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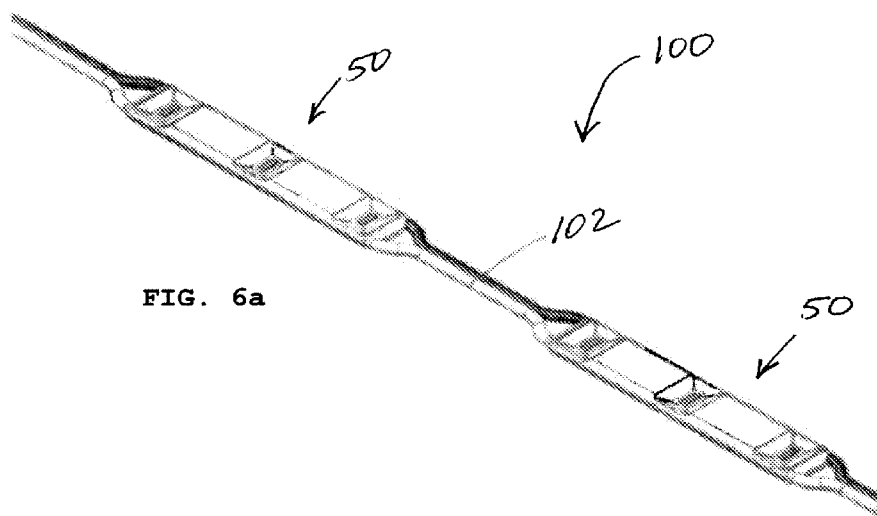


FIG. 6a

(57) Abstract: The invention described herein is directed to different embodiments of a low profile lighting unit that in some embodiments is adapted to conform to the shape of the mounting surface and/or adapted to be adjustable so as to be arranged in different configurations to accommodate various lighting applications.



FLEXIBLE RIBBON LED MODULERELATED APPLICATION

[0001] This application claims the benefit of priority of U.S. Provisional Application Serial No. 61/672,211 to Lind et al., which was filed on July 16, 2012. U.S. Provisional Application Serial No. 61/672,211, including its drawings, schematics, diagrams and written description, is hereby incorporated in its entirety by reference.

BACKGROUND OF THE INVENTIONField of the Invention

[0002] This invention relates to lighting units, which are well suited for use with solid state lighting sources, such as light emitting diodes (LEDs), and more particularly to LED based low profile lighting units for different illumination applications such as illuminating channel letters.

Description of the Related Art

[0003] Recent developments in LEDs have resulted in devices that are brighter, more efficient and more reliable. LEDs are rugged, consume less power, have a relatively long life (up to 100,000 hours), operate at low voltage, and are 30 to 70% more energy efficient than conventional lights, such as incandescent,

neon or fluorescent bulbs. As a result of these developments, LEDs are becoming utilized in many more lighting applications that were previously the realm of incandescent, neon or fluorescent light sources.

[0004] Channel letters are commonly found on the outside of buildings and are often used to advertise the name of the business. They are typically constructed of aluminum or plastic housing having the shape of a letter and are approximately 5" deep, while low profile channel letter housings are less than 5" deep. The housing has a generally U-shaped cross-section, with the top opening in the housing covered by a colored translucent lens that transmits light from within the housing. Low profile channel letters are being used in different settings, such as indoors or where physical space is limited.

[0005] Channel letters are typically illuminated with neon or fluorescent light sources that are mounted within the channel letter housing. Neon and fluorescent lights provide a bright and continuous light source that allows the channel letters to be visible at night. These light sources, however, have a relatively short life (20,000 hours), are fragile, operate at high voltage (7,000 to 15,000 volts for neon) and can consume a relatively large amount of power. Neon bulbs can also experience difficulty with cold starting, which can lead to the bulb's failure. These light sources can be bulky such that they would not be able to be used in low profile channel letter housings. Additionally, neon and fluorescent lights have rigid housings that are shaped to fit the desired application. Neon and fluorescent lights do not have the flexibility of being able to be manipulated and/or adjusted to accommodate for different applications after the shape of the housing has been formed.

[0006] Conventional channel letter lighting units are typically made of a rigid PCB within a housing, while other conventional channel letter lighting units are arranged as a long, flexible ribbon. Conventional rigid modules work well in shallow channel letters as long as the overall face of the letter is quite large. Shallow channel letters that are either very small overall or have a narrow cavity that allow only a single row of modules to be installed can appear blotchy and uneven when illuminated with conventional channel letter rigid modules. This trend holds for nearly every type of channel letter including: face-lit, back-lit or halo, and solid-lens acrylic letters. Because they are rigid, these modules are not ideal to install on tightly curved walls of small channel letters.

[0007] Conventional flexible ribbon-style products solve many of the above problems, encountered by rigid modules, as they typically feature more lower-powered LEDs spaced closely together. The closely spaced LEDs solve the blotchy appearance of many applications. However, the flexible ribbon products are limited in two key ways. The first is that they only flex in one plane. This does not limit their use on the walls around the perimeter of channel letters. However, if the channel letter shape or application is more conducive to mounting the LEDs on either the face or bottom of the letter, the flexible ribbon must be cut and spliced into several short, straight sections. This is analogous to attempting to create a circular pattern of tape on a flat piece of paper; an impossible feat without cutting the tape into short sections. The need for an installer to cut and splice sections of ribbon product together makes apparent the second key limitation of flexible ribbon

products. To connect the ribbon the installer must cut and strip two pieces of wire to solder between each connection. This process is quite tedious and requires soldering implements. The over molded versions of LED ribbon products require the additional step of scraping the overmold off to expose the solder connection point. Both types of ribbons leave the solder joint exposed unless the installer takes yet another additional step of coating or covering the joint.

[0008] For example, FIG. 1 shows a small, back-lit channel letter unit 10 with a very narrow cavity 12. The channel letter 10 only has enough room for 5-10 of the smallest conventional channel letter modules. Those modules do not spread emitted light sufficiently to provide an even light distribution. The ideal way to propagate the channel letter unit 10 with conventional channel letter products is with an LED ribbon device on the bottom flat surface 14. In order to ensure proper installation, the installer must cut and splice 2 or 3 sections together.

[0009] FIG. 2 shows another conventional shallow back lit channel letter unit 20 with a narrow cavity 22 propagated with small conventional channel letter modules 24. The configuration shown in FIG. 2 does not provide even light distribution, because the channel letter modules 24 are too far apart to blend evenly in such a shallow channel letter unit 20. The modules 24 occupy too much space to allow the light to properly reflect off the inner surfaces 26 of the channel letter 20. A better way to propagate the channel letter unit 20 is to use an LED ribbon product 30 mounted to either the wall 27 or bottom 29 of the channel letter unit 20, as shown in FIGs. 3 and 4. Mounting a ribbon product 30 to the wall 27 is relatively simple, as it

only requires one continuous strip. FIG. 3 shows an example of the conventional LED ribbon product 30 mounted to the wall 27 of the channel letter unit 20.

[0010] FIG. 4 shows an example of the conventional LED ribbon product 30 mounted to the bottom 29 of the channel letter unit 20. A disadvantage of mounting the LED ribbon product 30 to the bottom 29 of the channel letter unit 20 is that the LED ribbon product 30 must be cut and spliced forming multiple sections of the ribbon product 30, in order to provide illumination to the channel letter unit 20. This increases the complexity of the installation as well as the time and expense of installing the LED ribbon product 30.

[0011] LEDs have certain characteristics that make them desirable for many lighting applications that were previously the realm of incandescent or fluorescent lights. Incandescent lights are very energy-inefficient light sources with a vast majority of the electricity they consume being released as heat rather than light. Fluorescent light bulbs are more energy efficient than incandescent light bulbs, but are still relatively inefficient. LEDs by contrast, can emit the same luminous flux as incandescent and fluorescent lights using a fraction of the energy.

[0012] In addition, LEDs can have a significantly longer operational lifetime. Incandescent light bulbs have relatively short lifetimes, with some having a lifetime in the range of about 750-1,000 hours. Fluorescent bulbs can also have lifetimes longer than incandescent bulbs such as in the range of approximately 10,000-20,000 hours, but provide less desirable color reproduction. In comparison, LEDs can have lifetimes

between 50,000 and 70,000 hours. The increased efficiency and extended lifetime of LEDs is attractive to many lighting suppliers and has resulted in LED lights being used in place of conventional lighting in many different applications. It is predicted that further improvements will result in their general acceptance in more and more lighting applications. An increase in the adoption of LEDs in place of incandescent or fluorescent lighting would result in increased lighting efficiency and significant energy saving.

[0013] The increased efficiency and extended lifetime of LEDs is attractive to many lighting suppliers and has resulted in LED lights being used in place of conventional lighting in different sign applications. For example, U.S. Patent No. 5,697,175 to Schwartz, discloses a low power illuminated sign that is particularly adapted for use with common EXIT signs over doorways. The back of each sign comprises a reflector with a series of cavities with curved surfaces. Each cavity corresponds to a letter and background area in the sign. LEDs are mounted in the center of the cavities to illuminate the letters or background area. The LEDs are provided on a separate perpendicular circuit board or on a central projection formed in the bottom of the cavities, with light from the LEDs directed outward. The letters and background area of the sign are illuminated by light reflecting forward from the curved surfaces of the cavities, so that the only visible light is from the illumination of the cavities.

[0014] U.S. Patent No. 6,042,248, to Hannah et al., discloses an LED assembly for channel letter illuminating signs having an enclosure/housing covered by a translucent lens. Each sign includes a plurality of track moldings at the base of its

enclosure, with the moldings running along the longitudinal axis of the sections of the channel letter. Linear arrays of LEDs are mounted on printed circuit boards (PCBs) that are then mounted in the track moldings. Each track molding can hold two PCBs in parallel with each of the PCBs arranged on a longitudinal edge, with the LEDs directed outward.

[0015] U.S. Patent No. 4,439,818 to Scheib discloses a lighting strip that utilizes LEDs as the light source. The strip is flexible in three dimensions and is useful in forming characters and is capable of providing uniform illumination regardless of the characters selected for display. The strip comprises a flexible multi-layered pressure sensitive adhesive tape, having a plurality of triangle cutout sections on each side of the tape, with LEDs connected in a series with a resistor. One disadvantage is that this arrangement is not durable enough to withstand the conditions for outdoor use. The flexible tape and its adhesive can easily deteriorate when continually exposed to the elements. Furthermore, this strip cannot be cut to different lengths for different, custom applications.

[0016] U.S. Patent Nos. 6,932,495 and 7,241,031, both to Sloan et al., disclose channel letter lighting units and lighting systems utilizing the lighting units. In some embodiments these lighting units can be provided as multiple lighting units interconnected by conductors in a chain so that an electrical signal applied to the chain causes the lighting units to emit light. The chain can be made available to purchasers on different holding devices such as a box, reel or rack. Different lengths of the chain can be utilized for a particular channel letter, with the desired length of chain

being cut from the holding device and mounted within the channel letter. Power can then be applied to the chain in the channel letter causing the units to emit light.

[0017] Different types of chains can have different numbers of lighting units per a length, or stated differently, a different density of lighting units. These chains are typically sold at a cost per measure of length, and the cost per length is typically greater for lighting systems having higher density. To accommodate the different needs of customers for chains of different densities, many different types of lighting system chains need to be maintained and stored and made available to customers. In some channel letter applications it may be desirable to have different densities of units in different locations. This can require purchasing multiple chains with different densities for the same job.

[0018] It is desirable to provide a lighting unit that is flexible, has a relatively low profile, and can be customized to fit and be mounted on a variety of different structures. As part of this ability to customize, it is desirable to provide a lighting unit that can be cut on location without compromising the function of the underlying light emitting devices.

SUMMARY

[0019] The invention provides various embodiments of lighting units that are efficient, reliable, cost effective and can be arranged to provide illumination for channel letters. The different embodiments comprise elements to provide a flexible low profile lighting unit that is able to be bent in various

directions. The lighting units can comprise many different materials or devices arranged in different ways, with some devices comprising a reflector. The invention is also configured such that the lighting units can be easily installed by a single individual.

[0020] In one embodiment, as broadly described herein, a lighting unit comprises a flexible printed circuit board (PCB) comprising a top surface and a bottom surface, at least one light emitting element on said PCB, and a housing, wherein said housing covers part of said PCB and is configured to receive said at least one light emitting element. The lighting unit further comprises conductors to provide an electrical current to each of said at least one light emitting element. The light emitting elements are adapted to emit light in a direction away from said housing, in response to the electrical current supplied by the conductors.

[0021] In another embodiment, a lighting unit comprises an elongated flexible PCB, at least one light emitting element on a top surface of said PCB, and first and second conductors adapted to provide an electrical current to each of said at least one light emitting element. The lighting unit further comprises a housing that covers part of said lighting unit while allowing each of said at least one light emitting element to be uncovered. The lighting unit further comprises at least one perforation such that part of said PCB is configured to be separated from said PCB while maintaining the connection of said first and second conductors, wherein the separated portion of said PCB comprises at least one of said light emitting elements. The separated portion of said PCB is adapted to be positioned in

different configurations to accommodate various lighting applications.

[0022] Some further embodiments provide channel letter lighting systems. These embodiments can comprise a channel letter housing having a translucent or transparent channel letter cover, a plurality of electrically connected lighting units mounted to the channel letter housing, and conductors to provide an electrical signal to each of the units. Each of these lighting units comprise a PCB having a plurality of light emitting elements adapted to emit light substantially away from said PCB. The PCB is adapted to conduct and dissipate heat from the light emitting elements. The lighting units are configured to accommodate for the shape of the channel letter housing, such that said lighting units can be bent and/or twisted in different directions. In some embodiments, the lighting units are further configured such that part of the lighting unit is separable forming an individualized lighting unit, wherein the separated individualized lighting unit can be repositioned, bent and/or twisted to accommodate for the shape of the channel letter housing.

[0023] These and other aspects and advantages of the invention will become apparent from the following detailed description and the accompanying drawings which illustrate by way of example the features of the invention.

BRIEF DESCRIPTION OF THE DRAWINGS

[0024] FIG. 1 is a perspective view of one embodiment of a prior art channel letter unit;

[0025] FIG. 2 is a perspective view of another embodiment of a prior art channel letter unit;

[0026] FIG. 3 is a perspective view of another embodiment of a prior art channel letter unit;

[0027] FIG. 4 is a perspective view of another embodiment of a prior art channel letter unit;

[0028] FIG. 5a is a perspective view of an embodiment of a lighting unit according to the invention;

[0029] FIG. 5b is a bottom view of the light unit of FIG. 5a;

[0030] FIG. 5c is a perspective view of another embodiment of a lighting unit according to the invention;

[0031] FIG. 6a is a perspective view of an embodiment of a light assembly according to the invention;

[0032] FIG. 6b is a bottom view of the light assembly of FIG. 6a;

[0033] FIG. 7a is a perspective view of an embodiment of a channel letter lighting system according to the invention;

[0034] FIG. 7b is a perspective view of another embodiment of a channel letter lighting system according to the invention;

[0035] FIG. 7c is a zoomed in perspective view of the channel letter lighting system of FIG. 7b;

[0036] FIG. 8a is a perspective view of another embodiment of a lighting unit according to the invention;

[0037] FIG. 8b is another perspective view of the lighting unit of FIG. 8a;

[0038] FIG. 8c is another perspective view of the lighting unit of FIG. 8a;

[0039] FIG. 9 is a perspective view of another embodiment of a lighting unit according to the invention.

DETAILED DESCRIPTION

[0040] The invention described herein is directed to different embodiments of a low profile lighting unit that in some embodiments is adapted to be adjustable, such that the lighting unit can be arranged in different configurations to accommodate various lighting applications. The lighting unit can comprise many different materials and can be used in many different lighting applications, such as but not limited to channel letter lighting. The lighting unit according to the present invention can be arranged in many different ways with many different components, and is generally arranged to provide uniform illumination to a channel letter. In some embodiments, the lighting unit can comprise a flexible PCB, at least one light emitting element on the flexible PCB, conductors to provide an electrical current to each of the at least one light emitting elements, and a housing covering part of the flexible PCB. The housing is adapted to be flexible and configured to expose the light emitting elements, such that the light emitting elements emit light in a direction away from the housing in response to an electrical current supplied by the conductors. This arrangement allows for the lighting unit to be bent and/or

twisted in different directions in order to accommodate different channel letter housings. An advantage of the lighting unit is that the shape of the lighting unit can be easily adjusted to take the form of the channel letter housing, to which it is mounted to, without having to cut lighting unit and/or conductors. This allows a single individual to easily install the lighting unit.

[0041] Some embodiments of the lighting units according to the invention can be used to provide illumination for channel letter lighting applications. However, the invention is not intended to be limited to such applications. The lighting units can be used in many different lighting applications, such as but not limited to, perimeter or border lighting. The lighting units can also be arranged to allow a single individual to easily install and manipulate the lighting unit to accommodate the shape of the housing unit which the light units are being installed.

[0042] The invention is described herein with reference to certain embodiments, but it is understood that the invention can be embodied in many different forms and should not be construed as limited to the embodiments set forth herein. In particular, the present invention is described below in regards to certain lighting units in different configurations, but it is understood that the invention can be used for many other devices having many different configurations. The components can have different shapes and sizes beyond those shown in the figures or discussed herein.

[0043] It is to be understood that when an element or component is referred to as being "on" another element or

component, it can be directly on the other element or intervening elements may also be present. Furthermore, relative terms such as "between", "within", "below", and similar terms, may be used herein to describe a relationship of one element or component to another. It is understood that these terms are intended to encompass different orientations of the device in addition to the orientation depicted in the figures.

[0044] Although the terms first, second, etc. may be used herein to describe various elements or components, these elements or components should not be limited by these terms. These terms are only used to distinguish one element or component from another. Thus, a first element discussed herein could be termed a second element without departing from the teachings of the present application. It is understood that actual systems or fixtures embodying the invention can be arranged in many different ways with many more features and elements beyond what is shown in the figures.

[0045] Embodiments of the invention are described herein with reference to illustrations that are schematic illustrations. As such, the actual thickness of elements can be different, and variations from the shapes of the illustrations as a result, for example, of manufacturing techniques and/or tolerances are expected. Thus, the elements illustrated in the figures are schematic in nature and their shapes are not intended to illustrate the precise shape of a region of a device and are not intended to limit the scope of the invention.

[0046] With reference to FIGs. 5a-5c, an exemplary lighting unit 50 is shown. In some embodiments the lighting unit 50 is configured such that the lighting unit 50 can be used to provide

illumination for channel letters and/or perimeter or border lighting applications. The lighting unit 50 comprises a PCB 66 having a top surface 65 and a bottom surface 67, at least one light emitting element 58 on the top surface 65, and a housing 52. The lighting unit 50 further comprises first and second conductors 54, 56 adapted to provide an electrical current to each of the at least one light emitting elements 58. The light emitting elements 58 are configured to emit light in a direction away from the housing 52, in response to the electrical current supplied by the first and second conductors 54, 56. The PCB 66 is further configured to be flexible, such that the PCB 66 is adapted to be bent in many different directions. In some embodiments, the PCB 66 is able to be twisted in a spiral formation, without negatively compromising the structural integrity of the PCB 66 or the electrical connection between the conductors 54, 56 and the light emitting elements 58. In other embodiments, the PCB 66 can be bent to form an obtuse angle, acute angle or a substantially right angle. In yet other embodiments, the PCB 66 is able to substantially conform to the shape of the structure to which it is mounted thereon. In yet further other embodiments, the PCB 66 can additionally be bent along multiple axes, such as being twisted into a spiral and bent such that the PCB 66 forms an obtuse angle, acute angle or a substantially right angle.

[0047] The housing 52 is configured to cover part of the PCB 66 and is arranged to receive each of the at least one light emitting elements 58. The housing 52 comprises an opening 60 to receive a respective one of the at least one light emitting elements 58. The opening 60 can be configured in many different ways, for example, as shown in FIG. 5a, the opening 60 has a

plurality of angled sidewalls 61 that are arranged to assist in directing the emitted light from the light emitting elements 58. The embodiment shown in FIG. 5a discloses that each opening 60 comprises four angled sidewalls 61, but the sidewalls 61 are not intended to be limited to the configuration of the embodiment of FIG. 5a. In other embodiments, the opening 60 has a continuous sidewall 61 such that the opening 60 has a substantially conical shape. However, in other embodiments, the opening 60 can have any number of sidewalls 61 that can be arranged to direct the emitted light in a desired light distribution pattern. In other embodiments, the opening 60 comprises a reflector on the sidewalls 61. The reflector assists in directing the emitted light away from the PCB 66 in a desired light distribution pattern. The reflector can also reduce the amount of emitted light that can be emitted in a direction not consistent with the desired light distribution pattern. The reflector can be in many different configurations, such as but not limited to, a reflective layer, reflective particles on the sidewalls 61, a reflective cup, or the like.

[0048] The housing 52 in FIG. 5a is configured to cover part of the top surface 62 of the PCB 66 and part of the first and second conductors 54, 56. However, the housing 52 does not enclose all of the PCB 66. As shown in FIG. 5b, the bottom surface 64 of the PCB 66 is exposed and is not covered by the housing 52. This configuration results in an overall profile of the lighting unit 50 that is reduced such that the lighting unit 50 does not protrude as far as conventional lighting modules, which allows the lighting unit 50 to have a low profile. An advantage of the invention is that the low profile lighting unit 50 can be used in channel letter applications wherein the

channel letter has limited and/or reduced spacing for the lighting unit. The exposed bottom surface 64 is mounted onto a surface within the channel letter housing and has the ability to alter the shape of the lighting unit 50 so as to conform to the shape of the mounting surface. In one embodiment, the back surface 64 of the PCB 66 has an adhesive strip to mount the lighting unit 50 onto the mounting surface. While in other embodiments, the lighting unit 50 is configured to receive a screw, nail, rivet, or the like to mount the lighting unit 50 to the mounting surface. However, in other embodiments, both the adhesive strip and the screw, nail, rivet, or the like can be used together to mount the lighting unit 50 to the mounting surface.

[0049] In one embodiment, the housing 52 is an overmolded housing and can be made of many different types of materials known in the art, such as but not limited to plastic, polyvinyl chloride (PVC) or any other material able to be overmolded. The housing 52 is arranged to be thin to allow the PCB 66 to be bent and/or twisted, while thick enough to provide sufficient protection to the electronic circuitry and components that may be on the PCB 66. The housing 52 provides protection to the components on the PCB 66, namely the light emitting elements 58 and the point at which the conductors 54, 56 are connected to the PCB 66. The components on the PCB 66 are not intended to be limited to only the light emitting elements 58, the PCB 66 can have other electrical elements or components that can be used to control, adjust, modify and/or regulate the emission of the light emitting elements 58, such as but not limited to resistors, microcontrollers, constant current circuitry and the like. In some embodiments, the components on the PCB 66 and/or

the PCB 66 can be covered by an encapsulant or other sealant, in addition to being within the overmolded housing 52, which further assists in protecting the components on the PCB 66 and/or the PCB 66. While in other embodiments, the components on the PCB 66 and/or the PCB 66 are only covered by an encapsulant or other sealant without the overmolded housing 52. In FIGs. 5a and 5b, the housing 52 is an overmolded housing that extends past the ends of the PCB 66 to seal the first and second conductors 54, 56, while not covering the bottom surface 64 of the PCB 66. The housing 52 is not intended to be limited to overmolded housing, but instead can be any type of housing, encapsulant and/or sealant that allows the PCB 66 to be bent and provide protection to the electrical circuit and other elements on the PCB 66.

[0050] The first and second conductors 54, 56 are electrically connected to the PCB at opposite ends of the PCB 66 and are adapted to provide an electrical current to each of the at least one light emitting elements 58. Part of the conductors 54, 56 are covered by the housing 52, specifically the electrical connection point, and extend outwards from the housing 52. In other embodiments, the conductors 54, 56 are electrically connected to the PCB 66 and continue on the PCB 66 towards the next electrical connection point, such that the housing 52 covers the conductors 54, 56 that are on the PCB 66. The conductors 54, 56 can be electrically connected to a power supply and/or another lighting unit 50 to form an array of lighting units 50. In some embodiments, the conductors 54, 56 can be bonded conductors, as shown in FIGs. 5a and 5b, whereas in other embodiments, the conductors 54, 56 can be individual conductors, as shown in FIG. 5c.

[0051] FIGs. 6a-7c disclose a light assembly 100 comprising a plurality of lighting units 50 that can be used in a channel letter lighting application. For the same or similar features, the same reference numbers will be used throughout the application herein. FIGs. 6a and 6b show the light assembly 100 using only two lighting units 50 connected together in a daisy chain configuration. However, in other embodiments, more than two lighting units 50 can be used in the light assembly 100 and the invention is not intended to be limited to a light assembly 100 comprised of only two lighting units 50.

[0052] The light assembly 100 is a low profile lighting solution due to the lighting units 50. As discussed above, the housing 52 of the lighting units 50 is configured to minimize the amount that the lighting unit 50 protrudes into the channel letter housing to which it is mounted. The light assembly 100 further comprises a joint 102 between each of the lighting units 50, such that the joint 102 allows the light assembly 100 to bend along the joint 102. The light assembly 100 can be installed in a variety of ways, such as but not limited to, multiple rows or in curved patterns on a surface of the channel letter housing. An advantage of the invention is that the lighting units 50 allows for the light assembly 100 to bend and/or twist to accommodate for different shapes of the surface to which the light assembly 100 is mounted, much like conventional LED ribbon products, while yet overcoming the limitations of conventional LED ribbon products discussed above. Conventional LED ribbon products can only be bent in one direction and often requires an installer to cut and splice the LED ribbon into several short, straight sections. The configuration of the invention allows the light assembly 100 to

be more elegantly installed around the curved walls or routed out channels of channel letters without having to cut and splice, as is customary in conventional LED ribbon products.

[0053] The light assembly 100 is adapted to conform to the shape of the walls and/or surfaces of the channel letter housing. For example, as shown in FIG. 7a, a channel letter lighting system 150 comprises a channel letter housing 110 comprising a plurality of sidewalls 112, wherein at least one of the sidewalls 112 is curved. The light assembly 100 is mounted onto the sidewalls 112 and is adapted to conform to the shape of the sidewall 112 such that the lighting units 50 and/or the joint 102 are flexed to correspond with the shape of the sidewall 112. An advantage of the invention is that the light assembly 100 has a low profile and does not substantially protrude into the channel letter housing 110. Furthermore, the low profile configuration of the lighting unit 50 allows the lighting unit 50 to be able to be bent or flexed to correspond to its mounting surface. The light assembly 100 can be mounted onto the sidewall 112 using a variety of methods, such as but not limited to, using adhesive between the lighting unit 50 and the sidewall 112, using a nail, screw, rivet or the like to mount the lighting unit 50 onto the sidewall 112. The first and second conductors 54, 56 between adjacent lighting units 50 in the embodiment of FIG. 7a, are shown as being individual conductors. However, in other embodiments, the first and second conductors 54, 56 can be bonded. Also, in the embodiment shown in FIG. 7a, the housing 52 is not present so as to provide an internal view of the PCB 66 when in a flexed configuration. It is to be understood that the lighting units 50 of the light

assembly 100 can comprise a housing 52, while in other embodiments, the lighting units 50 do not have a housing.

[0054] FIGs. 7b and 7c show another embodiment of a channel letter lighting system 250 comprising a channel letter housing 210 having a plurality of sidewalls 212, wherein at least one of the sidewalls 212 is curved or bent, such that the sidewall 212 has an angled surface. The channel letter housing 210 can also be configured such that adjacent sidewalls 212 come together to form a junction 214, wherein the junction 214 of the adjacent sidewalls 212 forms an acute, obtuse or right angle. As shown in FIGs. 7b and 7c, the light assembly 100 is mounted onto the sidewalls 212 and is adapted to substantially conform to the shape of the sidewalls 212. At least one of the junctions 214, in FIGs. 7b and 7c, is arranged to form an acute angle, wherein the lighting unit 50 is bent to substantially conform to the acute angle formed by the junction 214. The lighting unit 50 is arranged to be flexible such that the lighting unit 50 can be bent to match the angled shape of the junction 214, and not break due to being bent to substantially conform to the acute angle formed by the adjacent sidewalls 212 that form junction 214. The lighting assembly 100 provides sufficient lighting so as to give the appearance that a single light source is illuminating the channel letter housing 210. An advantage of the invention is that the lighting assembly is arranged to provide an even light distribution, even in the configuration where one or more of the lighting units 50 are bent to conform to the shape of the mounting surface. Another advantage of the invention is that the joint 102 allows the lighting assembly 100 to bend at the joint 102 around abruptly angled sidewalls or junctions that are excessively bent, such that mounting the

lighting unit 50 would be difficult or could result in excessive bending of the lighting unit 50 thereby causing deformation, breaking and/or failure of the lighting unit 50.

[0055] The embodiments shown in FIGs. 7a-7c show the lighting assembly 100 mounted on the sidewalls 112, 212 of the channel letter housings 110, 210. However, the invention is not intended to be limited to such arrangements. In other embodiments, the lighting assembly 100 can be mounted on the channel letter housing floor instead of the sidewalls. In yet other embodiments, the lighting assembly 100 can be mounted on the sidewalls and the floor of the channel letter housing. Furthermore, the channel letter housings 110, 210 are described as comprising a plurality of sidewalls, wherein at least one of the sidewalls is curved, but the invention is not intended to be limited to a channel letter housing wherein one of the sidewalls is curved. Channel letter housings can be arranged in many different shapes such as but not limited to letters, numbers, or polygons, and can have sidewalls arranged in many different ways such as but not limited to curved, flat or a combination thereof.

[0056] FIGs. 8a-8c show another embodiment of a low profile lighting unit 70, according to the invention. The lighting unit 70 comprises an elongated flexible PCB 72 having a top surface 74 and a bottom surface 76, and at least one light emitting element 58 on the top surface 74. The lighting unit 70 further comprises first and second conductors 78, 80 adapted to provide an electrical current to each of the at least one light emitting elements 58, and at least one connector 82, wherein the first and second conductors 78, 80 are received by a respective at least one connector 82 in order to form an electrical connection

with the PCB 72. The lighting unit 70 is adapted to be separable, such that part of the PCB 72 is configured to be separated from the remainder of the PCB 72 while maintaining the electrical connection of the first and second conductors 78, 80. The separated portion of the PCB 72 comprises at least one of the light emitting elements 58 and is adapted to be arranged in different configurations to accommodate various lighting applications.

[0057] The PCB 72 is similar to the PCB 66 discussed above, such that the PCB 72 is configured to be flexible and is adapted to be bent in many different directions. In some embodiments, the PCB 72 is able to be twisted in a spiral formation, without negatively compromising the structural integrity of the PCB 72. In other embodiments, the PCB 72 can be bent to form an obtuse angle, acute angle or a substantially right angle. In yet other embodiments, the PCB 72 is able to substantially conform to the shape of the structure to which it is mounted thereon. In yet further other embodiments, the PCB 72 can additionally be bent along multiple axes, such as being twisted into a spiral and bent such that the PCB 66 forms an obtuse angle, acute angle or a substantially right angle.

[0058] The first and second conductors 78, 80 are configured to run along the length of the PCB 72 and are electrically connected to the PCB 72. The conductors 78, 80 are received by the respective at least one connector 82 that is on the top surface 74 of the PCB 72. As shown in FIG. 8a-8b, the conductors 78, 80 are arranged to run along the first edge 84 and the second edge 86 of the PCB 72 in a repetitive serpentine-like pattern. The invention is not intended to be limited to arranging the conductors 78, 80 in the serpentine-like pattern

shown in FIGs. 8a-8c, the conductors 78, 80 can be arranged in many different configurations. In other embodiments, the conductors 78, 80 can run along only one of the edges 84, 86. In yet other embodiments the conductors 78, 80 do alternate running along the first and second edges 84, 86, but do so in a random or non-repetitive pattern configuration. Each of the at least one connector 82 are positioned on the top surface 74 of the PCB 72 between adjacent light emitting elements 58 and form the electrical connection between the conductors 78, 80 and the light emitting elements 58 on the PCB 72. The connector 82 can be any type of connector known in the art. In some embodiments, the connectors 82 can be Insulation-displacement connectors (IDC), Insulation-piercing connectors (IPC), or a combination thereof.

[0059] The PCB 72 further comprises a perforation 88 such that part of the PCB 72 is adapted to be separated from the remaining PCB 72, forming a separated lighting unit 90. The separated lighting unit 90 comprises at least one light emitting element 58 and maintains the electrical connection between the remaining part of the PCB 72. An advantage of the invention is that the lighting unit 70 can be installed in multiple rows or in curved patterns on a flat surface without the need to cut, splice or solder due to the PCB 72 adapted to form one or more separated lighting units 90. FIGs. 8a-8c depict the perforation 88 as being a hole through the PCB 72. However, the invention can be configured in many different ways and is not intended to be limited to the embodiments shown in FIGs. 8a-8c. In some embodiments, the perforation 88 can be a plurality of aligned holes arranged to allow the PCB 72 to be easily separated. In other embodiments, the perforation 88 can be a score, notch, or

groove that allows the PCB 72 to be separated. In yet other embodiments, the perforation 88 can be a hole in combination with a score, notch, or groove.

[0060] An advantage of the invention is that the lighting unit 70 can be partitioned to form a plurality of separated lighting units 90 that can allow the lighting unit 70 to be manipulated and arranged to accommodate the surface to which it is being mounted. The separated lighting units 90 are flexible and have a low profile, similar to the lighting units 50 discussed above, and can be bent in many different ways. The lighting unit 70 is easily configurable to account for many different lighting applications and allows an installer to selectively form separated lighting units 90, of any length, while installing the lighting unit 70. FIGs. 8b-8c, show that the separated lighting units 90 are formed by separating the PCB 72 at each perforation 88. However, in other embodiments, the separated lighting units 90 can be different lengths and can have a perforation 88 that is intact and has not been utilized to form a separated lighting unit 90.

[0061] In some embodiments, the lighting unit 70 comprises a housing 85, as shown in FIG. 9. The housing 85 covers part of the PCB 72 and part of the conductors 78, 80, and can also provide protection for the light emitting elements 58 from moisture, dust and other environmental elements that may cause the light emitting elements 58 to fail or have a reduced or altered light output. The housing 85 can also be configured to disperse light emitted from the light emitting elements 58. The housing 85 is also arranged to be clear, flexible overmolded housing to cover at least part of the lighting unit 70. In some embodiments, the conductors 78, 80 are near the top surface 74

and covered by the housing 85, and are arranged to allow the installer to easily peel the conductors 78, 80 out from the housing 85 during installation. In some embodiments of the invention, the housing 85 encloses the entire lighting unit 70.

[0062] The lighting unit 70 can be utilized in a similar fashion as the light assembly 100, discussed above. The lighting unit 70 is a low profile lighting solution that is configured to minimize the protrusion into the channel letter housing or other lighting application to which the lighting unit 70 is mounted. The lighting unit 70 can be installed in a variety of ways, such as but not limited to, multiple rows or in curved patterns on a surface of the channel letter housing. An advantage of the invention is that the separated lighting units 90 allows for the lighting unit 70 to bend and/or twist to accommodate for different shapes of the surface to which the lighting unit 70 is mounted, much like conventional LED ribbon products, while yet overcoming the limitations of conventional LED ribbon products discussed above. Conventional LED ribbon products can only be bent in one direction and often requires an installer to cut and splice the LED ribbon into several short, straight sections. The configuration of the invention allows the lighting unit 70 to be more elegantly installed around the curved walls or routed out channels of channel letters without having to cut and splice, as is customary in conventional LED ribbon products.

[0063] The lighting unit 70 is adapted to conform to the shape of the walls and/or surfaces of the channel letter housing. The lighting unit 70 is flexible and can be bent to conform to the curved surface of the mounting surface. In some instances, the curvature of the mounting surface does not allow

the lighting unit 70 to be mounted, and instead a separated lighting unit 90 is better suited to be mounted on such a curved surface. The lighting units 70 and the separated lighting units 90 can be mounted onto the mounting surface in similar manners as the light assembly 100. The lighting unit 70 is arranged to provide sufficient lighting so as to give the appearance that a single light source is illuminating the channel letter housing or other lighting application to which the lighting unit 70 is mounted. An advantage of the invention is that the lighting unit 70 is arranged to provide an even light distribution, even in configurations where one or more separated lighting units 90 are present and/or bent to conform to the shape of the mounting surface. Another advantage of the invention is that the conductors 78, 80 allow the separated lighting units 90 to be placed around abruptly angled mounting surfaces that could present difficulty in mounting the lighting unit 70.

[0064] Although the invention has been described in considerable detail with reference to certain configurations thereof, other versions are possible. For instance, the lighting units 50, 70 are depicted as having light emitting elements only on their respective top surfaces 62, 74. In other embodiments, the lighting units 50, 70 can have light emitting elements on both the top surface 62, 74 and the bottom surface 64, 76, such that the lighting units 50, 70 can be used as double-side lighting application. The gage of the conductors and length can be varied and determined by the lighting application based on current, voltage, and voltage drop over a given length. Therefore, the spirit and scope of the invention should not be limited to the versions described above.

WE CLAIM:

1. A light assembly, comprising:

a plurality of lighting units, wherein each of said plurality of lighting units comprises a flexible printed circuit board (PCB) and at least one light emitting element on said flexible PCB;

conductors electrically connected to each of said plurality of lighting units and adapted to provide an electrical signal to each of said plurality of lighting units; and

a joint between each of said plurality of lighting units, such that said light assembly can be arranged in different configurations to accommodate various lighting solutions.

2. The light assembly of claim 1, wherein adjacent lighting units are distally separated by a length of conductors running between said adjacent lighting units.

3. The light assembly of claim 2, wherein said conductors running between said adjacent lighting units forms said joint between said adjacent lighting units.

4. The light assembly of claim 1, wherein said PCB comprises an elongated PCB such that said elongated PCB is separable in order to form one of said plurality of lighting units.

5. The light assembly of claim 4, wherein said PCB comprises at least one perforation such that said PCB can be separated at said at least one perforation whereby said separated portion of said PCB forms one of said plurality of lighting units.

6. The light assembly of claim 4, wherein said conductors are arranged along a first edge and a second edge of said PCB in a serpentine pattern.

7. The light assembly of claim 6, wherein said conductors comprises elongated continuous conductors electrically connected to said PCB.

8. The light assembly of claim 1, wherein each of said plurality of lighting units comprises a housing covering part of said PCB and part of said conductors.

9. A channel letter lighting system, comprising:

a channel letter housing comprising a front, a back and a plurality of sidewalls; and

a light assembly within said channel letter housing comprising a plurality of lighting units interconnected in a daisy chain configuration with conductors and a joint between adjacent lighting units, said plurality of lighting units comprising a printed circuit board (PCB) and at least one light emitting element on said PCB;

wherein said light assembly is adapted to be arranged in different configurations to accommodate various lighting solutions

10. The channel letter lighting system of claim 9, wherein each of said plurality of interconnected lighting units comprise a flexible printed circuit board such that said lighting units are adapted to conform to a mount surface of said channel letter housing.

11. The lighting unit of claim 10, wherein said PCB comprises an elongated flexible PCB wherein said elongated flexible PCB is separable such that part of said elongated flexible PCB is configured to be separated from the remainder of said elongated flexible PCB forming a separated portion of said PCB while maintaining the electrical connection of said conductors.

12. The lighting unit of claim 11, wherein said elongated flexible PCB comprises at least one perforation such that said PCB can be separated at said at least one perforation whereby said separated portion of said PCB forms one of said plurality of lighting units

13. The channel letter lighting system of claim 9, wherein said light assembly is mounted on at least one of said plurality of sidewalls of said channel letter housing.

14. The channel letter lighting system of claim 9, wherein each of said plurality of lighting units comprise an encapsulation layer covering at least a top surface of said PCB, such that said plurality of lighting units forms a low profile light assembly.

15. The lighting unit of claim 9, wherein said PCB can be bent to form an obtuse angle, an acute angle, or a substantially right angle.

16. The channel letter lighting system of claim 9, wherein each of said plurality of lighting units comprise a housing adapted to cover a top surface of said PCB such that a back surface of

said PCB is exposed allowing said plurality of lighting units to be a low profile light assembly.

17. The lighting unit of claim 16, wherein said housing comprises at least one opening to receive each of said at least one light emitting element on said PCB.

18. The lighting unit of claim 17, wherein each of said at least one opening comprises a plurality of angled sidewalls arranged to assist in directing the emitted light from said at least one light emitting element.

19. The lighting unit of claim 17, wherein each of said at least one opening comprises a continuous sidewall such that said at least one opening has a substantially conical shape.

20. The lighting unit of claim 17, wherein each of said at least one opening further comprises a reflector on said angled sidewalls.

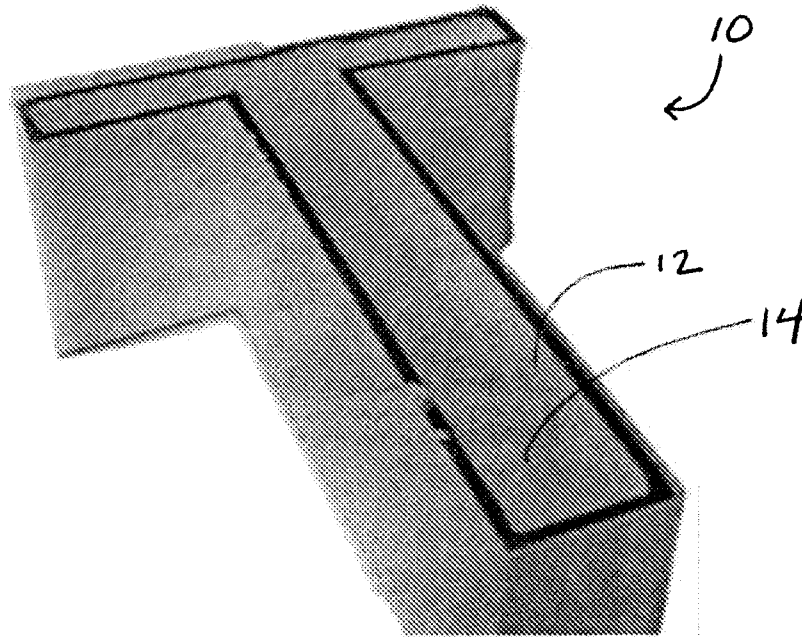


FIG. 1
PRIOR ART

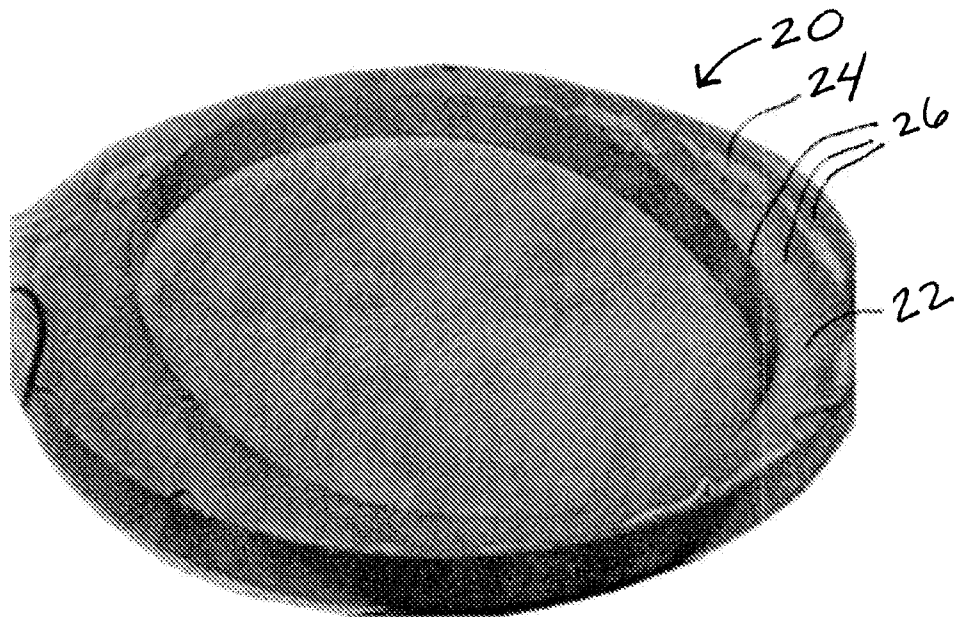


FIG. 2
PRIOR ART

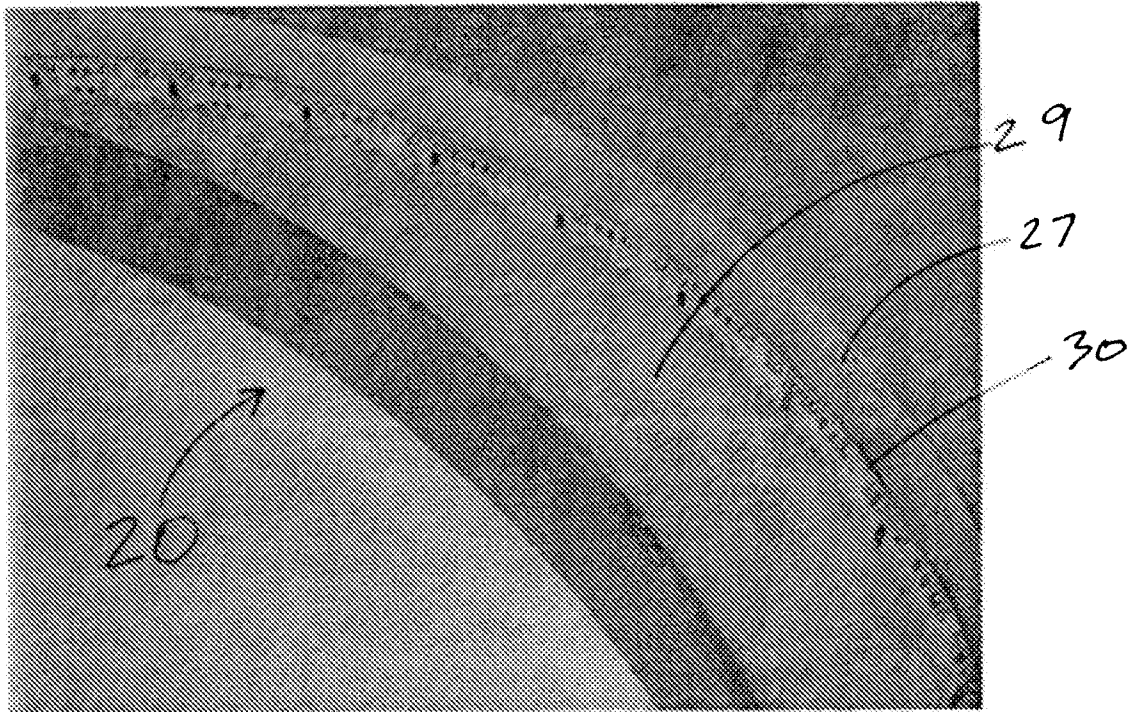


FIG. 3
PRIOR ART

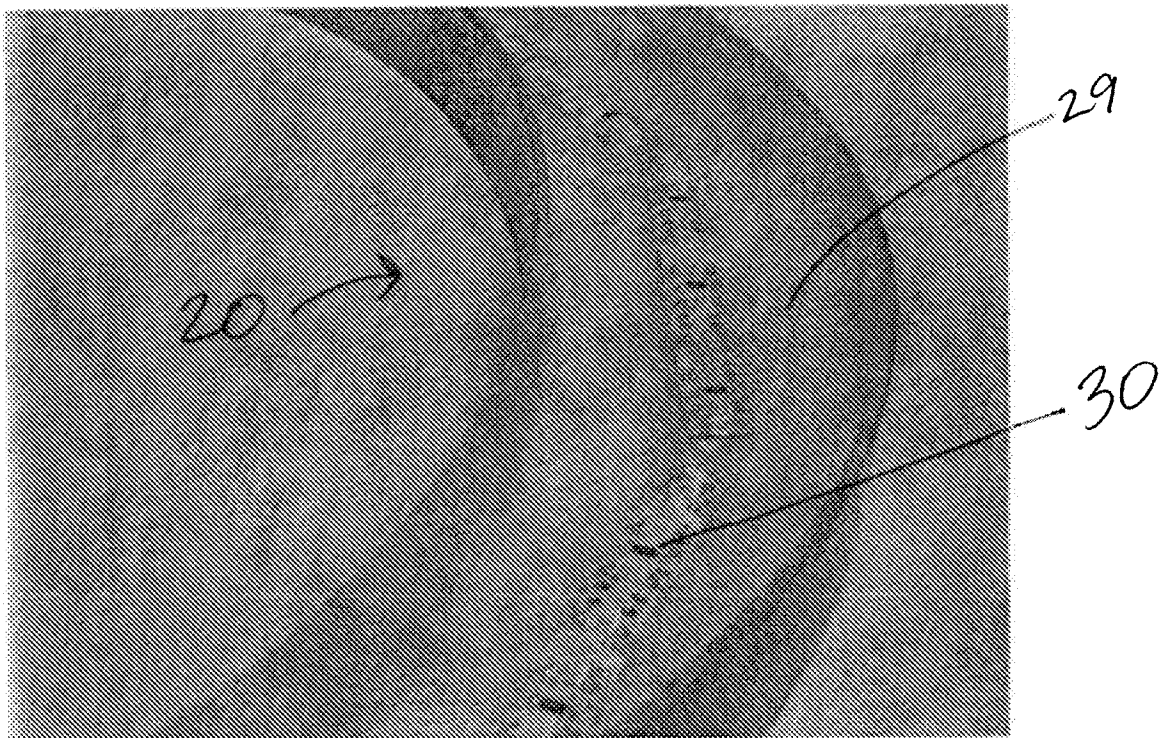


FIG. 4
PRIOR ART

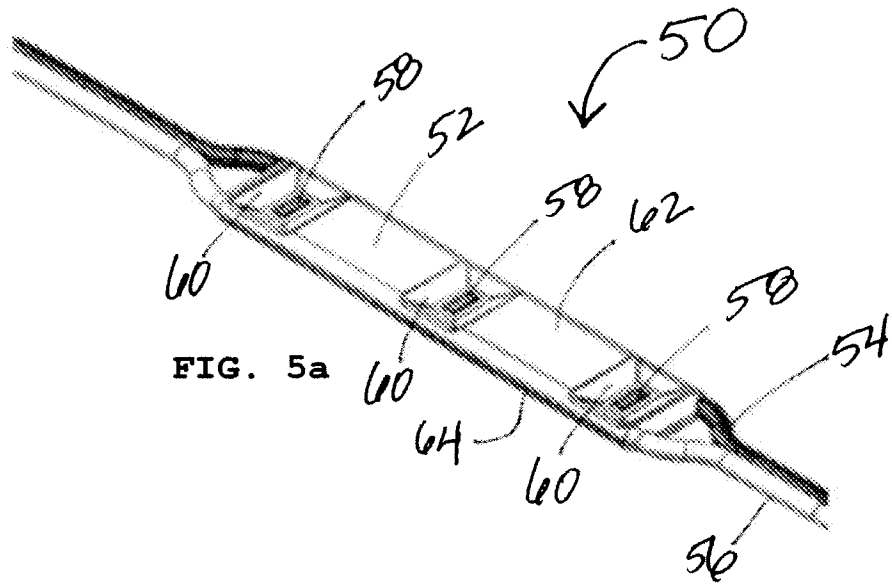


FIG. 5a

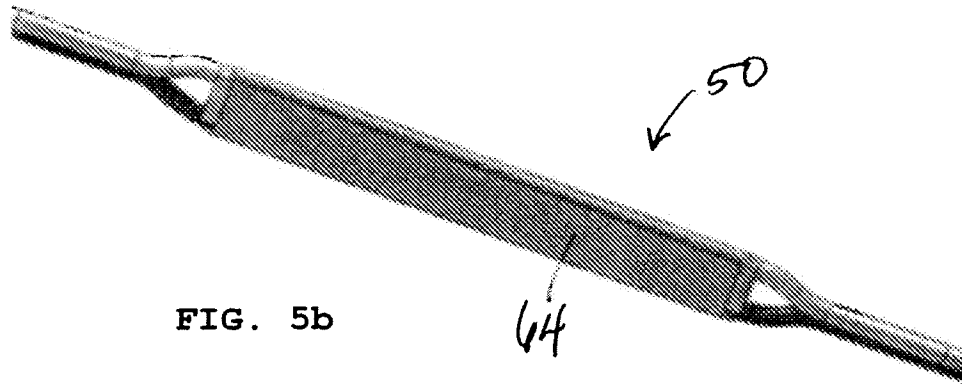


FIG. 5b

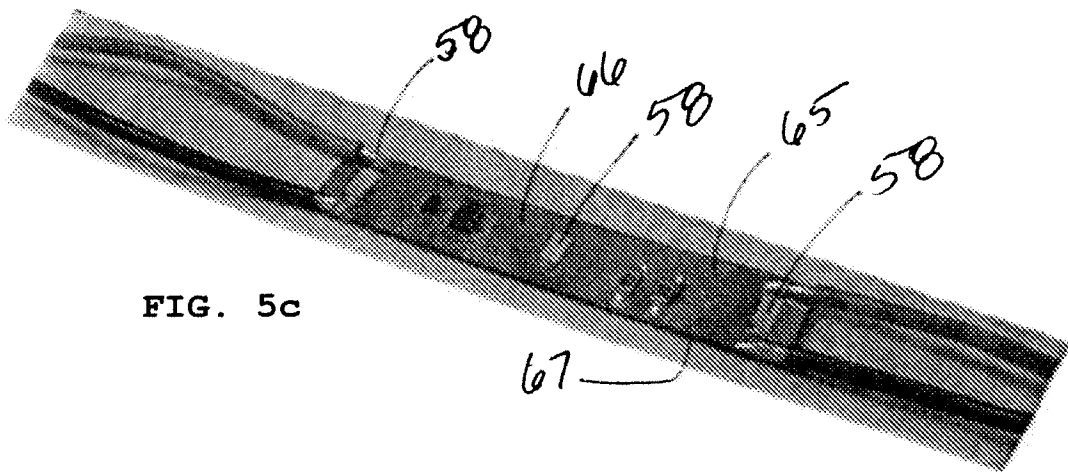


FIG. 5c

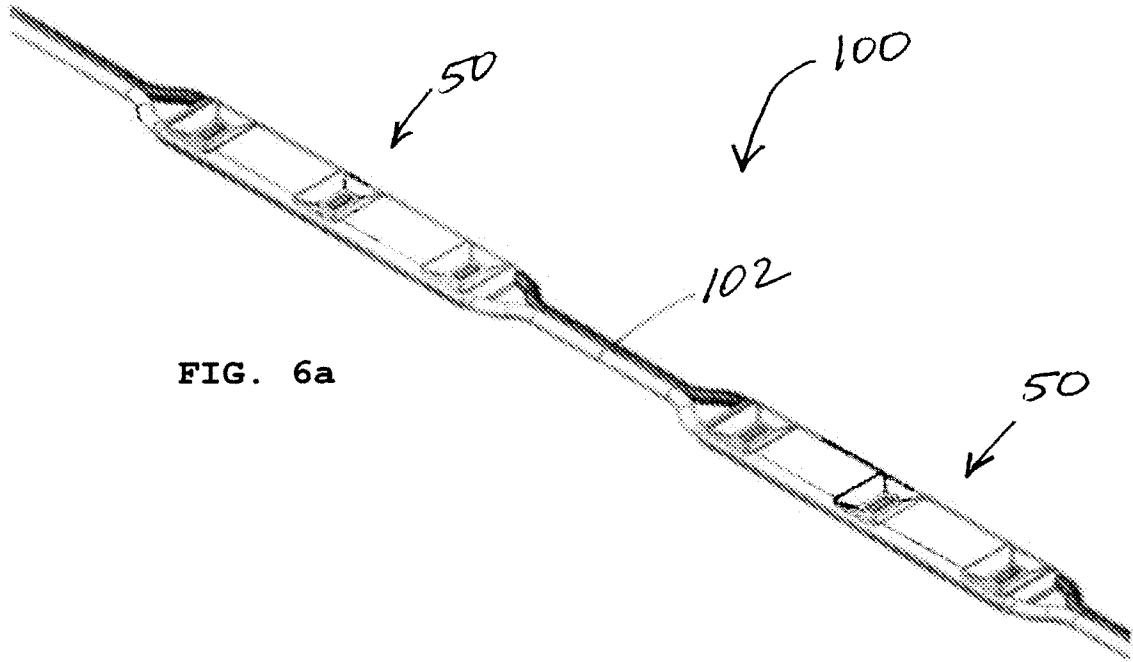


FIG. 6a

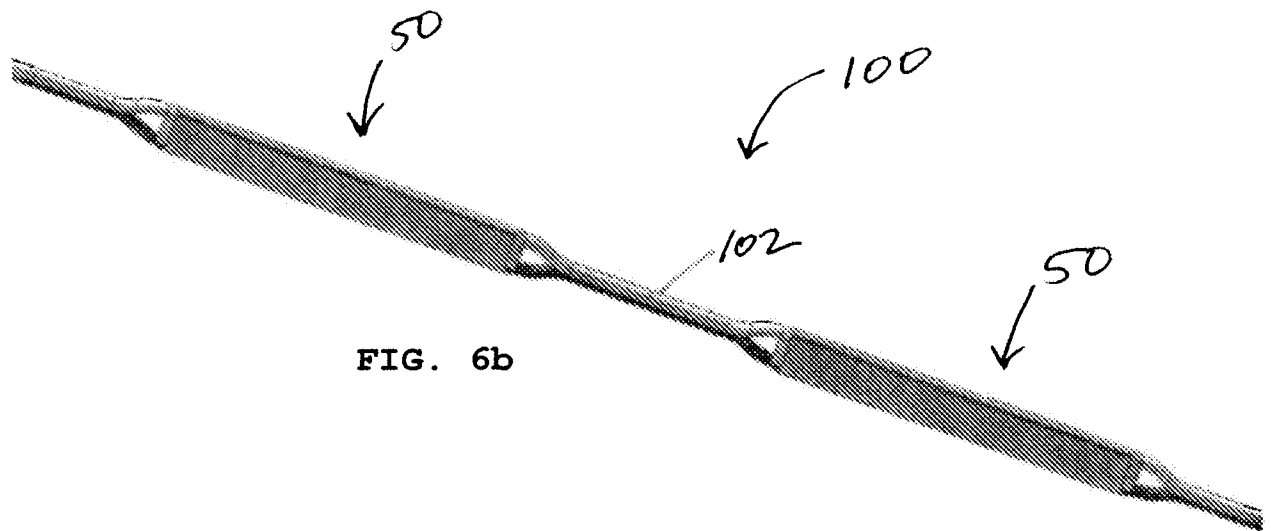


FIG. 6b

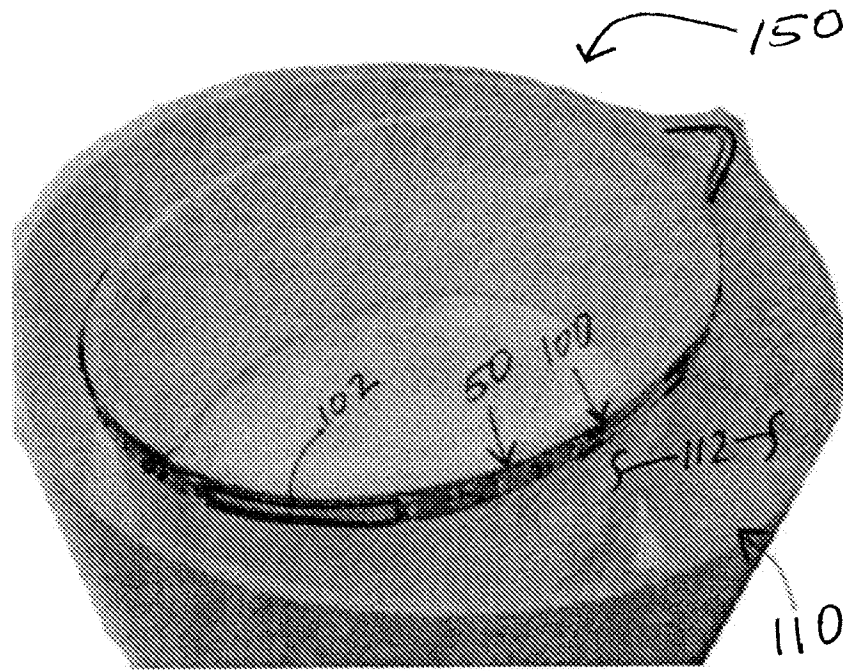


FIG. 7a

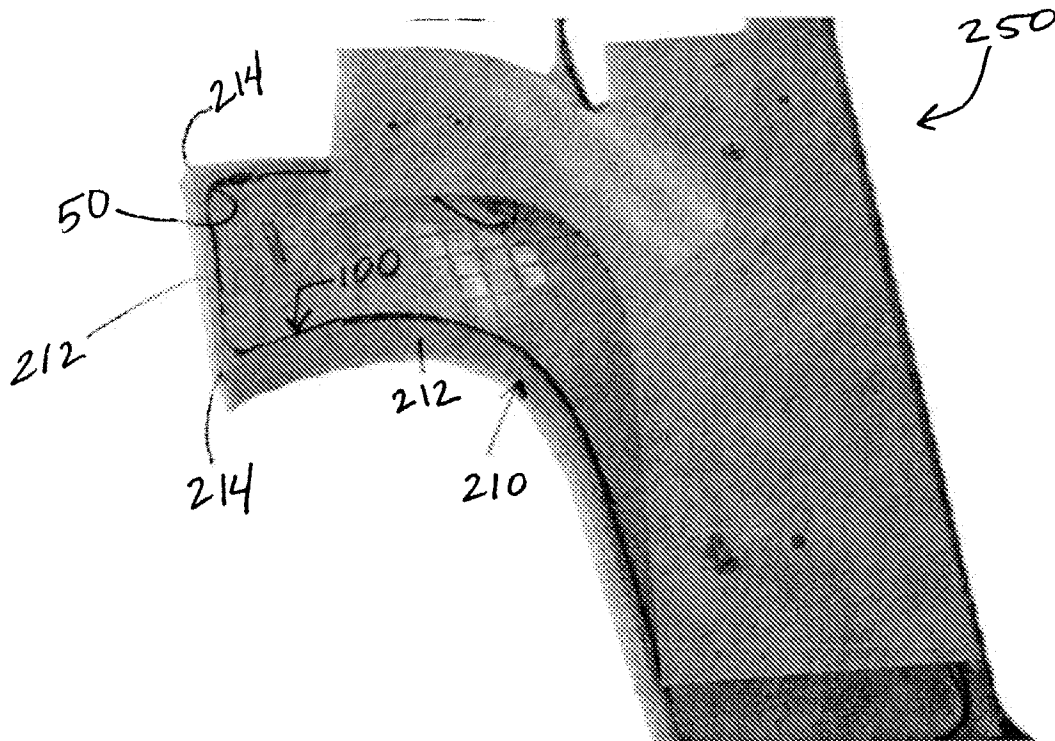


FIG. 7b

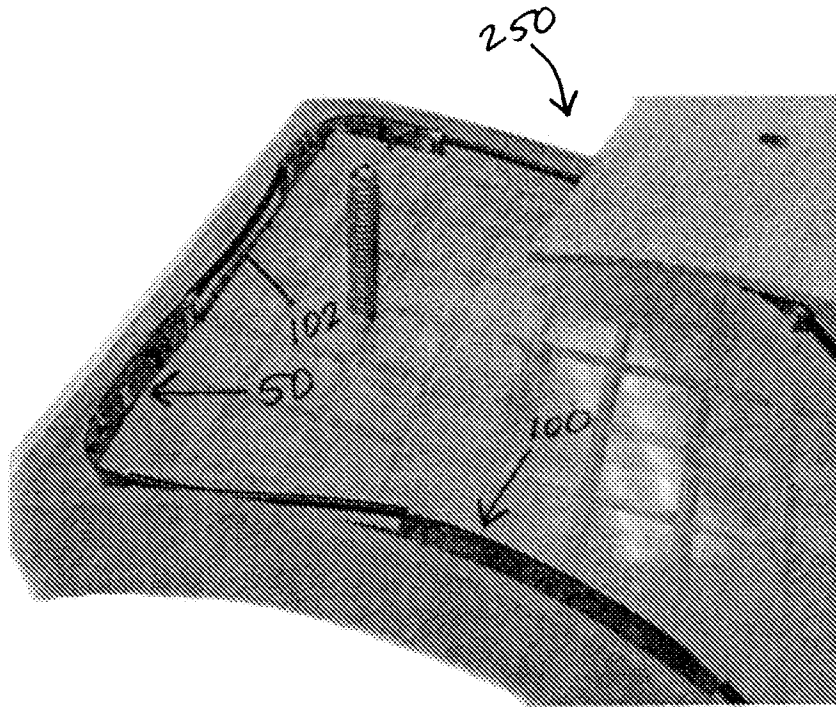


FIG. 7c

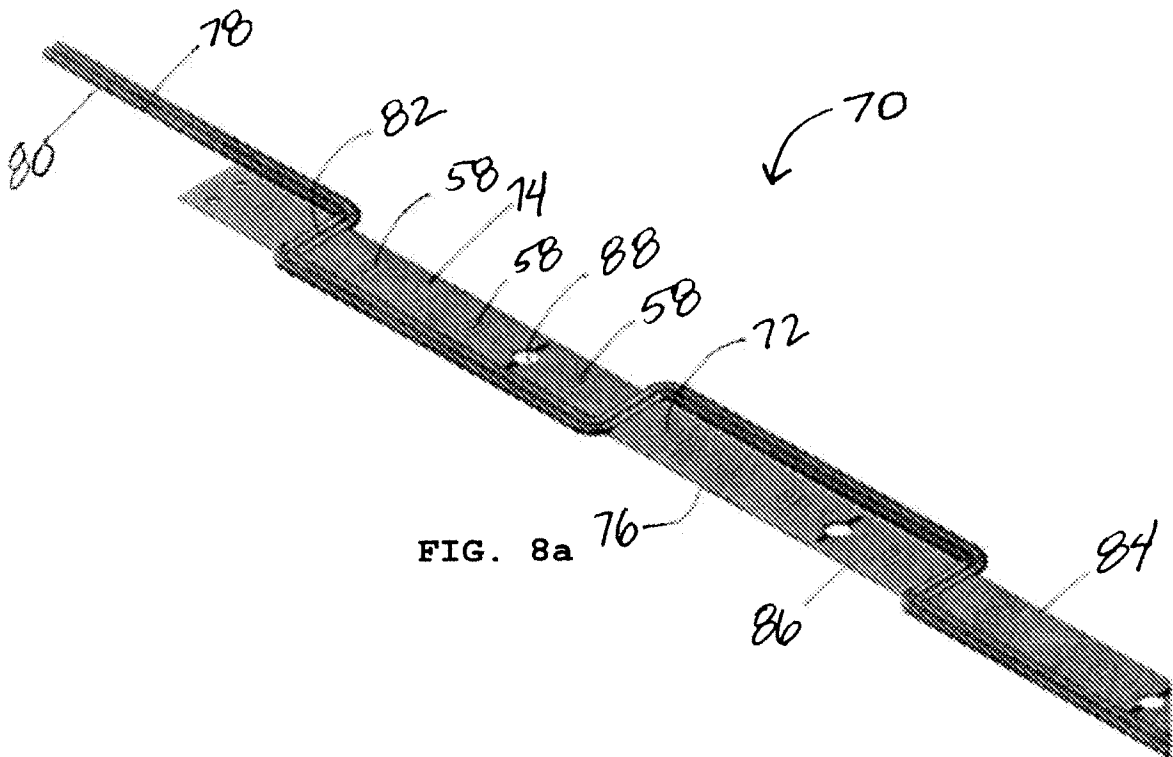


FIG. 8a

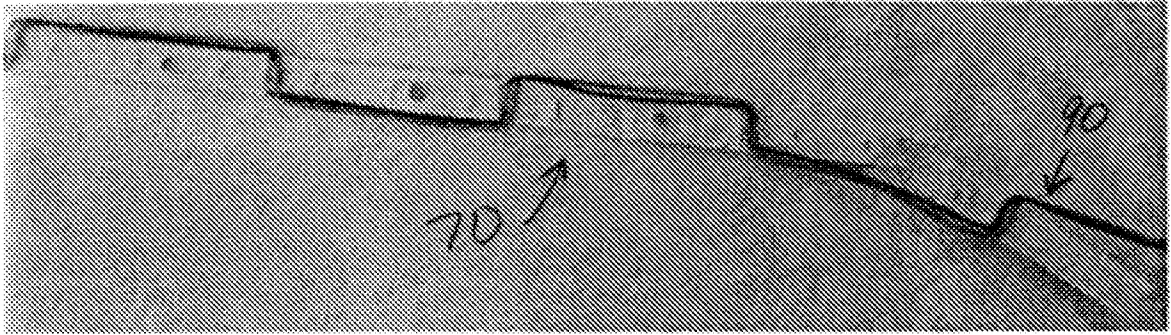


FIG. 8b

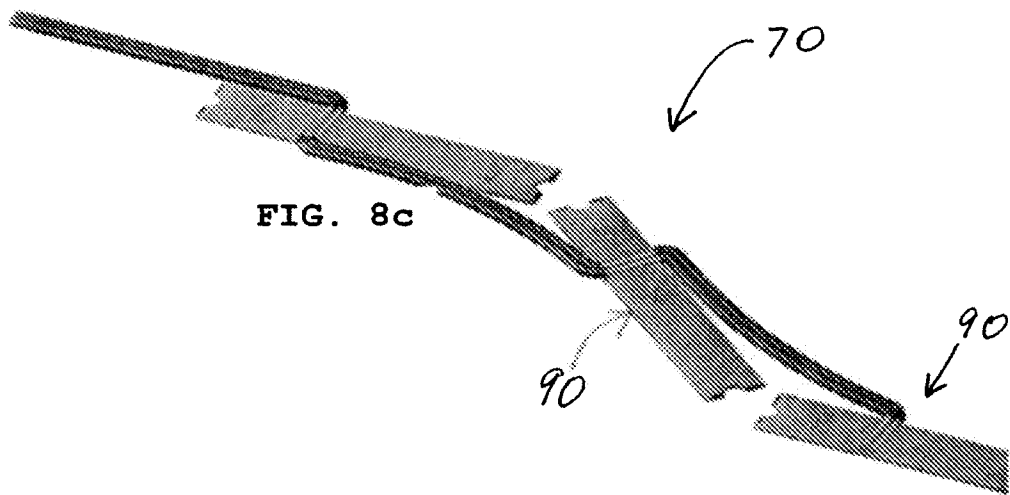


FIG. 8c

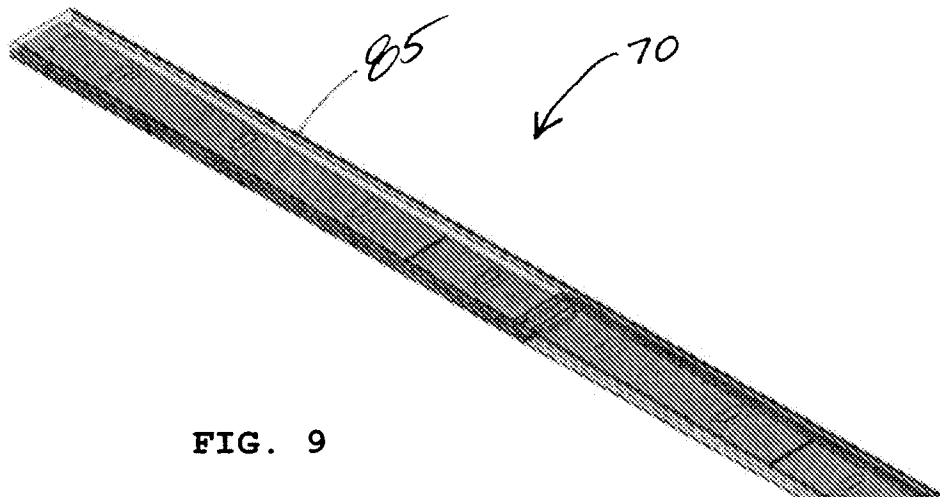


FIG. 9

INTERNATIONAL SEARCH REPORT

International application No
PCT/US2013/050668

A. CLASSIFICATION OF SUBJECT MATTER
INV. F21S4/00 G09F13/04
ADD.
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)
G09F F21S H05K

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

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)
EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2012/002417 A1 (LI QING CHARLES [US]) 5 January 2012 (2012-01-05)	1-12, 14, 16
Y	paragraph [0009] - paragraph [0023]; figures 1A-17	13, 15, 17-20
Y	paragraph [0047] - paragraph [0068] -----	
Y	US 2003/112627 A1 (DEESE RAYMOND E [US]) 19 June 2003 (2003-06-19)	13, 15
Y	paragraph [0024] - paragraph [0035]; figures 1-7 -----	
Y	DE 10 2008 059552 A1 (OSRAM OPTO SEMICONDUCTORS GMBH [DE]) 2 June 2010 (2010-06-02)	17-20
A	paragraph [0069]; figures 1-3 -----	1-16
	-/--	

Further documents are listed in the continuation of Box C.

See patent family annex.

* Special categories of cited documents :

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier application or patent but published on or after the international filing date
- "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)
- "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

"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

"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

"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

"&" document member of the same patent family

Date of the actual completion of the international search 3 October 2013	Date of mailing of the international search report 10/10/2013
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Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016	Authorized officer Pacholec, Darek
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INTERNATIONAL SEARCH REPORT

International application No
PCT/US2013/050668

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	WO 01/77578 A2 (LUMILEDS LIGHTING LLC [US]) 18 October 2001 (2001-10-18) figures 2A-4	1-20
A	----- WO 2004/076913 A1 (HE ZHENGZHONG [CN]) 10 September 2004 (2004-09-10) abstract; figures 1-11 -----	1-20

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No PCT/US2013/050668

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