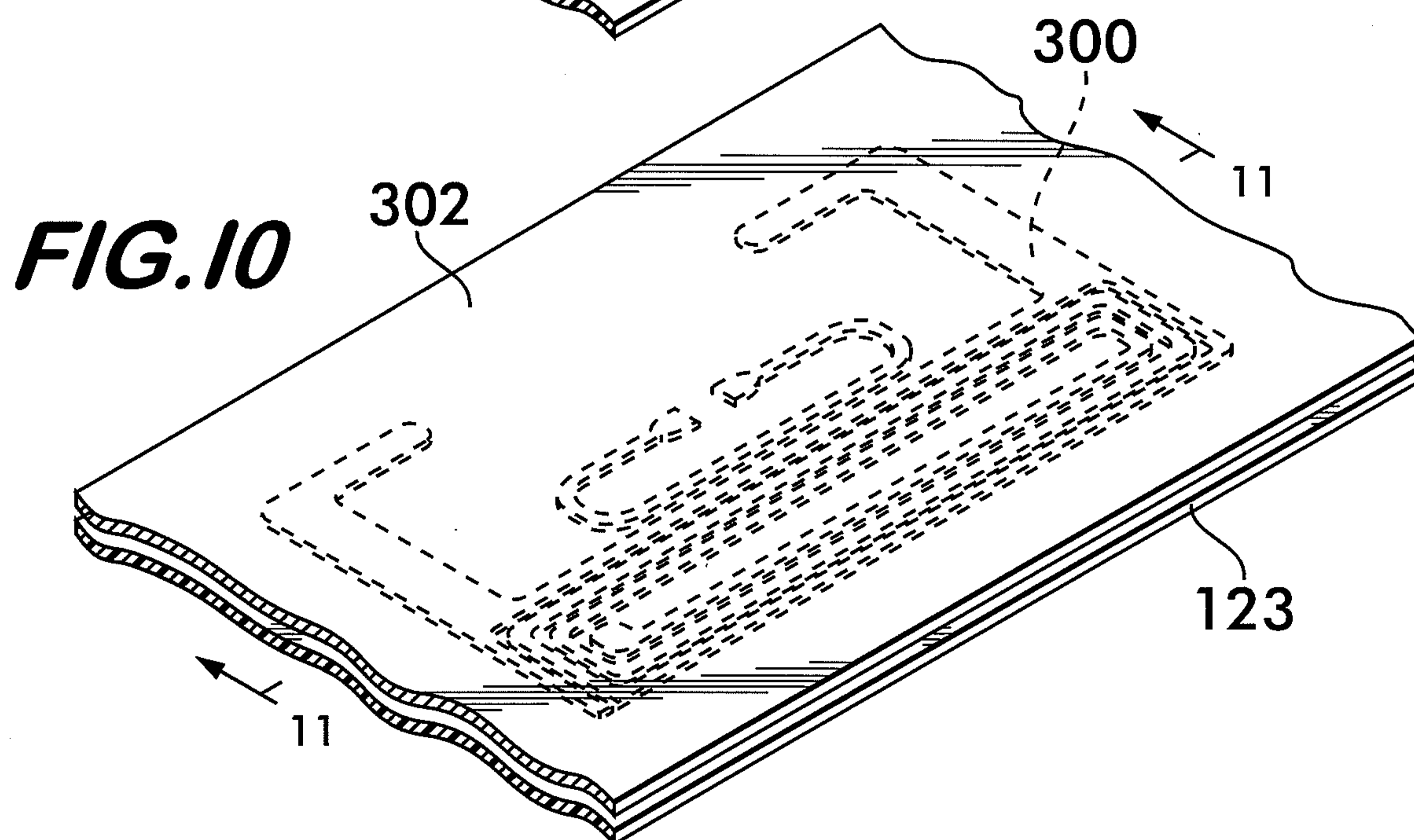
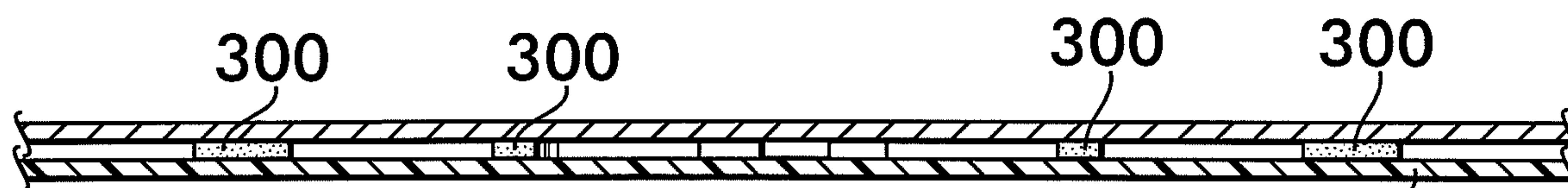
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**FIG. 1****FIG. 2****FIG. 3**

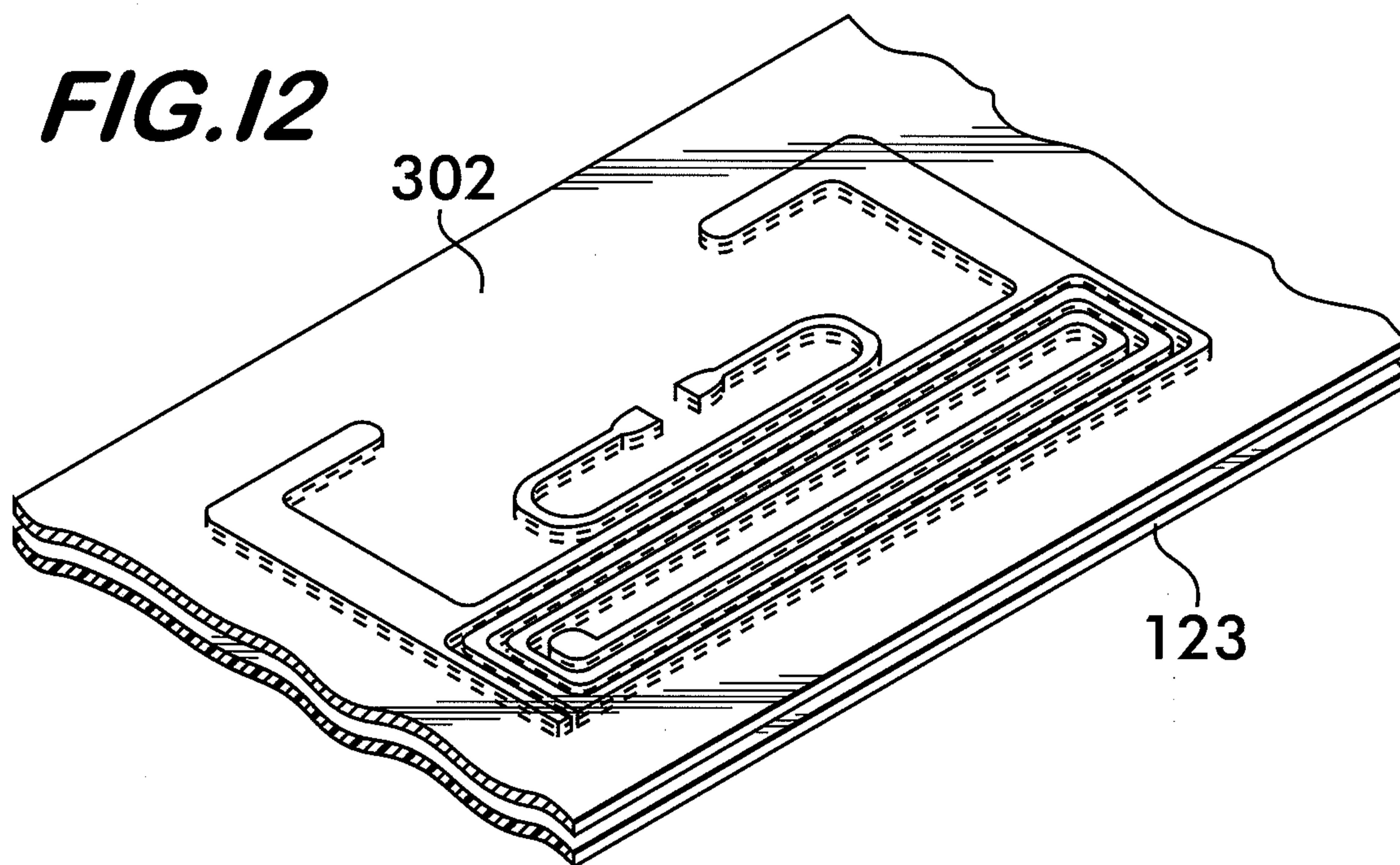
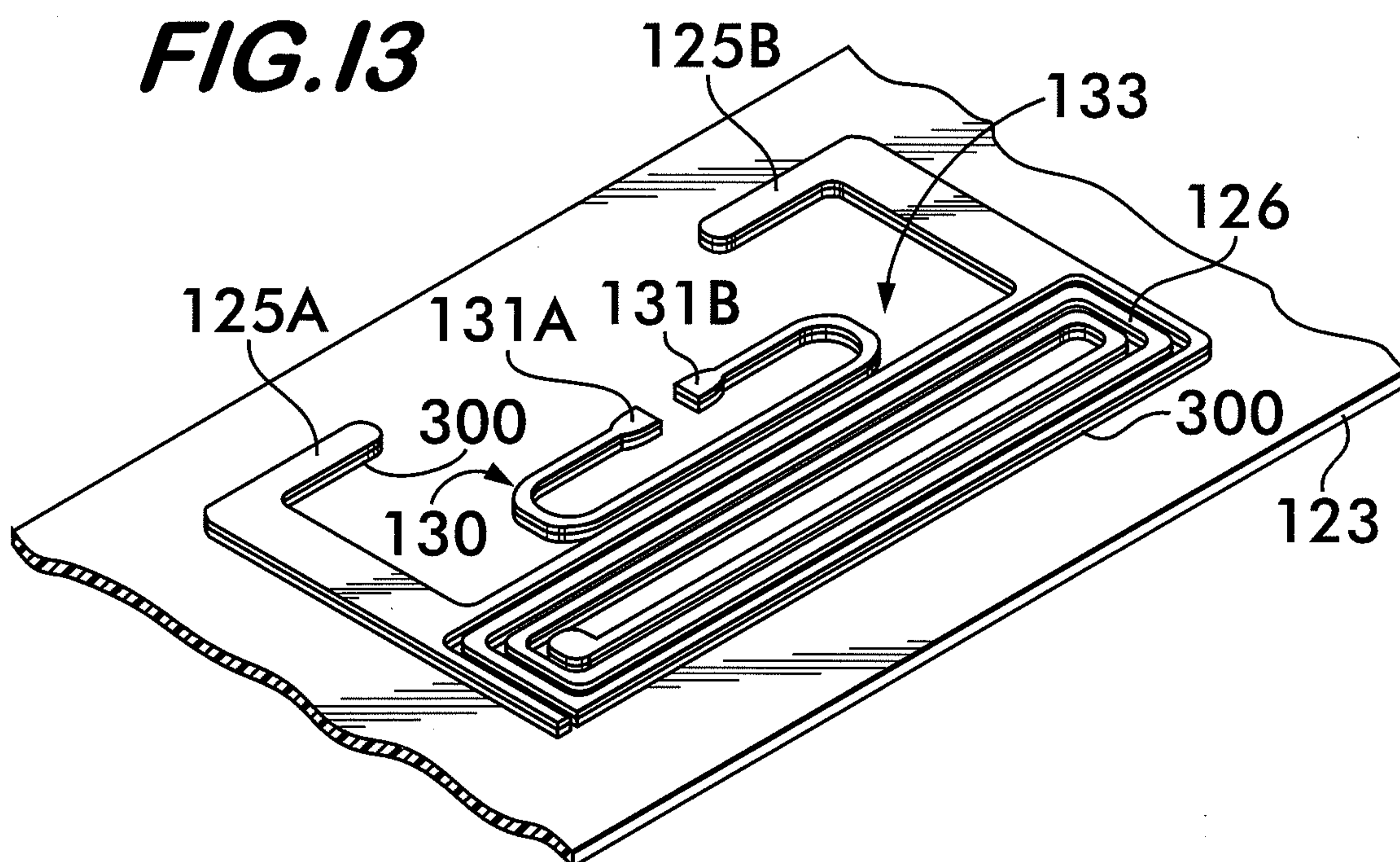
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**FIG. 4****FIG. 5****FIG. 6****FIG. 7****FIG. 8**

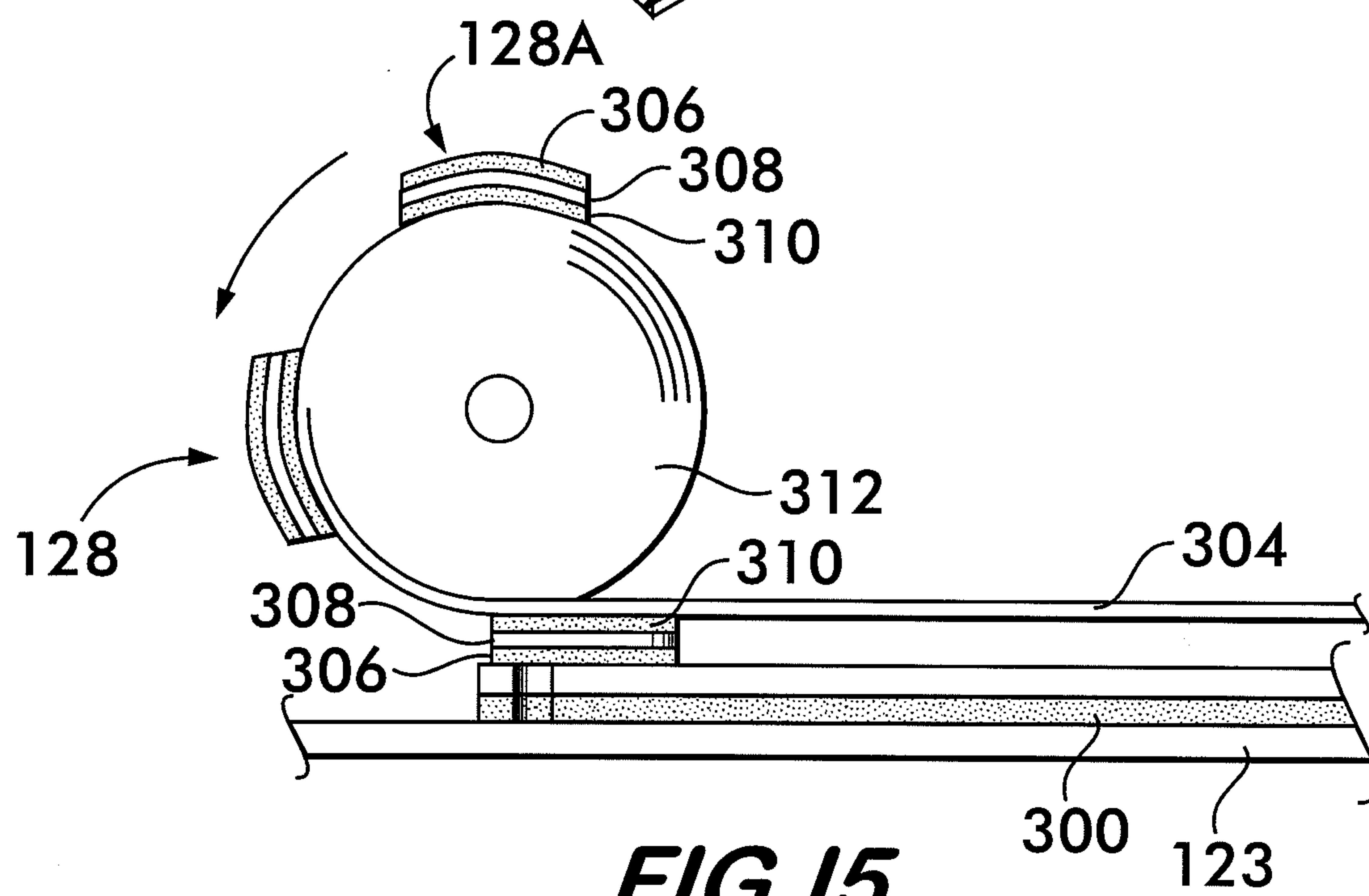
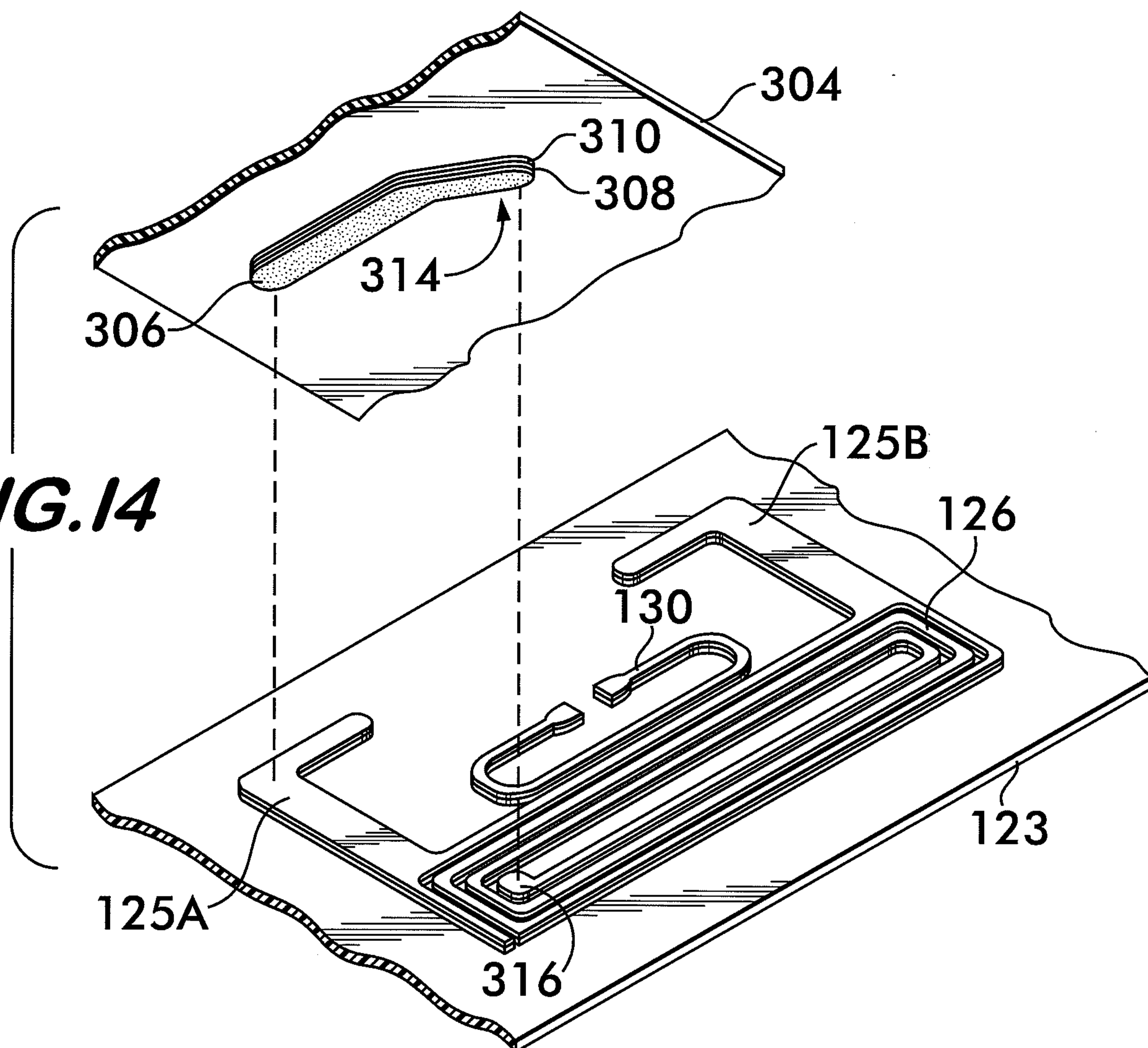
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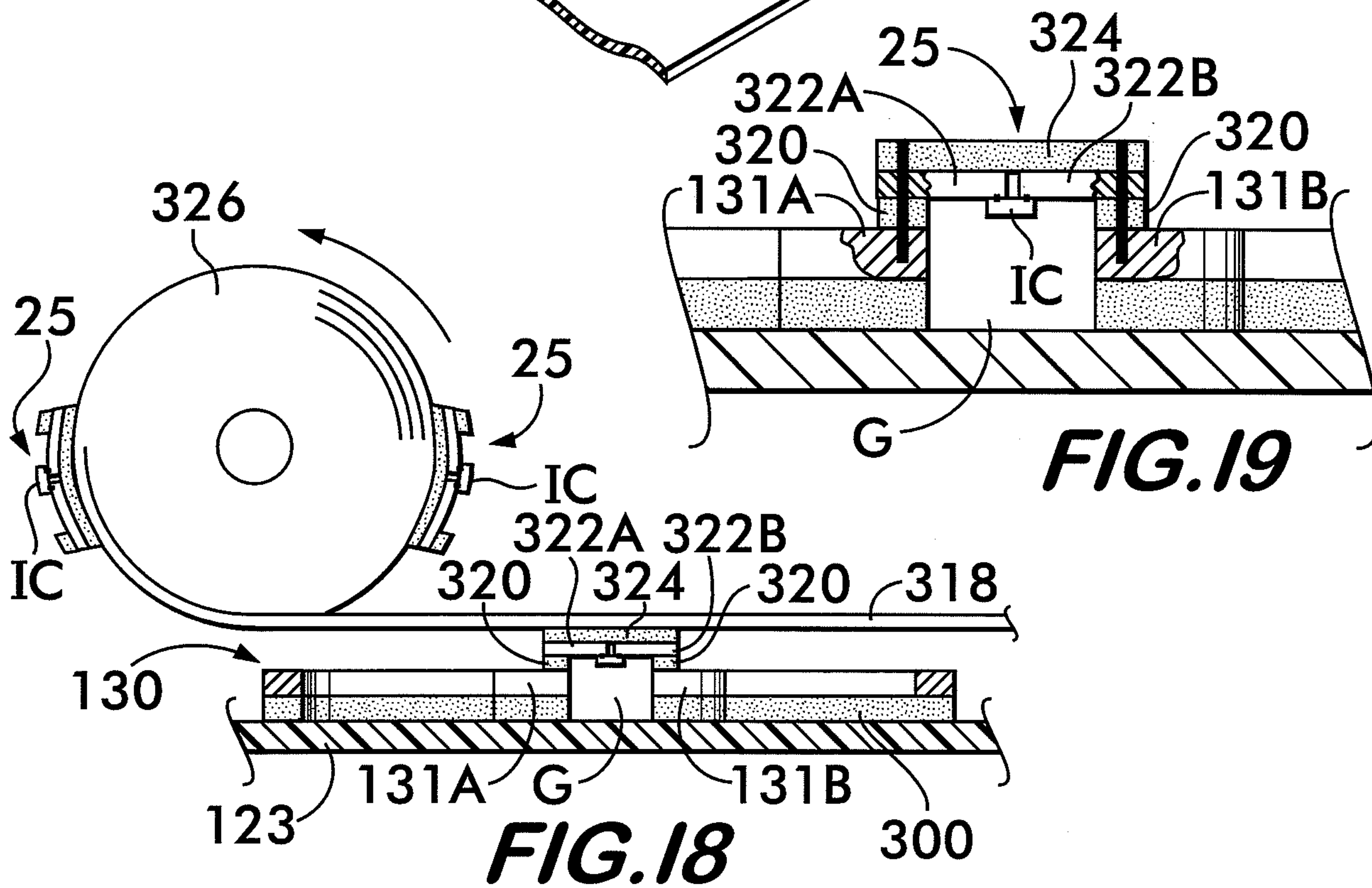
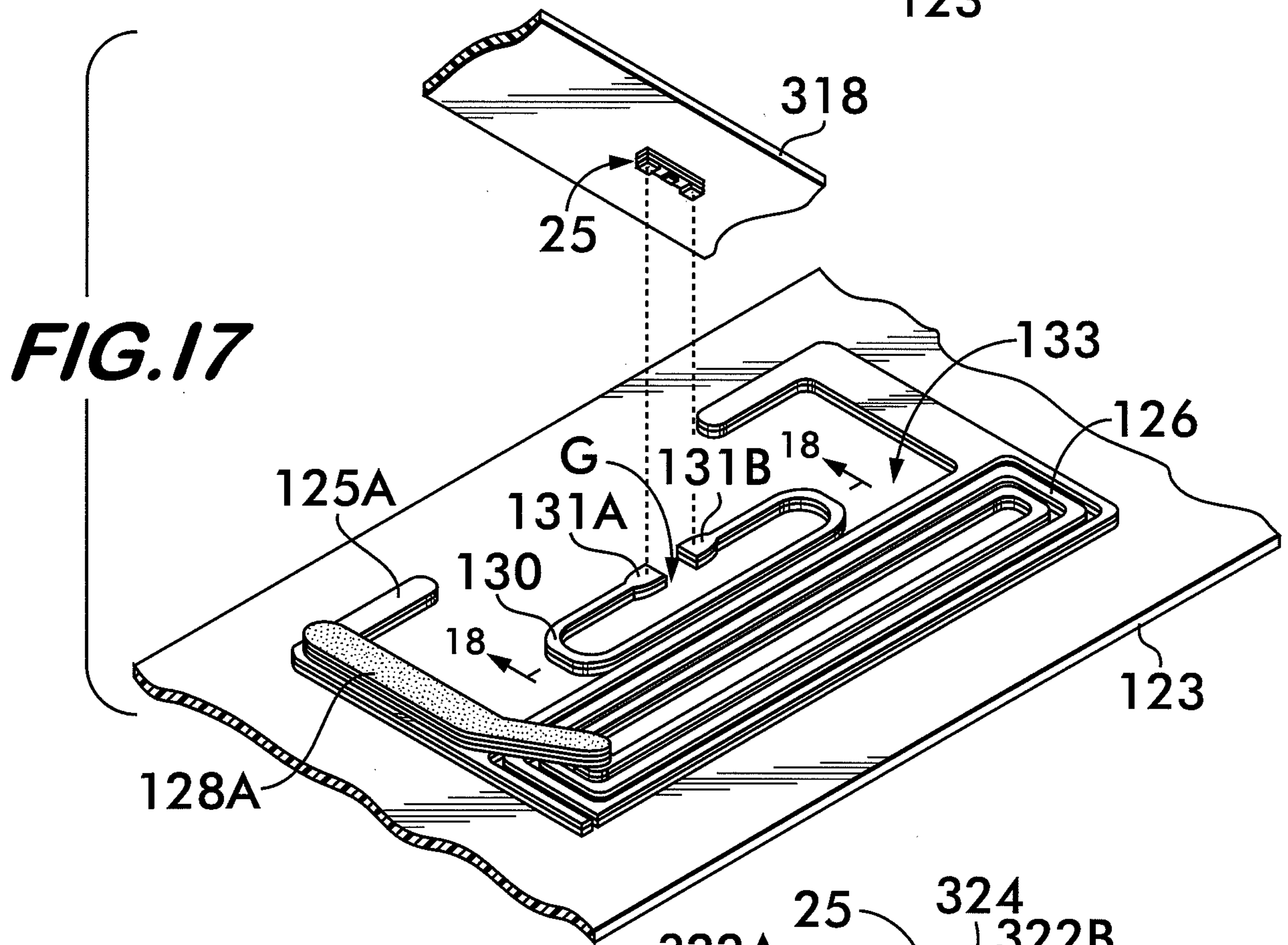
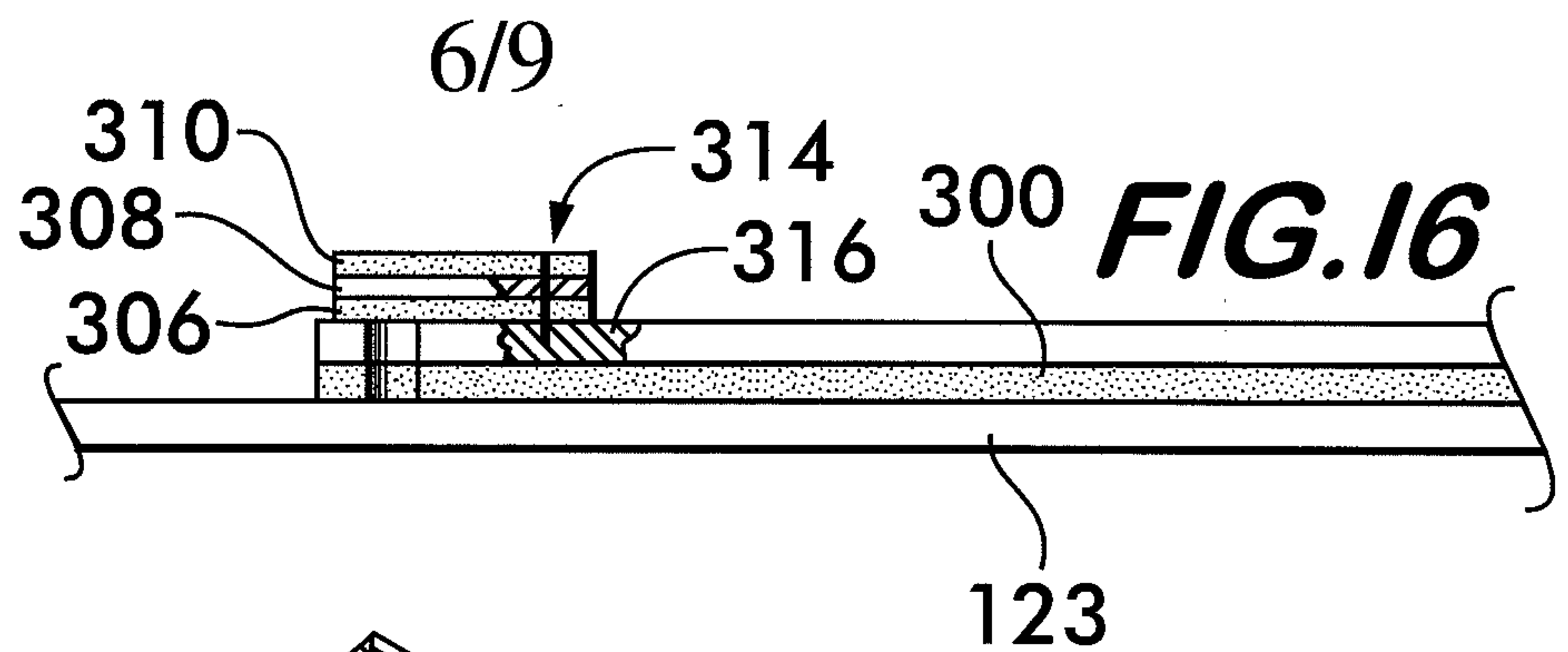
**FIG. 8A****FIG. 9****FIG. 10****FIG. 11**

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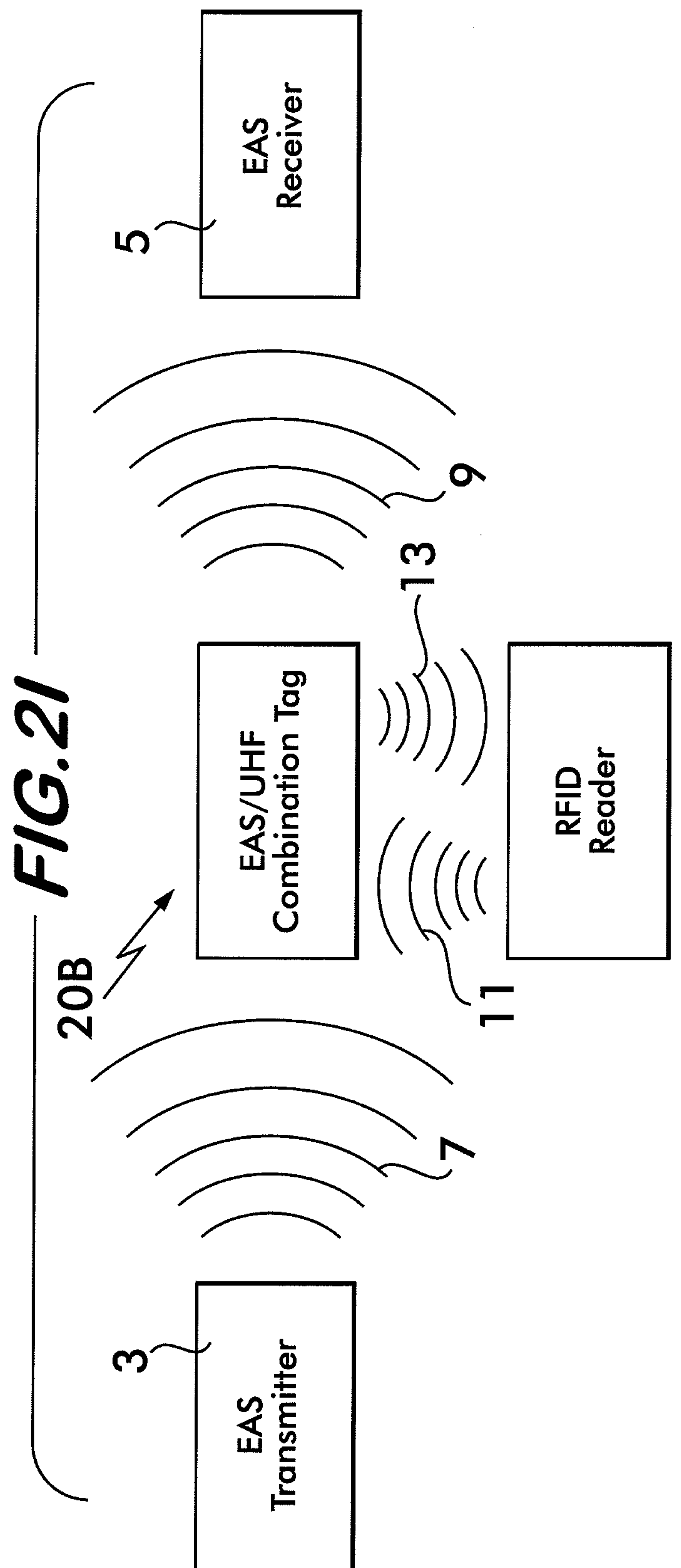
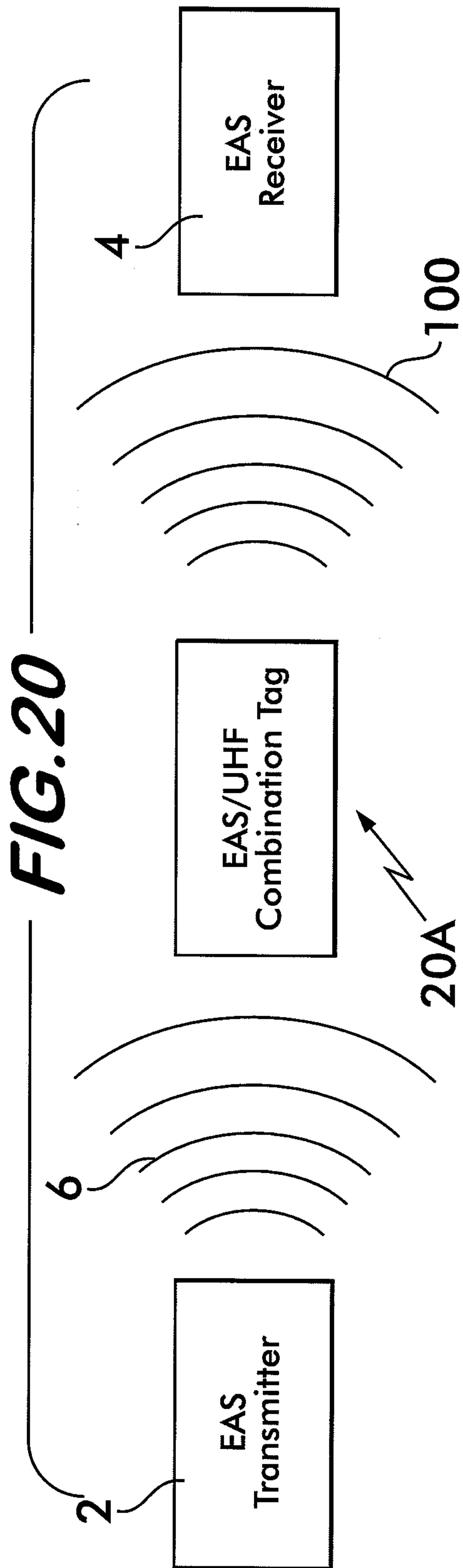
FIG. 12**FIG. 13**

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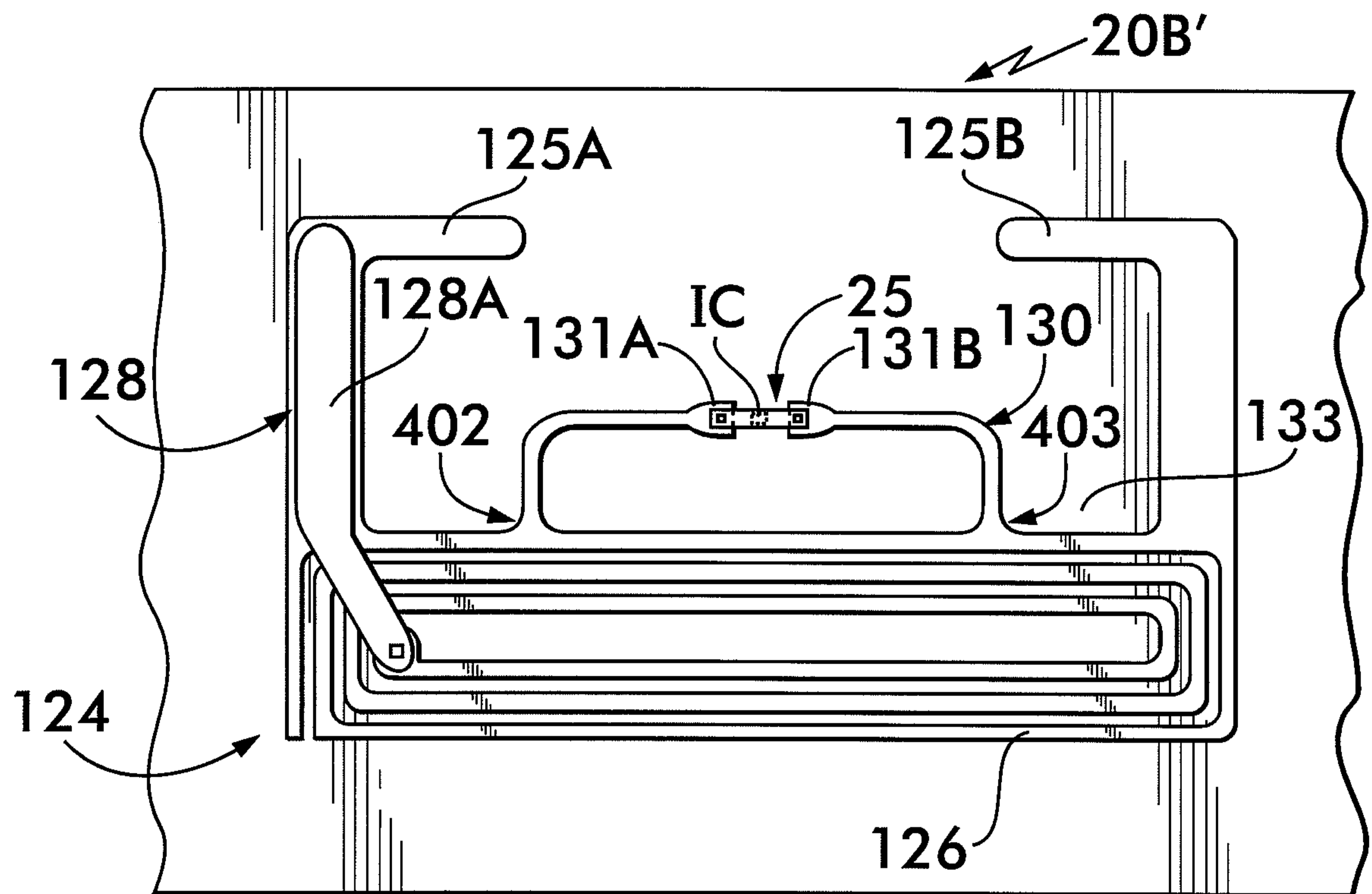
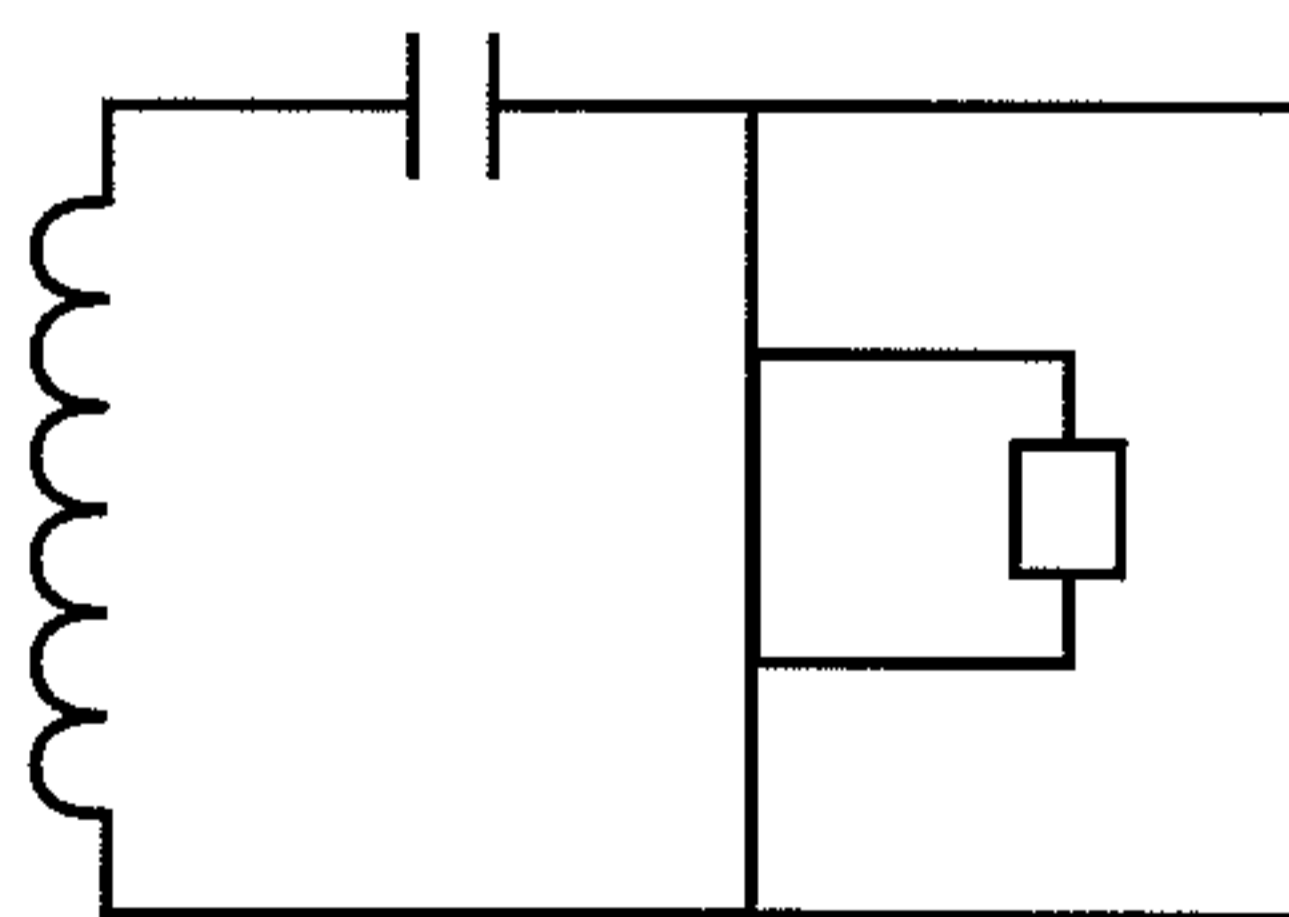
FIG. 14



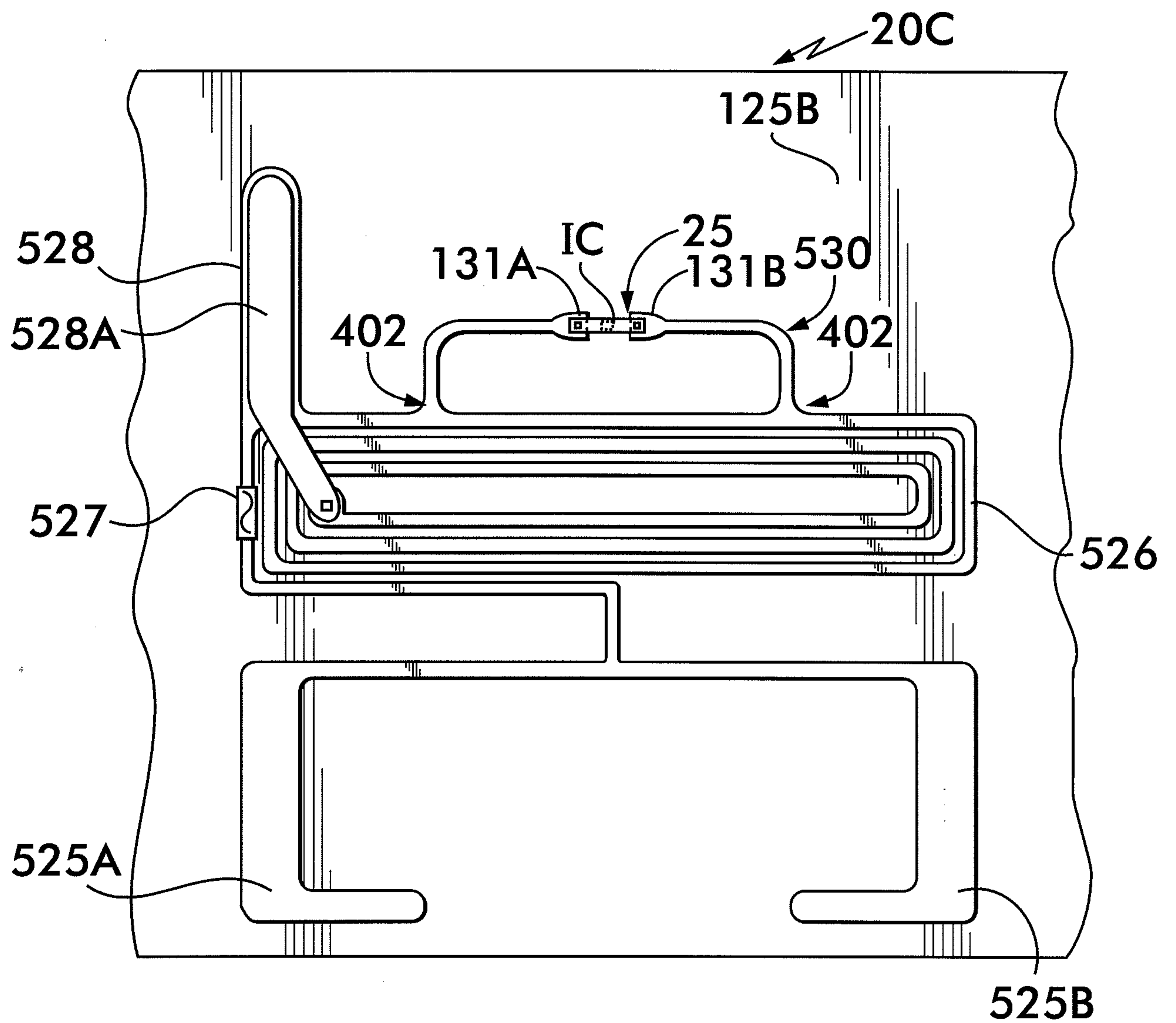
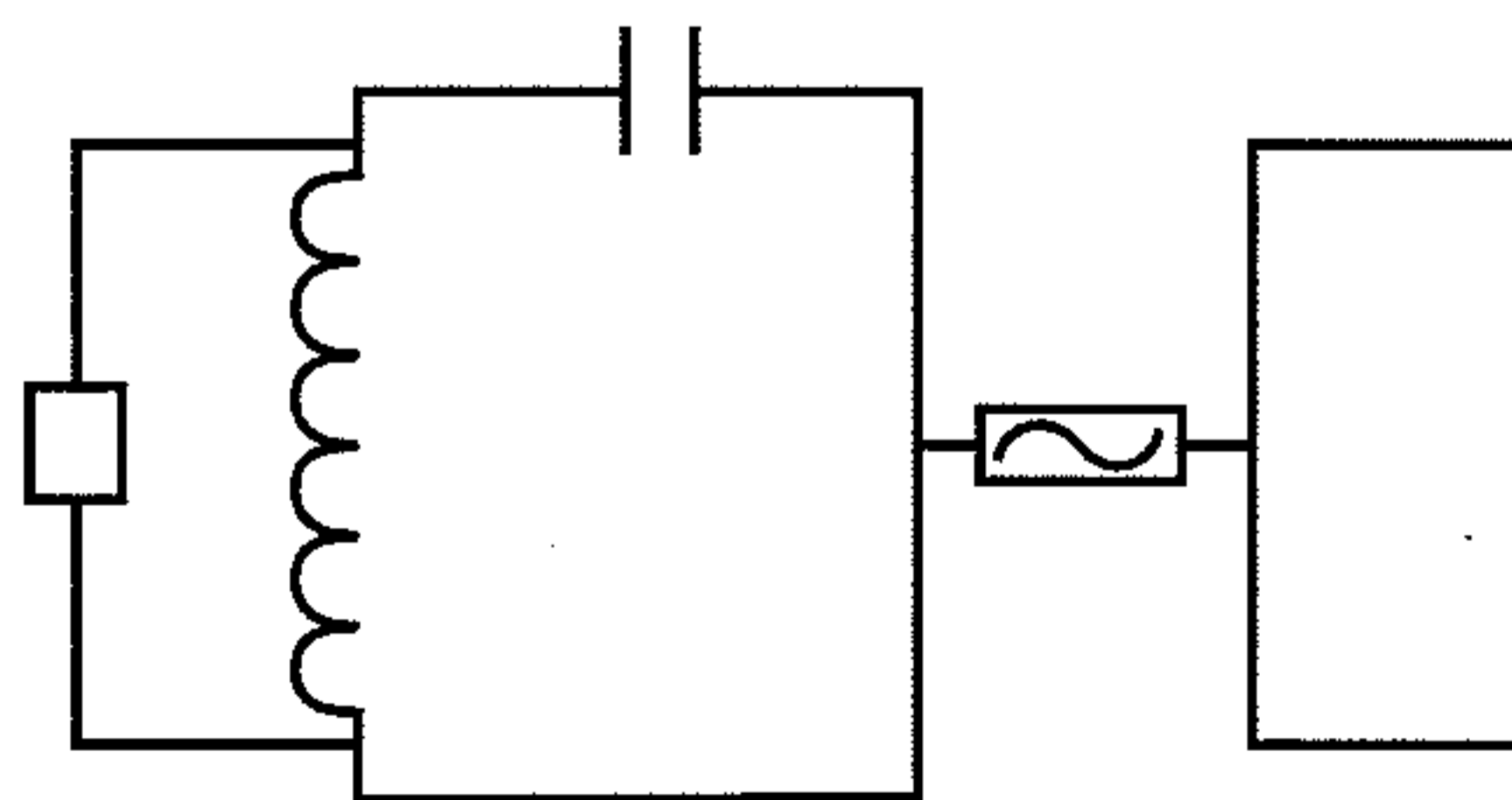
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**FIG. 22****FIG. 23**

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**FIG. 24****FIG. 25**

