



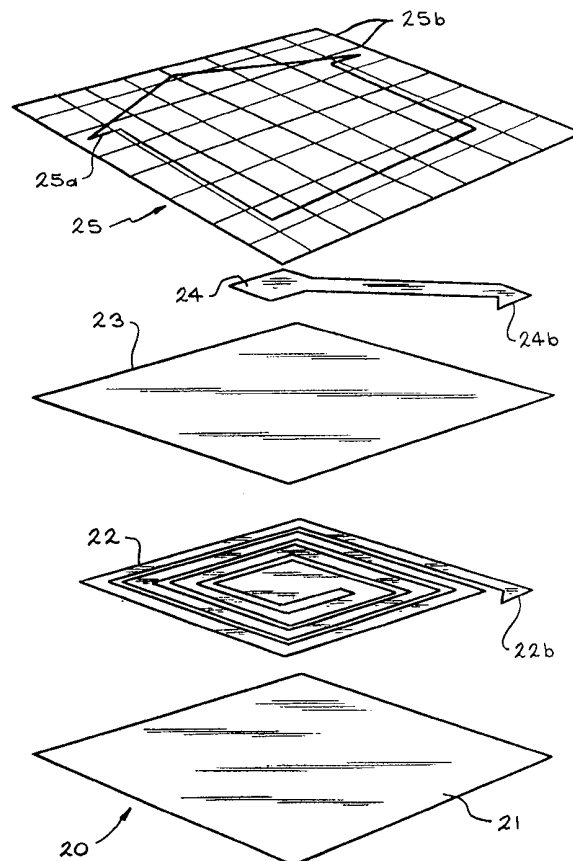
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<p>(21) International Application Number: PCT/US99/15179 (22) International Filing Date: 6 July 1999 (06.07.99)</p> <p>(30) Priority Data: 60/094,421 28 July 1998 (28.07.98) US 60/124,984 18 March 1999 (18.03.99) US 09/330,808 11 June 1999 (11.06.99) US</p> <p>(71) Applicant: NOVA VISION, INC. [US/US]; 12836 South Dixie Highway, Bowling Green, OH 43402 (US).</p> <p>(72) Inventors: CAPERNA, Albert, J.; 700 Brittany Avenue, Bowling Green, OH 43402 (US). WATERBURY, Mark, C.; 506 Campbell Hill Road, Bowling Green, OH 43402 (US).</p> <p>(74) Agents: PORCELLO, James, F., Jr. et al.; Emch, Schaffer, Schaub & Porcello Co., P.O. Box 916, Toledo, OH 43697 (US).</p>	<p>(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SL, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).</p> <p>Published <i>With international search report.</i></p>	

(54) Title: ARTICLE SURVEILLANCE DEVICE AND METHOD FOR FORMING

(57) Abstract

A security tag (20, 30, 40) and method for forming the tag in a substantially continuous in-line operation. The tag includes a substrate (21, 31, 41) with first (22, 32, 42) and second (24, 34, 44) conductive elements separated by a dielectric layer (23, 33, 43) and means establishing electrical contact between the first and second conductive elements. The means for establishing electrical contact includes utilizing an electrically conductive ink (35) or providing an interruption (43a) in the dielectric layer. Under one embodiment a layer of foil (25) having a series of interruptions (25b) is further provided.



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DESCRIPTION

ARTICLE SURVEILLANCE DEVICE AND METHOD FOR FORMING

5 Cross-Reference To Related Applications

The present application is related to Provisional Applications Serial Nos. 60/094,421 filed July 28, 1998 and 60/124,984 filed March 18, 1999.

10 Background Art

The use of electronic/radio frequency (RF) article surveillance devices has become extremely widespread, particularly on retail products for security purposes. However, despite such widespread use, RF devices are fairly expensive, in part because they involve the
15 manufacture of the device in one operation and, in a second, separate operation, adding other enhancements like European Article Numbering (EAN) or Universal Product Code (UPC) bar codes and holograms for product authentication purposes. Yet another operation is then required to affix the RF tag or combined tag to merchandise or packaging
20 materials. U.S. Patent No. 3,938,044, incorporated herein by reference, shows one prior art device for use in an electronic security system wherein a resonant tag circuit is sensed to denote an alarm condition. The device includes an antenna system which senses the presence of a resonant tag circuit and, upon such sensing, can automatically activate
25 a deactivation field for destruction of the resonant properties of the tag circuit at its sensing frequency and provide output indication that tag deactivation has been achieved.

Although integration of a RF EAS tag with a hologram for authentication purposes is a desirable means of conserving package real
30 estate, the electromagnetic radiation required for the RF circuit would be

occluded by the presence of an embossed hologram sheet produced by the methods described in prior art.

It is believed that the present invention incorporates advantages not available in that or any other prior art. Other patents which disclose various methods for forming an RF device or resonant tag labeling system include U.S. Patent Nos. 3,913,219; 4,498,076; 4,846,922; 5,485,154; 5,479,172; 5,446,447; 5,500,651; 5,457,461; and 5,751,256.

Disclosure of the Invention

10 An Electronic Article Surveillance (EAS) device incorporates various European Article Numbering (EAN) and Universal Product Code (UPC) bar codes and heterogeneous holographic effects. The method for forming disclosed herein permits the party producing the final article to incorporate the various elements in-line thereby permitting such party to retain and maintain control over all the elements in the manufacturing process and if desired to form the device in a single, on-going operation.

15 The article surveillance device of the present invention utilizes a composite sheet having a metal layer with a thickness preferably in the range of 20 millimicrons to 100 millimicrons and forming an RF resonating circuit with a resonance peak, for example, in the range of 7 to 9 megahertz. Utilizing the composite sheet adhered to a substrate, other elements may be directly stamped thereon in the steps of forming the final article. The metal layer of the composite sheet may be stamped to form an antenna of a radio frequency (RF) resonator. Under one embodiment, a second composite sheet is adhered to the opposite surface of the substrate. Under another embodiment, a second composite sheet is adhered to a dielectric coating placed on the opposite side of the first composite sheet from the substrate. The second composite sheet has embossed thereon one or more of (1) a holographic or kinetic image, (2) European Article Numbering (EAN) or Universal

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Product Code bar-code (UPC), (3) high density optical information including digitized optical commands, (4) a holographic bar code, or (5) complex script scannable by an optical scanner. The European Article Numbering or Universal product bar-code may utilize an infinity of printed
5 digits in the range of 1 to 1000.

The present invention provides new and unique articles of manufacture and a method for forming a RF tag or other article with a bar code and/or a holographic image directly on a substrate forming a component to be applied in-line at high speed to a product. For example
10 the product could be photographic film package, pharmaceutical, toiletry, CD, or video cassette or any other retail item prone to pilfering, counterfeiting or parallel importing upon which it is desired to provide a RF tag.

Accordingly, it is an object of the present invention to provide a
15 method of forming the improved RF device in which a major component is to be applied directly to the retail products or its packaging and to do so with high speed production efficiency and low cost.

It is a further object of the present invention to provide a combination sheet and method for forming such combination sheet which
20 may be used in directly forming an electronic surveillance device which incorporates a EAN/UPC bar code and holographic image. The combination sheet may be applied at high speed directly to the substrate of the intended finished retail product or article. A composite sheet which can be adapted for use in the method and for forming the
25 combination sheet of the present invention is disclosed in U.S. Patent Nos. 5,464,690, 5,643,678 and 5,674,580 which are incorporated herein by reference and are hereinafter referred to as "NovaVision® composite sheet." The present invention is not, however, limited to the use of the NovaVision® composite sheet but may be, for example,

implemented using conventional hot or cold stamping foils or improved conductivity stamping foil.

It is, therefore, a further object of the present invention to provide a means of forming RF EAS tags through the use of conventional stamping foils and stamping foils that have been modified to improve electrical conductivity. The accuracy of the edges of the antennae or capacitors fabricated by stamping of such foils may be enhanced in the present invention by inclusion of a step of die cutting, partial die cutting or scaring of the stamping foil prior to or during the stamping step. One advantage of die cutting is thicker layers may be used, including a thicker metal layer.

It is a further object of the present invention to provide methods for in-line tuning of RF tag frequency by changing the capacitance of the capacitor element, or the inductance of the inductor element. Information required for in-line tuning may obtained, for example, from a high-speed, in-line tag reader that measures tag resonance frequency and circuit Q and provides feedback to the printing line to control any of the parameters below, or other characteristics that influence tag resonant frequency.

The resonant frequency of a simple capacitance, inductance circuit, such as those in the present invention, is given by: Frequency (Hz) = $1/(2\pi) * 1/(CL)^{1/2}$. Where $\pi = 3.14159\dots$ C = capacitance of capacitor element in Farads, and L = inductance in Henrys. The capacitance of a parallel plate capacitor element, in turn, is given by: $C = (KA)/(4 \pi d)$. Where C = capacitance in Farads, K = dielectric constant of dielectric element, A = area of the plates, d = separation between plates.

It may be seen from these formulae that the resonant circuit may be tuned to an appropriate resonant frequency by adjustment of the capacitor plate area, the spacing between capacitor plates, or the

dielectric constant of the dielectric component, or any combination of these factors, in addition to other possible factors, such as the inductance of the antenna element. More specifically, such in-line tuning may be accomplished by one or more of the following:

- 5 1) Adjusting the overlap of two regions of adhesive applied in cold stamping capacitor plate fabrication. Greater overlap will reduce the area of the cold stamped capacitor thereby reducing the capacitance.
- 10 2) Control of the dielectric constant of the dielectric element of the capacitor by varying the polarity, or polarizability, of the ink mix.
- 3) Control of capacitance by changing thickness of dielectric element. For a printed dielectric, this may be accomplished through variations in print process parameters.
- 15 4) Control of extent of capacitor plates by printing conductive ink to extend the dimensions of the smaller of two plates forming a capacitor.
- 5) Control of extent of capacitor plates by laser trimming of plates.

20 It is a further object of the present invention to provide a means of making electrical contact between the RF antenna on one side of a printed dielectric layer, and the capacitor plate element on the other side of that layer by either of the following means:

- 25 1) Printing an overlapping layer of conductive ink over the conductors and dielectric as shown in Fig. 4A and 4B.
- 2) Limiting the extent of the dielectric layer so that an electrical contact point is formed at the site of omission of the dielectric layer, as shown in Fig. 5A and 5B.

30 It is a further object of the present invention to provide a combination sheet design (Fig. 3) that reduces electrical conductivity, for

example by interruptions, to allow compatibility with the transmission of radio frequency energy as required for RF EAS and RF ID tag use. It is a further object of the present invention to provide a metallized foil design for packaging materials and methods for producing same that allow integration of those foils with RF EAS tags without attenuation of RF energy.

Description of the Drawings

Figs. 1 and 1A through 1E show various embodiments of the EAS device of the present invention utilizing a single layer of composite sheet or stamping foil on each side of a supporting substrate.

Figs. 2 and 2A through 2E show additional embodiments of the EAS device of the present invention utilizing two layers of composite sheet or stamping foil on the same side of a supporting sheet.

Figs. 3, 4A, 4B, 5A and 5B show embodiments of RF EAS resonator tags formed according to the present invention.

Fig. 6 shows apparatus for in-line production of the security device of the present invention.

Figs. 6A, 6B, 6C and 6D show the changes in the structure at each in-line station shown in Fig. 6.

Fig. 7 shows a further embodiment.

Detailed Description of the Invention

Referring to Fig. 1, NovaVision® composite sheet or conventional hot or cold stamping foil or high conductivity stamping foil, hereinafter referred to as first foil (2), is stamped onto a supporting substrate (1) comprising paper or a dielectric film such as oriented polypropylene or polyester. The first foil (2) is stamped such that the metal layer thereof forms the shape of an antenna for a radio frequency (RF) resonator. One form of antenna is designated by the numeral (22) in Fig. 3. The

supporting substrate (1) is reversed and a second NovaVision® composite sheet, conventional hot or cold stamping foil, or high conductivity stamping foil, second foil (4), is stamped on the opposite surface of the supporting substrate (1) to the form and shape of, and to function as, a capacitor. For example, one form of capacitor is designated by the numeral (24) in Fig. 3. In those instances where the second foil (4) is formed using NovaVision® composite sheet, the capacitor formed from the metal layer thereof may then be stamped with a die to form a holographic or kinetic image (5). As will be appreciated from Figs. 3 through 6 and the description related thereto, following the stamping operations, it is only those portions of the respective metal layers of the first foil (2) forming the resonator/antenna and second foil (4) forming the capacitor which remain on the substrate (1) and all other portions of said first foil (2) and second foil (4) are removed following the transfer of such metal layer portions. See Fig. 6. A self adhesive carrier (3) is laminated or printed on to the RF resonator/antenna stamped from the first foil (2). The adhesive carrier (3) could be, for example, a three mil double-sided tape supported by a 30 pound glassine liner available from Fasson, Inc., Stow, Ohio.

Figs. 1A, 1B, 1C, 1D and 1E show similar layer to layer structures as that of Fig. 1 but show other features added thereto.

In Fig. 1A, where the second foil (4) is NovaVision® composite sheet, the capacitor stamped from the metal layer thereof is embossed with a heterogeneous holographic effect or kinetic image containing within it an additional holographic bar-code, or a printed bar code.

In Fig. 1B, where the second foil (4) is NovaVision® composite sheet the capacitor stamped from thereof is embossed with a heterogeneous holographic effect or kinetic image containing within it an additional holographic two-dimensional bar code (8).

In Fig. 1C, where the second foil (4) is NovaVision® composite sheet, the capacitor stamped from the metal layer thereof is embossed with a heterogeneous holographic effect or kinetic image containing within it an additional hologram (9) containing a multitude of high-density optical information and commands.

In Fig. 1D, where the second foil is formed from NovaVision® composite sheet, the capacitor stamped from the metal layer thereof is embossed with a heterogeneous holographic effect or image containing within it an additional hologram (10) containing high-density digitized and optical commands to interface with computers or printed high-density digitized.

In Fig. 1E, where the second foil is formed from NovaVision® composite sheet, the capacitor stamped from the metal layer thereof is embossed with a heterogeneous holographic effect or image containing within it an additional hologram (11) containing complex script scannable by an optical scanner.

Referring to Fig. 2, a supporting substrate of film or paper (1) has stamped thereon a first foil (2) of NovaVision® composite sheet, conventional hot or cold stamping foil, or high conductivity stamping foil is stamped such that the metal layer thereof forms the shape of a radio frequency (RF) resonator (antenna). A dielectric coating (13) is printed, coated, laminated or stamped onto the surface of the RF resonator/antenna and those portions of the substrate (1) not covered by such RF resonator/antenna. A second foil (4) which may be NovaVision® composite sheet, conventional hot or cold stamping foil, or high conductivity stamping foil, is stamped onto the dielectric coating (13) such that the stamped portion of the metal layer thereof is adhered to the dielectric coating (13) in the shape of and functions as a capacitor. In those instances where the second foil (4) is NovaVision® composite sheet, it may then be embossed with holographic or kinetic images (5).

A self adhesive carrier (21) is applied to the reverse side of the supporting substrate (1).

In Figs. 2A, 2B, 2C, 2D and 2E show similar layer to layer structures as that of Fig. 2 but show other features added thereto.

5 In Fig. 2A, in those instances where the second foil (4) is NovaVision® composite sheet, it may then be embossed with a holographic or kinetic image containing within it a European Article Numbering (EAN) or Universal Product Code (UPC) bar code (6).

10 In Fig. 2B, in those instances where the second foil (4) is NovaVision® composite sheet, it may then be embossed with a holographic or kinetic image containing within it an additional holographically generated (2D) two dimensional bar code (17).

15 In Fig. 2C, in those instances where the second foil (4) is NovaVision® composite sheet, it is then embossed with a holographic or kinetic image containing within it an additional hologram containing a multitude of high-density optical information (18).

20 In Fig. 2D, in those instances where the second sheet (4) is NovaVision® composite sheet, it is then embossed with a holographic or kinetic image containing within it an additional hologram containing high-density digitized and optical commands (19) to interface with computers.

In Fig. 2E, in those instances where the second foil (4) is NovaVision® composite sheet, it is then embossed with a holographic or kinetic image containing within it an additional hologram containing complex script (20) scanable by an optical scanner.

25 Fig. 3 is an exploded perspective view of an in-line produced RF EAS resonator tag (20) with integrated hologram. The tag (20) comprises a substrate (21), an RF resonator/antenna (22) stamped onto the substrate (21) from a first foil such as that identified by numeral (2) of Figs. 1 and 2, dielectric layer (23), capacitor plate (24) stamped onto
30 the dielectric layer (23) from a second foil such as that identified by the

numeral (4) of Figs. 1 and 2, and a NovaVision® composite sheet (25) having a hologram (25a) embossed thereon. Additionally, the NovaVision® composite sheet has interruptions (25b), exaggerated here for clarity, formed in the metal layer of such sheet. In lieu of a
5 NovaVision® composite sheet (25) with a hologram embossed thereon, a conventional hot or cold stamping foil or metallized packaging material could be utilized with other decorative material or bar code embossed or printed thereon. In each case, the NovaVision® composite sheet (25), stamping foil, or metallized packaging material is modified by the
10 introduction of periodic interruptions (25b) in the metal layer of such NovaVision® composite sheet, conventional hot or cold stamping foil or metallized packaging material. The interruptions (25b) or breaks are preferably narrow enough to be invisible to the human eye, but wide enough to greatly reduce the electrical conductivity of the NovaVision®
15 composite sheet (25) or other foil. Preferably the interruptions should have a spacing on the order of one (1) centimeter in both the X and Y axes to divide the metal layer into small, non-continuous areas. Said interruptions (25b) or breaks result in transparency of the NovaVision® composite sheet (25) or other foil to electromagnetic radiation in the
20 radio frequency range and compatibility between the NovaVision® composite sheet (25) or other foil and the remaining portions of the RF EAS resonator tag (20). Electrical contact between capacitor (24) pad (24b) and the pad (22b) of antenna (22) may be accomplished as shown in Figs. 4A, 4B, 5A, 5B.

25 Fig. 4A is an exploded perspective view of an RF EAS tag (30) showing electrical contact established between contact pad (32b) of antenna/conductive element (32) and the contact pad (34b) of a second conductive element (34). The antenna/conductive element (32) includes a coil (32a), a pad (32b) and a first capacitor plate (32c). The second
30 conductive element (34) includes a second capacitor plate (34a) and a

pad (34b). A dielectric layer (33) is positioned between the antenna
conductive element (32) and the second conductive element (34). The
electrical contact is established by printing or otherwise applying an
overlapping layer of conductive ink (35) over a portion of substrate (31),
5 contact pad (32b), a portion of dielectric layer (33) and the second
capacitor contact pad (34b). The dielectric layer (33) is sized such that
the entire second conductive element (34) is supported on the dielectric
layer 33 thereby avoiding any electrical discontinuity that may result from
10 stamping the conductive element (34) over the edge of the dielectric
layer (33) thereby bending or otherwise disrupting the conductive
element (34). Contact is then established by printing or otherwise
applying conductive ink (35) to link the contact pad (32b) of
antenna/conductive element (32) and the second capacitor plate contact
pad (34b).

15 Fig 4B is a perspective view of the assembled components from
Fig. 4A to form the assembled RF EAS tag (30). As can be seen,
electrical contact has been established between the contact pad (32b) of
antenna conductive element (32) and the contact pad (34d) of the
second conductive element (34). This was accomplished by applying
20 conductive ink (35) to overlap the second capacitor contact pad (34b),
a portion of the dielectric layer (33) and the contact pad (32b). The
conductive ink (35) laps over and around the edge of dielectric layer (33)
to join the contact pad (32b) with the contact pad (34b) of the second
conductive element (34).

25 Fig. 5A is an exploded perspective view of another embodiment of
RF EAS tag (40). In this embodiment, electrical contact is established
between contact pad (42b) of antenna/conductive element (42) and
contact pad (44b) of a second conductive element (44). A dielectric
layer (43) is positioned between the antenna/conductive element (42)
30 and the second conductive element (44). The antenna/conductive

element (42) includes a coil (42a), extending between the pad (42b) and a capacitor plate (42c) stamped or otherwise affixed to substrate (41). The antenna/conductive element (42) is formed by stamping or otherwise transferring that portion of the metal layer having the desired shape of the antenna/conductive element (42) from a NovaVision® composite sheet, conventional hot or cold stamping foil or high conductivity stamping foil to the substrate (41).

The dielectric layer (43) is affixed to the antenna/conductive element (42) and the underlying substrate 41. The dielectric layer (43) is shown as being generally rectangular but having a cut corner defining a tapered edge (43a) extending between adjacent edges (43b) and (43b). The dielectric sheet is sized to overlay the antenna/conductive element (42) in all areas except the tapered edge (43a). In the area of the tapered edge (43a) the pad (42b) of the antenna/conductive element (42) outwardly therebeyond.

The second conductive element (44) is formed in a similar manner as the antenna/conductive element (42) by stamping or otherwise transferring the desired shaped portion of one of the specified foils to the dielectric layer (43).

As may be seen in the drawings, all portions of the second conductive element (44) except the pad (44b) are contained within the boundaries of the dielectric layer (43). The pad (44b) extends outwardly beyond the tapered edge (43a). The dielectric layer (43) is positioned between the conductive element (42) and the conductive element (44). By restricting the area of the dielectric layer (43) in the corner defined by the tapered edge (43a) adjacent the pad (42b) of the conductive element (42) and the pad (44b) of the second conductive element (44), it is possible to have direct contact between such pads (42b) and (44b). This embodiment is useful in cases where the second capacitor plate (44) is manufactured to be sufficiently robust that conductivity will not be

broken by printing or applying the contact pad (44b) over the edge of the dielectric layer (43). Electrical contact between the contact pad (42b) and the contact pad (44b) is established by direct physical contact, achieved by limiting the coverage of the dielectric layer (43) to all regions of the antenna (42) and second conductive element (44) other than in the area of the contact pads (42b) and (44b).

The second conductive element (44) has a second capacitor plate (44a) at the opposite end from the pad (44b).

Fig. 5B is a perspective view of the assembled RF EAS tag (30) showing electrical contact established between pad (42b) and second contact pad (44b) made by leaving the corner of dielectric layer (43) defined by tapered edge (43a) absent or cut away to allow direct contact between contact pad (42b) and contact pad (44b). The second contact pad (44b) material must be sufficiently robust to allow application over the edge of dielectric layer (43) without disruption of electrical conductivity.

The dielectric layer (43) or coating may be comprised, for example, of high density polyethylene, polyester, or other polymer material in the cases where it is applied, rather than printed. In the cases where the dielectric layer (43) or coating is a printed component, it may be comprised of ink with consistent dielectric properties, low dielectric loss factor, and of such a nature that it may be applied with highly consistent thickness to maintain accurate capacitance of the capacitor component. Solvent based inks with high solids content and no carbon black or other conductive pigments fulfill these requirements.

Referring to Figs. 6 and its related Figs. 6A, 6B, 6C and 6D, there is shown schematically apparatus for forming the security device of the present invention in an in-line production operation. It will be described in relation to the RF tag (40) of Figs. 5A and 5B. As shown in Fig. 6, substrate material (41) contained on a supply reel (101) may be fed along

a path in the direction of arrow P through a plurality of workstations to be hereinafter described, to a wind-up reel (104) for collecting and storing a supply of RF security tag material in continuous web form (105) resulting from processing through the various stations shown in Fig. 6.

5 The security tag web material (105) contained in the wind-up roll (104) is in roll form and can be simply trimmed or stamped to size to form the individual security tags of the present invention such as those designated by the numeral 40 in Fig. 5 or such as those of other embodiments of the present invention.

10 As shown in Fig. 6, the substrate (41) which may be paper or a dielectric film such as oriented polypropylene or polyester may be fed between a pair of nip rollers (51) and (52) after being passed over an idler roller (53). A layer of composite sheet or foil (2), such as that described with reference to Fig. 1, from supply reel (54) is engaged to
15 the upper surface (as shown in Fig. 6) of the substrate (41) prior to its passing between the nip rollers (51, 52).

The upper roller (51) may have a die face having a configuration such as that designated by the numeral 42 in Fig. 6A such that when the composite sheet or foil (2) is passed between the nip of rollers (51, 52)
20 with its metal layer facing the substrate (41), the die or roller 51, acting under heat and pressure will cause that portion of the metal layer of the composite sheet or foil (2) contacted thereby to be transferred to the substrate (41) as a conductive element (42) having a rectangular coil (42a) with a contact pad (42b) at the outer end and a capacitor plate
25 (42c) at the inner end. With such shape, the conductive element 42 will function as an antenna.

Although Fig. 6 shows the substrate (41) and the composite sheet/foil (2) passing between nip rollers (51, 52), it is possible in place of the nip rollers (51, 52) to utilize a stamping die having a die face with
30 the configuration shown for the antenna/conductive element (42)

positioned above the joined composite sheet or foil (2) and substrate (41) and a flat anvil positioned directly below. The die will be heated. When an appropriate length of joined substrate (41) and foil (2) are positioned between the die and anvil, the die will be lowered to stamp the joined
5 substrate (41) and composite sheet/foil (2) between it and the anvil under heat and pressure from the heated die to transfer a metallic layer from the composite sheet/foil (2) in the shape of the antenna/conductive element (42) onto the substrate (41). As will be appreciated, during the interval at which the die is in contact with the anvil, there will be no
10 relative longitudinal movement between the die and the joined substrate (41) and composite sheet/foil (2). This can be accomplished either by temporarily stopping movement of the joined substrate (41) and foil (2) during the stamping operation or moving the die and anvil longitudinally at the same rate of speed as the joined substrate (41) and foil (2) during
15 the interval that the die is stamping the joined foil (2) to the substrate (41) and anvil. The utilization of a reciprocating members for stamping to moving stock is well known in the art and forms no part of the present invention. For example U.S. Patent No. 5,618,378.

Following transfer of the antenna/conductive element (42) to the
20 substrate (41), the remaining portion or remnant of the foil, namely, that portion of the foil (2) minus the portion of the metal layer forming the antenna/conductive element (42) will be wound on a take-up reel 80 as scrap.

Fig. 6A shows the appearance of a segment of the partially formed
25 resonant tag as viewed from the top immediately following removal of the remnant portion of the foil being wound on the take-up reel (80).

The substrate (41) with the antenna/conductive element (42) stamped thereon then passes between the nip of a pair of rollers (55) and (56) immediately following which a dielectric layer (43) in the form of
30 dielectric film or coating is applied onto the surface of the

antenna/conductive element (42). As shown in Fig. 6, the dielectric layer (43) is in the form of a film released from a supply reel (57) and moved between the nip of rollers (58) and (59) which adhere the dielectric layer (43) to the antenna/conductive element (42) and substrate (41). In lieu of dielectric film, the dielectric layer (43) could be printed or stamped as a film or coating of dielectric ink or other dielectric material.

Fig. 6B shows the appearance of a segment of the partially formed resonant immediately following application of the dielectric layer (43).

The substrate (41) with the antenna/conductive element (42) and dielectric layer (43) overlay affixed thereto then passes through the nip of rollers (65) and (66). After leaving the rollers (65, 66), a second composite sheet or foil (4) of the type described with reference to Fig. 1 is dispensed from supply reel (60) and positioned over the dielectric layer (43) following which it is passed through rolls functioning as a stamping die (63), anvil (64) combination or a reciprocating die and anvil. The foil (4) has a metal layer facing the dielectric layer (43). The stamping die (63) is configured to form a second conductive element (44) and may have a configuration such as that shown in Fig. 6C. The die 63 is heated and, when rolled or stamped against the anvil (64) with the foil (4) joined to the dielectric coating (43), the heat and pressure will cause those portions of the metal layer of such foil (4) to adhere to the dielectric coating (43) to form the second conductive element (44). The second conductive element (44) has a capacitor plate (44a) and a contact pad (44b). The contact pad (44b) of the second conductive element (44) is joined to the contact pad (42b) of the antenna/conductive element (42). The joining of the contact pad (44b) to the contact pad (42b) may be accomplished either by trimming, having pre-trimmed areas or otherwise eliminating a small portion of the dielectric layer (43) in the corner area adjacent contact pad (44b) such as that defined by tapered edge (43a) in Fig. 5A to permit direct contact of the pads (42b) and

(44b) as shown in Figs. 5A and 5B or having a conductive ink effect such contact between the pads (42b) and (44b) as described in Figs. 4A and 4B.

5 Following transfer of the second conductive element (44) to the dielectric coating (43), the remaining portion or remanent of the foil, namely, that portion of the foil (4) minus the portion of the metal layer forming the second conductive element (44), will be wound on a take-up reel (81) as scrap.

10 In those embodiments which utilize NovaVision® composite sheet of the type disclosed in U.S. Patent No. 5,464,960 for foil (4), the joined second conductive element (44), dielectric coating (43), antenna/conductive element (42) and substrate (41) are then passed between a stamping die (73) and anvil (74). The stamping die (73) has had a holographic image formed therein such that upon stamping of the
15 heated stamping die (73) against a selected portion of such structure, for example, the capacitor pad (44a), a hologram (H) may be embossed therein. With this operation, the RF tag is completed except for cutting from the continuous web (105) which may be wound on the wind-up reel (104) after passing between additional nip rollers 76, 77 and over an idler
20 roller 78.

Fig. 6D shows the appearance of the formed RF tag segment (105a) immediately after leaving the station for embossing the hologram.

25 In those instances in which the NovaVision® composite sheet or other foil suitable for receiving a hologram is not utilized, the web (105) having conventional foil may be transferred directly from the station at which the stamping die 63, anvil 64 stamped the second conductive element (44) to the wind-up roll 104.

30 If desired, a portion of the stamping die (73) or other stamping die or roller may be utilized to print or emboss EAM, UPC bar code, holographically generated two dimensional bar code, high-density

digitized and/or optical information or complex script to the capacitor pad (44a) or intermittently to other portions of the web (105).

5 If desired, a third sheet of foil such as that shown in Fig. 3 and designated by the numeral (25) may be applied over the second conductive element (44) and the underlying dielectric layer (43). The third sheet of foil (25) is preferably a NovaVision® composite sheet and has a hologram (25a) embossed therein and a series of interruptions (25b) in the metal layer. A section of an RF tag of this embodiment is shown in Fig. 7.

10 Many modifications will become readily apparent to those skilled in the art. Accordingly, the scope of the present invention should be determined only by the scope of the claims.

5

WE CLAIM:

1. A length of security tags formed in a substantially continuous, in-line operation comprising

(a) a web of substrate material;

10

(b) a plurality of spaced apart first conductive elements successively affixed to said substrate material by successively transferring a discrete portion of a metal layer of a first composite sheet or foil to said substrate;

15

(c) a layer of dielectric material affixed to said first conductive elements and said substrate; and

(d) a plurality of second conductive elements successively affixed to said dielectric material by successively transferring a discrete portion of a metal layer of a second composite sheet or foil to said dielectric material.

20

2. A length of security tags according to claim 1 further including contact means for electrically connecting a first conductive element to a second conductive element.

25

3. A length of security tags according to claim 1 wherein a portion of each of said first conductive elements is aligned with a portion of a second conductive element and further including contact means for electrically connecting a first conductive element to a second conductive element.

30

4. A length of security tags according to claim 3 wherein said means for electrically connecting includes electrically conductive ink extending between said first conductive element and said second conductive element.

5

5. A length of security tags according to claim 3 wherein said means for electrically connecting includes a gap in said dielectric layer permitting direct contact between said first conductive element and said second conductive element.

10

6. A length of security tags according to claim 1 wherein a portion of said second conductive elements has a holographic image formed therein.

15

7. A length of security tags according to claim 1 wherein a portion of said second conductive element has formed therein a holographic image and one member selected from the group consisting of (i) UPC bar code, (ii) EAN, (iii) high density optical information and commands, (iv) high density digitized and optical commands, and (v) complex script scannable by an optical scanner.

20

8. A length of security tags according to claim 1 further including a third composite sheet or foil affixed to said second conductive elements, said third composite sheet or film having a metal layer with a plurality of interruptions, at least some portion of which overlie said second conductive elements.

25

9. A length of security tags according to claim 8 wherein said third composite sheet has a hologram formed therein.

30

10. A security tag comprising a
- (a) composite sheet or foil having a layer of metal, said layer of metal having a series of interruptions, said interruptions having a size and spacing permitting electromagnetic radiation to pass therethrough;
 - (b) a dielectric layer affixed to said composite sheet or foil;
 - (c) a first conductive element including a capacitor plate positioned between said composite sheet or foil and said dielectric layer, those portions of said composite sheet or foil and said dielectric layer overlying said first conductive element being in interfacial contact therewith and other portions of said composite sheet or foil being in interfacial contact with said dielectric layer, said first conductive element including a pad;
 - (d) a second conductive element engaged to the opposite side of said dielectric layer from said first conductive element, said second conductive element including a capacitor plate, a coil and a pad; and
 - (e) means establishing electrical contact between said first conductive element and said second conductive element.
11. A security tag according to claim 10, wherein said layer of metal has a hologram thereon.
12. A security tag according to claim 10, wherein one of said first conductive element capacitor plate and said second conductive element capacitor plate has a hologram thereon.
13. A security tag according to claim 10 wherein said security tag is one of a length of security tags formed in a substantially

continuous, in-line operation wherein each said first conductive element is applied to a substrate forming part of a continuous web by transferring, under pressure, a discrete portion of a metal layer from a length of first composite sheet or film and said second conductive
5 element is applied to said dielectric layer by transferring, under pressure, a discrete portion of a metal layer from a length of a second composite sheet or film.

14. A security tag according to claim 13, wherein the
10 untransferred portion of said first composite sheet or film is removed from said substrate prior to the transfer of said second conductive element to said dielectric layer.

15. A security tag according to claim 10, wherein said capacitor
15 plate has a holographic image embossed therein.

16. A security tag according to claim 10, wherein said capacitor
plate has (i) a holographic image embossed therein and (ii) a European
article numbering or universal product bar code embossed therein.

20

17. A security tag according to claim 10, wherein said capacitor
plate has (i) a holographic image embossed therein and (ii) a holographic
two-dimensional bar code embossed therein.

25

18. A security tag according to claim 10, wherein said capacitor
plate has (i) a holographic image embossed therein and (ii) a plurality of
high density optical information and commands embossed therein.

30

19. A security tag according to claim 10, wherein said capacitor
plate has (i) a holographic image embossed therein and (ii) a hologram

containing high density digitized and optical commands embossed therein.

20. A security tag according to claim 10, wherein said capacitor
5 plate has (i) a holographic image embossed therein and (ii) a hologram containing complex script scannable by an optical scanner.

21. A security tag comprising a

(a) composite sheet having a layer of metal with a
10 hologram embossed thereon, said layer of metal having a series of interruptions, said interruptions having a size and spacing permitting electromagnetic radiation in the radio frequency range to pass therethrough;

(b) a dielectric layer facing affixed to said composite
15 sheet;

(c) a first conductive element including a capacitor plate positioned between said composite sheet and said dielectric layer, those portions of said composite sheet and said dielectric layer overlying said first conductive element being in interfacial contact therewith and other
20 portions of said composite sheet being in interfacial contact with said dielectric layer, said first conductive element including a pad; and

(d) a second conductive element engaged to the opposite
side of said dielectric layer from said first conductive element, said second conductive element including a capacitor plate, a coil and a pad,
25 said pad extending outwardly beyond said dielectric layer and being engaged to said first conductive element.

22. An article comprising

(a) a substrate;

(b) a first conductive element transferred to said substrate from a first film selected from the group consisting of a hologram embossable composite sheet, a hot stamping foil, a cold stamping foil and a high conductivity stamping foil, said first conductive element including a capacitor, a coil and a pad;

(c) a layer of dielectric film engaged to said substrate and said first conductive element;

(d) a second conductive element transferred to said dielectric film, said second film selected from the group consisting of a hologram embossable composite sheet, a hot stamping foil, a cold stamping foil and a high conductivity stamping foil, said second conductive element having a capacitor and a pad joined thereto; and

(e) means establishing electrical contact between said first conductive element pad and said second conductive element pad.

15

23. An article according to claim 22, wherein one of said capacitors has a holographic image stamped thereon.

24. An article according to claim 23, wherein said one capacitor has a European article numbering or universal product bar code formed thereon.

25. An article according to claim 22, wherein said means for establishing electrical contact comprises electrically conductive ink extending between said first contact pad and said second contact pad.

26. An article according to claim 22, wherein said dielectric layer has an edge and said pads of said first and second conductive elements each has an edge aligned with the edge of said dielectric layer and wherein said means for establishing electrical contact comprises

30

electrically conductive ink extending between said first conductive element and said second conductive element and across said dielectric layer edge.

5 27. An article according to claim 22, further including a hologram embossable composite sheet having a layer of metal with interruptions, said composite sheet engaged to said second conductive element and having a hologram formed thereon.

10 28. An article according to claim 22, wherein one of said capacitors has (i) a holographic image stamped thereon and (ii) a holographic two-dimensional bar code stamped thereon.

15 29. An article according to claim 22, wherein one of said capacitors has (i) a holographic image stamped thereon and (ii) a plurality of high density optical information and commands formed thereon.

20 30. An article according to claim 22, wherein one of said capacitors has (i) a holographic image stamped thereon and (ii) a hologram containing high density digitized and optical commands formed thereon.

25 31. An article according to claim 22, wherein one of said capacitors has (i) a holographic image stamped thereon and (ii) a hologram containing complex script scannable by an optical scanner stamped thereon.

32. An article according to claim 22, wherein said means for establishing electrical contact comprises said first conductive element

pad and said second conductive element pad being in direct contact through a gap in said dielectric layer.

33. A method for forming a security tag comprising the steps of

- 5 along a path;
- (a) feeding a substrate web substantially continuously
- (b) placing a first composite sheet or foil having a layer of metal in interfacial relationship with said substrate;
- (c) transferring discrete portions of said first composite sheet or foil metal layer to said substrate to form a first conductive
- 10 element having a pad, a capacitor plate and a coil between said pad and said capacitor plate;
- (d) removing the portions of said first composite sheet or foil other than said discrete portions from said substrate;
- (e) affixing a layer of dielectric material to said substrate
- 15 and said discrete portions;
- (f) placing a second composite sheet or foil having a layer of metal in interfacial relationship with said layer of dielectric material;
- (g) transferring selected portions of said second
- 20 composite sheet or foil metal layer to said dielectric layer to form a second conductive element having a pad, a capacitor plate and a conductive element therebetween;
- (h) removing the portions of said second composite sheet or foil other than said selected portions from said dielectric layer; and
- 25 (i) establishing electrical contact between said first conductive element pad and said second conductive element pad.

34. A method for forming a security tag according to claim 33, wherein the step of establishing electrical contact comprises applying an

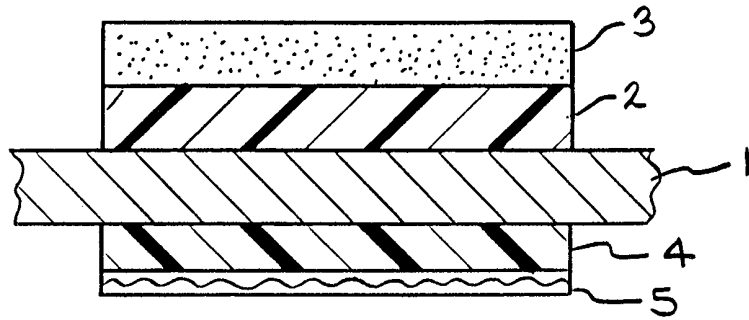
electrically conductive ink or coating to extend from said first conductive element pad to said second conductive element pad.

5 35. A method for forming a security tag according to claim 33, wherein said layer of dielectric material is shaped to overlie all of said first conductive element except said pad and said first conductive element pad is in direct contact with said second conductive element pad.

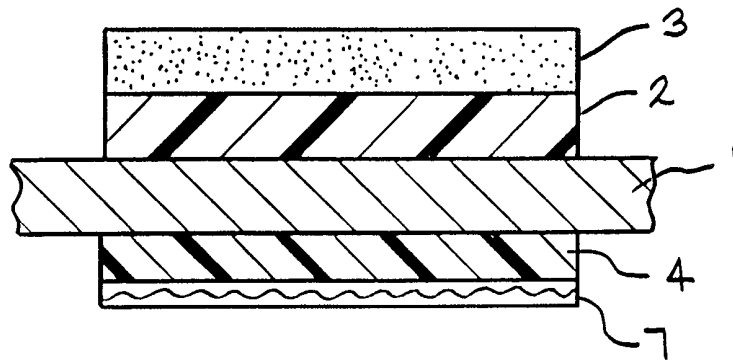
10 36. A method for forming a security tag according to claim 33, further including the step of forming a holographic image or diffraction grating image on said second conductive element capacitor plate.

15 37. A method for forming a security tag according to claim 33, further including the step of forming in said second conductive element capacitor plate an indicia selected from the group consisting of (1) two-dimensional bar code, (2) high density optical information, (3) high density digitized commands, and (4) complex script scannable by optical scanner.

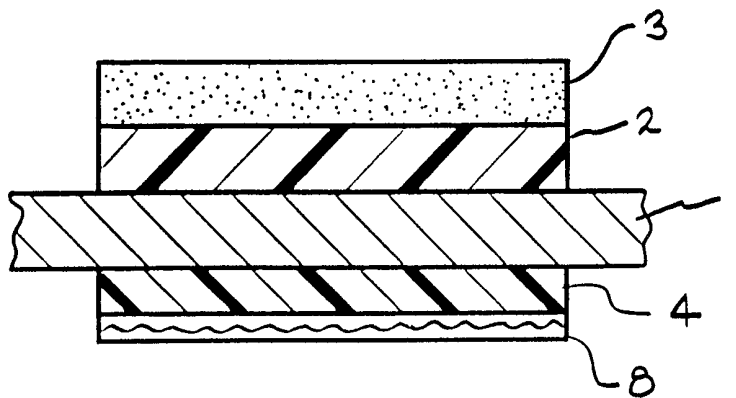
20 38. A method for forming a security tag according to claim 33, further including the step of forming in said second conductive element capacitor plate, a holographic or diffraction grating image and an indicia selected from the group consisting of (1) two-dimensional bar code, (2)
25 high density optical information, (3) high density digitized commands, and (4) complex script scannable by optical scanner.



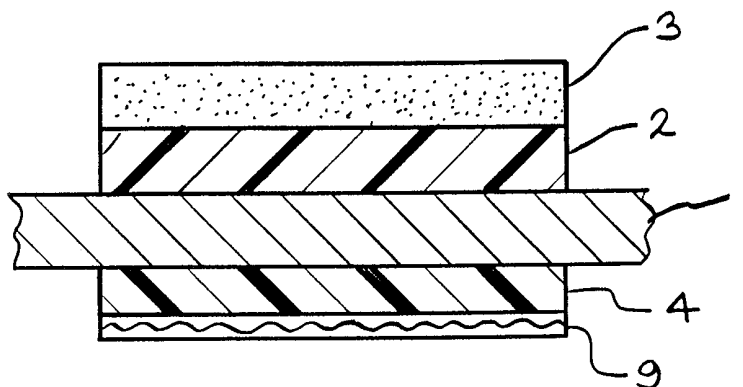
—FIG. 1



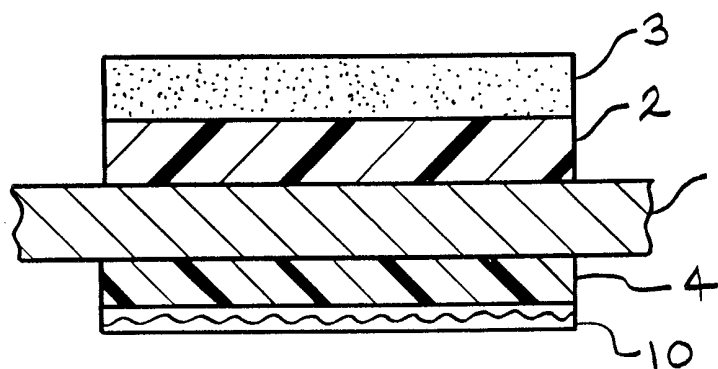
—FIG. 1A



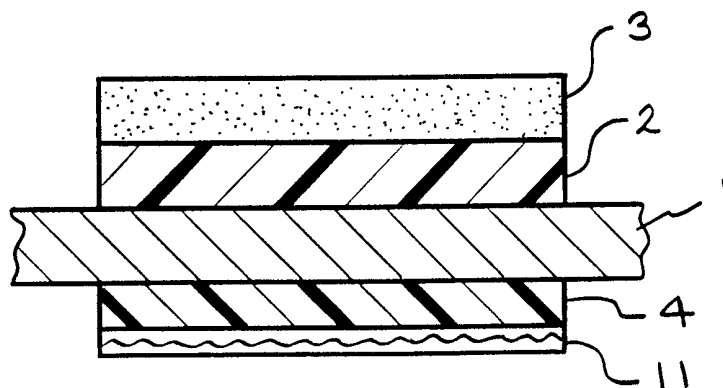
—FIG. 1B



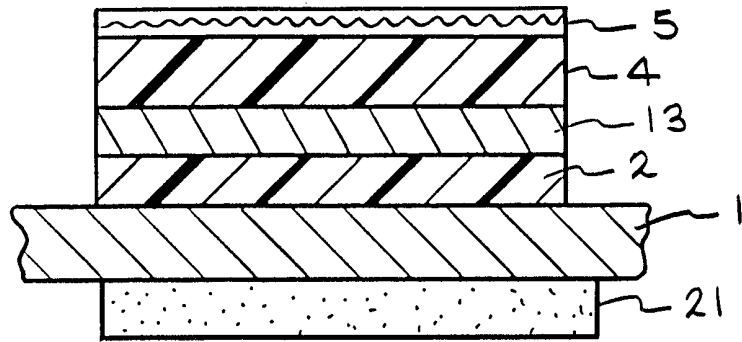
—FIG. 1C



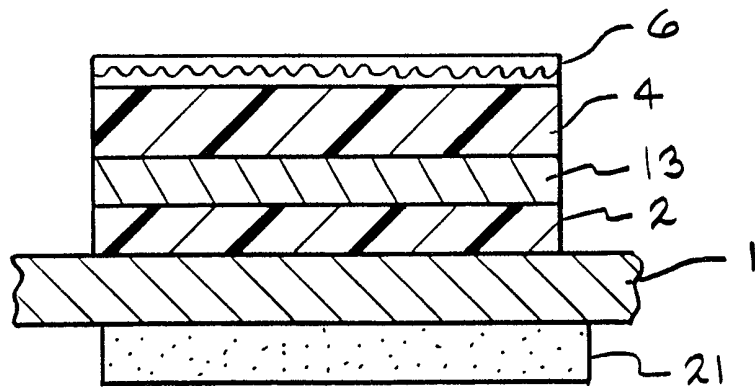
—FIG. 1D



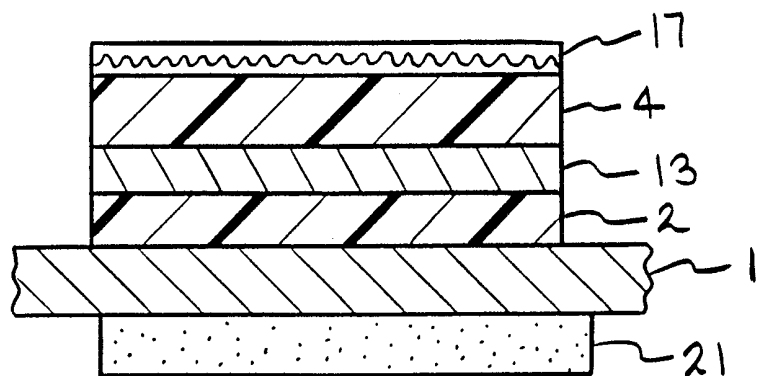
—FIG. 1E



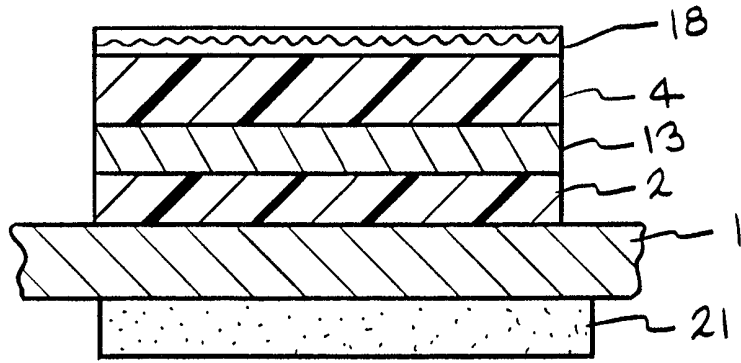
—FIG. 2



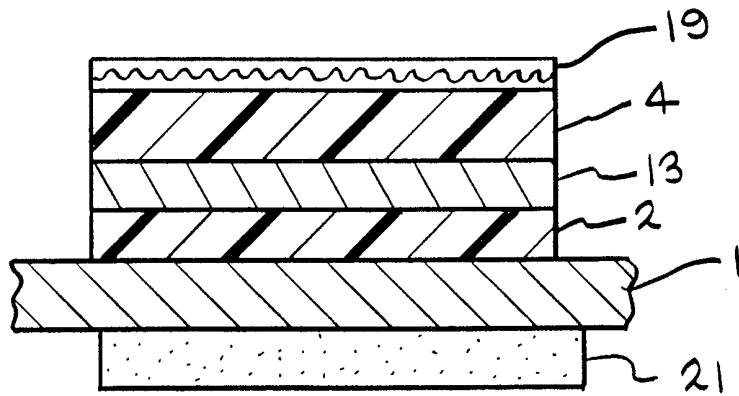
—FIG. 2A



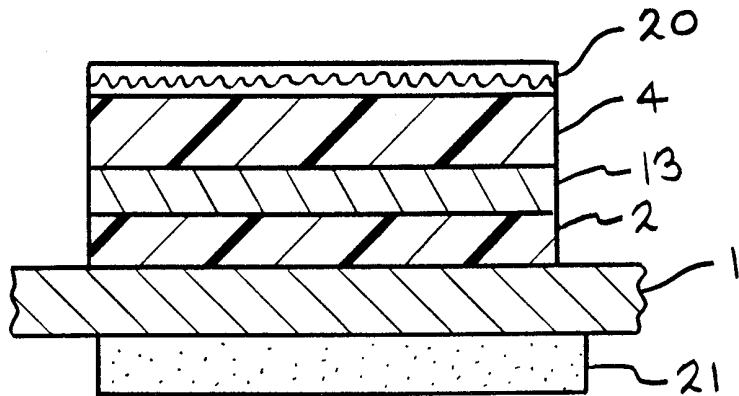
—FIG. 2B



—FIG. 2C

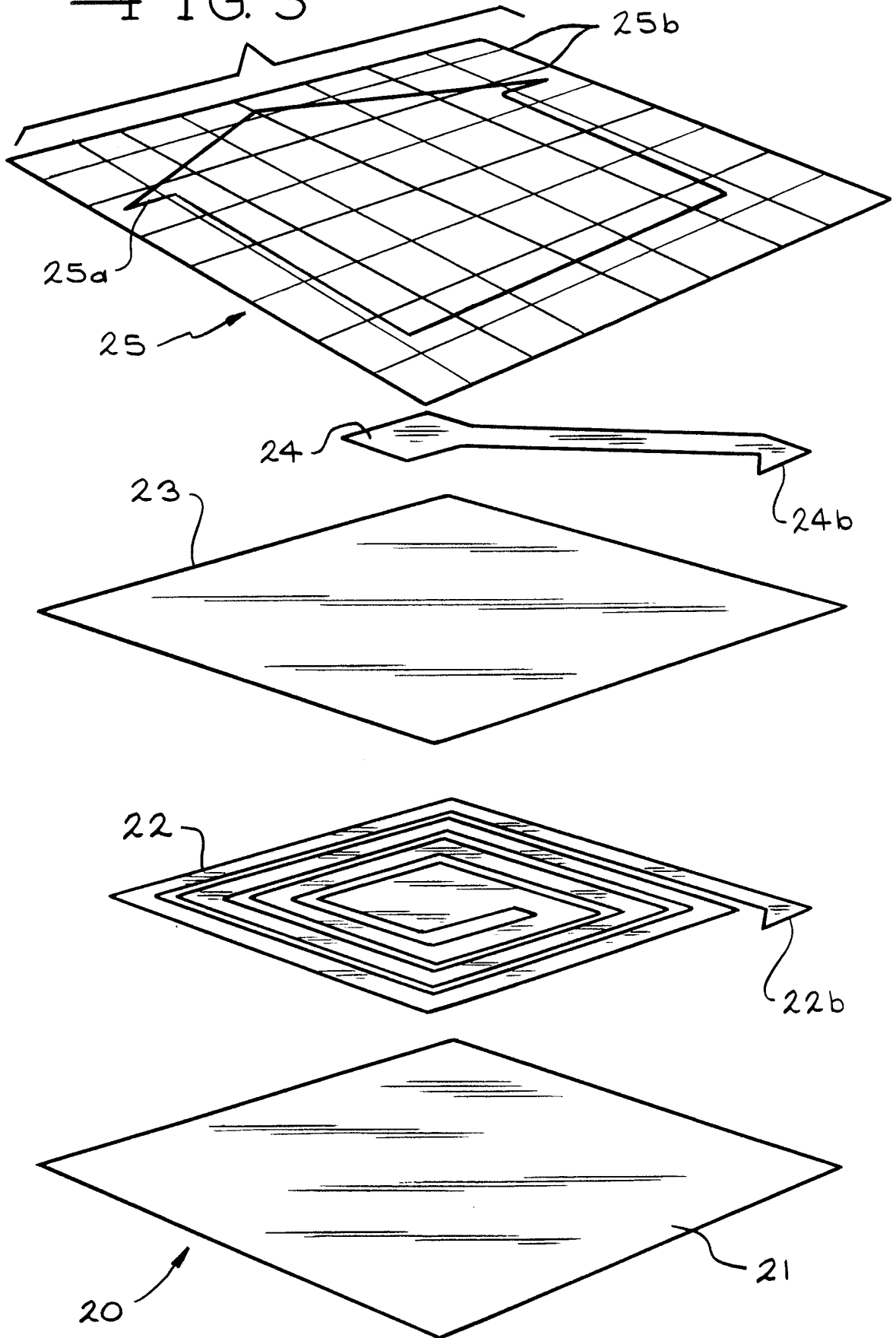


—FIG. 2D



—FIG. 2E

FIG. 3



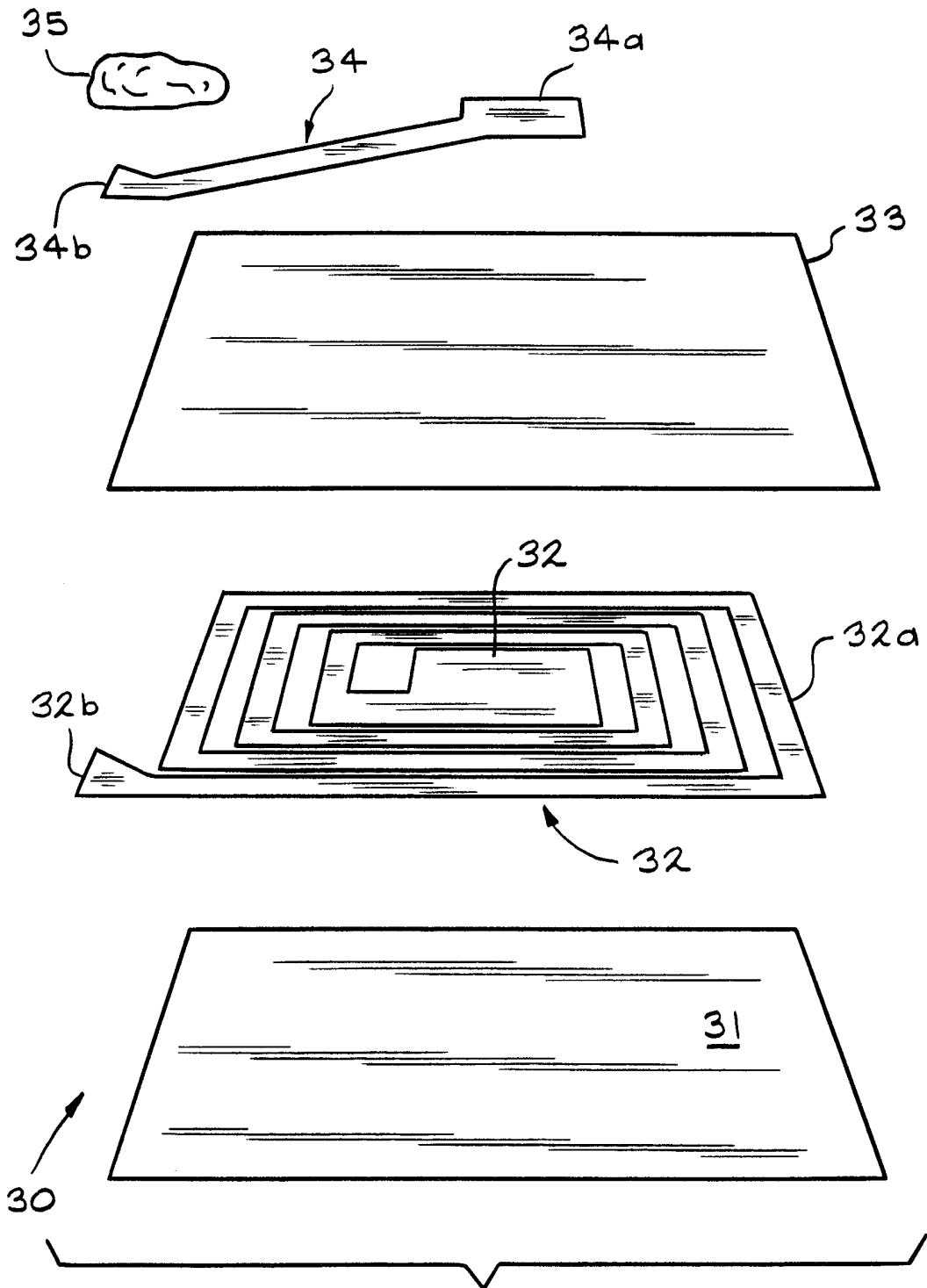


FIG. 4A

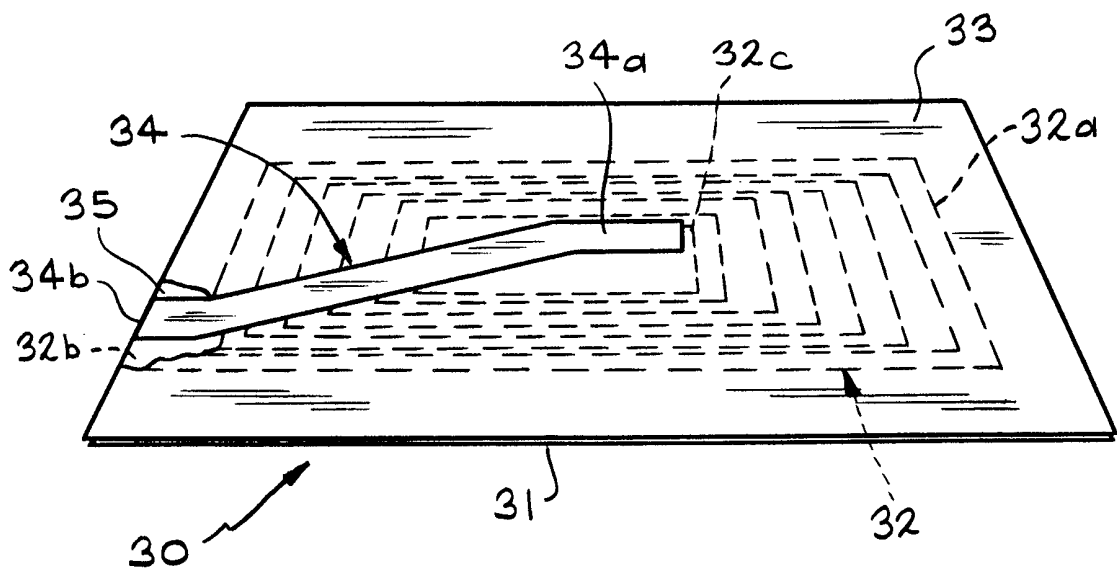


FIG. 4B

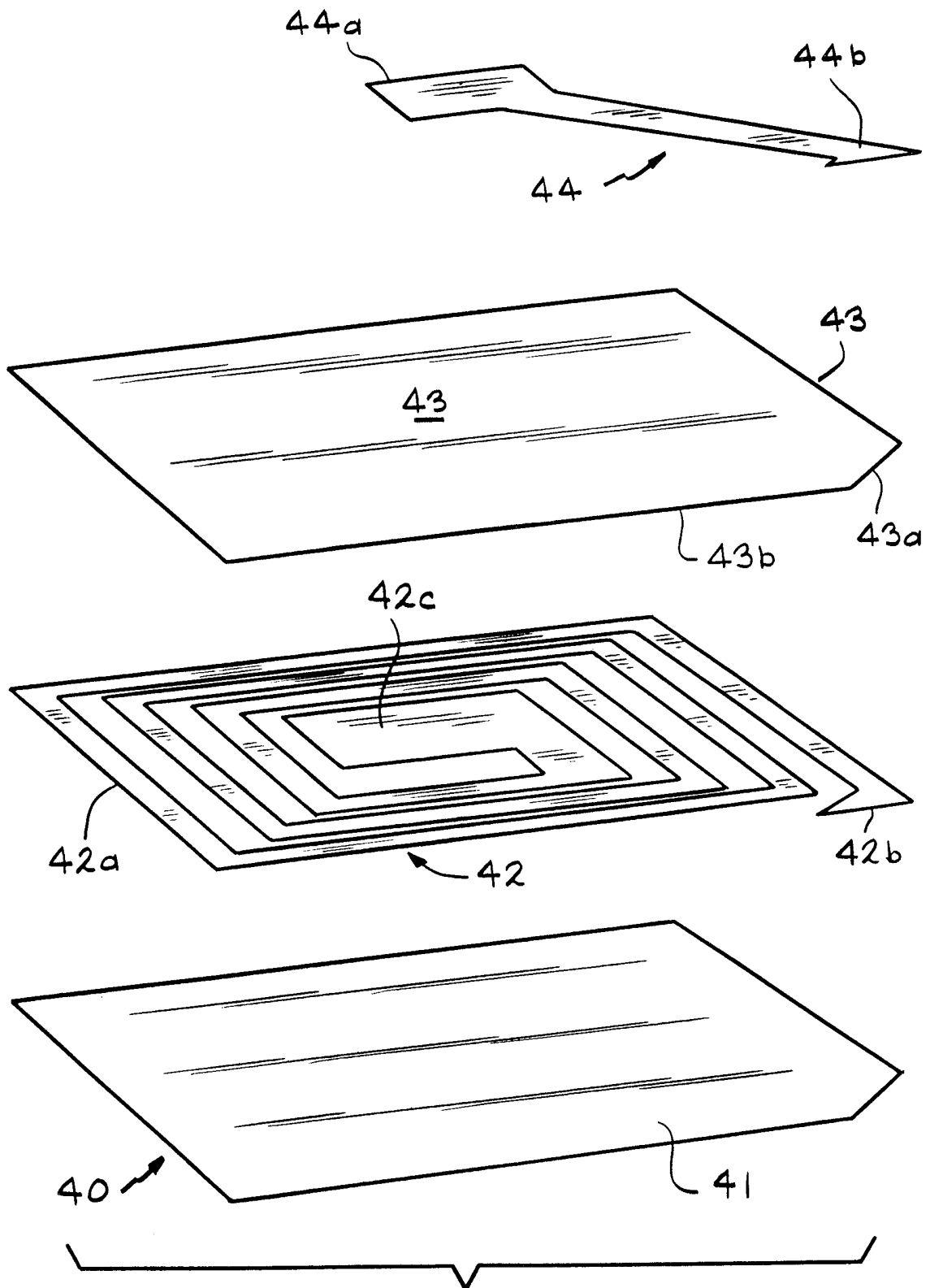


FIG. 5A

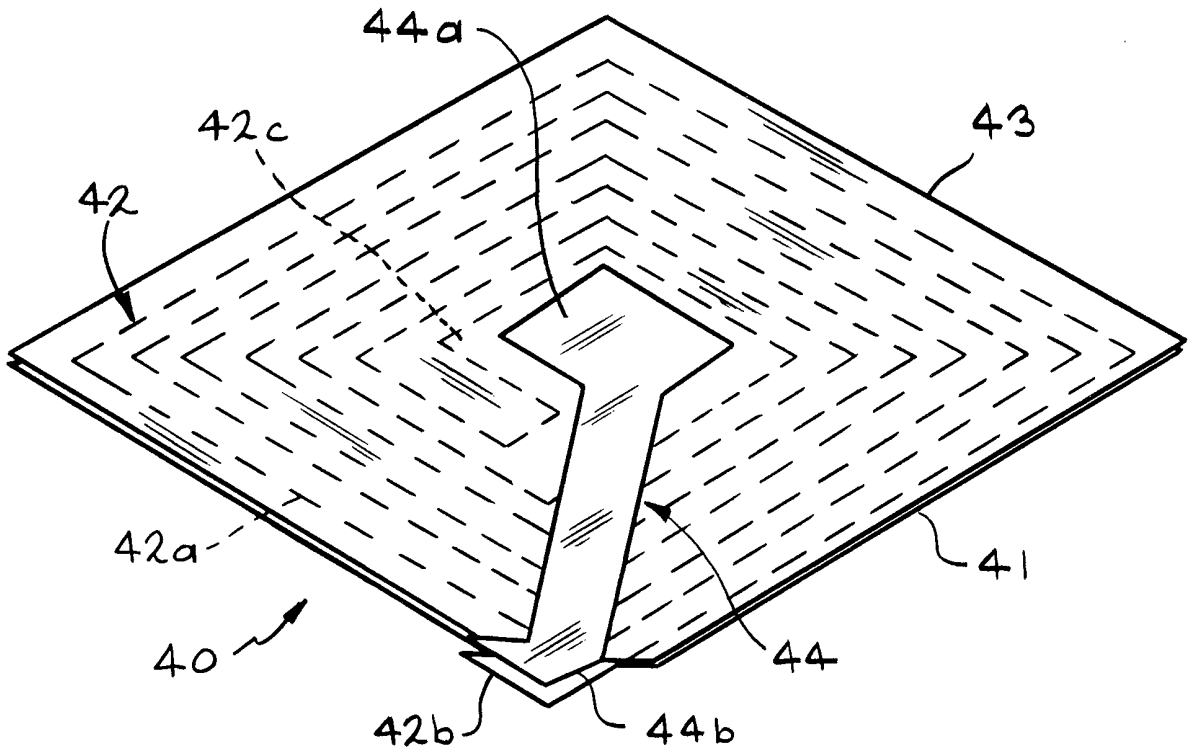


FIG. 5B

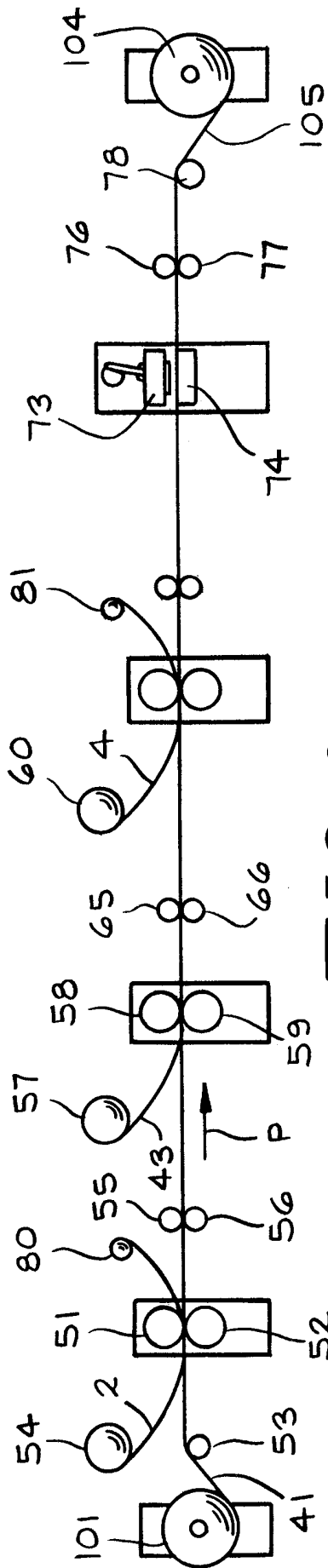


FIG. 6

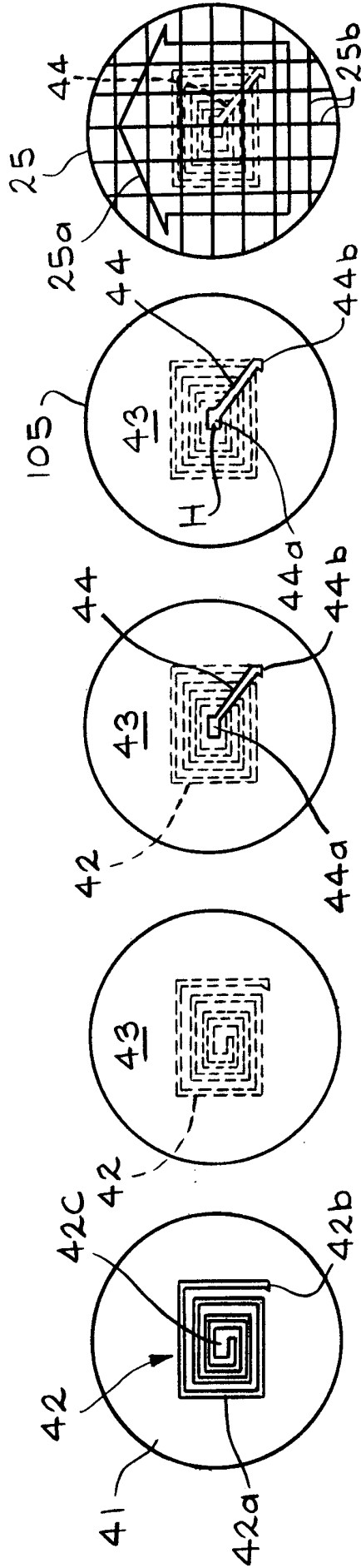


FIG. 6A FIG. 6B FIG. 6C FIG. 6D FIG. 7

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US99/15179

A. CLASSIFICATION OF SUBJECT MATTER

IPC(6) :G08B 13/14

US CL :340/572.5,572.7,825.34; 29/846; 156/269; 343/895

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 340/572.5,572.7,825.34; 29/829,846; 156/52,269; 343/895; 428/457,209; 427/96

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

NONE

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

APS (tag, web, substrate, dielectric, RF, security, electronic, foil, ink)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 4,846,922 A (BENGE et al.) 11 July 1989, Figs. 1-3, the Abstract, col. 4, lines 26-30 and col. 6, lines 27-31.	1-5, 22, 25-26,32

Further documents are listed in the continuation of Box C. See patent family annex.

* Special categories of cited documents:	*T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
A document defining the general state of the art which is not considered to be of particular relevance	*X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
E earlier document published on or after the international filing date	*Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
L document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	* & * document member of the same patent family
O document referring to an oral disclosure, use, exhibition or other means	
P document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search

16 SEPTEMBER 1999

Date of mailing of the international search report

08 OCT 1999

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