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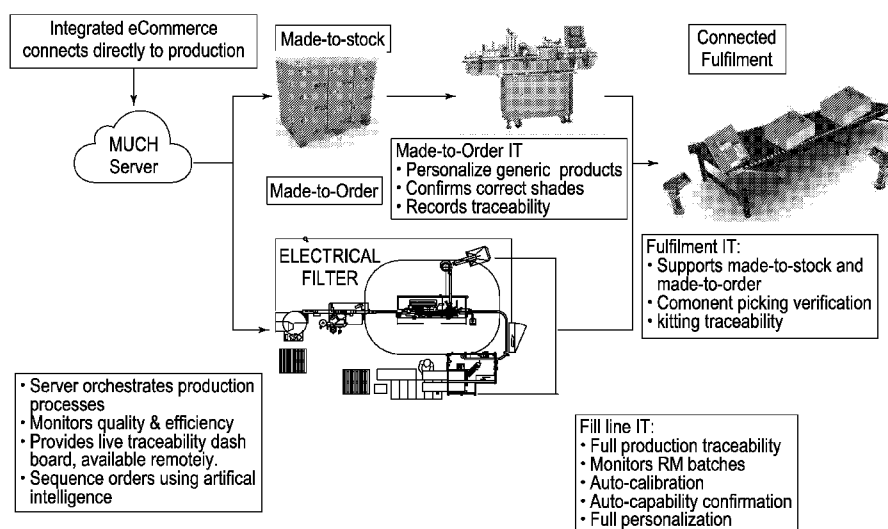


FIG. 1

(57) Abstract: A system is provided for dispensing a hair dye formulation into a customer container. The system includes a conveyor belt configured to transport the customer container along a fill line; a plurality of dispensing mechanisms, each connected to a respective container having a different bulk hair dye color, the plurality of dispensing mechanisms being disposed over a conveyor belt along the fill line. The system is configured to receive a formula for filling the customer container with one or more bulk hair dye colors from among the plurality of containers having the different bulk hair dye color, and control each of the plurality of dispensing mechanisms to perform a dispensing operation to dispense an amount of bulk hair dye color or to not perform a dispensing operation at a time when the customer container is transported to each of the plurality of dispensing mechanisms along the fill line.

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CUSTOM HAIR DYE DISPENSING SYSTEM AND INTERMEDIATE BULK
CONTAINER FOR STORING A BULK HAIR DYE

CROSS-REFERENCE TO RELATED APPLICATIONS

5 This application claims the benefit of priority from U.S. Provisional Application
Nos. 62/812,860 and 62/812,876, both filed on March 1, 2019, the entire contents of each
of which is hereby incorporated by reference.

BACKGROUND

10 A conventional hair dye kit includes a combination of a dye and a developer, each
of which may be packaged into a bottle for commercial sale. In the conventional art, a
color formulation to be dispensed into dye bottle comes from a source factory, and more
specifically from a large volume container.

 There is a need to provide a larger variety of color formulations, and even
15 customizable color formulations, to make available for customer purchase. However, the
conventional system has a problem in that it is difficult to efficiently predict and make
available such a large variety of hair dye formulations for dispensing into hair dye bottle
with the existing system in which hair dye formulations are produced and dispensed using
large volume containers.

20

SUMMARY

 In an embodiment, a system for dispensing a hair dye formulation into a customer
container, comprising: a conveyer belt configured to transport the customer container
along a fill line; a plurality of dispensing mechanisms, each connected to a respective
25 container having a different bulk hair dye color, the plurality of dispensing mechanisms

being disposed over a conveyer belt along the fill line; circuitry configured to receive a formula for filling the customer container with one or more bulk hair dye colors from among the plurality of containers having the different bulk hair dye color, and control each of the plurality of dispensing mechanisms to perform a dispensing operation to
5 dispense an amount of bulk hair dye color or to not perform a dispensing operation at a time when the customer container is transported to each of the plurality of dispensing mechanisms along the fill line.

In an embodiment, container is provided for storing a bulk hair dye color, comprising: a pouch for directly storing the bulk hair dye color; and a box for holding the
10 pouch, wherein the box is configured to be inserted in a system for dispensing a hair dye formulation into a customer container, the system having a conveyer belt configured to transport the customer container along a fill line, a plurality of dispensing mechanisms, and the container is one of a plurality of containers each storing a different bulk hair dye color and disposed directly adjacent to each other, wherein the container is configured to
15 connect to any of the respective dispensing mechanisms and allow the bulk hair dye to be dispensed into the customer container depending on a formula for filling the customer container.

BRIEF DESCRIPTION OF THE DRAWINGS

20 A more complete appreciation of the disclosure and many of the attendant advantages and features thereof can be readily obtained and understood from the following detailed description with reference to the accompanying drawings, wherein:

Fig. 1 shows a connection production system according to an embodiment.

Fig. 2 shows a process of dye fulfillment flow according to an embodiment.

Fig. 3 depicts a label that may be applied to a bottle of a customized dye formulation produced by the system according to an embodiment.

Fig. 4 shows an overview of the fill line and personalization process according to an embodiment.

5 Fig. 5 shows an overview and statistics of a personalized fill line according to an embodiment.

Figs. 6A-6E shows a walkthrough of different aspects of the fill line according to an embodiment.

Fig. 7 shows an over view of the fill station technology according to an
10 embodiment.

Fig. 8 shows a bulk container strategy according to an embodiment.

Fig. 9 shows more details related to the bulk container strategy according to an embodiment.

Fig. 10 shows that there are two types of intermediate bulk containers (IBCs) in
15 an embodiment.

Fig. 11 shows details of the “bag-in-box” type of IBC according to an embodiment.

Fig. 12 shows details of the heavy use IBC according to an embodiment.

Fig. 13 shows the IBC filling equipment used during production in an
20 embodiment.

Fig. 14 shows details related to the containers in an embodiment

Fig. 15 shows an overview of a process and system to receive an order of a personalized dye according to an embodiment.

Figs. 16-34 show examples of features provided the application used by the customer and the color consultant in an embodiment.

Fig. 35 shows an overview of the hardware components of a processing device according to an embodiment.

5 Fig. 36 shows a process performed at a fill site according to an embodiment.

Fig. 37 shows a process performed between a server, a customer, a colorist, and a fill site according to an embodiment.

DESCRIPTION

10 The present system and embodiments makes use of existing "bag in box" components - a soft sided, disposable bag with a bonded fitment that is designed for a "quick connect" interaction with a probe + hose assembly. We use these components in a novel manner to house multiple compounds in close proximity in the explosion proof confines of our fill machine. The bag size is optimized to be large enough to not need
15 refill on the line often, but small enough that the weight of fluid inside can be easily and ergonomically lifted/carried by an operator without mechanical assistance for very quick swapping to reduce machine downtime. The bags are couples with dispensing pumps and do not provide any pressure differential as fluid is extracted because the soft sides of the bag simply collapse. The bags are in corrugate boxes that are cost effective and easily
20 collapsible. On the corrugate boxes are labels with 2D barcodes that encode important data about what is inside each. When a new compound is loaded onto the fill line by the operator, the box is scanned and then a 2D barcode on the end of a corresponding hose is scanned and electronic feedback is given to alert the operator that the right hose is

connected to the correct compound (or not if incorrect). This ensures that the correct compounds are being dispensed when they are intended to be.

Most of the materials are loaded into the machine in this "bag in box" configuration (~10L capacity) but other materials may be coupled to the machine with
5 larger Intermediate Bulk container means plus an intermediate tank. In this case, compounds would be pumped from the large scale containers to an intermediate holding tank which is small enough to not apply too much pressure from gravity on the dispensing pumps.

The fill line described herein uses a linear fill format (empty bottles enter, bottles
10 labeled with serialized 2D barcode labels that can be scanned with a 2D barcode reader. Once bottles reach fill portion of machine, they are scanned and then filled with multiple compounds (5-9 compounds selected from a possible 20-27) per the information corresponding to the serial number per an order database. As each bottle is filled with different compounds, it is not practical to open up every single bottle and do a detailed
15 chemical analysis test or functional test to ensure the compounds and their individual fill quantities are correct. Instead, this system relies on multiple fill position (between 5-7) with multiple nozzles (between 1-6) affixed at each fill position. Each nozzle corresponds to one compound. The compounds are "dosed" in each bottle to makeup a final formula. Bottles are advanced in sequence from one fill position to the next by "walking" type
20 conveyor. In each fill position is a lab quality load cell (readout in the range of 0.1mg) that are mechanically isolated from vibration. Combined weights can be measured at each fill position.

The fill machine can function in two ways: 1) Production Mode - which is optimized for dispensing speed and 2) Calibration Mode - used periodically to ensure

process capability of dispensing nozzles. In Production mode, compounds are dispensed from multiple nozzles all at once and the load cells are used to verify that the expected combined dispense mass (based on the "Recipe" in the order database) is within tolerance. If within tolerance, the bottle continues down the line to the next station. If out of

5 tolerance, the bottle serial number is automatically/electronically marked as reject. In the Calibration Mode, each dispensing nozzle is fired one by one multiple times, and the weight of each individual dispense is checked by the load cell and electronically recorded. If the distribution of dispenses represent a high Cpk (process capability) value, the machine is considered qualified and is approved for production until the next scheduled

10 Calibration check period.

In an embodiment, sequence orders of the bottles may be configured using artificial intelligence to enhance efficiency. For instance, sequencing may be performed dynamically based on predicted fill times of each of a plurality of bottles based on the respective formulas for each bottle.

15 Moreover, the system described herein produces personalized cosmetic products on demand in a factory. The machine is comprised of several different stations linked together by collaborative robots. The system is self organizing, and the stations figure out on their own what they need to do in order to produce the products. The system can produce several SKUs concurrently at no efficiency loss. The same system can be used

20 for many

Additional details are described below and in the accompanying figures

Fig. 1 depicts a connection production system for integrating eCommerce directly to production, so that personalized products can be made-to-order at a filling system in order to make individual hair dye kits that are customized for users. As shown in Fig. 1,

a server orchestrates production processes, monitors quality & efficiency, provides live traceability dash boards, available remotely, and may sequence orders using artificial intelligence.

Fig. 1 further shows that there may be two paths in the production process: a
5 “made-to-stock” path and a “made-to-order” path. The “made-to-stock” path may produce bottles of stock or generic dye colors which are in high demand. The “made-to-stock” path further personalizes generic products; confirm correct shades; and records traceability of an order.

The “made-to-order” path includes a specialized fill station which will be
10 discussed in more detail below. The “made-to-order” path provides full production traceability; monitoring of RM batches; Auto-calibration of the dispensing mechanisms of the fill station; auto-capability confirmation; and full personalization.

Either of the above two paths leads to the connected fulfillment section of the process, where component picking verification is performed as well as ensuring
15 traceability of the dye and developer kits which are produced.

Fig. 2 provides an overview of the dye fulfillment flow, which shows the process from bulk production of the dye monochromes, to bulk filling of the intermediate batch containers, to the fill line, to fulfillment.

Fig. 3 depicts a label that may be applied to a bottle of a customized dye
20 formulation produced by the system. Among other information, the label specifies the customer name, the formula number, the recommended application, the shade level, and the tone.

Fig. 4 shows an overview of the fill line and personalization process according to an embodiment. It can be seen that there are two components involved in this process: a

fill line (dispensing occurs) and a fulfillment line (where kits are assembled and personalized labels are produced and applied).

Fig. 5 shows an overview and statistics of a personalized fill line. It can be seen that the personalized fill line described in the present embodiments provides:

- 5 • Fastest personalized manufacturing to date (10 units per minute). 1.5M units/year assuming 2*8 hours shifts
- 100% traceability and full unit serialization
- In-line quality checks
- Highly automated (<1 Full Time Operator required)
- 10 • Highly adaptable to allow for new dye colors in future
- Directly linked to kitting line
- Internet connected per Industry 4.0 standards

Additionally, the capacity of production of the fill line will increase heavily in the coming years with just 1 or 2 machines being needed.

15 Figs. 6A-6E shows a walkthrough of different aspects of the fill line.

Fig. 6A shows that an internet connected labeler prints custom info per order, and the labels can be applied at the egress of a bottle feeder.

Fig. 6B shows that a vision system can be used to scan the label after it is applied to ensure accuracy and enhance quality control.

20 Fig. 6C shows that super high precision pumps can be used to dose a large quantity of ingredients from the corrugated containers to create a custom dye formulation.

Fig. 6D shows that precision scales can be used for in-line quality control and automated pump calibration.

Fig. 6D shows that a robot arm may be used at fulfillment to support flexible packout configurations.

Fig. 7 shows an over view of the fill station technology. The fill line and dispensing station applies several simultaneous functions, such as real time capability and
5 monitoring, redundant volumetric & mass dispensing, RM batch tracking via QR codes, the ability to track the amount of time bottles are open and exposed to air, tracking bottles between stations, and tracking the identification of cartons which bottles are loaded into after filling.

Fig. 8 shows a bulk container strategy which can be used to provide a size of bulk
10 hair dye volume that is compatible with the needs of the fill station. The strategy involves filling intermediate bulk containers (IBCs) at a plant where a combination of bulk hair dye production and a specialized bulk filler can be used to fill a “bag” like container with hair dye, and then a box container can be used to hold the bag for safe storage. The bag may be collapsed into the box and the bags may be sized according to a
15 usage rate.

This bulk container strategy provides the following features.

- Rated to contain XP (explosive) material
- Approved for international shipping and easy to palletize
- Provide for quick swapping capability to reduce fill line downtime
- 20 • Easily disposable/recyclable
- Optimally sized for compound usage rates while remaining ergonomic for operators
- Chemical compatibility with 17+ compounds in long term storage
- Light blocking

- Completely airtight to prevent oxidation
- Reasonably priced to not affect FG piece price
- Long term availability from trusted supplier

Fig. 9 shows more details related to the bulk container strategy. It can be seen
5 that hair dye bottles can be filled not just by the boxed IBCs utilized at a fill station at
third party site, but they can also be filled based on larger containers provided by RM
suppliers, which may supply the developer to the third party site.

Fig. 10 shows that there are two types of intermediate bulk containers (IBCs). The
first type is described above as the “bag”-type container that stores standard use
10 compounds and can be accessed using a special valve and probe to form an airtight seal
as shown in Fig. 10. The second type is a larger sized hardened container that holds
heavy use compounds.

Fig. 11 shows details of the “bag-in-box” type of IBC and Fig. 12 shows details of
the heavy use IBC.

15 Fig. 13 shows the IBC filling equipment used during production. The fill device
shown in Fig. 13 may be for example, a Scholle IPN TrueFill 900, and all literature.

Fig. 14 shows details related to the containers used for direct RM ingredients such
as ammonia.

Fig. 15 shows an overview of a process and system to receive an order of a
20 personalized dye 1560 according to an embodiment. The system includes a customer site
device 1510, a color consultant site device 1520, and the fill site 1550 described above.
A server 1530 or any combination of devices (such as a cloud network) may be connected
to each of the customer device 1510, the color consultant 1520, and the fill line site 1550.
A controller device 1540 may control the functionality performed at the fill line site 1550.

In the system of Fig. 15, an application is provided which is configured to allow a customer to input user information in order to generate a prescribed formula which is used to dispense a custom color. The application may be installed on a server site and be accessed by a user via a web browser or an application (“app”) for example.

- 5 Additionally, the application, or a different application which is also installed on the server site may be accessed by a color consultant via a web browser or an application.

In an embodiment, the customer may be presented with two options: (1) speak with a color consultant, or (2) take a color quiz or questionnaire. In option (2), the customer may answer a series of questions about their hair and hair goals, and based on
10 the answers, a recommended hair color product will be generated automatically and provided to the user. However, during the quiz the customer will always have the option to exit and choose option (1). Additionally, based on the answers to the quiz, such as previous use of a non-dye color treatment, the user may be required to speak to a color consultant.

- 15 The application for the customer and the application for the color consultant is configured to facilitate a video consultation session between the customer and the color consultant.

The operating system of the computer devices used by the customer, the color consultant, any other points in the system can have a user interface that is configured to
20 perform multiple functions. In an aspect, the device can be in communication with a network and enable the user interface access to the Internet as well as Internet of Things (IOT). As can be appreciated, the network can be a public network, such as the Internet, or a private network such as an LAN or WAN network, or any combination thereof and can also include PSTN or ISDN sub-networks. The network can also be wired, such as

an Ethernet network, or can be wireless such as a cellular network including EDGE, 3G and 4G wireless cellular systems. The wireless network can also be WiFi, Bluetooth, or any other wireless form of communication that is known.

The device can also have a camera function either integrated or external that can
5 be used facilitate the video session.

Figs. 16-34 show examples of features provided the application used by the customer and the color consultant.

As shown in Fig. 16, a customer may be prompted to input the specific type of expertise they are seeking in a hair colorist. As shown in Figs. 16-18, the customer may
10 be prompted if they are seeking a colorist who specializes in hair color based on gender, color, or ethnicity. While not shown, a colorist may optionally be selected based on language – such as Spanish or English. As depicted in Fig. 19, based on the user's choices, the system will connect the customer with a colorist to form a video session, where the customer can see the colorist via video and vice versa.

As shown in Fig. 20, the colorist may provide an input to an “inspire” screen
15 which may show different enumerated examples of types of hair color based on different categories, as shown in Fig. 21. The input to the “inspire” screen may be based on a verbal description provided by the customer. While not shown, customers can also upload their own inspirations using image upload and/or social media such as Pinterest,
20 Instagram, Facebook, Twitter, or the like.

Fig. 22 shows that an input may be provided to further specify a customer's natural level and percentage of gray hair in a sub-menu.

At that point, the colorist may take the user's inputs and perform operations on an application display screen that is shown to the colorist. For instance, as shown in Fig. 23,

a colorist may be required to select different options for different categories on a “consult” screen. For example, if the colorist selects “hair goal,” then there are three required items which the colorist must input as shown in Fig. 24, such as a specification on gender, end results, and a type of service.

5 Fig. 25 shows that some selections may trigger an additional selection of “dependencies” (such as “vibrancy” if the end result of “copper, red, or violet” is selected.

Figs. 26-30 show the different requirements which are triggered from the options shown on the “consult” screen.

 When the colorist completes input of all selections in the “consult” screen, in
10 addition to selecting a hair goal from the inspiration swatches, a “prescribe screen” may be shown which summarizes the selections, and then further displays new options to specify an “application” of the hair dye for either “roots,” “roots then ends,” and “all over,” as shown in Fig. 32. Between selecting the application and the formula, the colorist chooses the service which then determines the set of personalized instructions the
15 customer will receive.

 As shown in Fig. 33, once a selection of “application” is made, the colorist may then specify a particular formula that is characterized by type, level, tone, DVLP, a root value, and an “ends” value.

 When all selections are finally made, a final screen is shown on Fig. 34, which
20 shows the customer’s color goal and the prescribed color. Additional options may be shown to remind the colorist of further explanations and recommendations he/she should mention.

 When the steps are completed, the colorist sends the final product to a cart. When the consultation ends, the colorist is disconnected and the customer is directed

automatically to their cart. The customer can then complete the purchase by entering payment information in order to purchase (via a secure connection to keep the payment information confidential). When the purchase is complete, the prescribed color will be sent to the fill site to dispense the custom hair dye as described above.

5 It is noted that if the colorist does not believe that a prescribed color can be given based on any concerns that come up during the video session, the colorist may select “No prescription recommended at this time” as shown in Fig. 31. In this event, the colorist may recommend that the customer visit a colorist in-person at a salon, and the application can facilitate connecting the customer to a particular salon for an appointment if
10 necessary.

Next, a hardware description of a processing device utilized in the above descriptions according to exemplary embodiments is described with reference to Figure 35. In Figure 35, the computing includes a CPU 3500 which performs the processes described above/below. The process data and instructions may be stored in memory 3502.
15 These processes and instructions may also be stored on a storage medium disk 3504 such as a hard drive (HDD) or portable storage medium or may be stored remotely. Further, the claimed advancements are not limited by the form of the computer-readable media on which the instructions of the inventive process are stored. For example, the instructions may be stored on CDs, DVDs, in FLASH memory, RAM, ROM, PROM, EPROM,
20 EEPROM, hard disk or any other information processing device with which the processing device communicates, such as a server or computer.

Further, the claimed advancements may be provided as a utility application, background daemon, or component of an operating system, or combination thereof, executing in conjunction with CPU 3500 and an operating system such as Microsoft

Windows, UNIX, Solaris, LINUX, Apple MAC-OS and other systems known to those skilled in the art.

The hardware elements in order to achieve the processing device may be realized by various circuitry elements, known to those skilled in the art. For example, CPU 3500
5 may be a Xenon or Core processor from Intel of America or an Opteron processor from AMD of America, or may be other processor types that would be recognized by one of ordinary skill in the art. Alternatively, the CPU 3500 may be implemented on an FPGA, ASIC, PLD or using discrete logic circuits, as one of ordinary skill in the art would recognize. Further, CPU 3500 may be implemented as multiple processors cooperatively
10 working in parallel to perform the instructions of the inventive processes described above.

The processing device in Figure 35 also includes a network controller 3506, such as an Intel Ethernet PRO network interface card from Intel Corporation of America, for interfacing with network 3530. As can be appreciated, the network 3530 can be a public network, such as the Internet, or a private network such as an LAN or WAN network, or
15 any combination thereof and can also include PSTN or ISDN sub-networks. The network 3530 can also be wired, such as an Ethernet network, or can be wireless such as a cellular network including EDGE, 3G and 4G wireless cellular systems. The wireless network can also be WiFi, Bluetooth, or any other wireless form of communication that is known.

The processing device further includes a display controller 3508, such as a
20 NVIDIA GeForce GTX or Quadro graphics adaptor from NVIDIA Corporation of America for interfacing with display 3510, such as a Hewlett Packard HPL2445w LCD monitor. A general purpose I/O interface 3512 interfaces with a keyboard and/or mouse 3514 as well as a touch screen panel 3516 on or separate from display 3510. General

purpose I/O interface also connects to a variety of peripherals 3518 including printers and scanners, such as an OfficeJet or DeskJet from Hewlett Packard.

A sound controller 3520 is also provided in the processing device, such as Sound Blaster 35-Fi Titanium from Creative, to interface with speakers/microphone 3522

5 thereby providing sounds and/or music.

The general purpose storage controller 3524 connects the storage medium disk 3504 with communication bus 3526, which may be an ISA, EISA, VESA, PCI, or similar, for interconnecting all of the components of the processing device. A description of the general features and functionality of the display 3510, keyboard and/or mouse 3514, as
10 well as the display controller 3508, storage controller 3524, network controller 3506, sound controller 3520, and general purpose I/O interface 3512 is omitted herein for brevity as these features are known.

The exemplary circuit elements described in the context of the present disclosure may be replaced with other elements and structured differently than the examples
15 provided herein. Moreover, circuitry configured to perform features described herein may be implemented in multiple circuit units (e.g., chips), or the features may be combined in circuitry on a single chipset.

The functions and features described herein may also be executed by various distributed components of a system. For example, one or more processors may execute
20 these system functions, wherein the processors are distributed across multiple components communicating in a network. The distributed components may include one or more client and server machines, which may share processing, in addition to various human interface and communication devices (e.g., display monitors, smart phones, tablets, personal digital assistants (PDAs)). The network may be a private network, such as a

LAN or WAN, or may be a public network, such as the Internet. Input to the system may be received via direct user input and received remotely either in real-time or as a batch process. Additionally, some implementations may be performed on modules or hardware not identical to those described. Accordingly, other implementations are within the scope
5 that may be claimed.

A processing device used by a user (customer) is configured to upload data regarding the user to an external system or server (such as a cloud-based system). The processing device can also provide an option to keep the user data anonymous.

Furthermore, the circuitry of the processing device may be configured to actuate a
10 discovery protocol that allows the processing device and a system to identify each other and to negotiate one or more pre-shared keys, which further allows the system and the processing device to exchange encrypted and anonymized information. The discovery protocol may further allow the client device and system to exchange treatment regimen information.

15 The above-described hardware description is a non-limiting example of corresponding structure for performing the functionality described herein.

Fig. 36 shows a process or algorithm performed by circuitry of the fill line site controller 1540 (see Fig. 15) according to an embodiment. In step 3610, the circuitry receives a formula for filling the customer container with one or more bulk hair dye colors from
20 among the plurality of containers having the different bulk hair dye color. In step 3620, the circuitry controls each of the plurality of dispensing mechanisms to perform a dispensing operation to dispense an amount of bulk hair dye color or to not perform a dispensing operation at a time when the customer container is transported to each of the plurality of dispensing mechanisms along the fill line.

Fig. 37 shows a process or algorithm performed by circuitry one or more devices in the system shown in Fig. 15 above, such as at least the server 1530. In step 3710, the circuitry establishes a connection with a user device of the particular customer over a network. In step 3720, the circuitry receives a selection of a preferred type of expertise of a colorist. In step 3730, the circuitry determines an available colorist that corresponds to the preferred type of expertise. In step 3740, the circuitry establishes a video communication session between the particular customer and a colorist device of the determined colorist. In step 3750, the circuitry causes display of a customer interface to the customer at the user device which is configured to display options for specifying a target type of hair color. In step 3760, the circuitry causes display of a colorist interface to the colorist device which is configured to display options, different from the display options at the user device, for inputting information about the particular customer and the target type of hair color, and for inputting information used to generating the custom hair dye formulation. In step 3770, the circuitry transmits the generated custom hair dye formulation to a fill site, via the network. Subsequently, controller 1540 controls the fill site to dispense one or more of a plurality of bulk hair dye colors into the single customer container based on the generated custom hair dye formulation.

The principles, representative embodiments, and modes of operation of the present disclosure have been described in the foregoing description. However, aspects of the present disclosure which are intended to be protected are not to be construed as limited to the particular embodiments disclosed. Further, the embodiments described herein are to be regarded as illustrative rather than restrictive. It will be appreciated that variations and changes may be made by others, and equivalents employed, without departing from the spirit of the present disclosure. Accordingly, it is expressly intended

that all such variations, changes, and equivalents fall within the spirit and scope of the present disclosure, as claimed.

WHAT IS CLAIMED IS:

1. A system for dispensing a hair dye formulation into a customer container, comprising:
- a conveyer belt configured to transport the customer container along a fill line;
- 5 a plurality of dispensing mechanisms, each connected to a respective container having a different bulk hair dye color, the plurality of dispensing mechanisms being disposed over a conveyer belt along the fill line;
- circuitry configured to
- receive a formula for filling the customer container with one or more bulk
- 10 hair dye colors from among the plurality of containers having the different bulk hair dye color, and
- control each of the plurality of dispensing mechanisms to perform a dispensing operation to dispense an amount of bulk hair dye color or to not perform a dispensing operation at a time when the customer container is transported to each of the
- 15 plurality of dispensing mechanisms along the fill line.
2. A container for storing a bulk hair dye color, comprising:
- a pouch for directly storing the bulk hair dye color; and
- a box for holding the pouch,
- 20 wherein the box is configured to be inserted in a system for dispensing a hair dye formulation into a customer container, the system having a conveyer belt configured to transport the customer container along a fill line, a plurality of dispensing mechanisms, and the container is one of a plurality of containers each storing a different bulk hair dye color and disposed directly adjacent to each other, wherein the container is configured to

connect to any of the respective dispensing mechanisms and allow the bulk hair dye to be dispensed into the customer container depending on a formula for filling the customer container.

AMENDED CLAIMS

received by the International Bureau on 14 July 2020 (14.07.2020)

WHAT IS CLAIMED IS:

1. A system for dispensing a hair dye formulation into a customer container, comprising:
a conveyer belt configured to transport the customer container along a fill line;
a plurality of dispensing mechanisms, each connected to a respective container having a different bulk hair dye color, the plurality of dispensing mechanisms being disposed over a conveyer belt along the fill line;
circuitry configured to
receive a formula for filling the customer container with one or more bulk hair dye colors from among the plurality of containers having the different bulk hair dye color, and
control each of the plurality of dispensing mechanisms to perform a dispensing operation to dispense an amount of bulk hair dye color or to not perform a dispensing operation at a time when the customer container is transported to each of the plurality of dispensing mechanisms along the fill line.

2. A container for storing a bulk hair dye color, comprising:
a pouch for directly storing the bulk hair dye color; and
a box for holding the pouch,
wherein the box is configured to be inserted in a system for dispensing a hair dye formulation into a customer container, the system having a conveyer belt configured to transport the customer container along a fill line, a plurality of dispensing mechanisms, and the container is one of a plurality of containers each storing a different bulk hair dye color and disposed directly adjacent to each other, wherein the container is configured to connect to any of the

respective dispensing mechanisms and allow the bulk hair dye to be dispensed into the customer container depending on a formula for filling the customer container.

3. The system according to claim 1, wherein the formula is received from a customer site device via a network.

4. The system according to claim 3, wherein an application is provided which is configured to allow a customer to input user information in order to generate a prescribed formula which is used to dispense a custom color.

5. The system according to claim 1, further comprising:

customer site device;

a color consultant site device; and

a server,

wherein the conveyor belt and the plurality of dispensing mechanisms are located at a fill site, and the customer site device, the color consultant site device, and the fill site are all connected to the server.

6. The system according to claim 1, wherein the customer container is configured to receive one or more of the bulk hair dye colors at one of a plurality of fill positions along the fill line, wherein a plurality of nozzles are disposed at each fill position, each of the plurality of nozzles corresponding to a different bulk hair dye.

7. The system according to claim 6, wherein each fill position includes a load cell to measure of the weight of the customer container.

8. The system according to claim 7, wherein when a weight of a customer container is within a predetermined tolerance based on a measurement of the load cell, the customer container is allowed to proceed along the fill line, and when the weight of the customer container is not within the predetermined tolerance, the customer container is marked as rejected.

9. The system according to claim 1, wherein sequence orders of a plurality of customer containers are configured dynamically based on predicted fill times of each of a plurality of customer containers based on the respective formulas for each customer container.

10. The system according to claim 1, further comprising a second conveyor belt configured to transport stock containers along a separate fill line than the customer container.

11. The system according to claim 1, further comprising a fulfillment line where a kit is assembled for the specific customer, the kit including the customer container that has been filled with the one or more bulk hair dye colors.

12. The system according to claim 1, wherein a label is applied to the customer container prior to the customer container being transported along the fill line.

13. A method, implemented by a system for dispensing a hair dye formulation into a customer container, comprising:

transporting, by a conveyor belt, the customer container along a fill line, wherein a plurality of dispensing mechanisms, each connected to a respective container having a different

bulk hair dye color, the plurality of dispensing mechanisms being disposed over a conveyer belt along the fill line;

receiving a formula for filling the customer container with one or more bulk hair dye colors from among the plurality of containers having the different bulk hair dye color; and

controlling each of the plurality of dispensing mechanisms to perform a dispensing operation to dispense an amount of bulk hair dye color or to not perform a dispensing operation at a time when the customer container is transported to each of the plurality of dispensing mechanisms along the fill line.

14. The container according to claim 2, wherein the pouch is a soft-sided, disposable bag.

15. The container according to claim 2, wherein the pouch further includes a bonded fitment configured to couple with a probe and/or hose assembly.

1/46

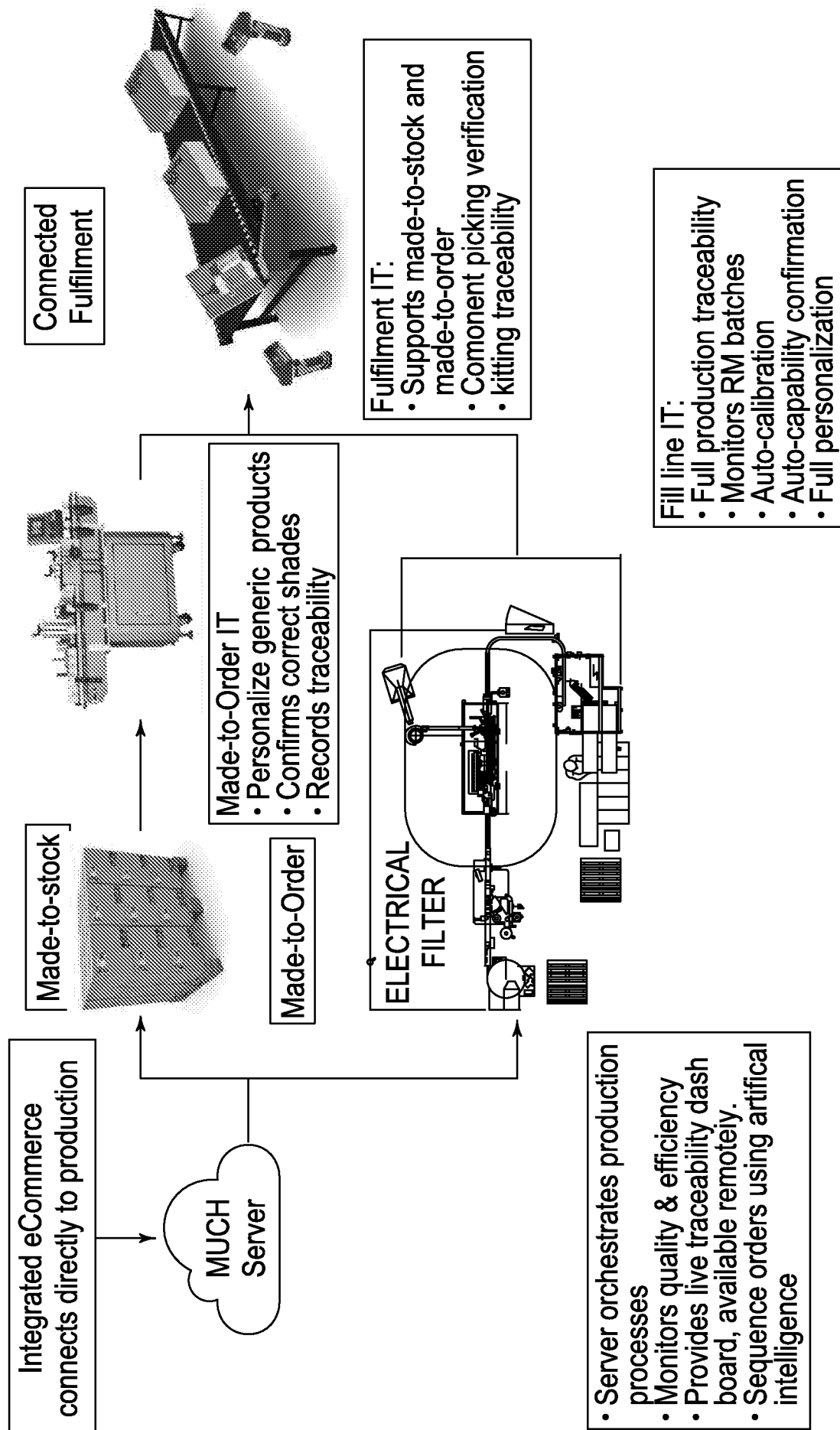


FIG. 1

DYE FULFILLMENT FLOW

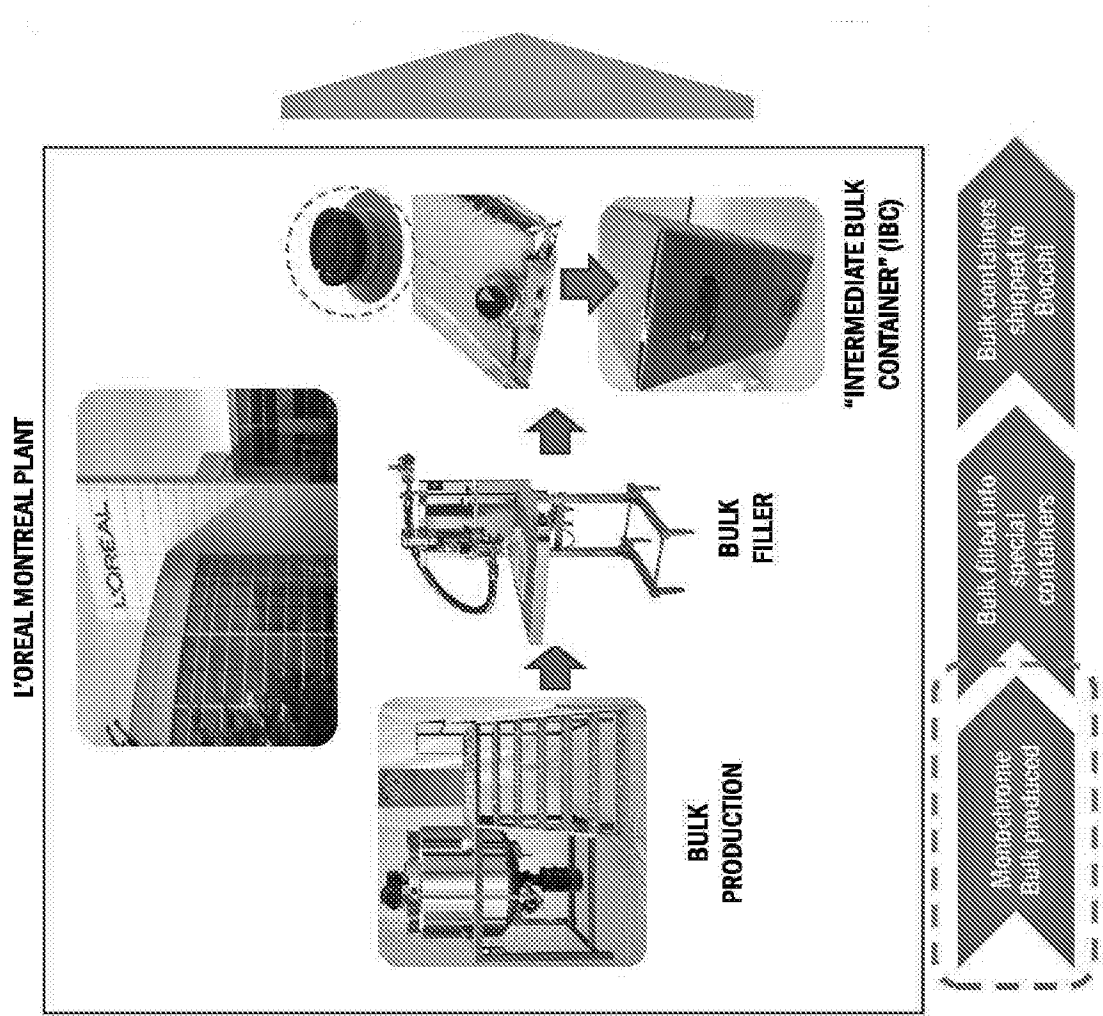


FIG. 2

Your Color Profile

Formula
ABC12345

Application
Apply All Over

Level
Dark

Tone
Natural

CO & CO

color

Cocreated for
Penny

Permanent

To be mixed with
10V Developer

2 oz (60 ml)

USAGE ADVISORY - SAFETY WARNINGS:

Can cause an allergic reaction (skin allergy test see insert). Rinse hair well after application of the mixture. If product gets into eyes, rinse immediately. Keep out of reach of children

CAUTION: THIS PRODUCT CONTAINS INGREDIENTS WHICH MAY CAUSE SKIN IRRITATION ON CERTAIN INDIVIDUALS AND A PRELIMINARY TEST ACCORDING TO ACCOMPANYING DIRECTIONS SHOULD FIRST BE MADE. THIS PRODUCT MUST NOT BE USED FOR DYEING THE EYELASHES OR EYEBROWS. TO DO SO MAY CAUSE BLINDNESS.

Read and follow the instruction sheet & safety warnings

0123456789

FIG. 3

FILL LINE & PERSONALIZATION - OVERVIEW

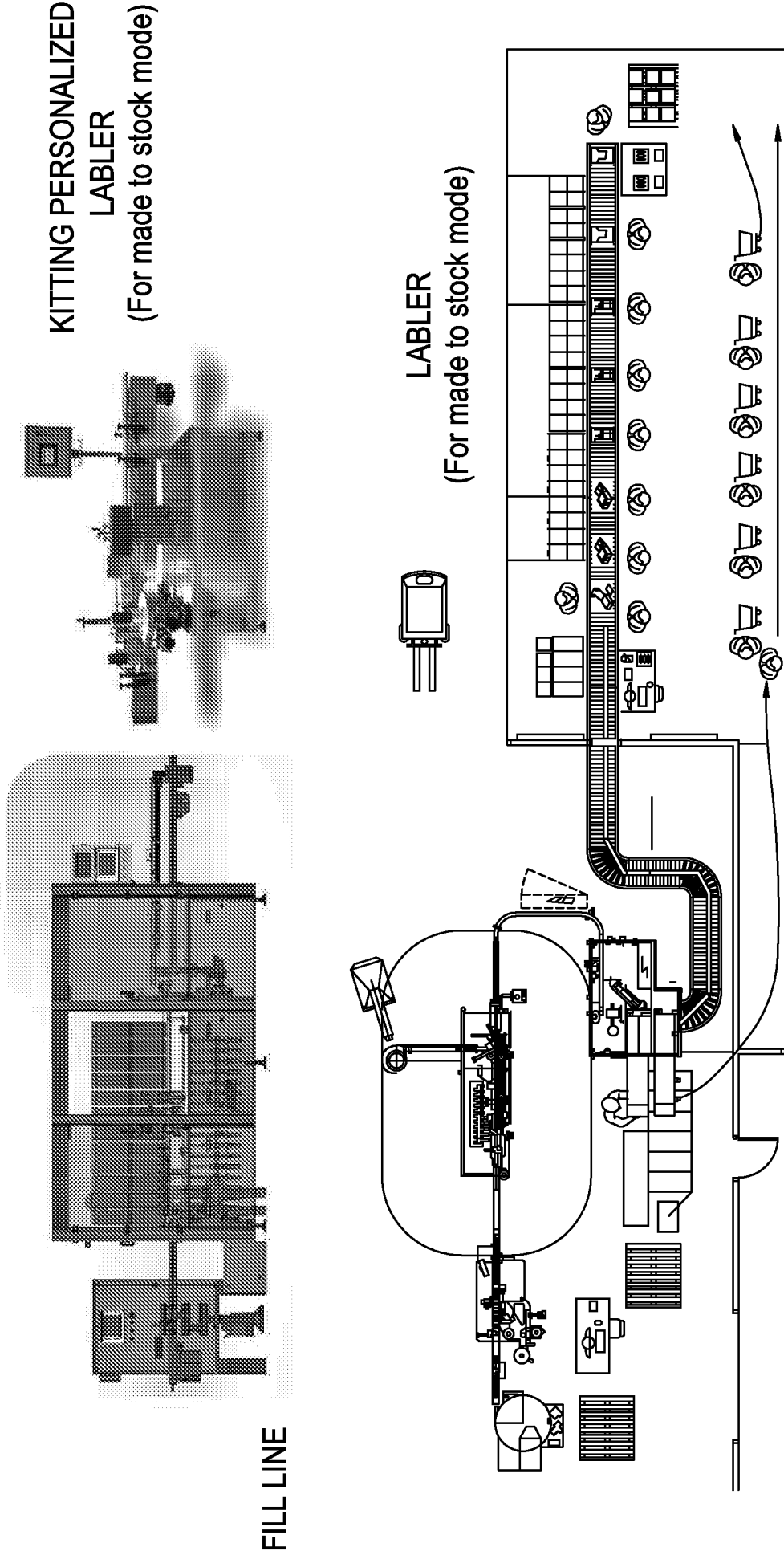
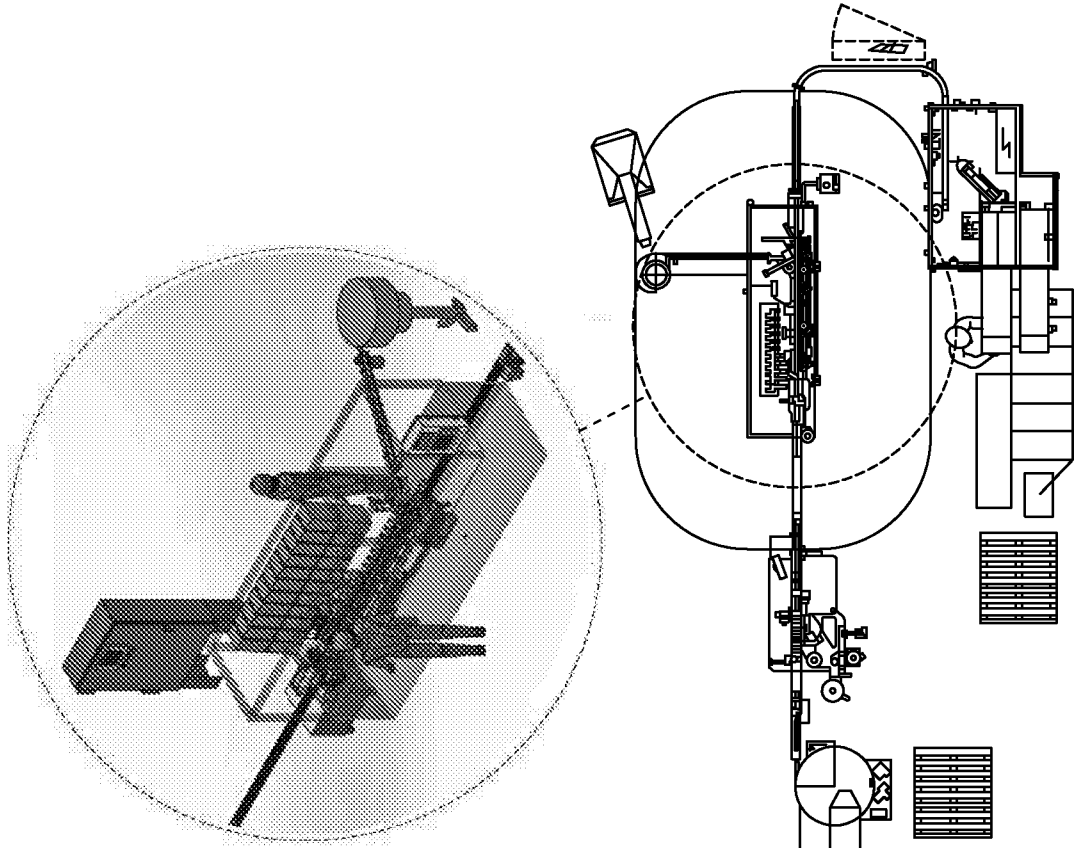


FIG. 4

PERSONALIZED FILL LINE

KEY STATISTICS:

- Fastest personalized manufacturing to date (10 units per minute). 1.5M units/year assuming 2*8 hours shifts
- 100% traceability and full unit serialization
- In-line quality checks
- Highly automated (<1 Full Time Operator required)
- Highly adaptable to allow for new dye colors in future
- Directly linked to kitting line
- Internet connected per Industry 4.0 standards



Year	Machines needed	Dye Bottle QTY
2019	1	273K
2020	1	1.0M
2021	1 (assuming triple shifts)	1.8M
2022	2	2.5M

FIG. 5

FILL LINE - WALKTHROUGH

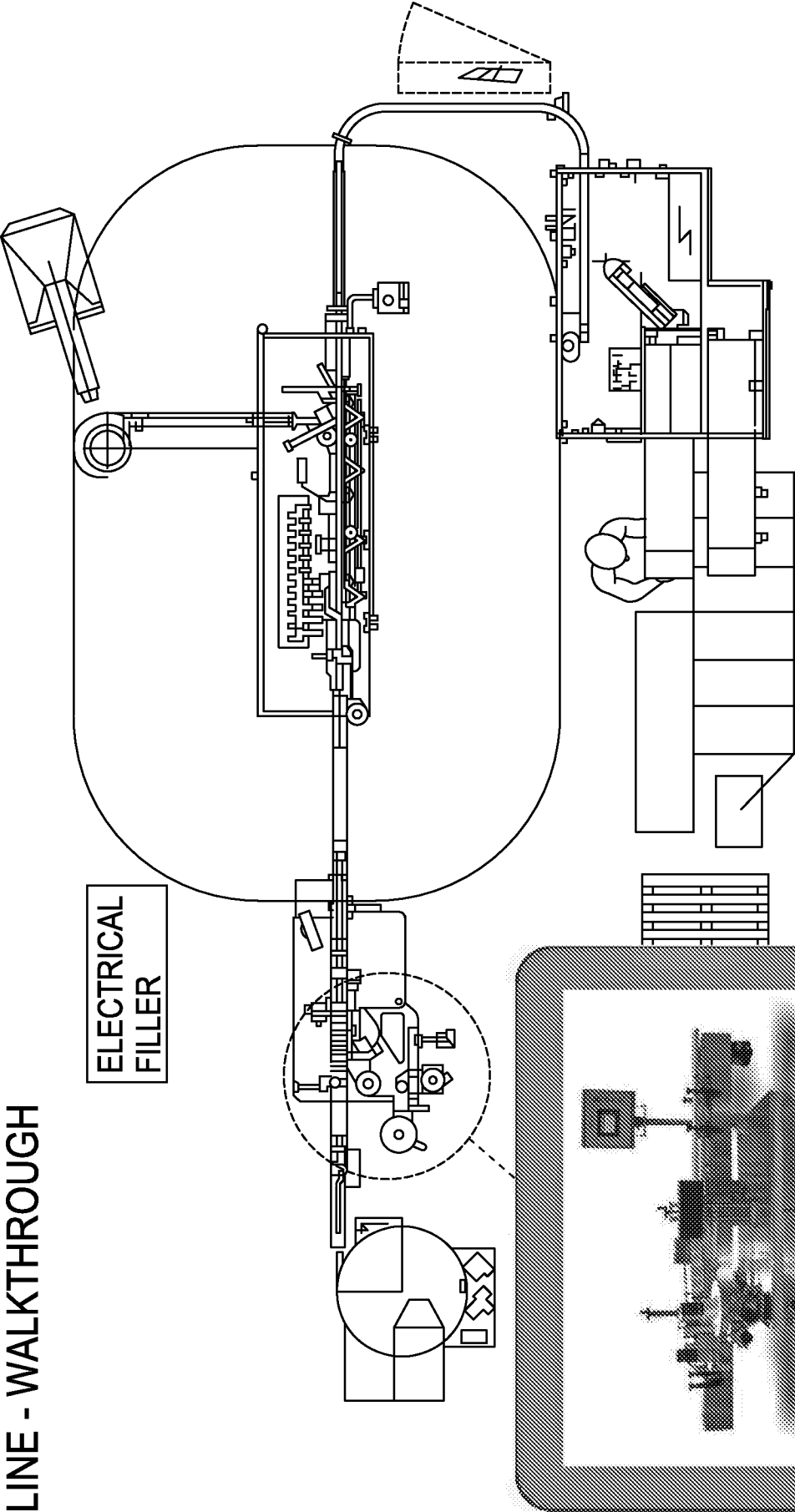
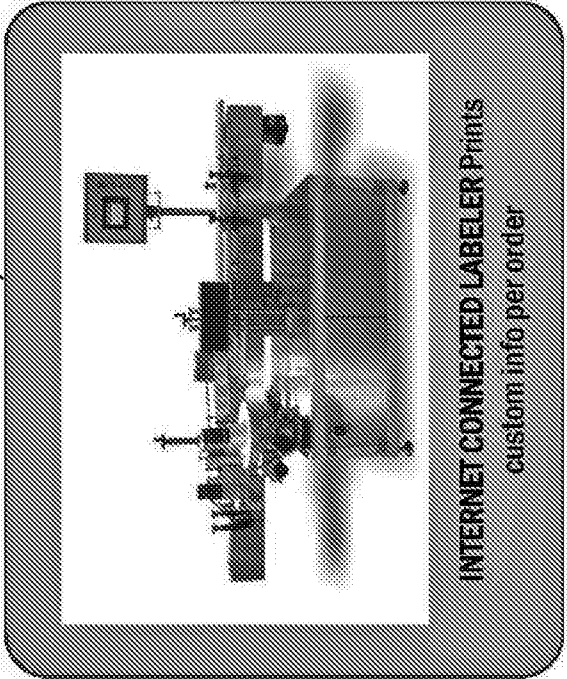


FIG. 6A



FILL LINE - WALKTHROUGH

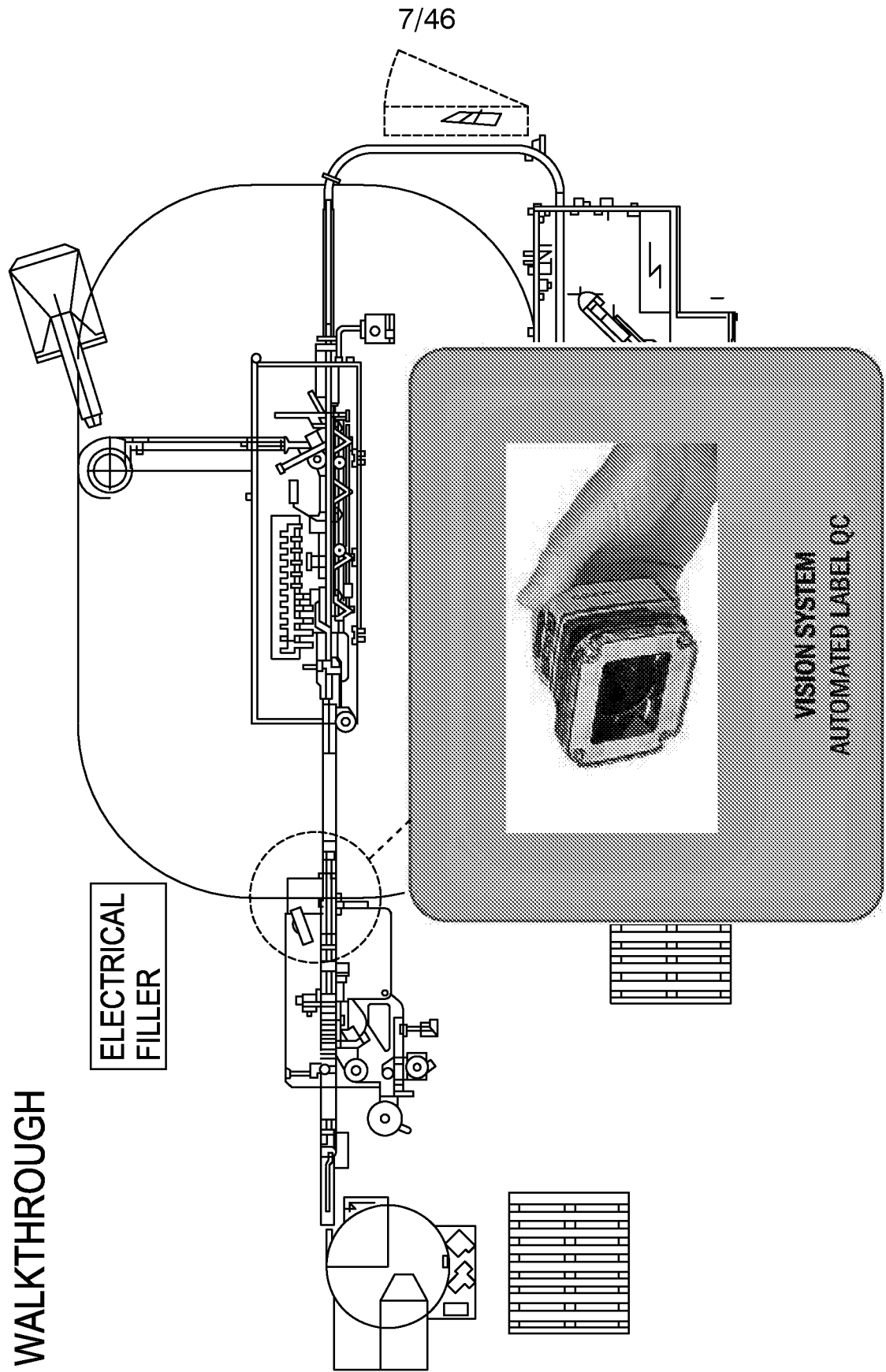


FIG. 6B

FILL LINE - WALKTHROUGH

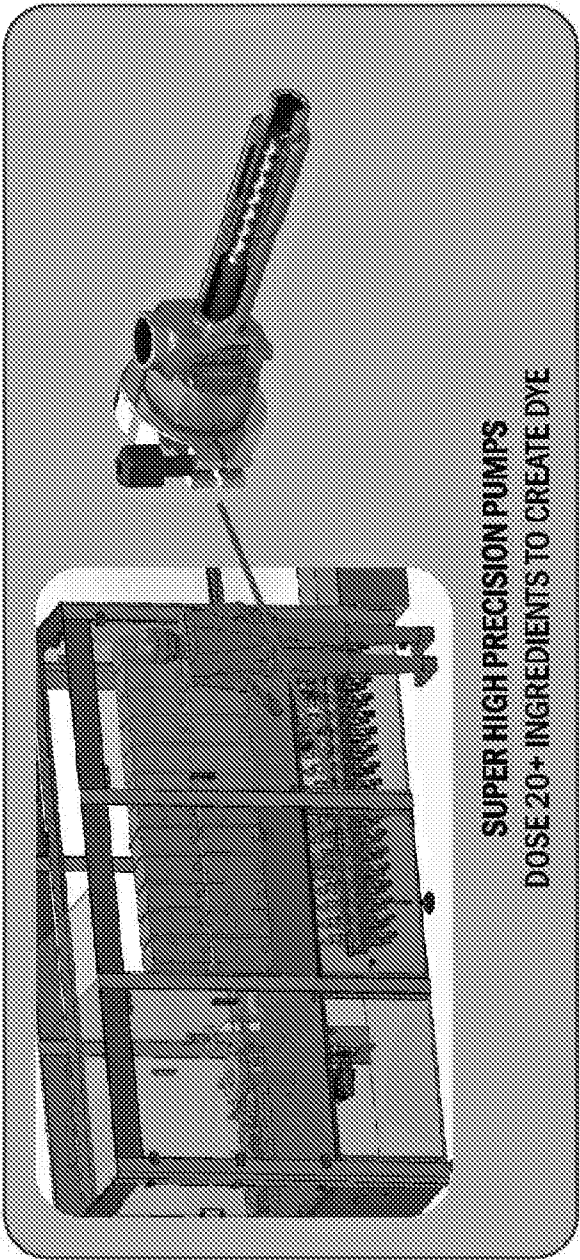
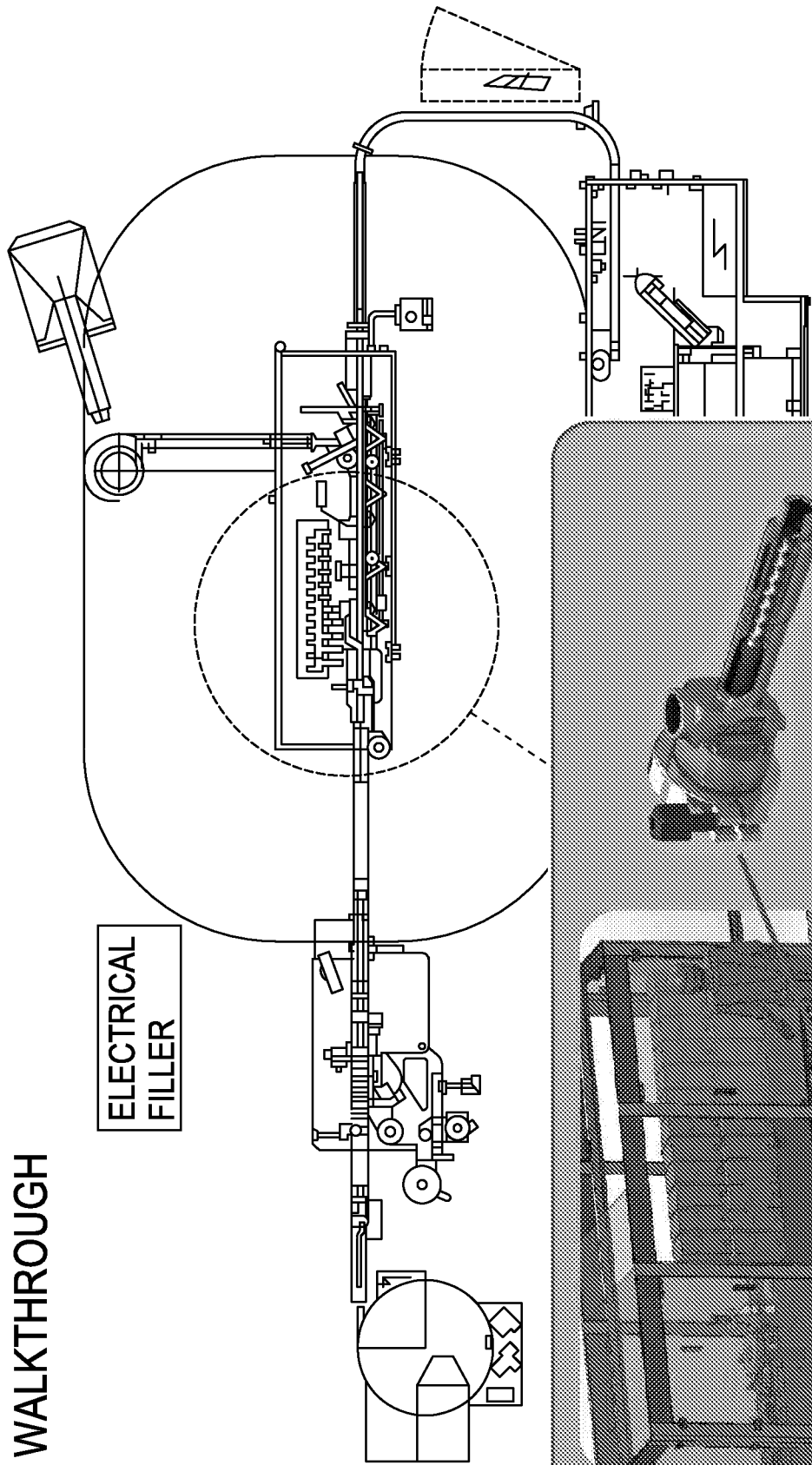
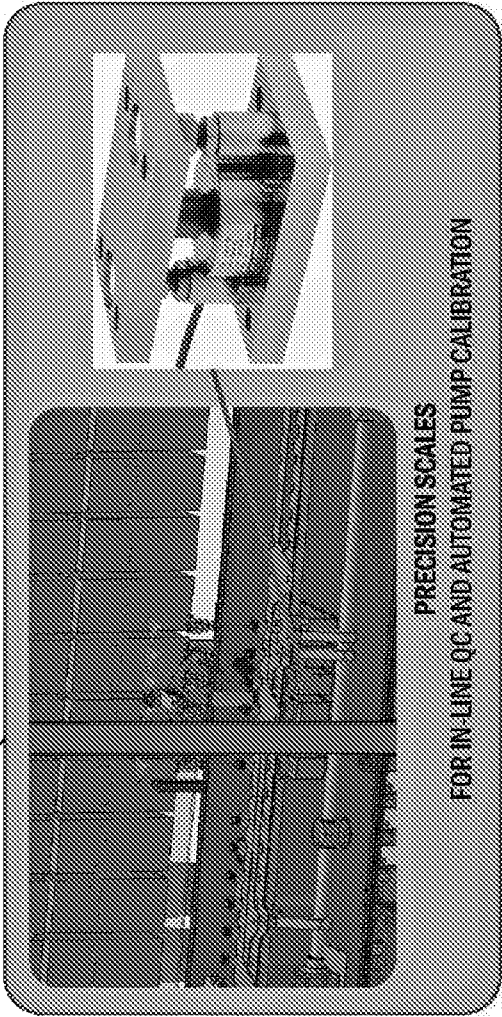
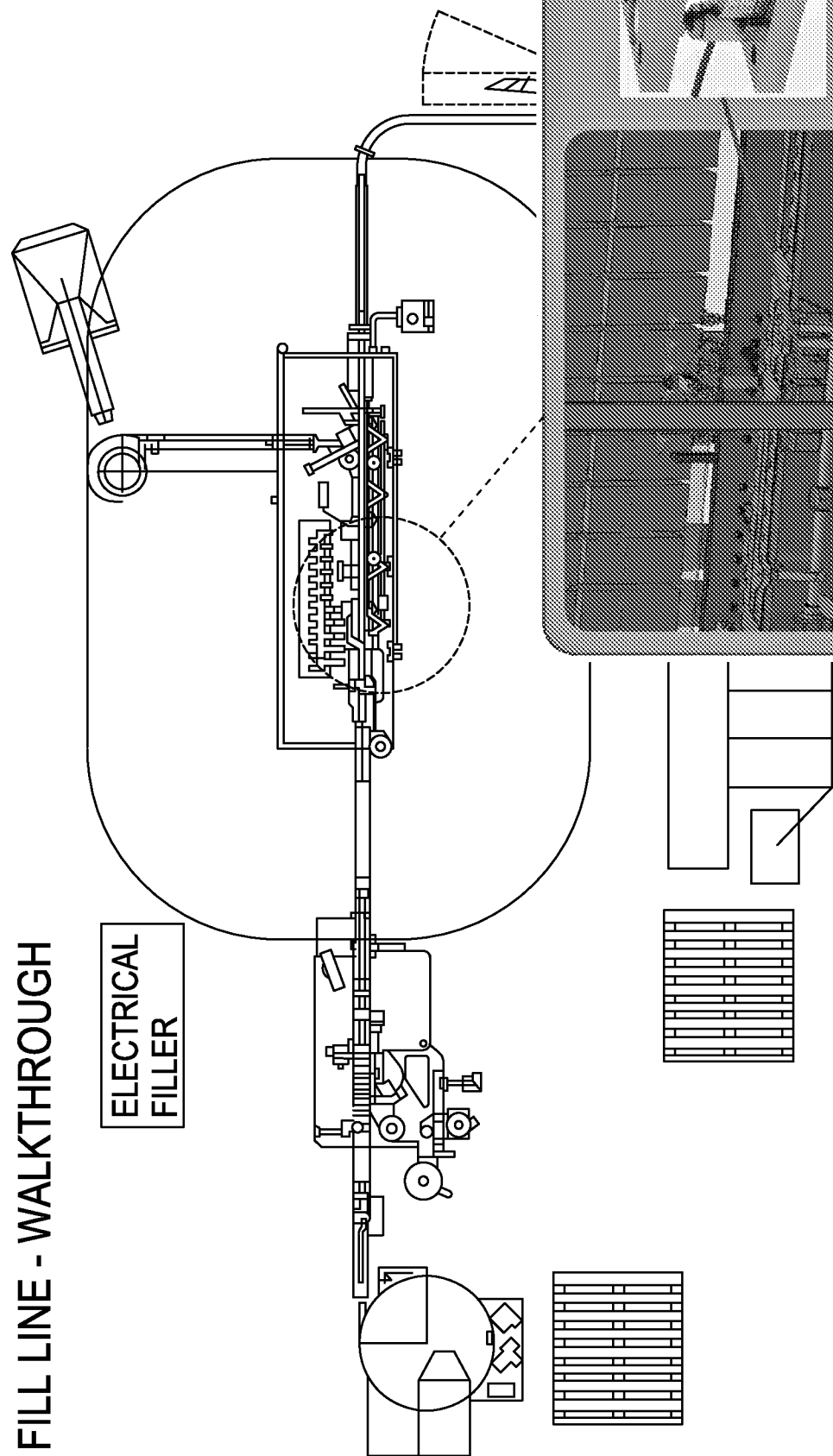


FIG. 6C

FIG. 6D

FILL LINE - WALKTHROUGH

ELECTRICAL
FILLER



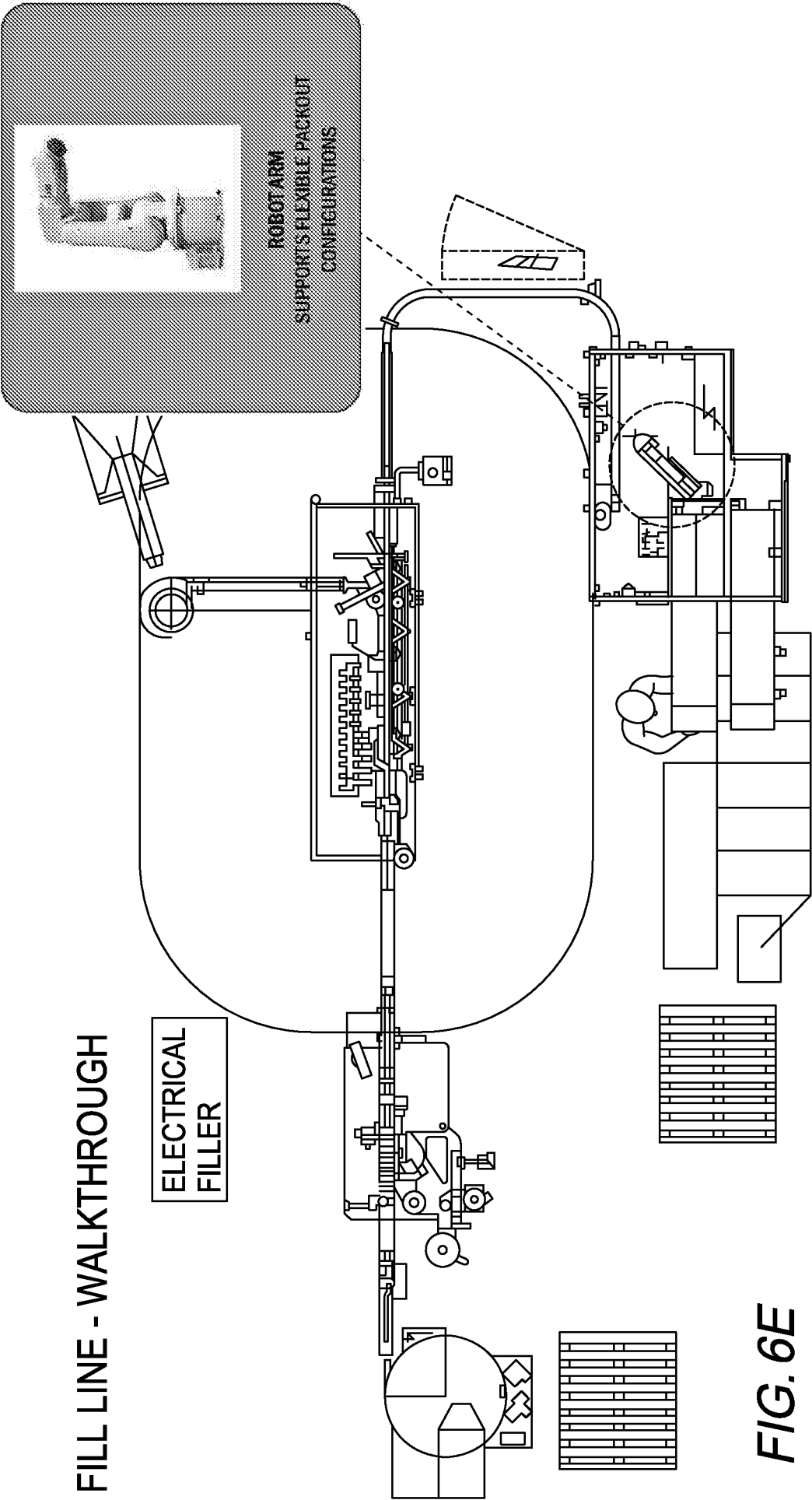


FIG. 6E

MUCH IT - FILL STATION NOI TECHNOLOGY



Fill Line & Dispensing station applies several simultaneous functions

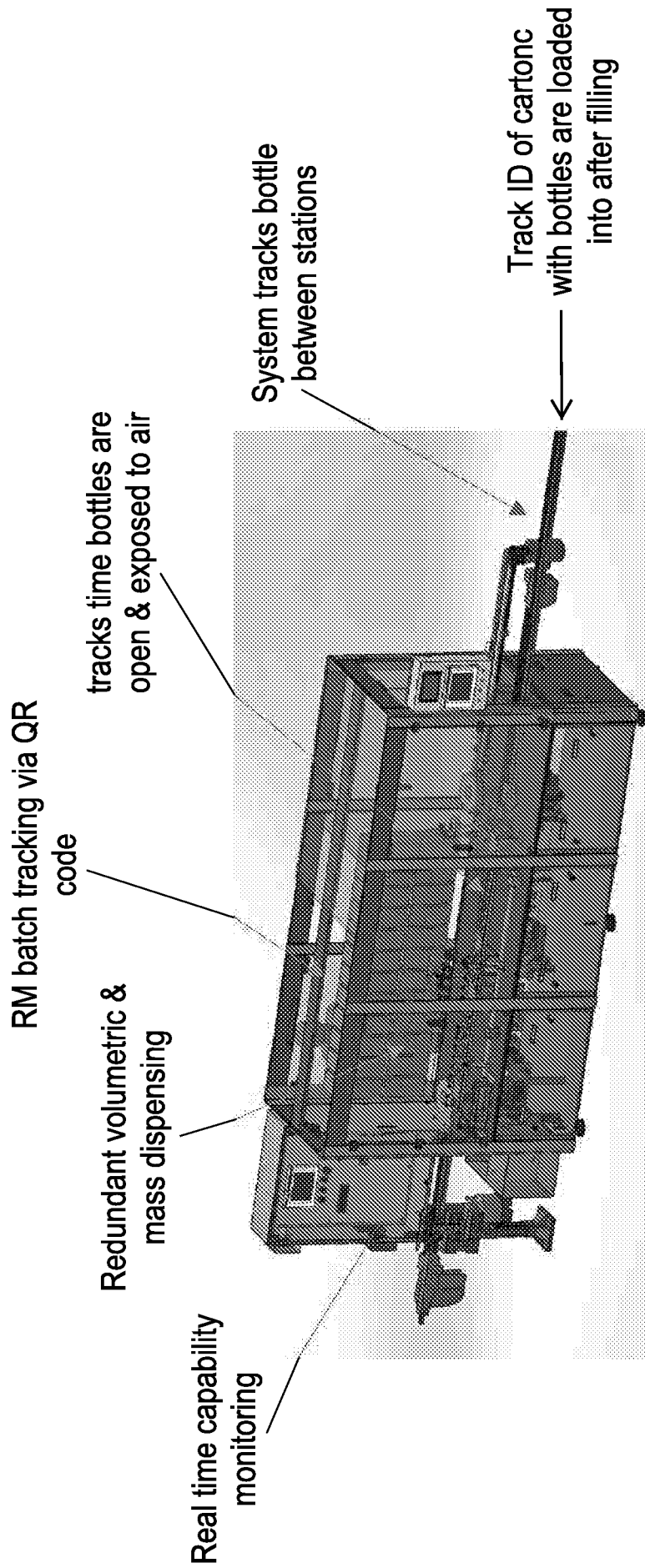


FIG. 7

BULK CONTAINER STRATEGY

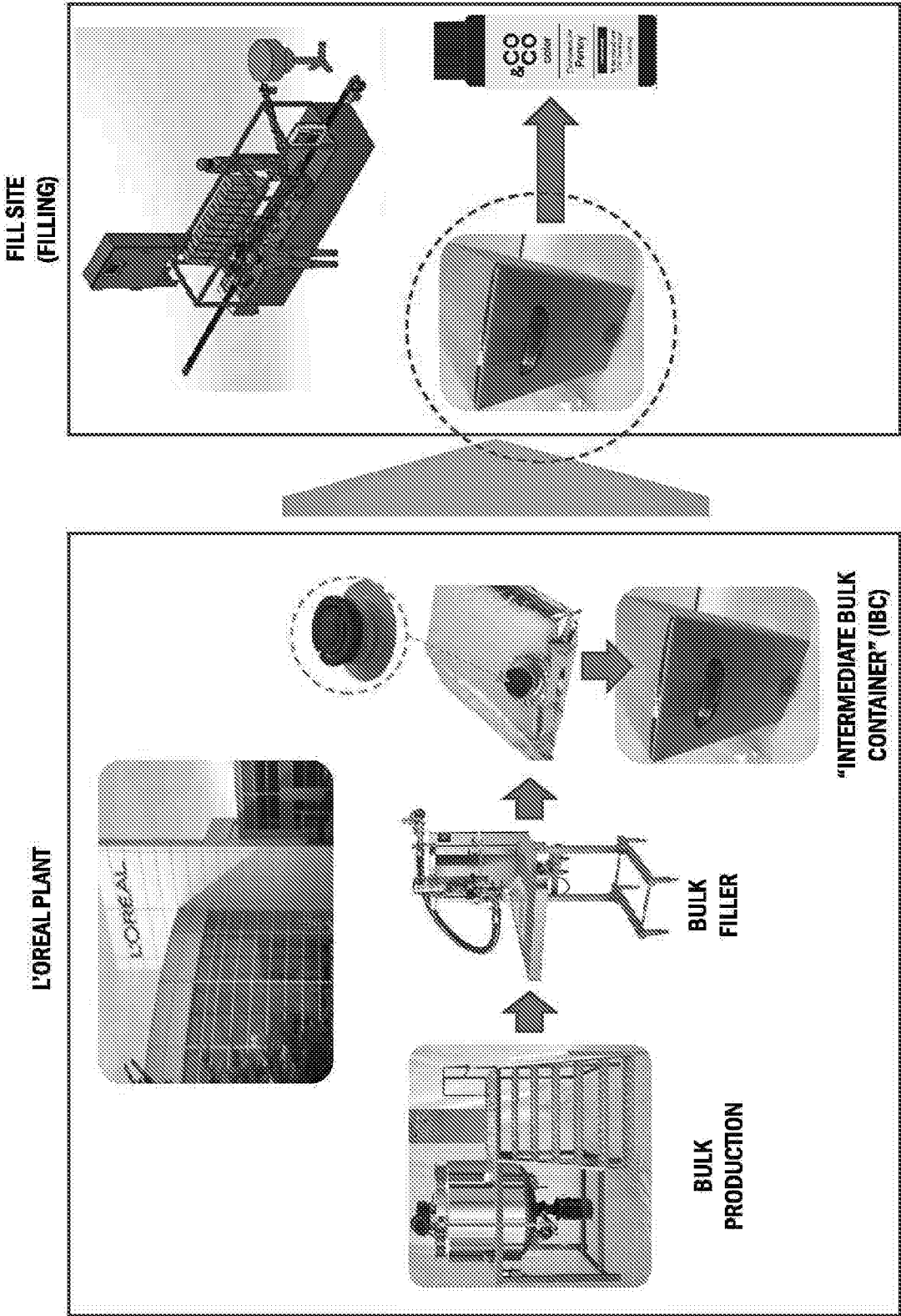


FIG. 8A

BULK CONTAINER REQUIREMENTS

- Related to contain XP (explosive) material
- Approved for international shipping and easy topelletize
- Provide for quick swapping capability to reduce fill line downtime
- Easily disposable/recyclable
- Optimally sized for compound usage rates while remaining ergonomic for operators
- Chemical compatibility with 17+compounds in long term storage
- Light blocking
- Completely airtight to prevent oxidation
- Reasonably priced to not affect FG piece price
- Long term availability from trusted supplier

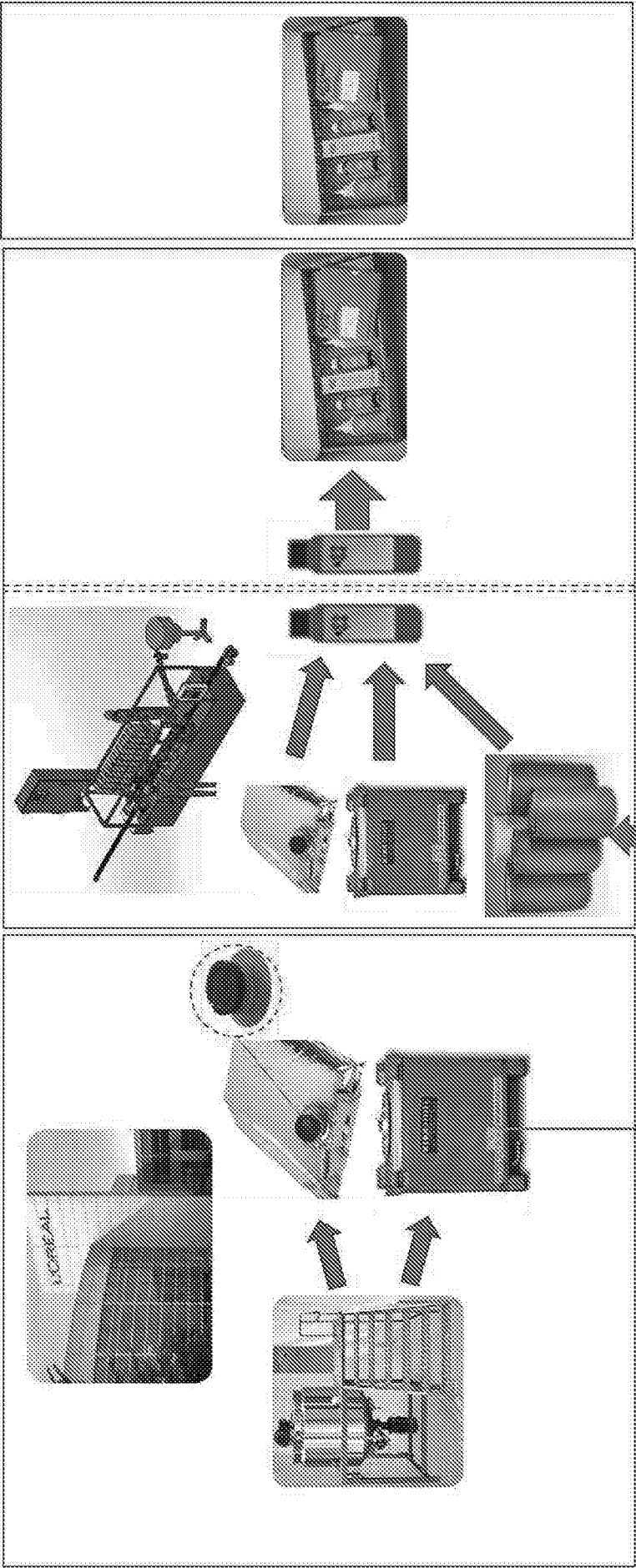
FIG. 8B

COREAL PLANE

3rd PARTY FILLER
(CENTRAL US)

FUFILLMENT

CUSTOMER



"INTERMEDIATE BULK
CONTAINER" (ibc)

RM SUPPLIERS

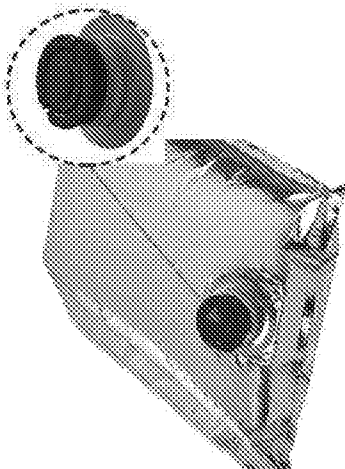
FIG. 9

MUCH – INTERMEDIATE BULK CONTAINERS (IBC)

TWO TYPES OF IBCs

STANDARD USE COMPOUNDS
(10L)

(MAY ADD MORE AFTER LAUNCH)



HEAVY USE COMPOUNDS
(1000L)

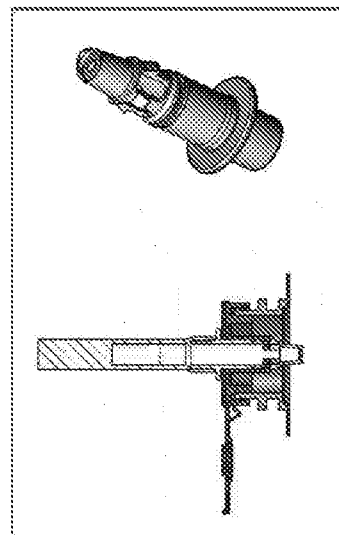
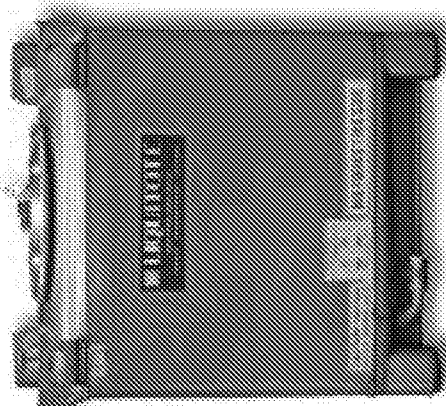


FIG. 10

16/46

MUCK - REGULAR USE IBC + CORRUGATE

MARKING/LABELING:

- RM 617 (REA)
- Monochrome compounds (15-24 types)

SIZE:

- 10.6L capacity, target fill = ~10L

GENERAL CONSTRUCTION:

- The bulk containers consist of a bag+sealed valve assembly
- The bulk tag would be shipped inside a corrugate box with an opening for the valve

BAG CONSTRUCTION:

- Bag film: minimum 2-ply engineered materials
 - Scholle Flexituff for O2 barrier and compatibility as this ply is in contact with material
 - Scholle HyBar for UV blocking
- Valve:
 - Scholle Sentry SafeLock: valve is foil sealed and is adapted to work with a "probe" on the MUCH fill machine. Valve + from watertight/airtight seal
 - Seal this video: <http://www.scholleipn.com/scholle-ipn-sentry-safelock-fitment-how-t-works/>
- See attachments:
 - Scholle-ipn-sentry-4.jpg (overview image of bag + valve construction)
 - L'Orel Potential Bag_10.6L.pdf (drawing of 10.6L bag)
 - FlexiTuff20.pdf & HyBar45HF.pdf (film materials datasheets)
 - Sentry SafeLock on 900 Spout, 20181018.pdf (valve datasheet)

FIG. 11A

17/46

CORRUGATE:

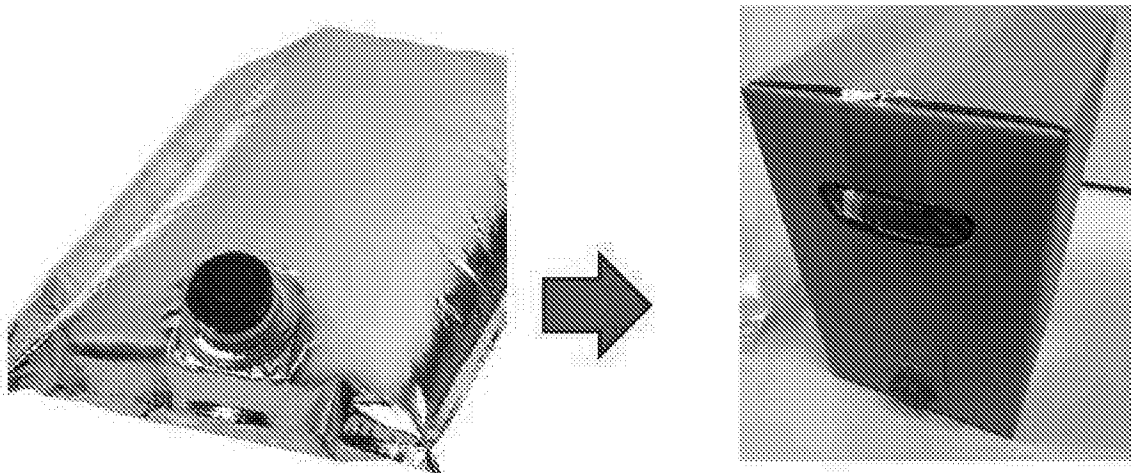
- Standard corrugate with handhold cutouts and cutout for bag spout
- Confirm dimensions from Scholle: of roughly 7.725" x 8" x 11.5"
- See attachment: Corrugate_mockup_v01.pdf (Size estimate for reference only, not final)

MARKING/LABELING:

- The inner bag as well as the corrugate should include a label that identifies the bag contents
- The outer label (on the corrugate) will contain human readable text (contents, expiration date, batch info) as well as 2D barcode with the same information encoded
- See attachment: Corrugate_mockup_vD1.pdf

SHIPPING:

- Would plan to ship palletized (pending review) - ESTIMATE 90 boxes/pellet

***FIG. 11B***

MUCK - HEAVY USE IBC

MATERIALS TO FILL:

- Clear Base compounds

SIZE:

- 1325 L capacity, target fill = ~1000L

GENERAL CONSTRUCTION:

- Industrial tote lined with bag + Cap

TOTE:

- Hoover 1325L tote (currently used in MTL and Bocchi)
- See attachment:
 - Metal Liquitote drawing.pdf
 - Liquitote-IBC-Tanks.pdf (look at 1325L option)

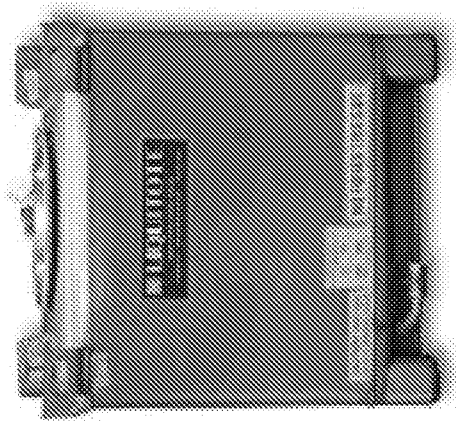


FIG. 12

LINER CONSTRUCTION:

- Bag film: minimum 3-ply engineered materials
 - FreedomMFG liner (Currently used in Montreal plant) - TBD per compat

MARKING/LABELING:

- Outer label (on the tote) will contain human readable text (contents, expiration date, batch info) as well as a 2D barcode with the same information encoded

SHOPPING:

- Would ship non-palletized
- to recycle, liner could be disposed, and tote shipped empty back to Montreal for refill

CLOCK ATTACHMENTS
TO OPEN

MUCK - IBC FILLING EQUIPMENT - PRODUCTION

- minute). 1.5M units/year assuming 2*8 hours shifts
- Fills the bag
 - Caps the bag with foil sealed valve
 - Has capability to flush with nitrogen or create vacuum

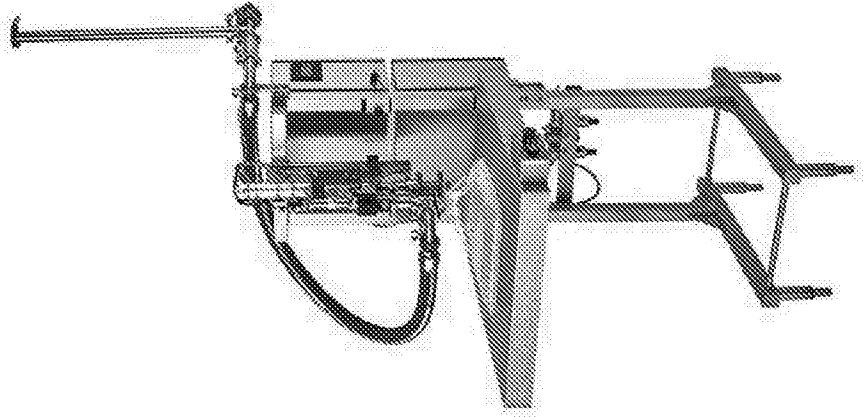


FIG. 13

MUCH - DIRECT rm INGREDIENTS

MATERIALS TO PURCHASE:

- Ammonia 14B
- At vendor (Ammonia Lab supplier like WD Service Co.; 14B Chimex)

SIZE:

- Ammonia: 200L drum
- 14B: 6L aluminum bottle

GENERAL CONSTRUCTION:

- industrial pre-DOT approved containers

MARKING/LABELING:

- Ammonia: 200L drum
- 14B: 6L aluminum bottle

SHIPPING:

- Would ship non-palletized

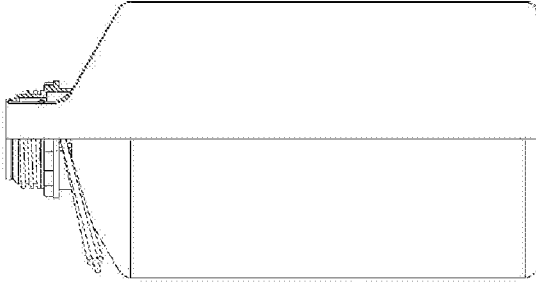
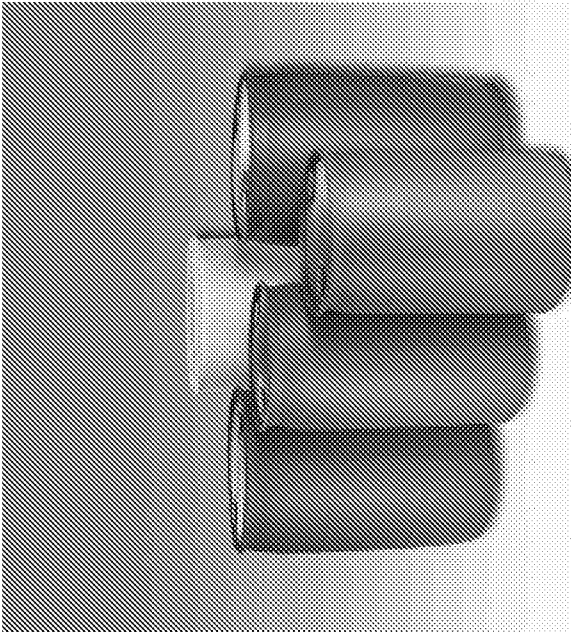


FIG. 14

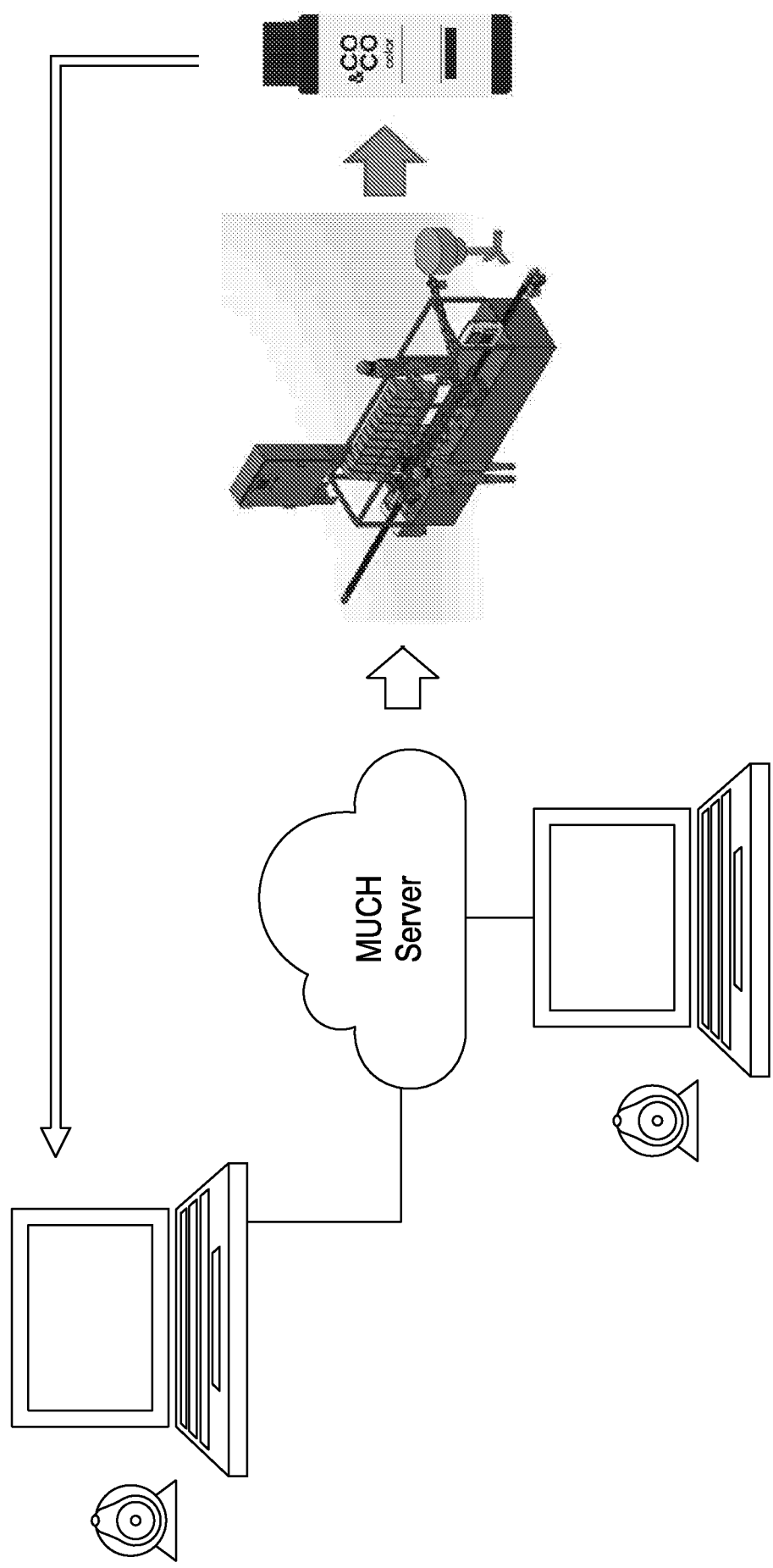
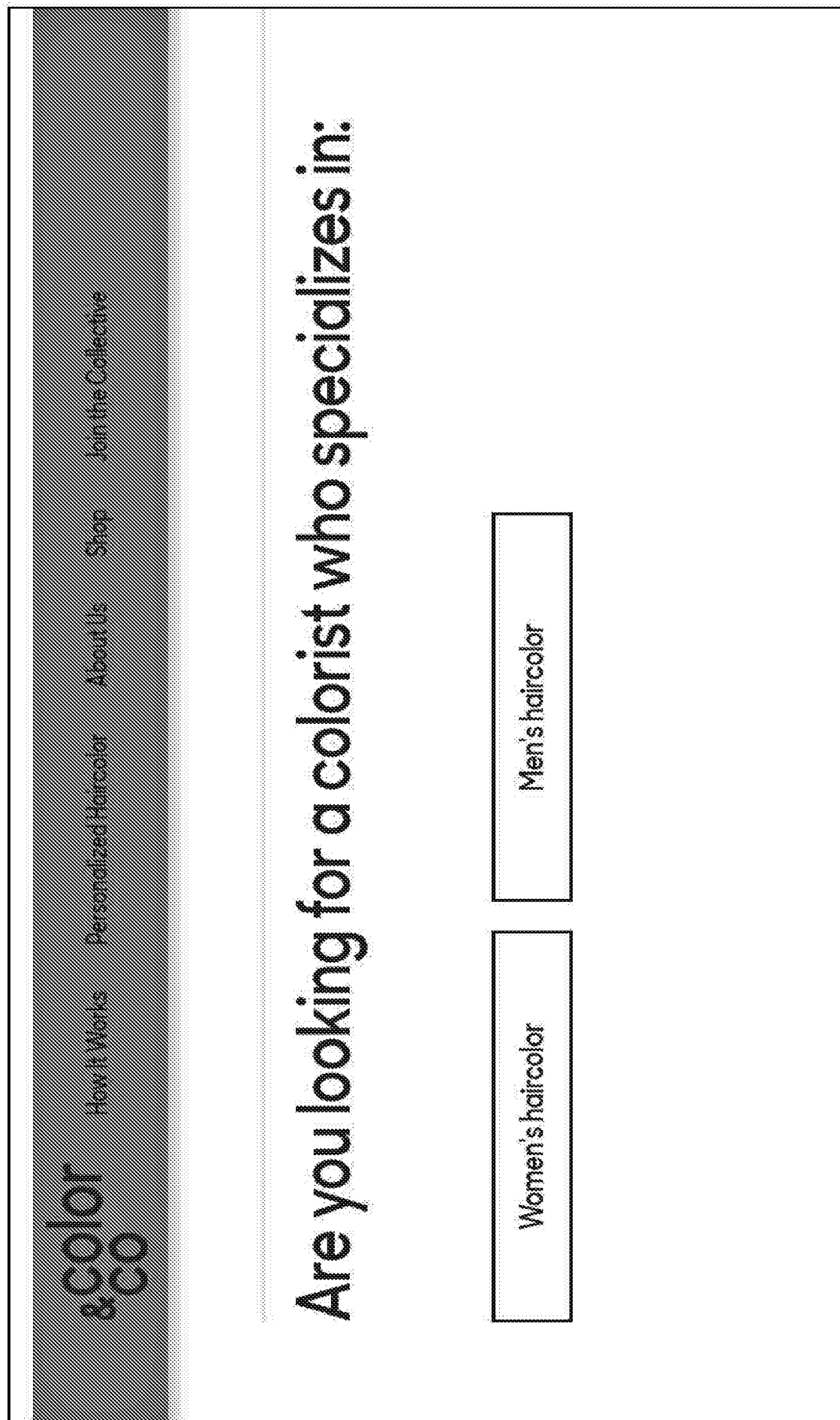


FIG. 15

**FIG. 16**

[color & co](#)
[How it Works](#)
[Personalized Hair color](#)
[About it](#)
[Shop](#)
[Join the Collective](#)
[Sign in](#)

Should your colorist be an expert in:

Blonde	Brown	Block	Copper, Red or Violet	Highlight or Ombre	Pastels or Vivids
I'm not sure			Coming Soon		

FIG. 17

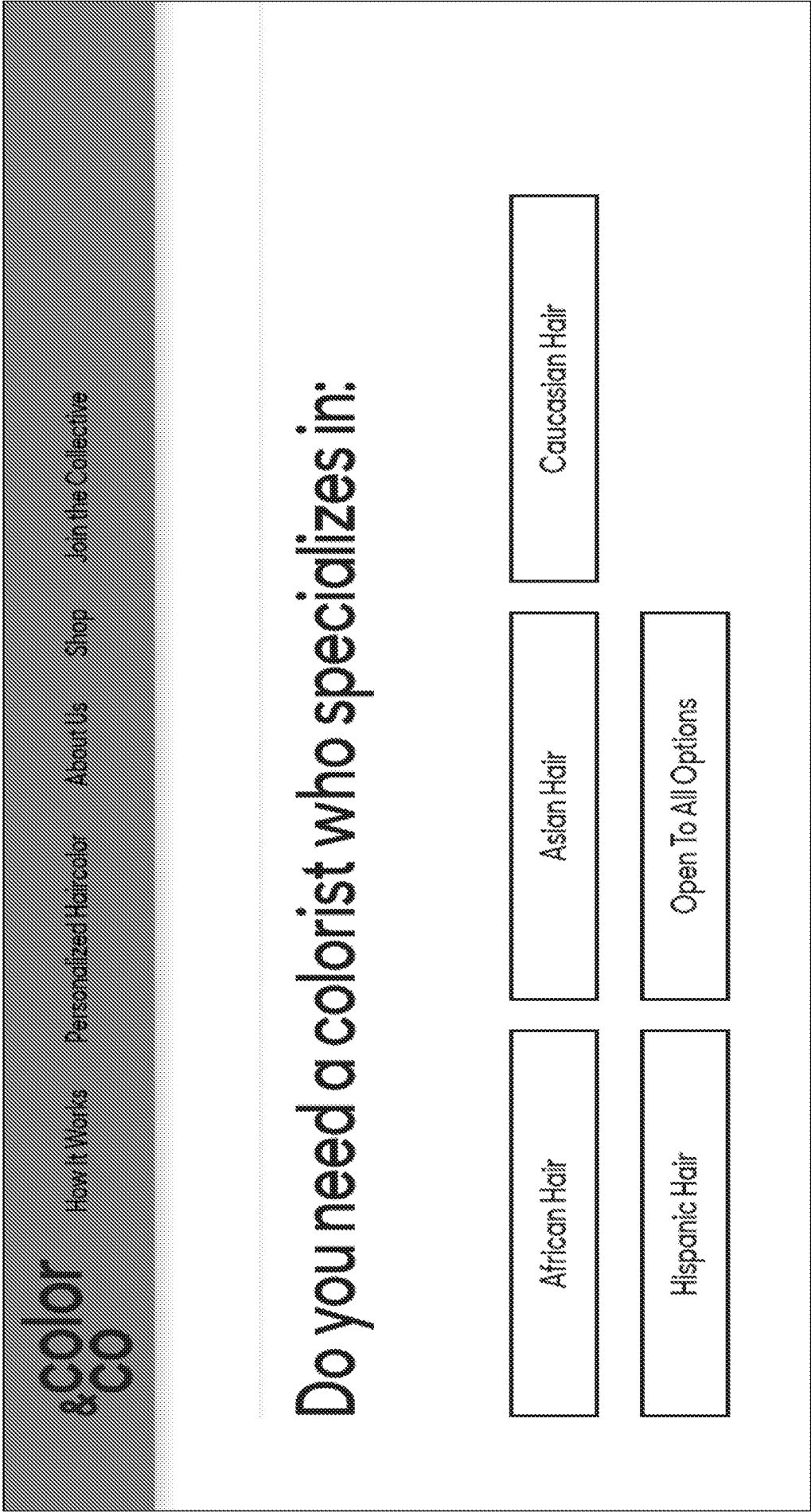


FIG. 18

25/46

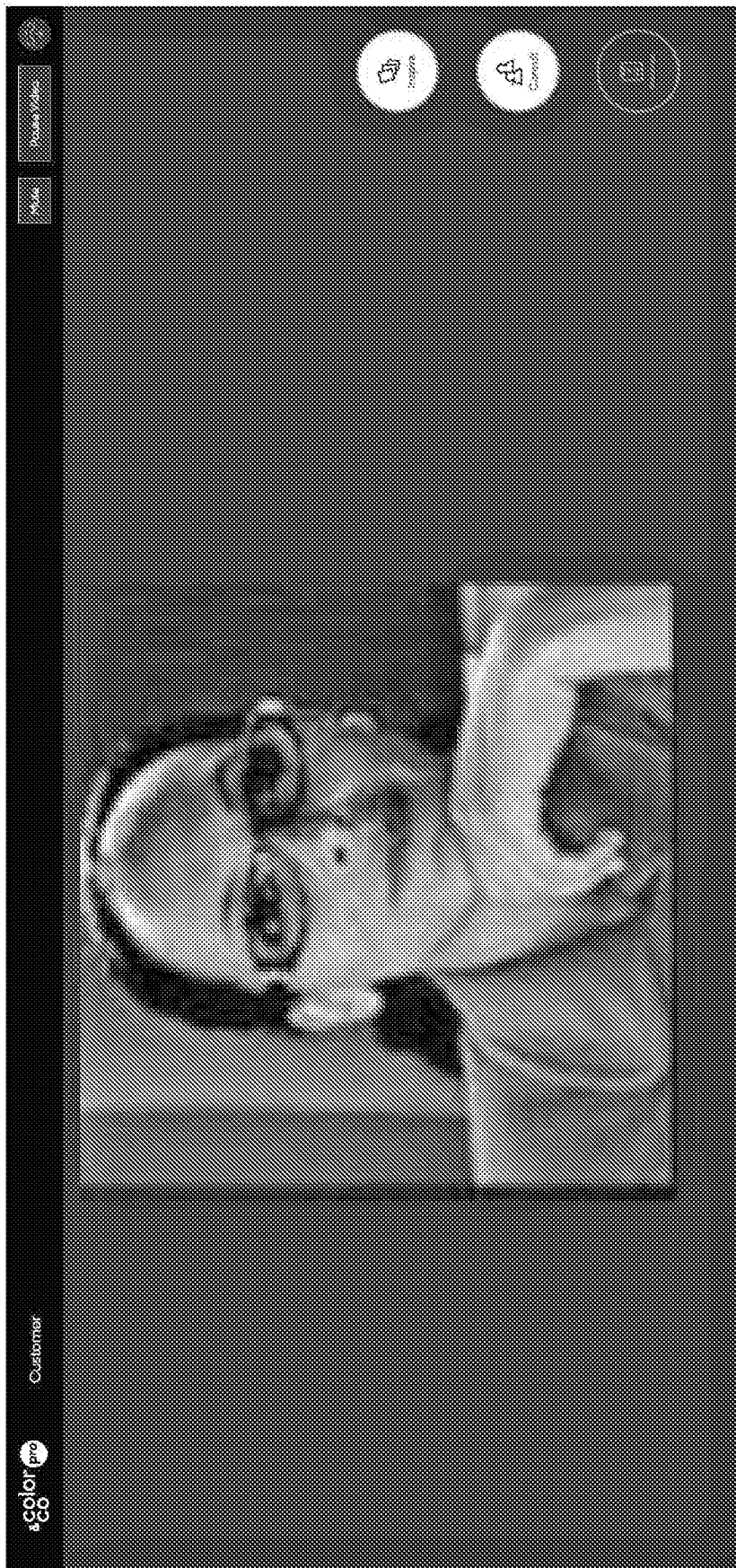


FIG. 19

Inspire

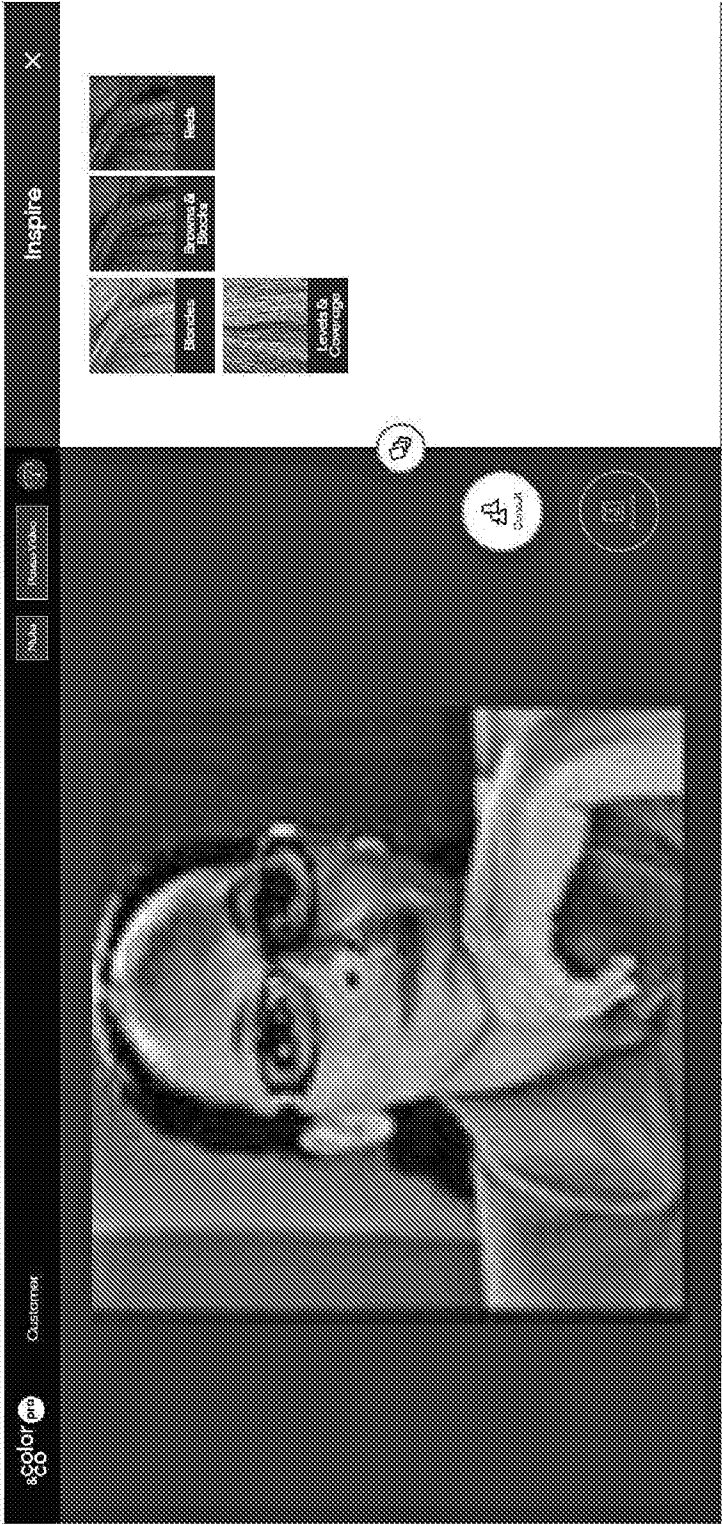


FIG. 20

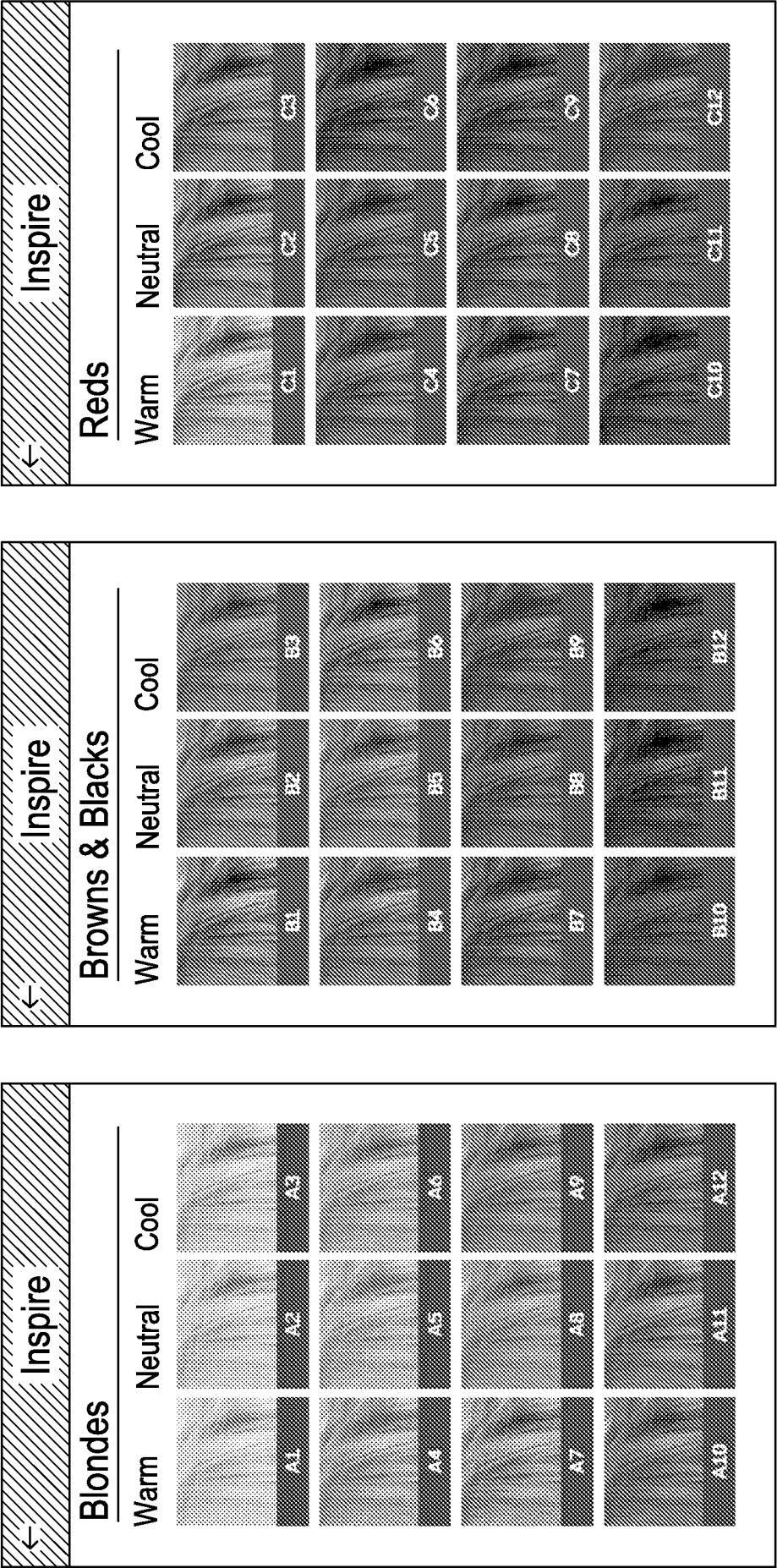


FIG. 21

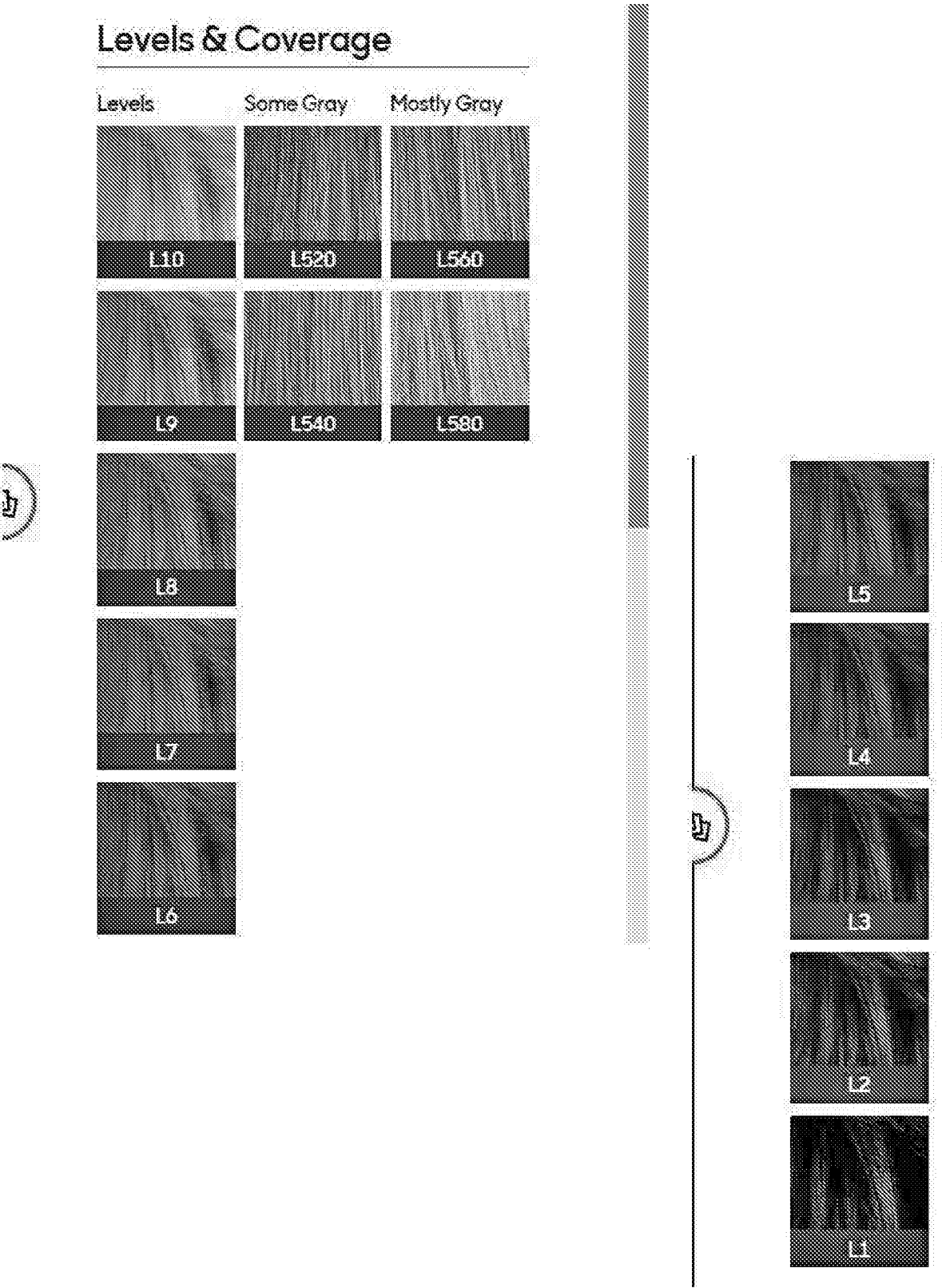


FIG. 22

Consult

Consult

Hair Goal
3 remaining

Natural/Current Hair
3 remaining

Hair Type & Style
3 remaining

Color-Treated Hair
1 remaining

Lifestyle
1 remaining

Eye & Skin Tone
Optional

⚠ Don't forget to select a swatch!

Continue To Prescribe Colorbox

FIG. 23

Consult

Hair Goal

3 remaining

Hair Type & Style

3 remaining

Lifestyle

1 remaining

Natural/Current Hair

3 remaining

Color-Treated Hair

1 remaining

Eye & Skin Tone

Optional

⚠ Don't forget to select a swatch!

Continue To Prescribe Colorbox

×

←

Hair Goal

Looking For Required

Highlight or Omber

Pastels or Vivid

End Result Required

Blonde

Brown

Black

Copper, Red or Violet

Highlight or Omber

Pastels or Vivid

Service Required

Match

Lighten

Darken

New shade

Done

FIG. 24

Dependencies • Only Copper, Red or Violet asks for Vibrancy	Looking For Required Match Pastels or Vivids End Result Required Blonde Brown Black Copper, Red or Violet Match Pastels or Vivids Service Required Match Lighten Darken New shade Vibrancy Required Classic Expressive Adventurous Done
--	--

FIG. 25

×

Consult

Hair Goal
3 remaining

Natural/Current Hair
3 remaining

Hair Type & Style
3 remaining

Color-Treated Hair
1 remaining

Lifestyle
1 remaining

Eye & Skin Tone
Optional

⚠ Don't forget to select a swatch!

Continue To Prescribe Colorbox

3

FIG. 26A

←	Natural / Current Hair	
Chemical History Required		
Perm	Relaxer	
Keratin	Bleach	
Henna	No chemicals	
Gray Required		
No gray	Same gray	
Mostly gray	All gray	
Natural Level Required		
1 - Black	2 - Natural Black	
3 - Darkest Brown	4 - Dark brown	
5 - Medium Brown	6 - Light Brown	
7 - Dark Blonde	8 - Medium Blonde	
9 - Light Blonde	10 - Lightest Blonde	
N/A - All Gray		
Natural Tone		
	Cool	Natural
	Warm	Red/Copper
Done		

FIG. 26B

Consult

×

Hair Goal
3 remaining

Natural/Current Hair
3 remaining

Hair Type & Style
3 remaining

Color-Treated Hair
1 remaining

Lifestyle
1 remaining

Eye & Skin Tone
Optional

⚠ Don't forget to select a swatch!

Continue To Prescribe Colorbox

←

Hair Type & Style

Density Required

Spase/thinning

Thin

Medium Density

Thick/very thick

Texture Required

Fine

Medium Texture

Coarse

Length Required

Very Short (cropped)

Short

Medium (chain length)

Long (shoulder length)

Very Long (past shoulders)

Condition

Healthy

Slightly damaged

Very damaged

FIG. 27

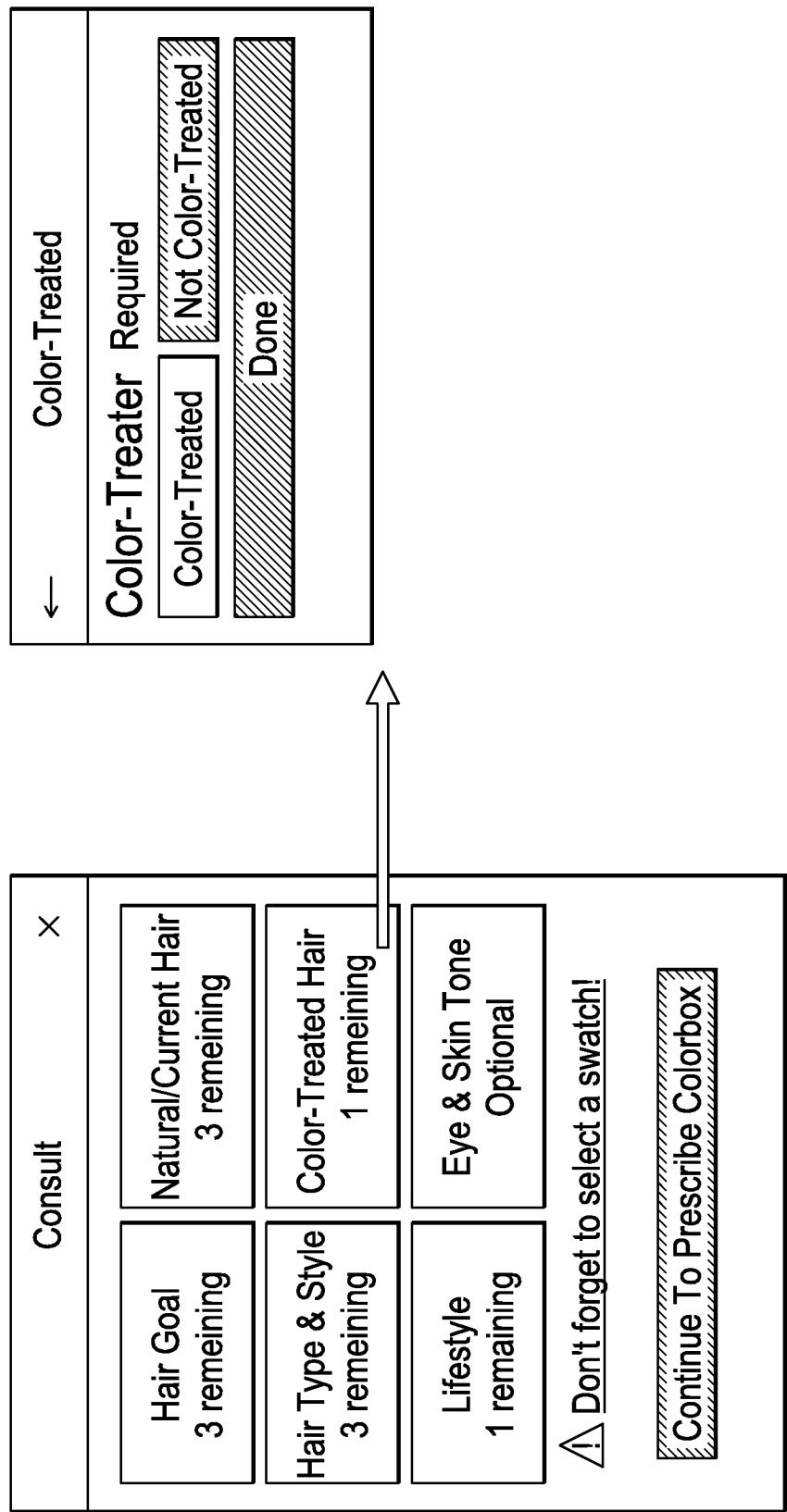


FIG. 28A

36/46

← Color-Treated

Color-Treater Required

 1 - Black	2 - Natural Black
3 -Darkest Brown	4 - Dark Brown
5 - Mediun Brown	6 - Light Brown
7 - Dark Blonde	8 -Medium Blonde
9 - Light Blonde	10 - Lightest Blonde

OR

Color-Treated Tone

Ash	Natural
Gold	Red/Copper
Other	

Last Color

Less than 1 month	1-2 Months
2-3 Months	More than 3 Months

Resistant

Yes	No
-----	----

 Done

FIG. 28B

Consult		X
Hair Goal 3 remaining	Natural/Current Hair 3 remaining	⚠ Don't forget to select a swatch! Continue To Prescribe Colorbox ↑
Hair Type & Style 3 remaining	Color-Treated Hair 1 remaining	
Lifestyle 1 remaining	Eye & Skin Tone Optional	

←	Lifestyle	
Color-Frequency Required		
Every 3 weeks	Every 4 weeks	
Every 5 weeks	Every 6 weeks	
Every 7 weeks	Every 8 weeks	
Every 9 weeks	Every 10 weeks	
Lifestyle		
Shampoos frequently	Outdoors/in the sun	
Hard water	Swims	
Styling Habits		
Air, diffuse or rough dry	Blow dry/iron-volume	
Blow dry/iron-smooth		
Done		

FIG. 29

Consult

Hair Goal
3 remaining

Natural/Current Hair
3 remaining

Hair Type & Style
3 remaining

Color-Treated Hair
1 remaining

Lifestyle
1 remaining

Eye & Skin Tone
Optional

⚠ Don't forget to select a swatch!

Continue To Prescribe Colorbox

←

Eye & Skin Tone

Eye Color

Blue

Green

Brown

Hazel

Complexion

Mahogany, Espresso, Ebony

Bronze, Dark Brown, Chestnut

Caramel, Tan Honey

Golden, Olive, Sand

Vanilla, Beige, Cream

Porcelain, Ivory, Alabaster

Skin Tone

Cool

Warm

Neutral

Done

FIG. 30

←

Prescribe

×

Prescribe

Summary

Edit

Hiar Goal

Natural/CurrentHair

• Women's Hair Color

• No Chemical

• Copper, Red or Violet

• No gray

• Lighten

• 4 - Dark Brown

• Adventurous

• Red/Copper

View More

+

☐ No prescription recommended at this time.

Application

At the roots

>

Roots then ends

>

All Over

>

FIG. 31

40/46

Application	
At the roots	^
☐ Touch up <i>match color-treated hair</i>	
Roots then ends	^
☐ Darken <i>darken, color-treated hair</i>	
☐ new Tone <i>change tone of color-treated hair</i>	
All Over ✓	^
☒ Darken <i>darken, not color-treated</i>	
☐ New Tone <i>change tone of natural hair, not color-treated</i>	
☐ Short Hair <i>short or very short hair</i>	
☐ Match <i>match natural, not color-treated</i>	
☐ Men's Color <i>full gray coverage or all over color</i>	
☐ Lighten <i>lighten medium to long hair</i>	

FIG. 32

☐ Touchup
match color-treated hair

☐ Darken
darken, color-treated hair

☐ New Tone
change tone of color-treated hair

☒ All Over ✓

☐ Darken
darken, not color-treated

☐ New
change tone of natural hair, not color-treated

☐ Short
short hair

☐ Match
match natural, not color-treated

☐ Men's
full coverage or all over color

☒ Light
lighten from medium to long hair

☐ Formula

☐ Roots To Ends

☐ TYPE

☐ TONE DVLP ROOT ENDS

☐ Perm

☐ Set Formula

FIG. 33A

42/42

☐ Touchup
match color-treated hair

Roots then ends ^

☐ Darken
darken, color-treated hair

☐ New Tone
change tone of color-treated hair

All Over ✓ ^

☐ Darken
darken, not color-treated

☐ New Tone
*change tone of natural hair,
not color-treated*

☐ Short Hair
short or very short hair

☐ Match
match natural, not color-treated

☐ Men's Color
full gray coverage or all over color

☒ Lighten
lighten medium to long hair

Formula 1 -Roots To Ends

TYPE	LEVEL	ZONE	DVLP	ROOT	ENDS
Perm	8	CG - .43	30	35	35

FIG. 33B

• EXPLAIN WHY YOU'RE SUGGESTING IT • Explain and additional products you're • Recommending (e,g, special shampoo / conditioners) • Remand them of the personalized video tutorials they will receive to help apply the hair color	
Customer's Color Goal Edit	
☐	Classic mocha plum
Prescribed Color Edit	
☐	Darkest Intense Violet Brown: Bold, cool violet tones. 3.22 / 3V (30)
Closing Checklist Edit	
✓ Describe - Prescribed Color ✓ Explain - Application Technique ✓ Recommend - Ancillary Products ✓ Perform - Skin Allergy Test	
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FIG. 34

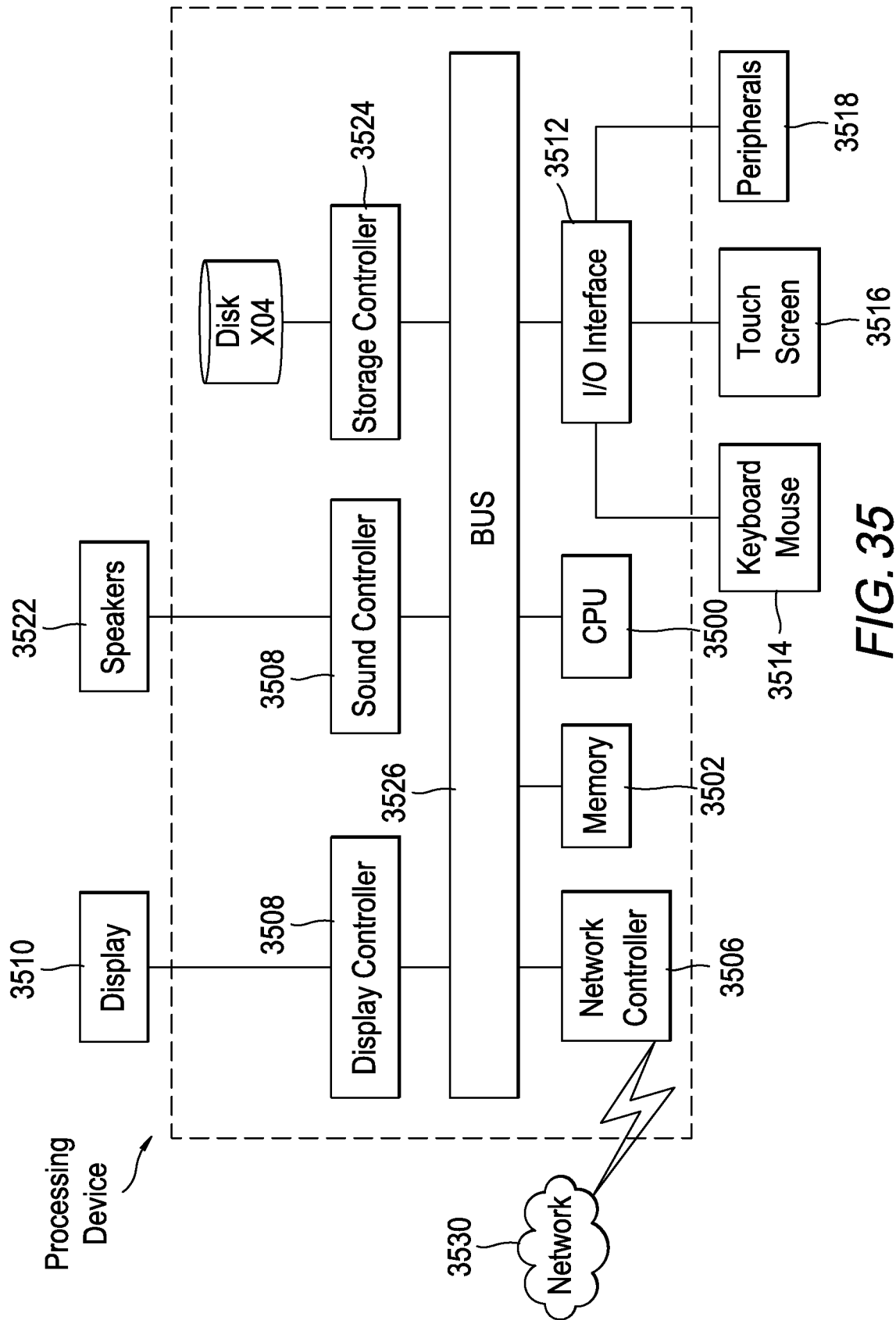
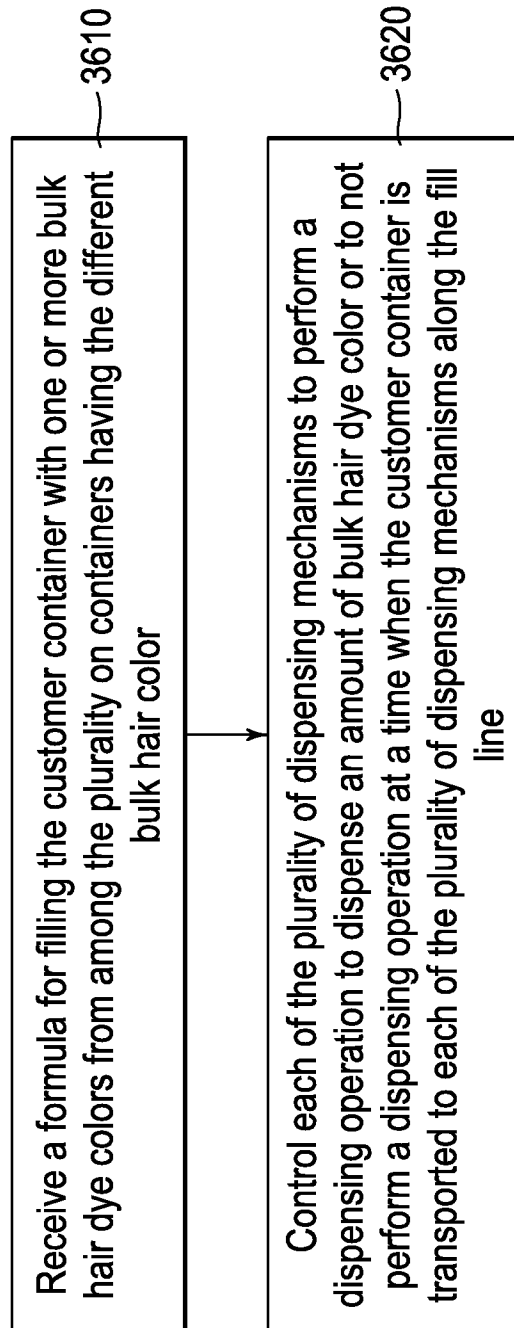


FIG. 35

45/46

*FIG. 36*

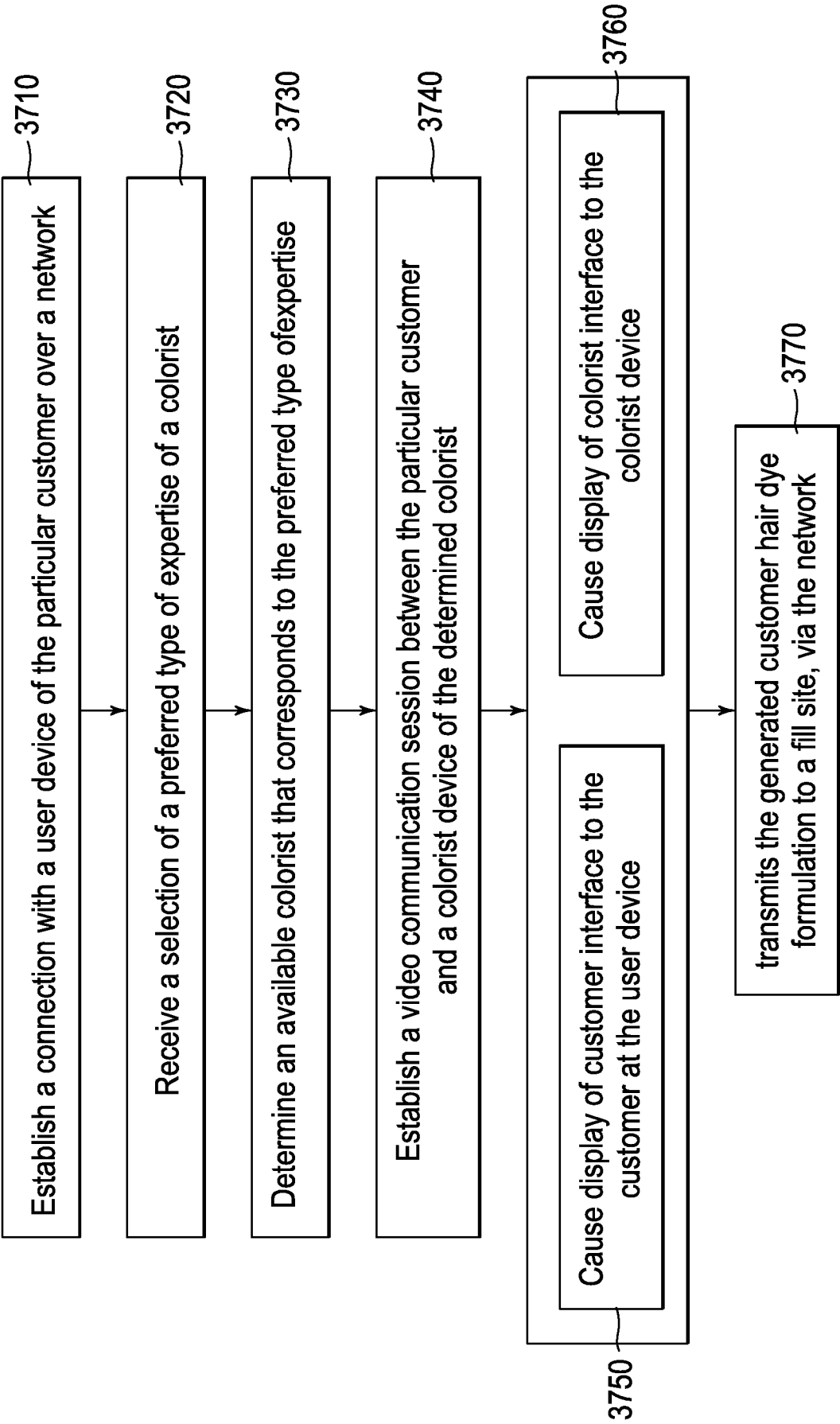


FIG. 37

INTERNATIONAL SEARCH REPORT

International application No
PCT/US2020/020669

A. CLASSIFICATION OF SUBJECT MATTER
INV. A45D44/00 A45D44/02
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)
A45D

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 2015/021356 A1 (WITCHELL DAVID J [US] ET AL) 22 January 2015 (2015-01-22) paragraphs [0105] - [0122]; figure 3 -----	1,2
X	US 2018/357695 A1 (WOLFF PAUL [US] ET AL) 13 December 2018 (2018-12-13) paragraphs [0041] - [0043]; figure 1 -----	1



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents :

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Date of the actual completion of the international search

29 April 2020

Date of mailing of the international search report

11/05/2020

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/US2020/020669

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
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			HK 1224274 A1 18-08-2017
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			WO 2015009943 A2 22-01-2015

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