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**Funderburk et al.**(10) **Pub. No.: US 2015/0025345 A1**(43) **Pub. Date: Jan. 22, 2015**(54) **SENSOR INSERTER ASSEMBLY****Publication Classification**(71) Applicant: **Abbott Diabetes Care Inc.**, Alameda, CA (US)(72) Inventors: **Jeffery V. Funderburk**, Stevenson Ranch, CA (US); **Duane O. Yamasaki**, El Cerrito, CA (US); **Brian VanHiel**, Marietta, GA (US); **Stephen J. Flynn**, Peachtree City, GA (US); **Bradley D. Kelemen**, Longmont, CO (US)(73) Assignee: **Abbott Diabetes Care Inc.**, Alameda, CA (US)(21) Appl. No.: **14/509,993**(22) Filed: **Oct. 8, 2014****Related U.S. Application Data**

(63) Continuation of application No. 14/244,831, filed on Apr. 3, 2014, which is a continuation of application No. 12/538,067, filed on Aug. 7, 2009, now abandoned, which is a continuation of application No. 11/899,917, filed on Sep. 6, 2007, now Pat. No. 8,029,442, which is a continuation of application No. 10/703,214, filed on Nov. 5, 2003, now Pat. No. 7,381,184.

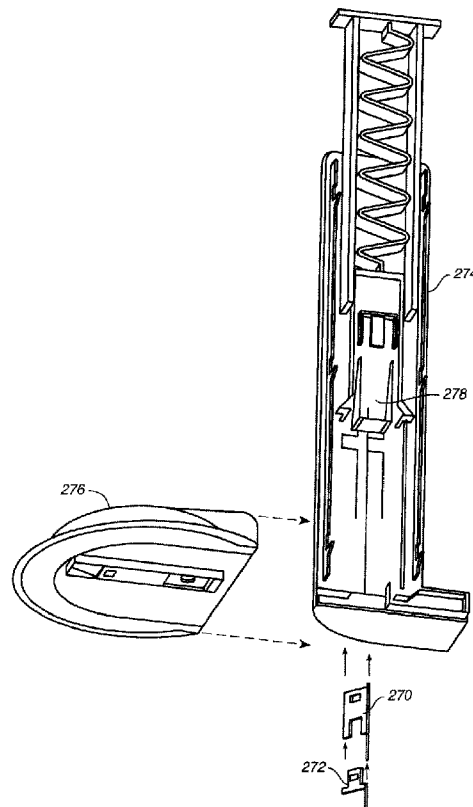
(60) Provisional application No. 60/424,099, filed on Nov. 5, 2002.

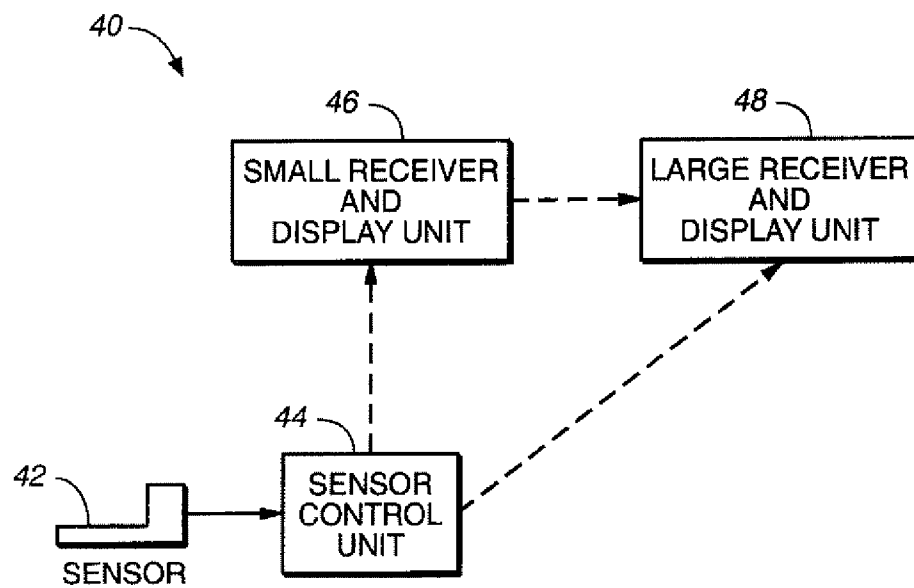
(51) **Int. Cl.****A61B 5/1473** (2006.01)**A61B 5/00** (2006.01)**A61B 17/34** (2006.01)**A61B 5/145** (2006.01)(52) **U.S. Cl.**CPC ..... **A61B 5/1473** (2013.01); **A61B 5/14532** (2013.01); **A61B 5/14546** (2013.01); **A61B 5/6833** (2013.01); **A61B 17/3468** (2013.01)USPC ..... **600/345**

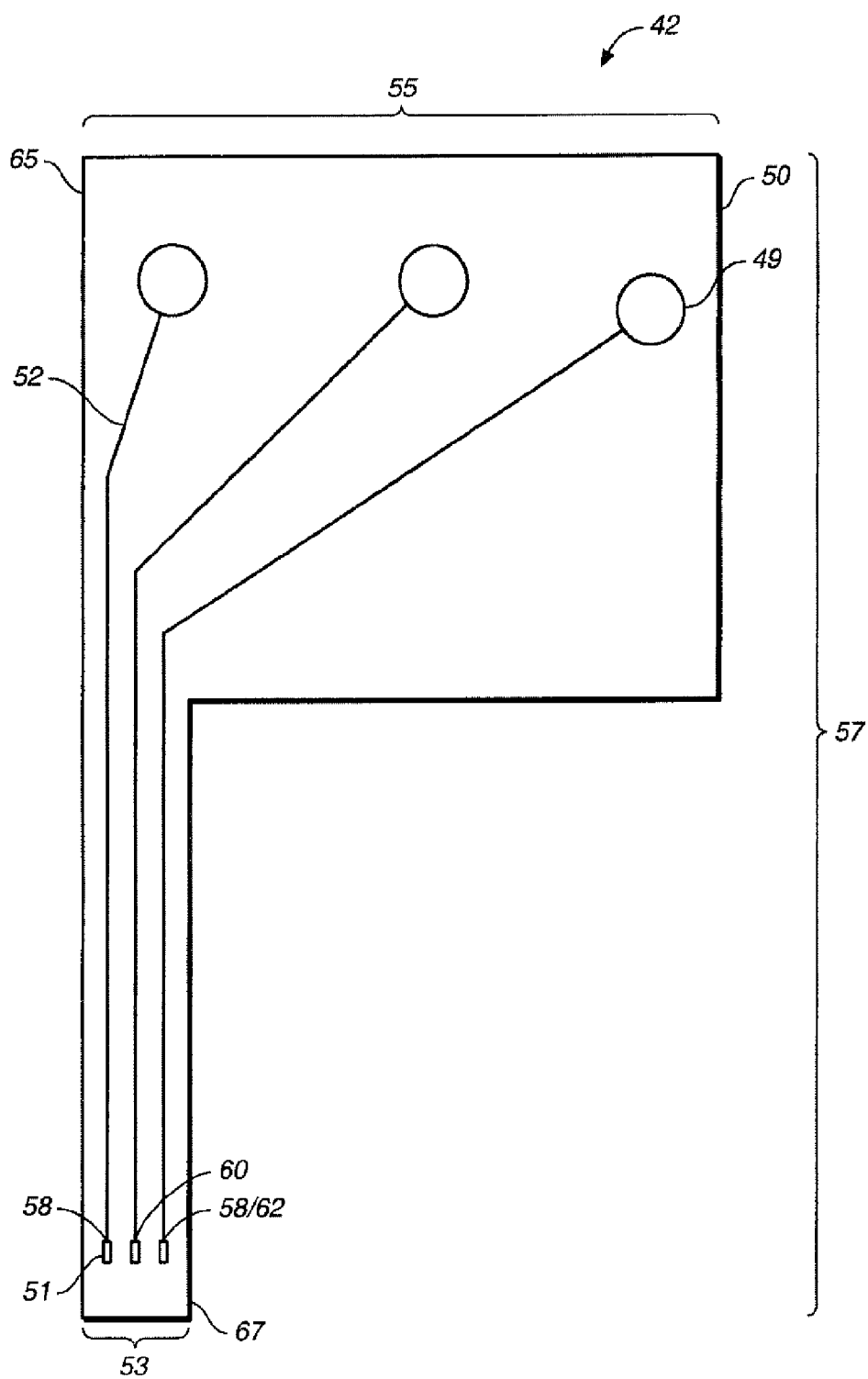
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**ABSTRACT**

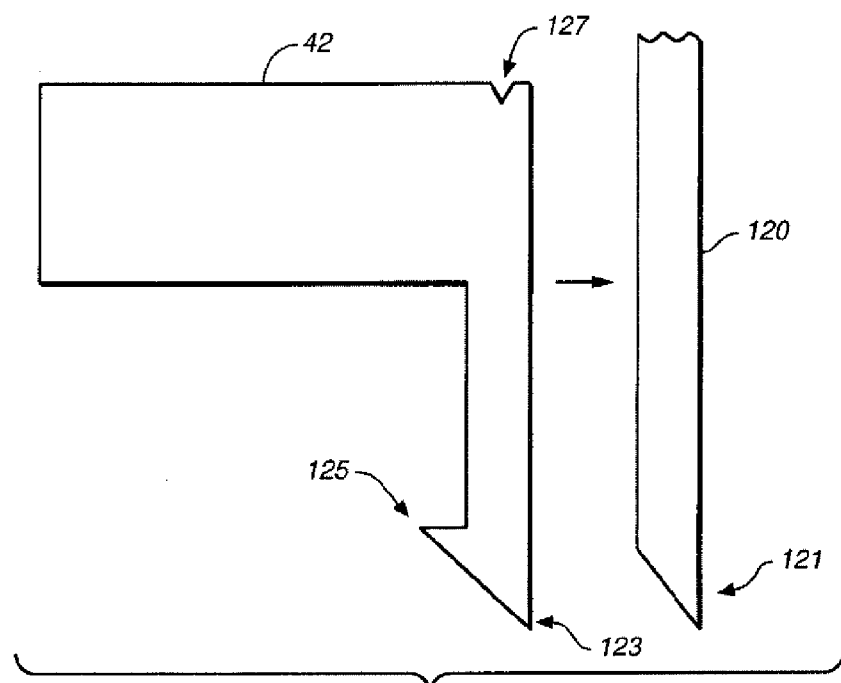
An analyte monitor includes a sensor, a sensor control unit, and a display unit. The sensor control unit typically has a housing adapted for placement on skin and is adapted to receive a portion of an electrochemical sensor. The sensor control unit also includes two or more conductive contacts disposed on the housing and configured for coupling to two or more contact pads on the sensor. A transmitter is disposed in the housing and coupled to the plurality of conductive contacts for transmitting data obtained using the sensor. The display unit has a receiver for receiving data transmitted by the transmitter of the sensor control unit and a display coupled to the receiver for displaying an indication of a level of an analyte, such as blood glucose. An inserter having a retractable introducer is provided for subcutaneously implanting the sensor in a predictable and reliable fashion.



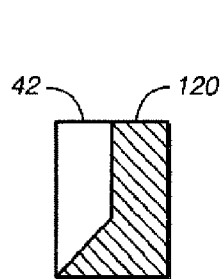
**FIG. 1**



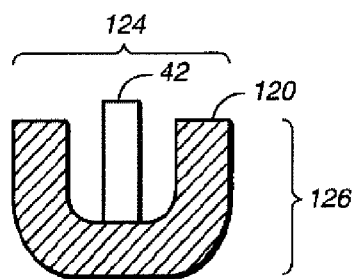
**FIG. 2**



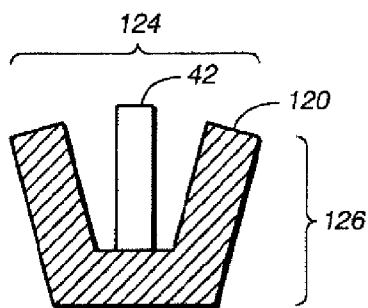
**FIG. 3**



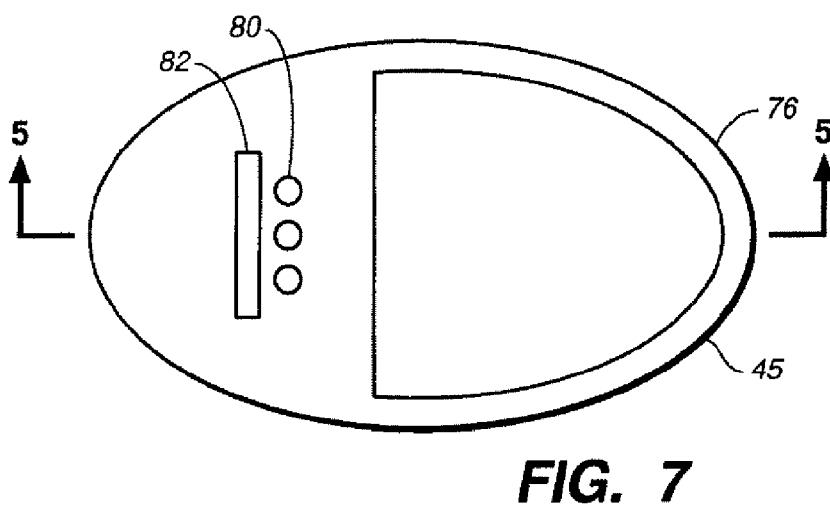
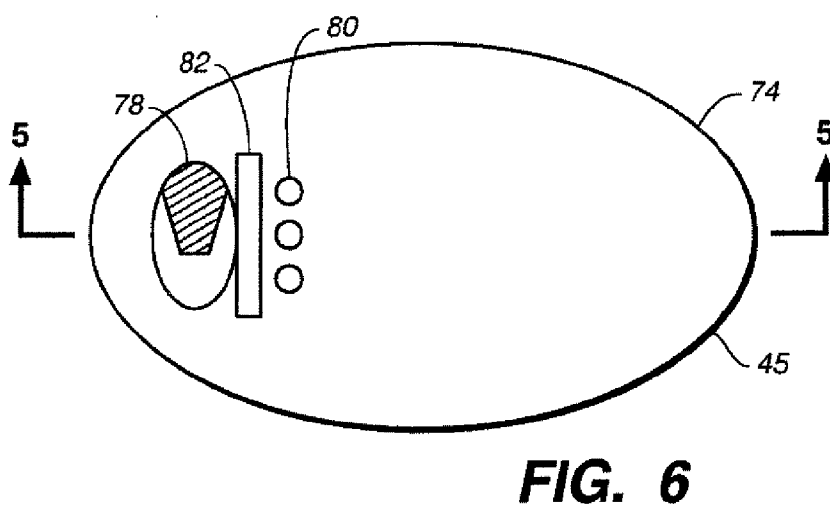
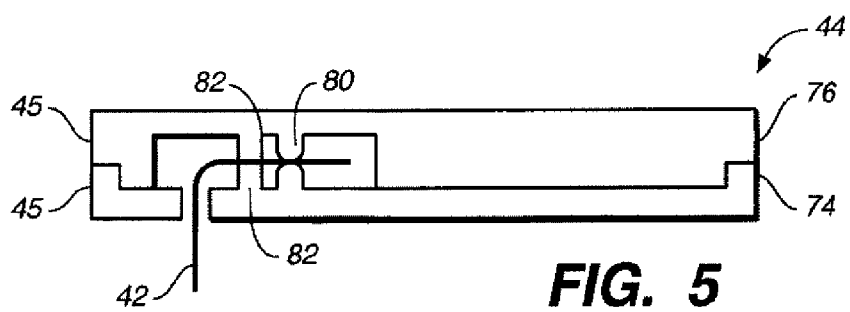
**FIG. 4A**

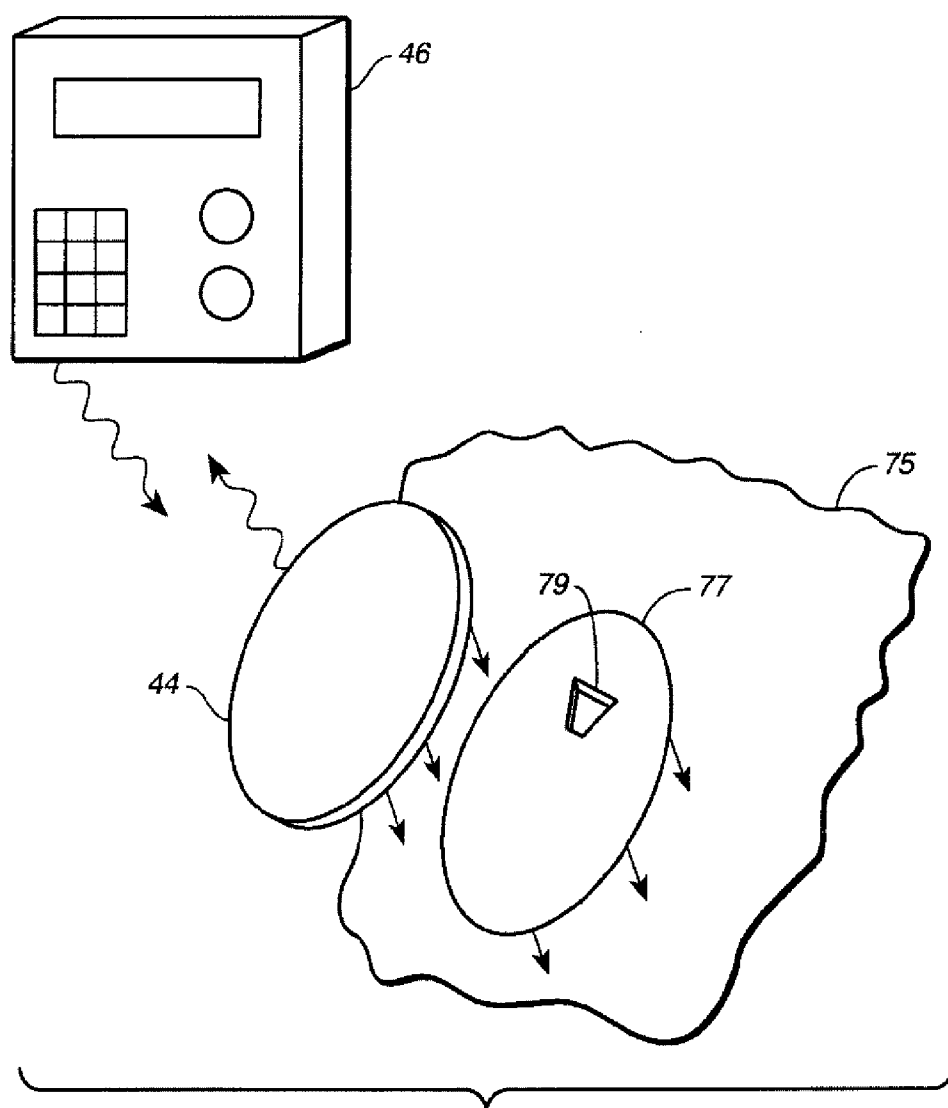


**FIG. 4B**



**FIG. 4C**





**FIG. 8**

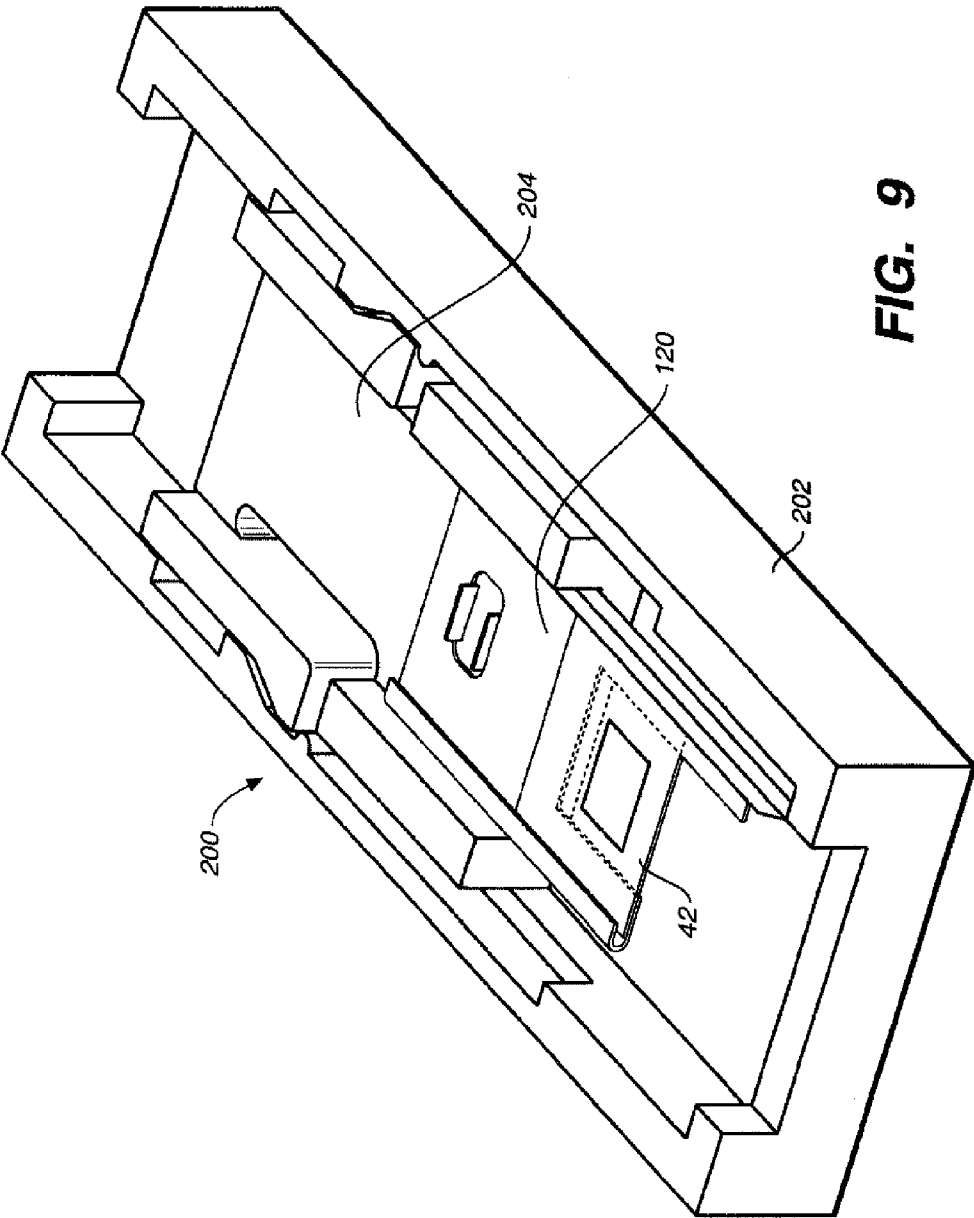
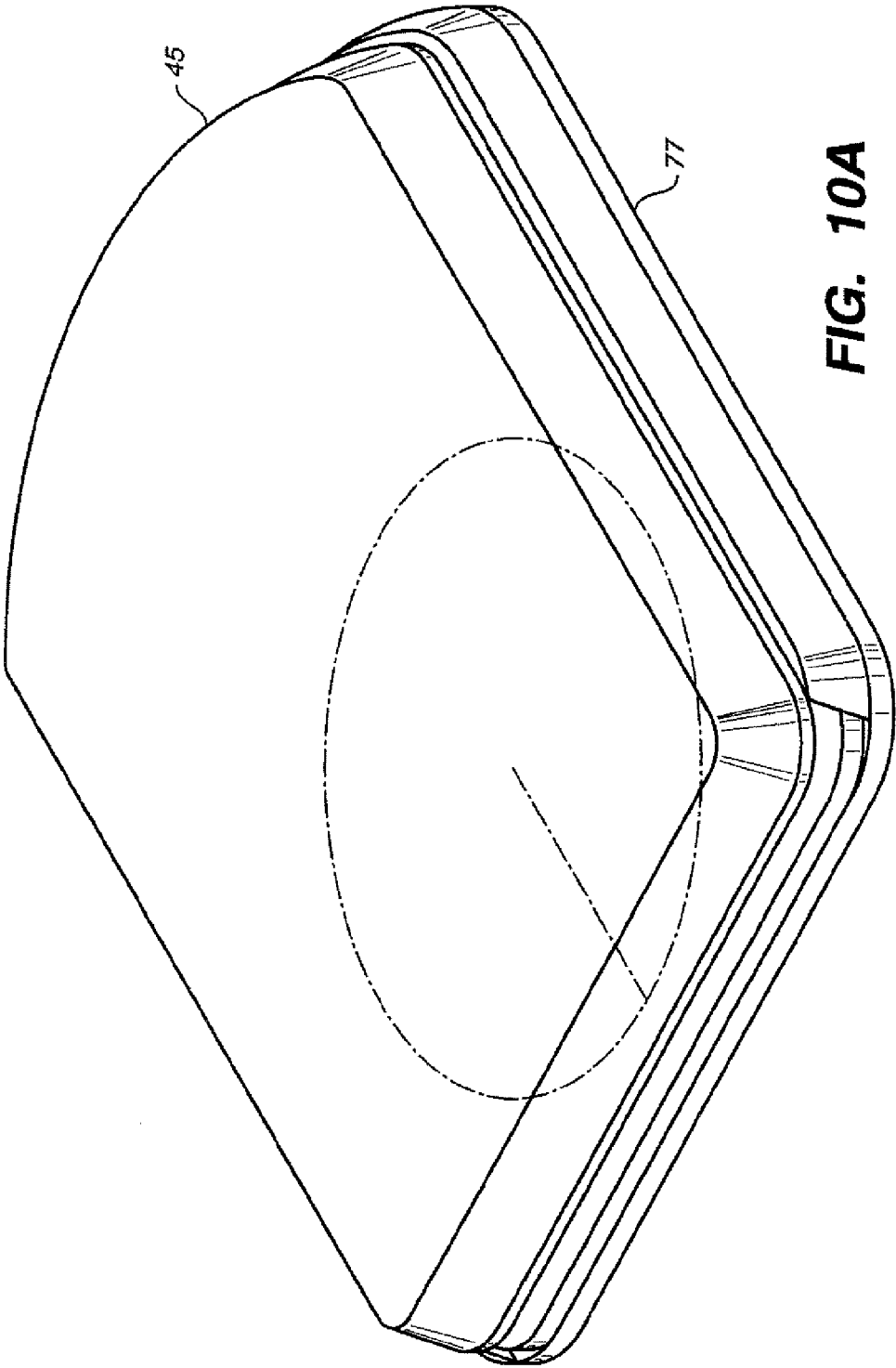
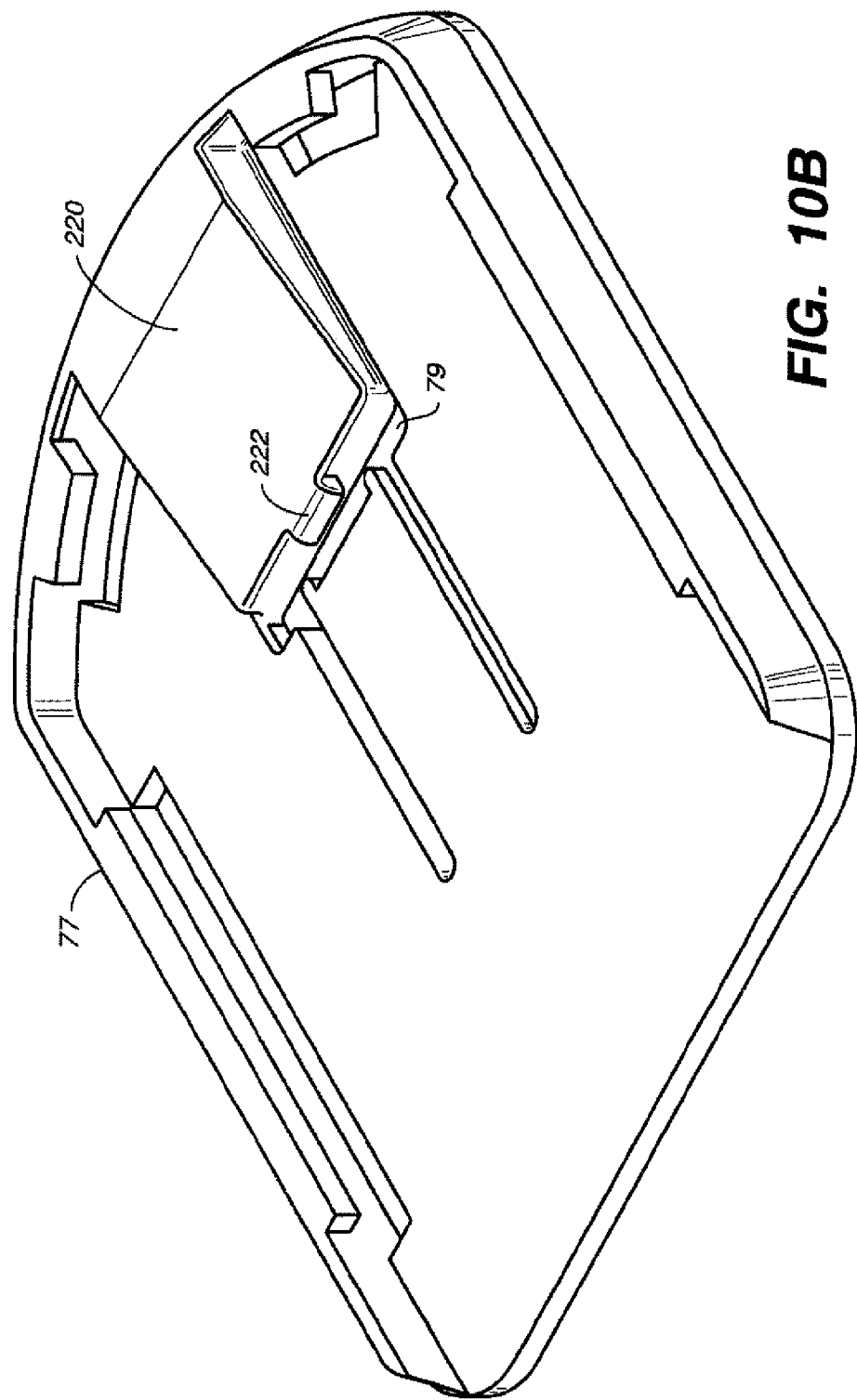


FIG. 9



**FIG. 10A**



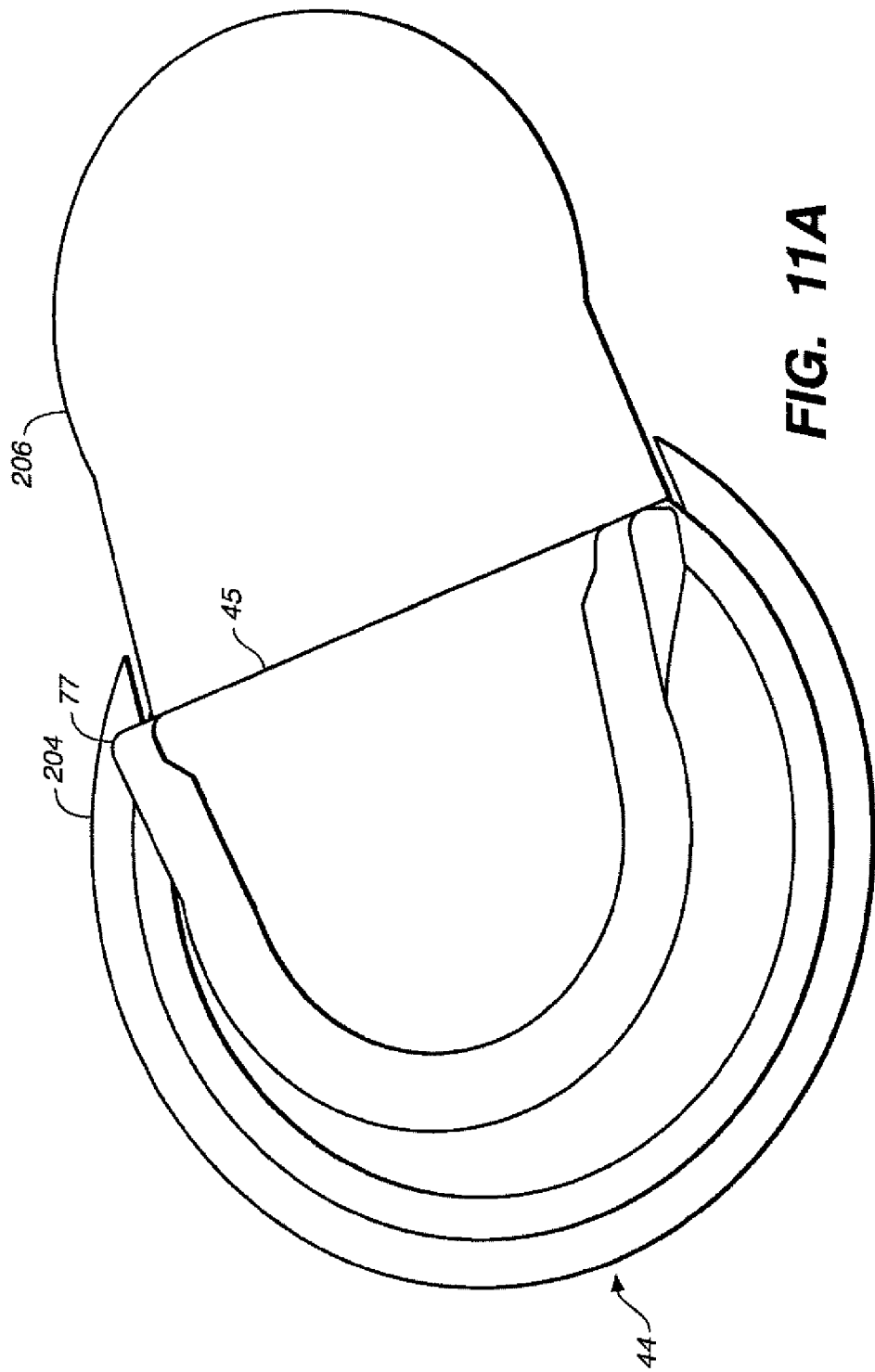


FIG. 11A

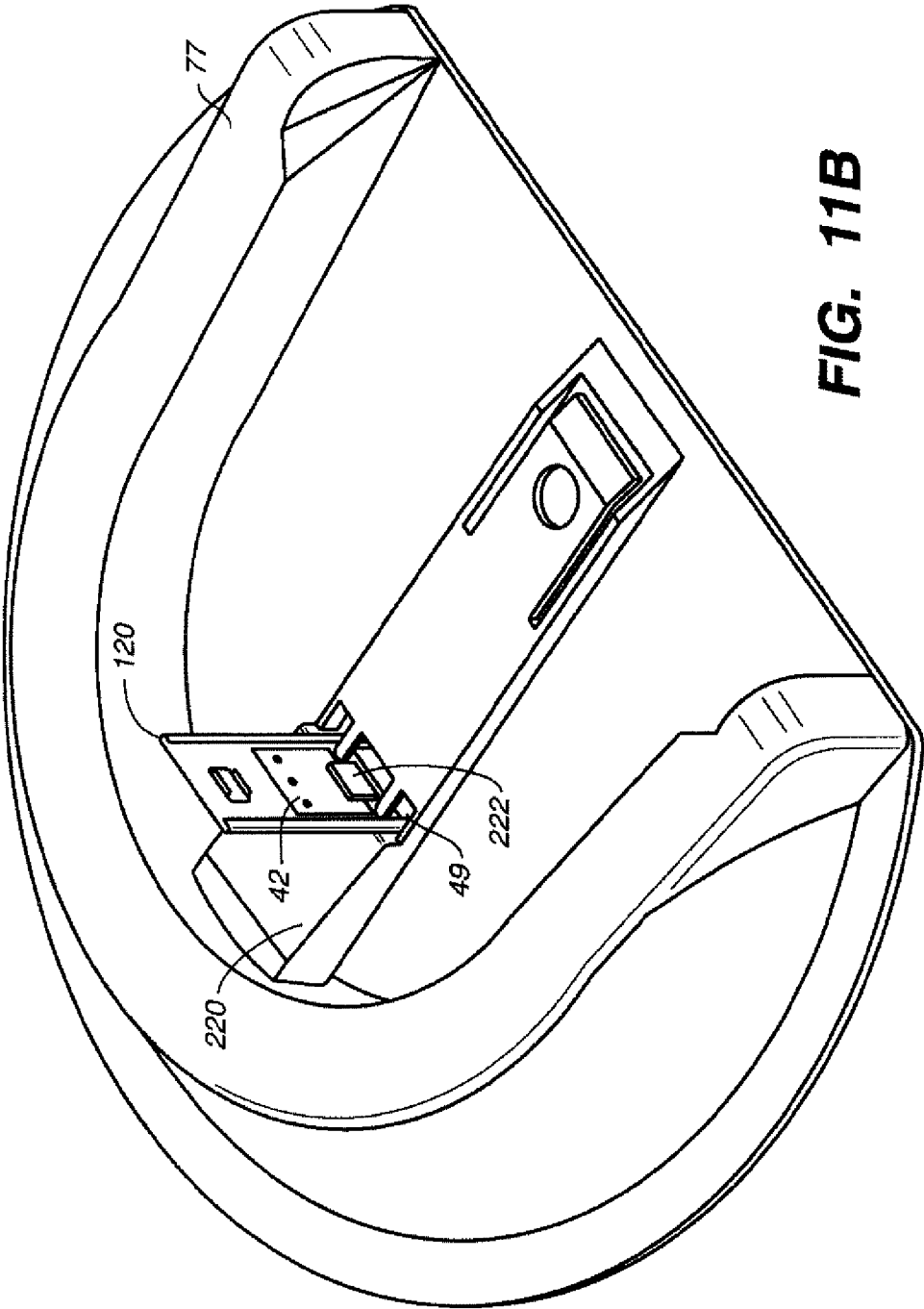
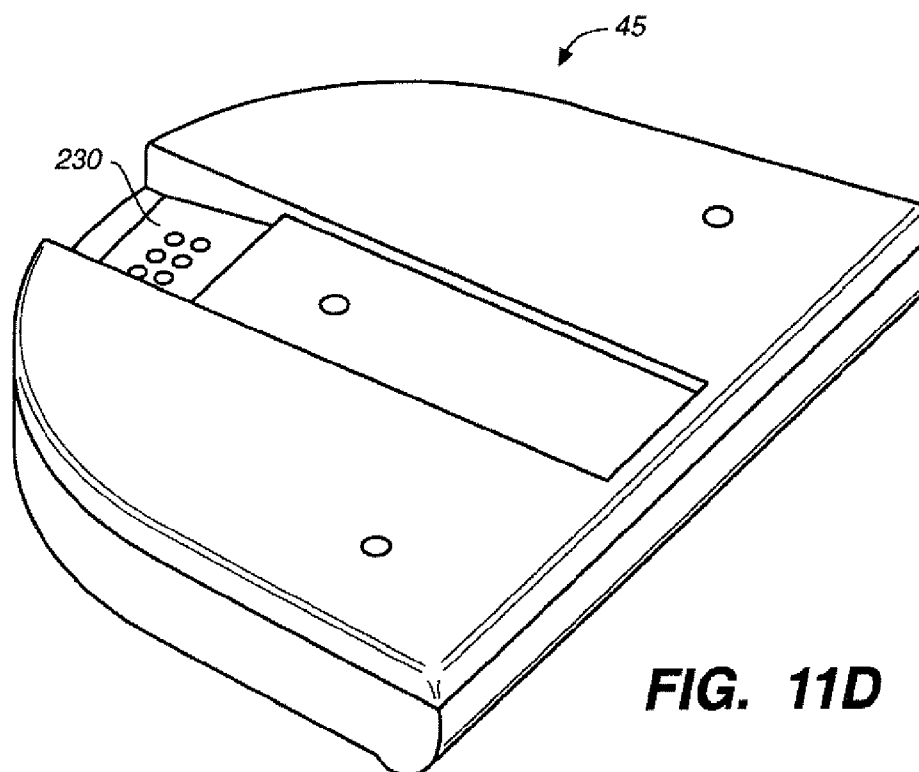
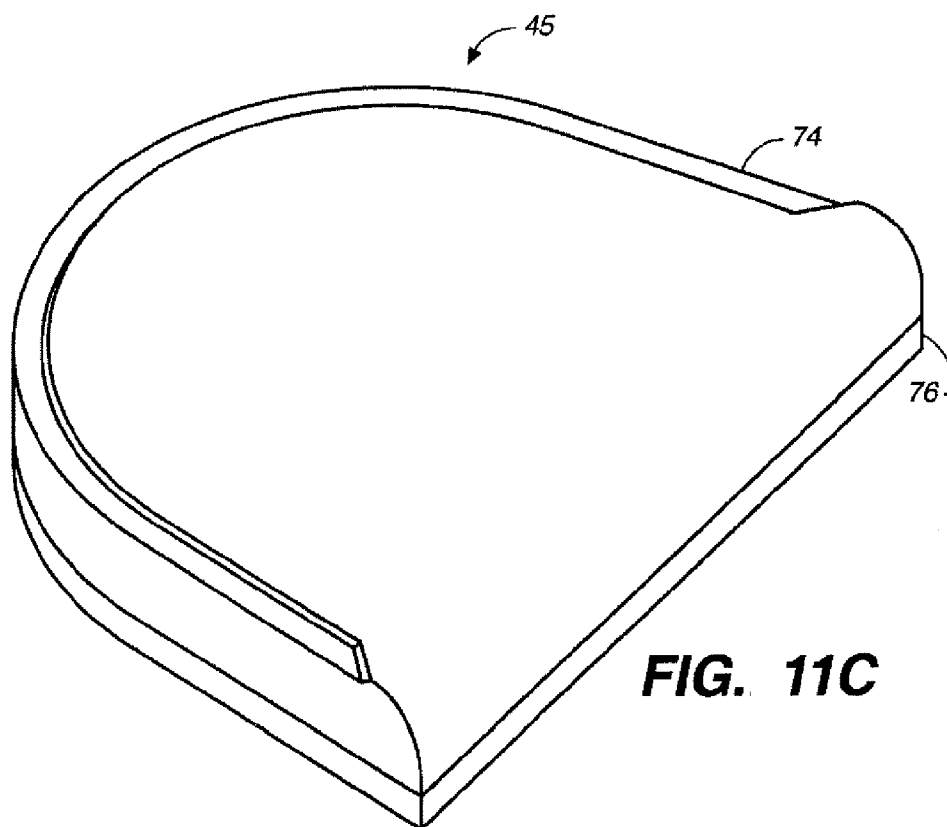


FIG. 11B



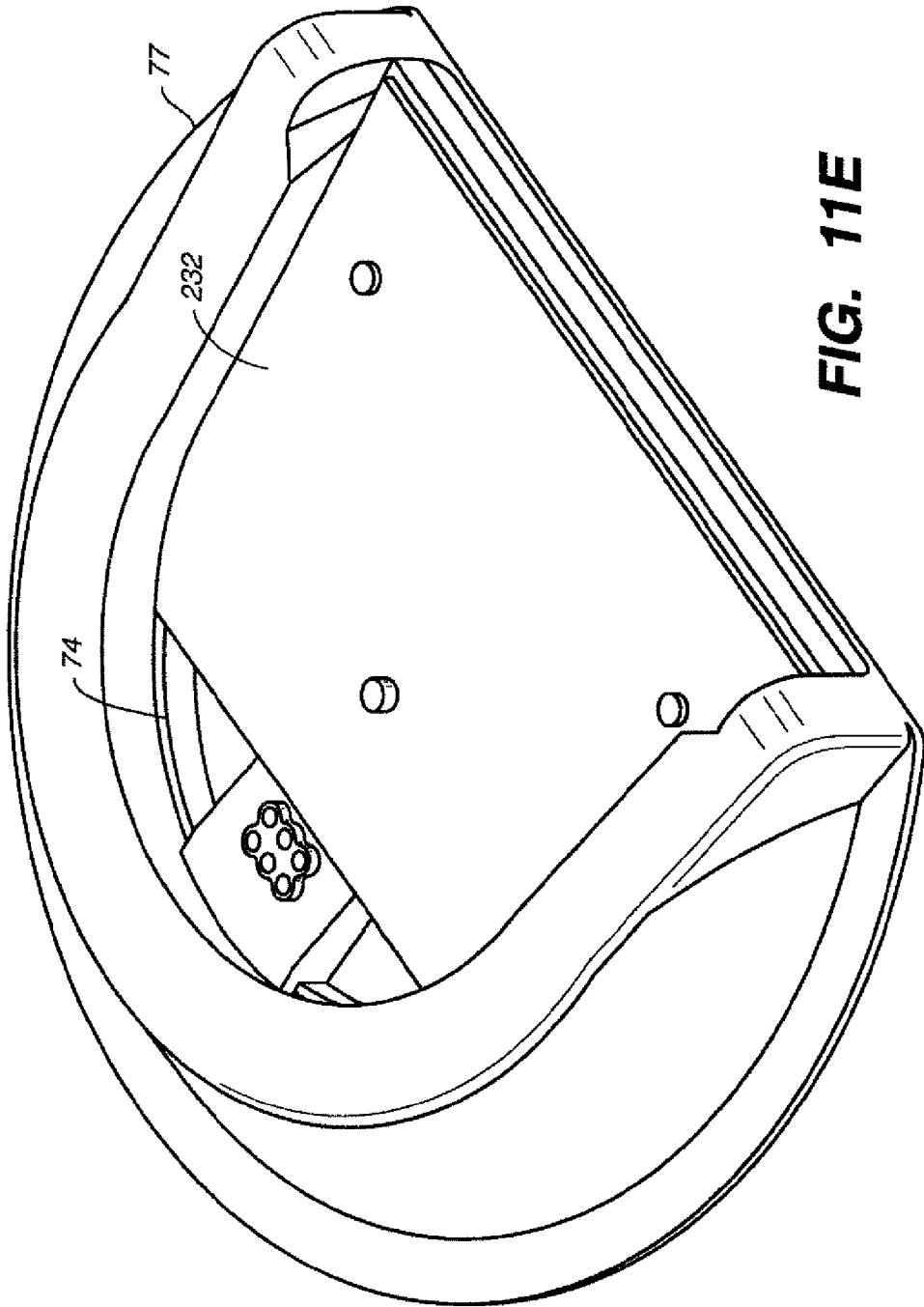
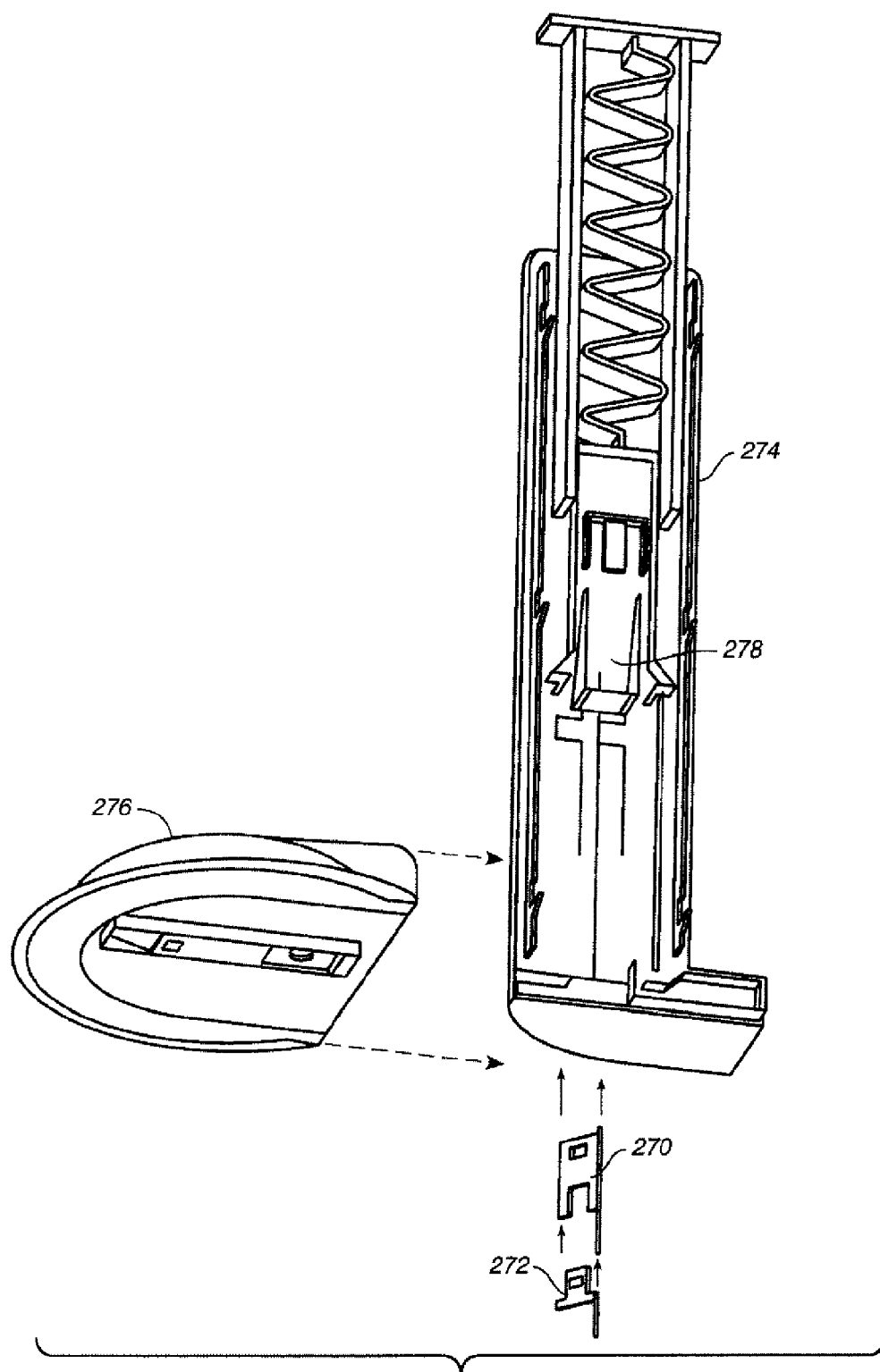
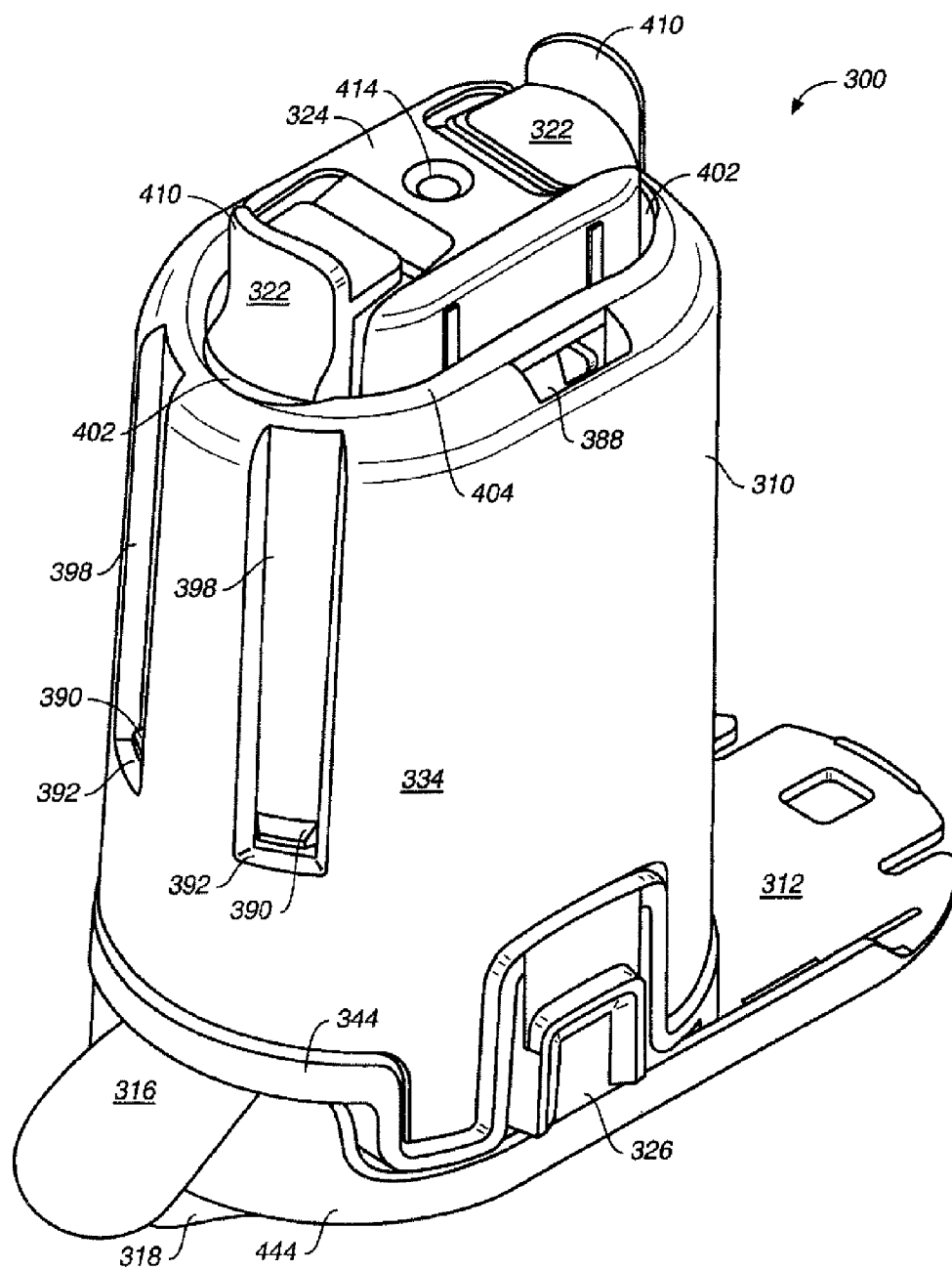


FIG. 11E

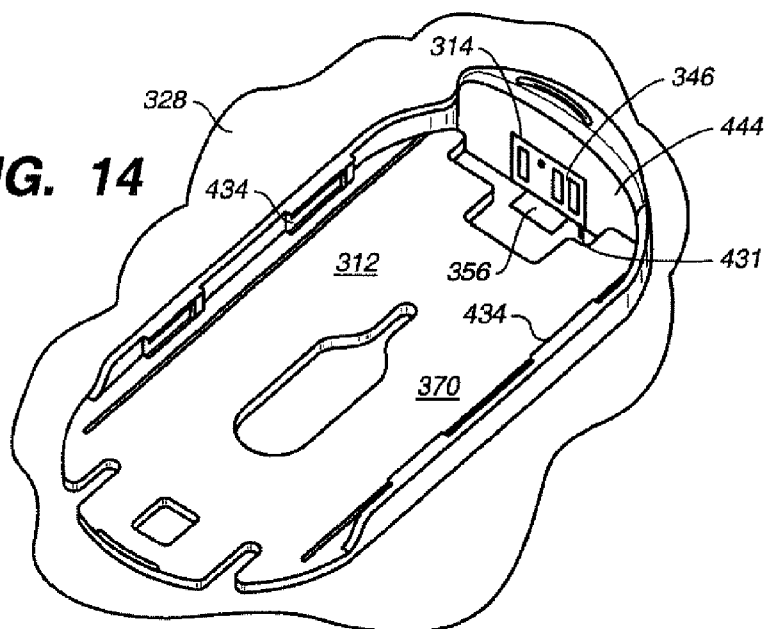


**FIG. 12**

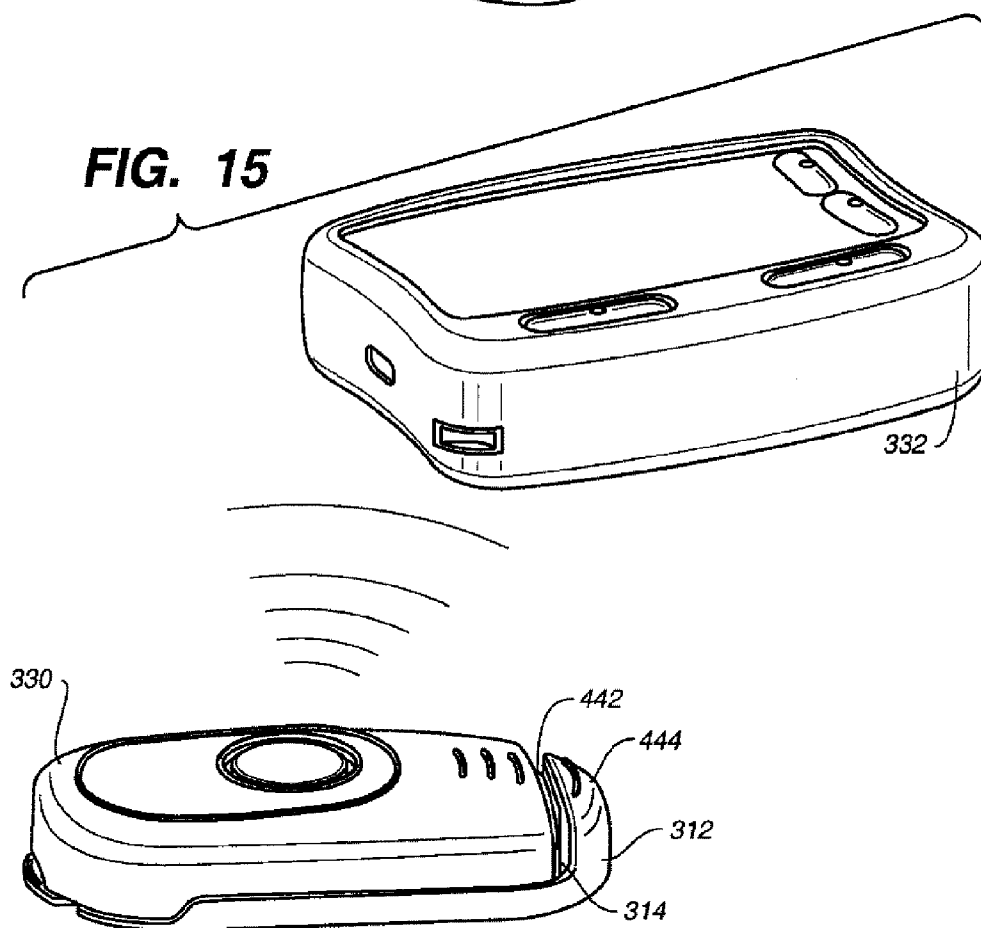


**FIG. 13**

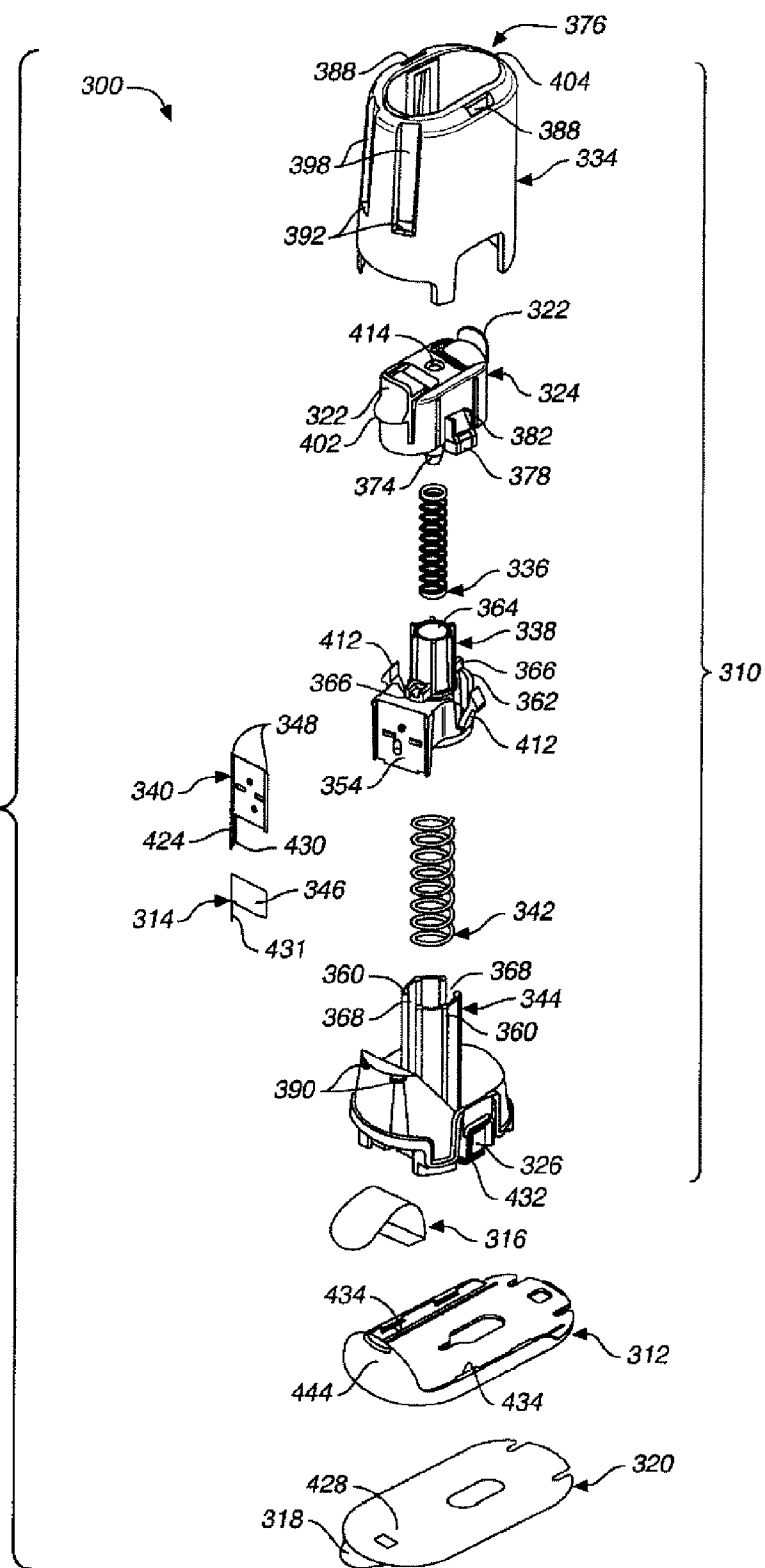
**FIG. 14**



**FIG. 15**



**FIG. 16**



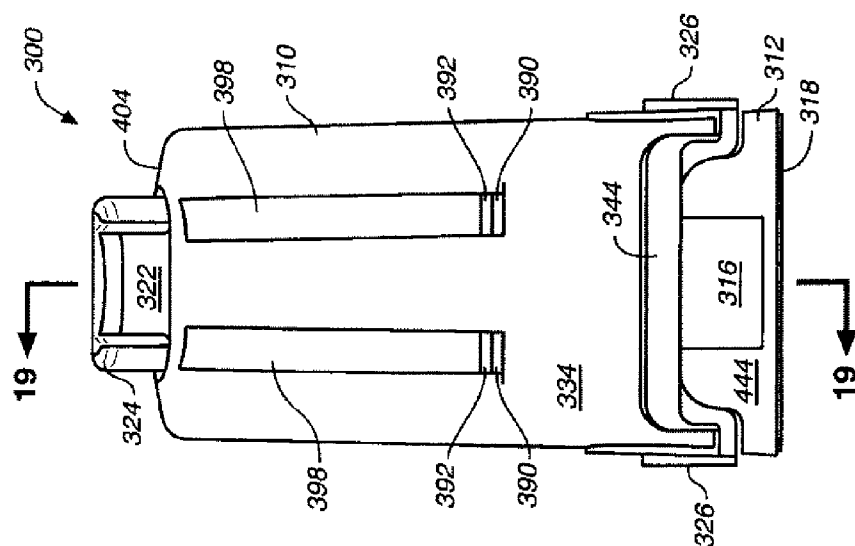


FIG. 18

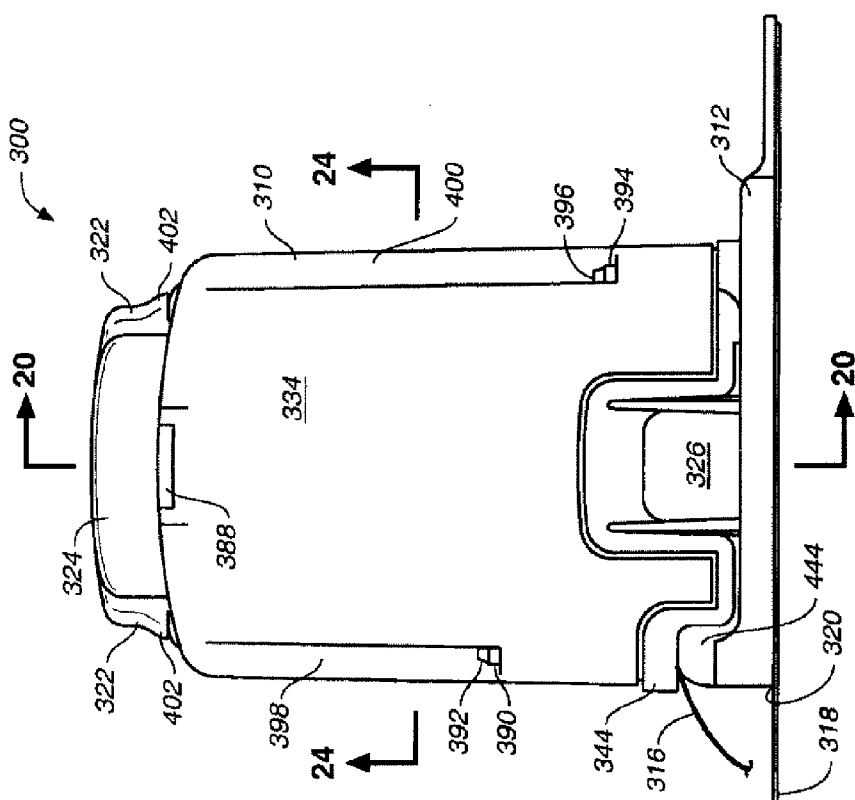
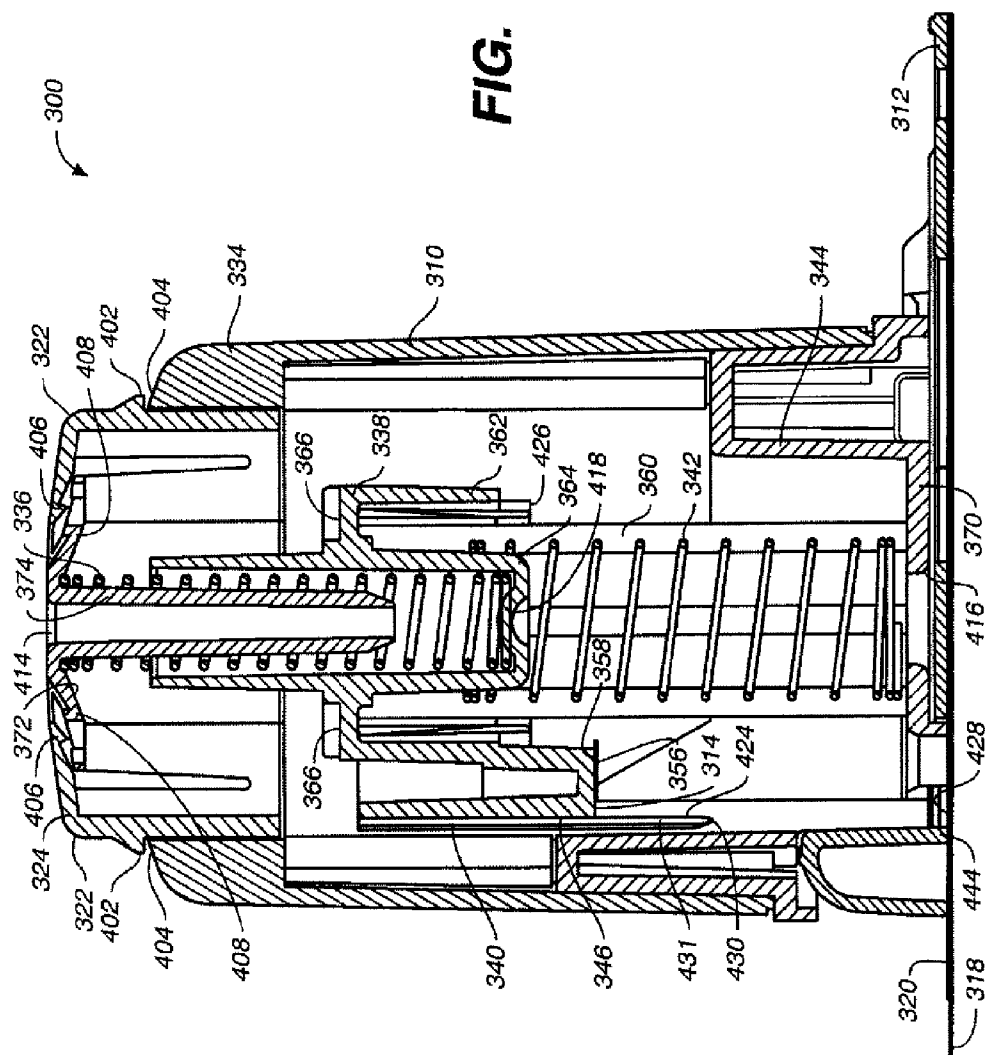
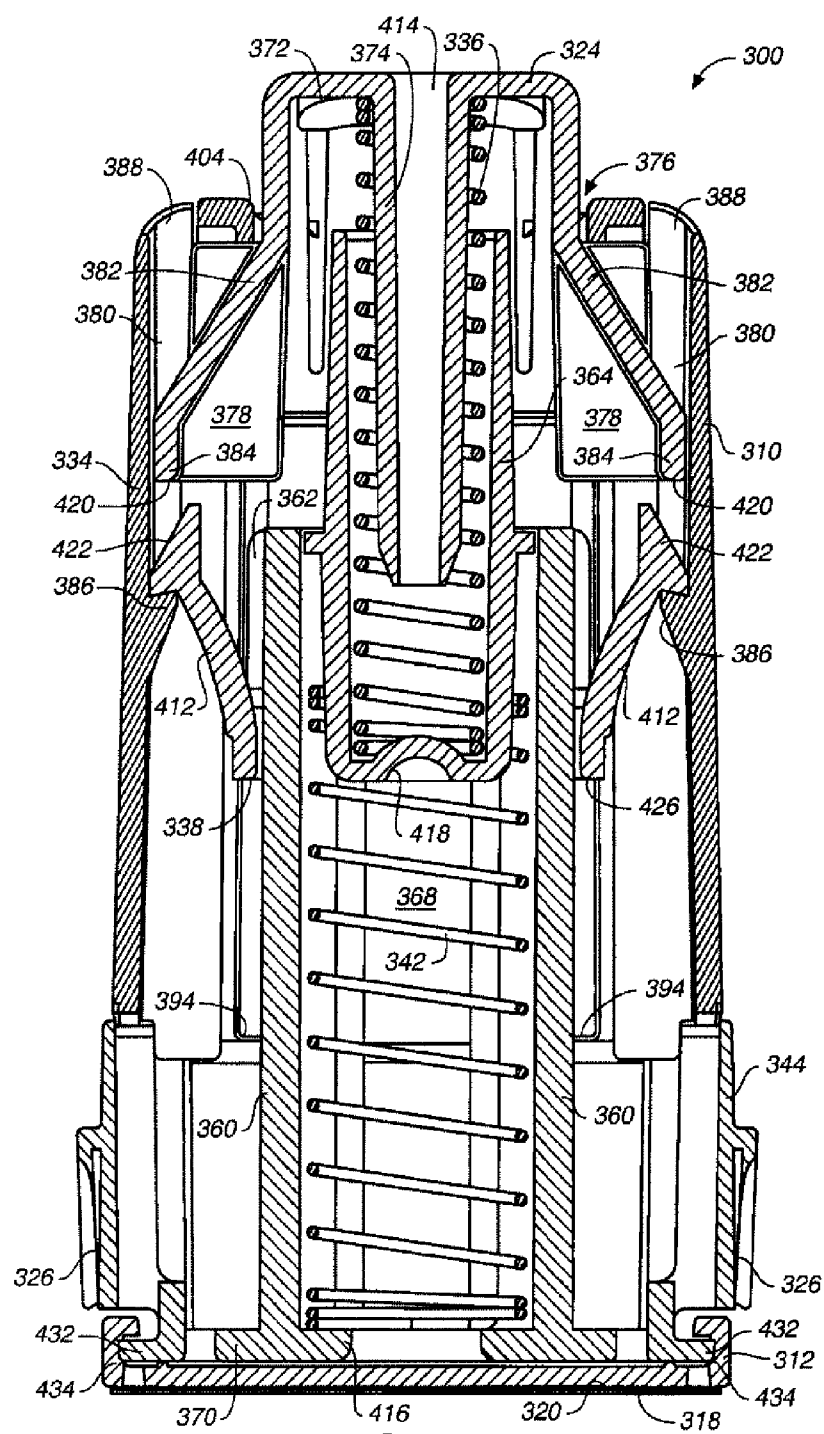


FIG. 17

FIG. 19





**FIG. 20**

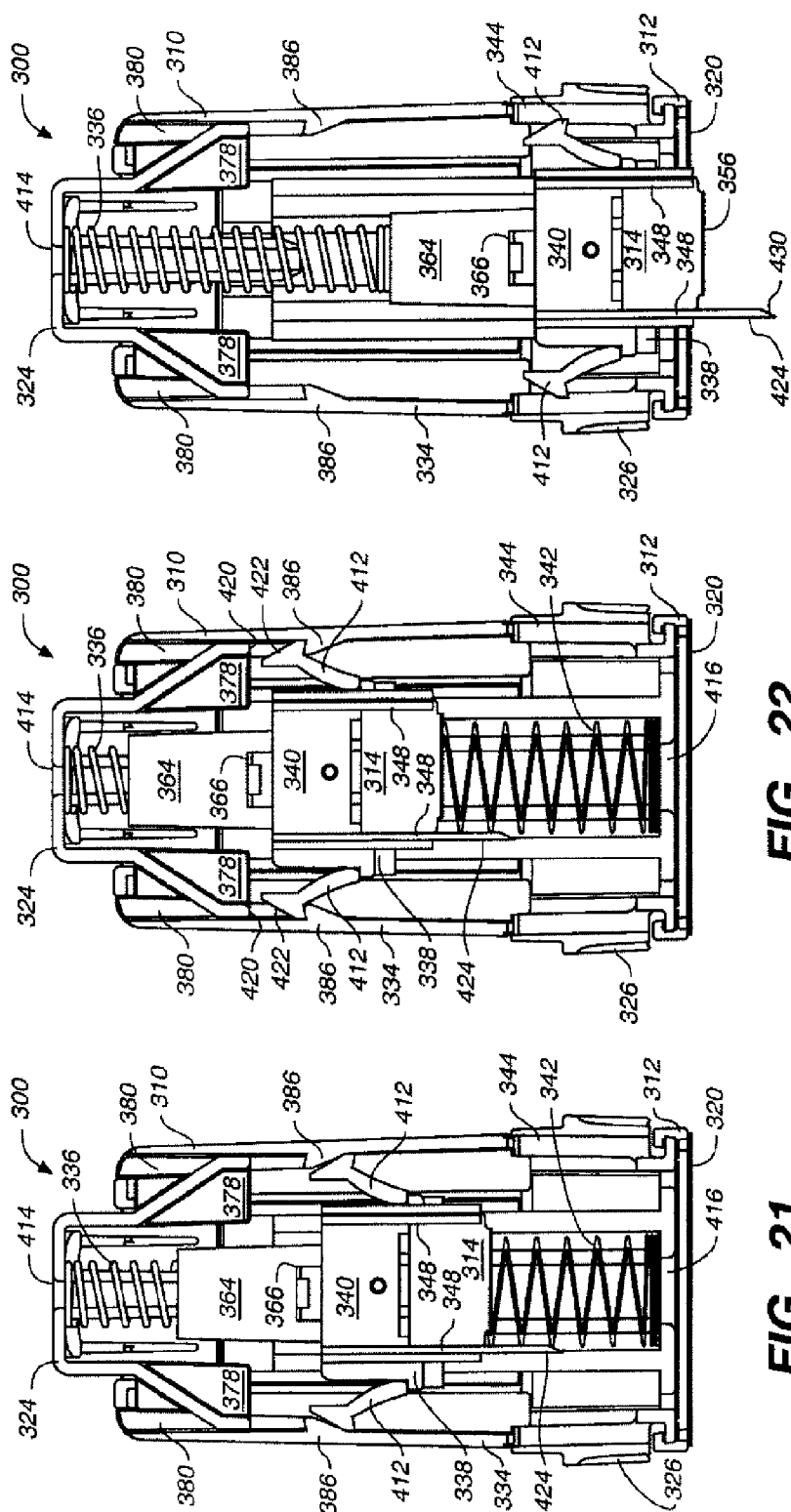
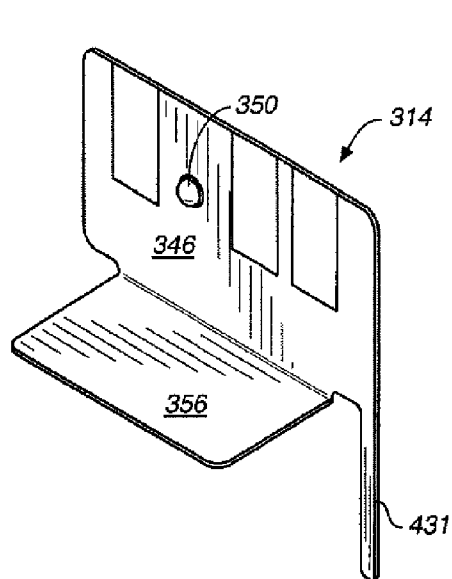


FIG. 23

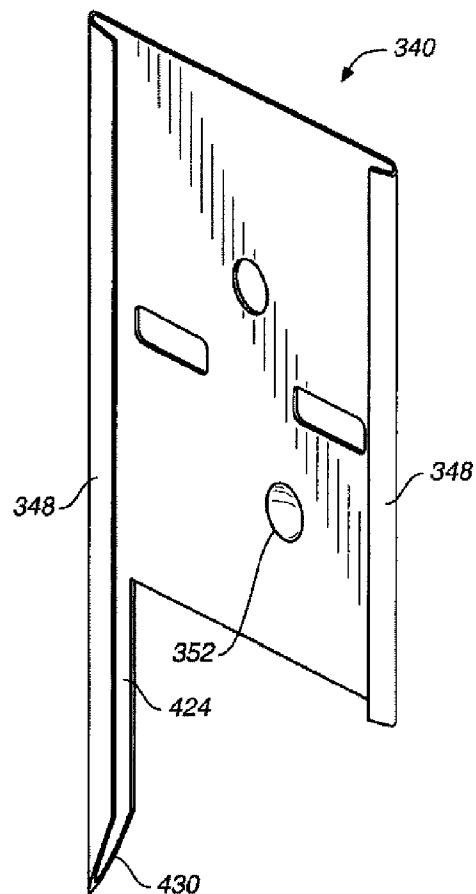
FIG. 22

FIG. 21

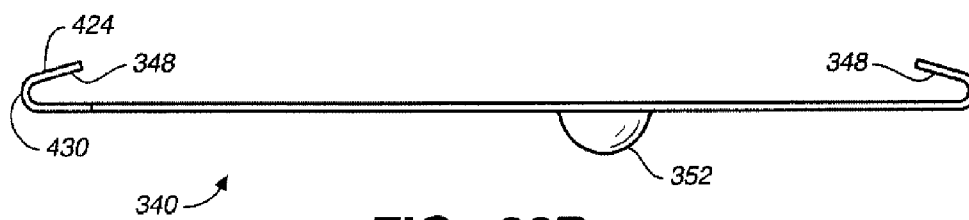
**FIG. 24**



**FIG. 25**

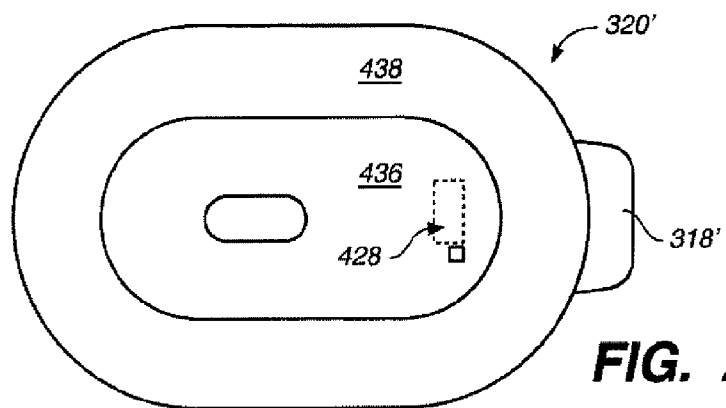
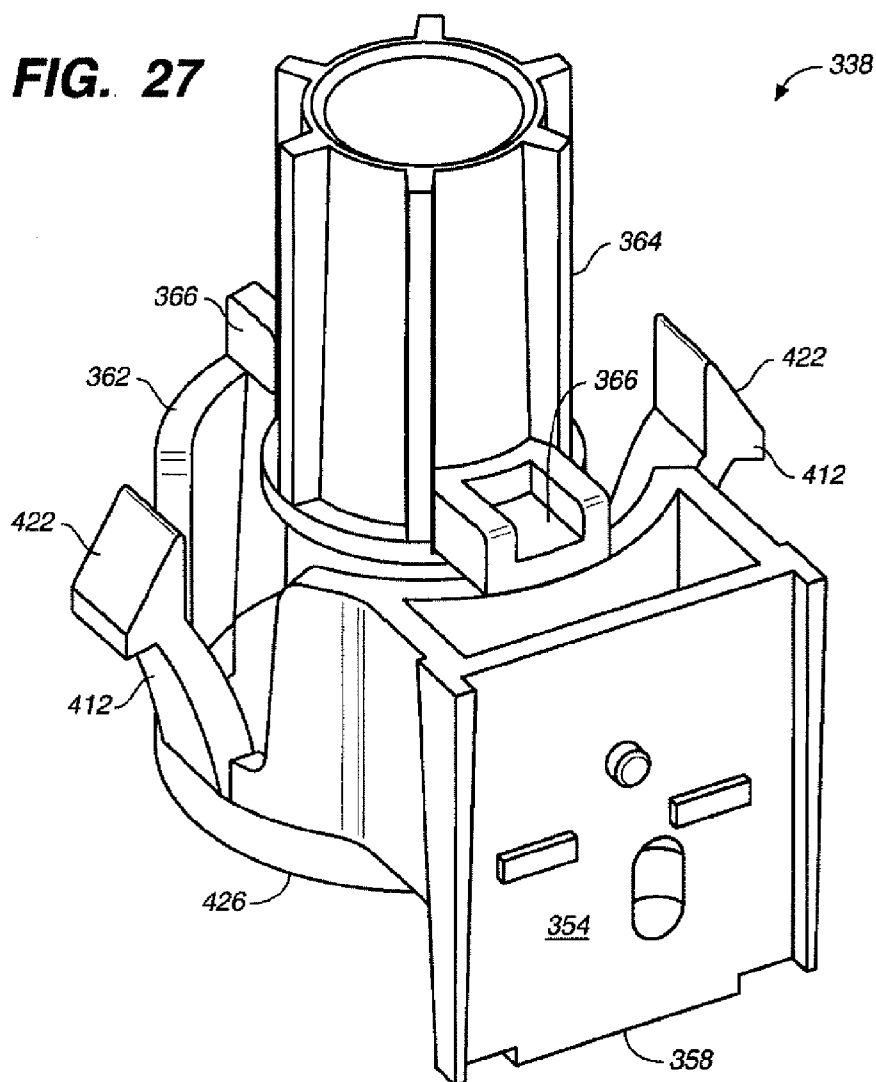


**FIG. 26A**

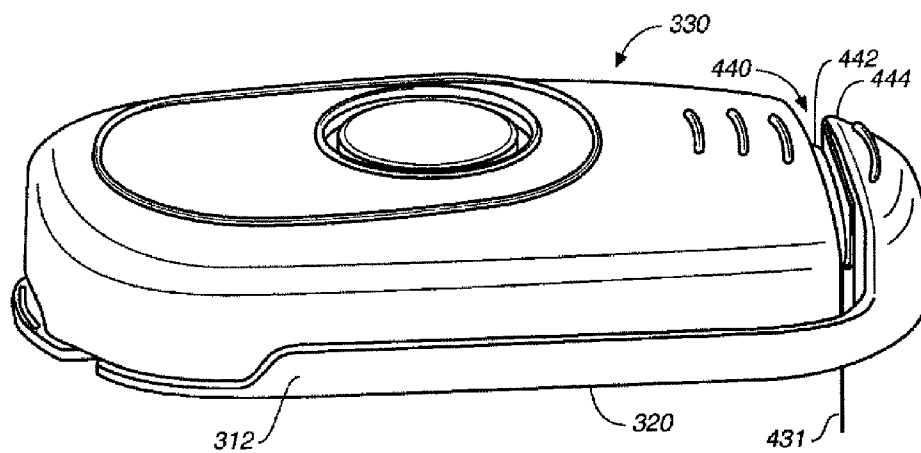


**FIG. 26B**

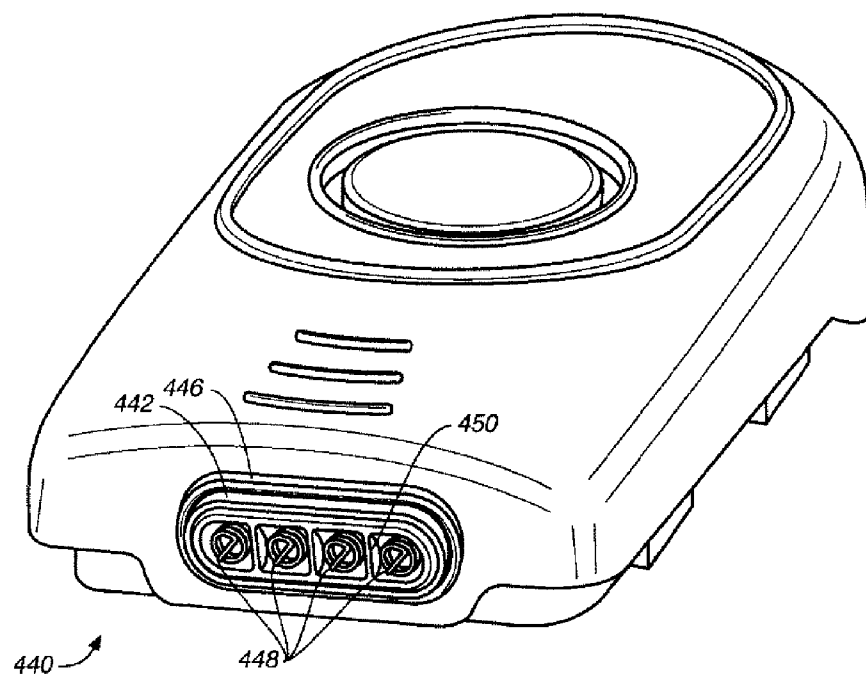
**FIG. 27**



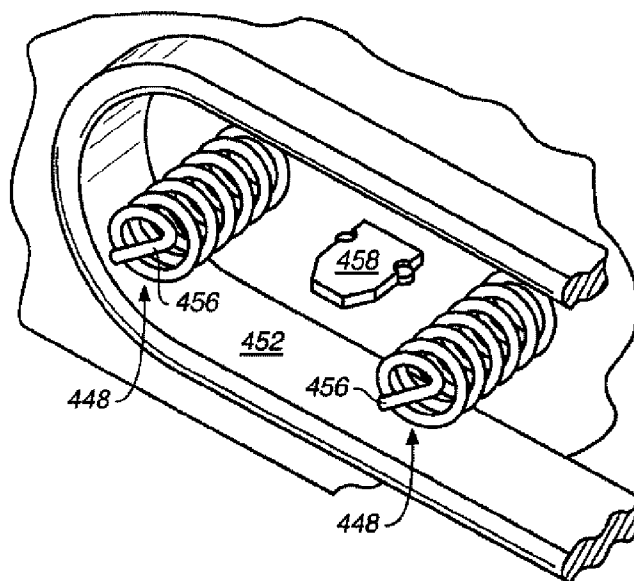
**FIG. 28**



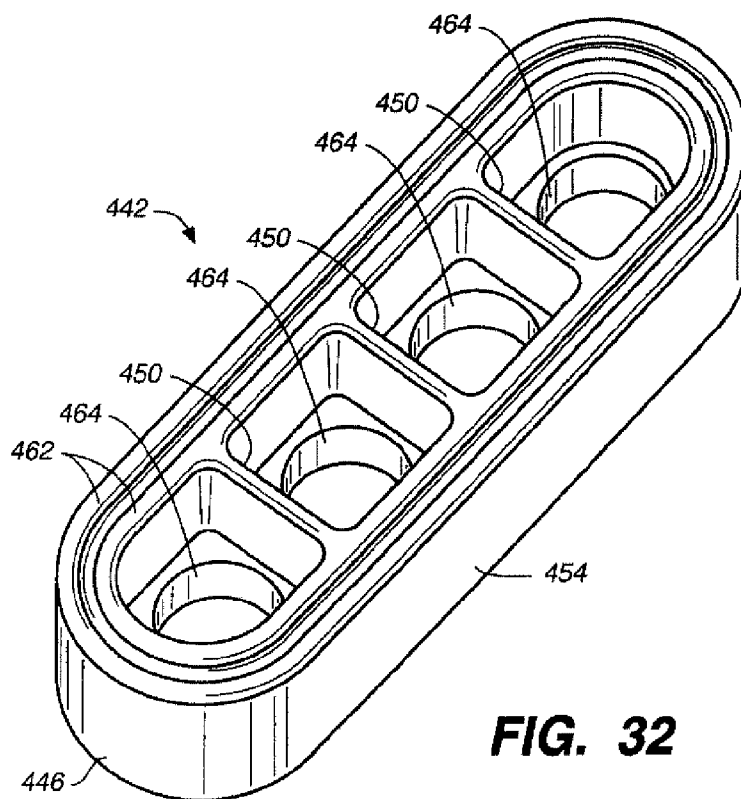
**FIG. 29**



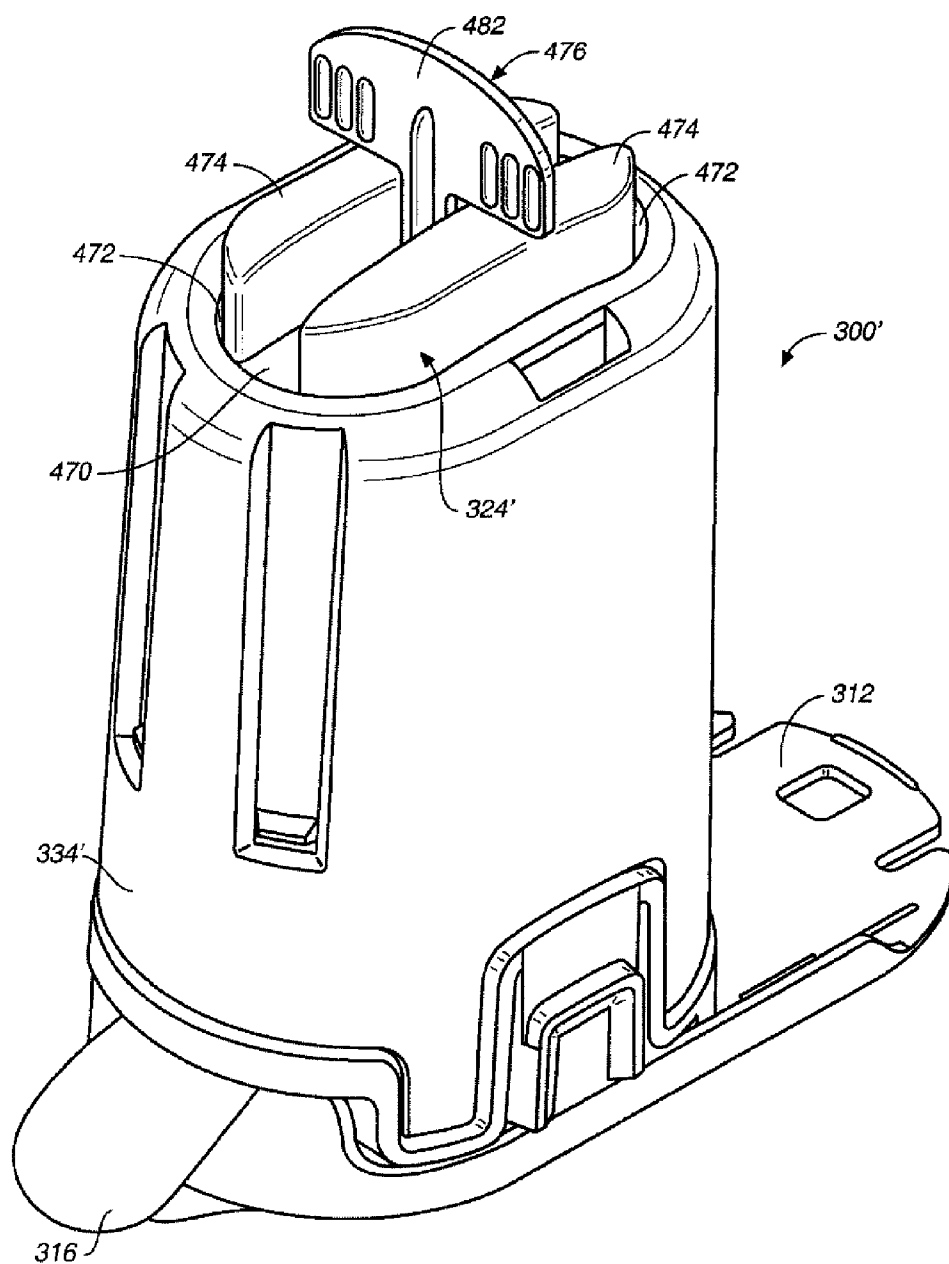
**FIG. 30**



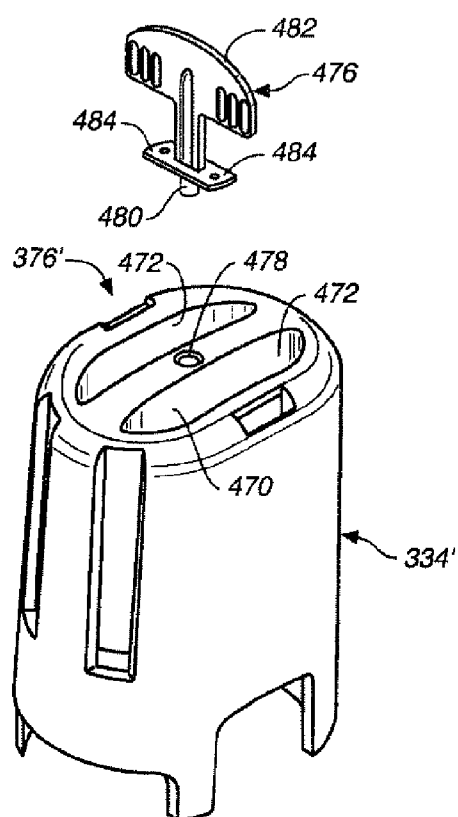
**FIG. 31**



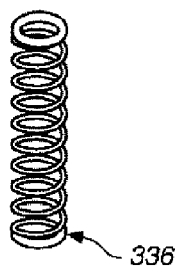
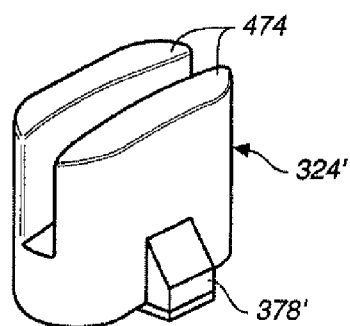
**FIG. 32**



**FIG. 33A**



**FIG. 33B**



## SENSOR INSERTER ASSEMBLY

### RELATED APPLICATIONS

[0001] This application is a continuation of U.S. patent application Ser. No. 14/244,831 filed Apr. 3, 2014, which is a continuation of U.S. patent application Ser. No. 12/538,067 filed Aug. 7, 2009, which is a continuation application of U.S. patent application Ser. No. 11/899,917 filed Sep. 6, 2007, now U.S. Pat. No. 8,029,442, which is a continuation application of U.S. patent application Ser. No. 10/703,214 filed Nov. 5, 2003, now U.S. Pat. No. 7,381,184, which claims priority based on U.S. Provisional Application No. 60/424,099, entitled "Sensor Inserter Device and Methods of Use," filed on Nov. 5, 2002, the disclosures of each of which are incorporated herein in their entirety by this reference.

### BACKGROUND

[0002] The monitoring of the level of glucose or other analytes, such as lactate or oxygen, in certain individuals is vitally important to their health. High or low levels of glucose or other analytes may have detrimental effects. The monitoring of glucose is particularly important to individuals with diabetes, as they must determine when insulin is needed to reduce glucose levels in their bodies or when additional glucose is needed to raise the level of glucose in their bodies.

[0003] A conventional technique used by many diabetics for personally monitoring their blood glucose level includes the periodic drawing of blood, the application of that blood to a test strip, and the determination of the blood glucose level using colorimetric, electrochemical, or photometric detection. This technique does not permit continuous or automatic monitoring of glucose levels in the body, but typically must be performed manually on a periodic basis. Unfortunately, the consistency with which the level of glucose is checked varies widely among individuals. Many diabetics find the periodic testing inconvenient and they sometimes forget to test their glucose level or do not have time for a proper test. In addition, some individuals wish to avoid the pain associated with the test. These situations may result in hyperglycemic or hypoglycemic episodes. An in vivo glucose sensor that continuously or automatically monitors the individual's glucose level would enable individuals to more easily monitor their glucose, or other analyte, levels.

[0004] A variety of devices have been developed for continuous or automatic monitoring of analytes, such as glucose, in the blood stream or interstitial fluid. A number of these devices use electrochemical sensors which are directly implanted into a blood vessel or in the subcutaneous tissue of a patient. However, these devices are often difficult to reproducibly and inexpensively manufacture in large numbers. In addition, these devices are typically large, bulky, and/or inflexible, and many cannot be used effectively outside of a controlled medical facility, such as a hospital or a doctor's office, unless the patient is restricted in his activities.

[0005] Some devices include a sensor guide which rests on or near the skin of the patient and may be attached to the patient to hold the sensor in place. These sensor guides are typically bulky and do not allow for freedom of movement. In addition, the sensor guides or the sensors include cables or wires for connecting the sensor to other equipment to direct the signals from the sensors to an analyzer. The size of the sensor guides and presence of cables and wires hinders the convenient use of these devices for everyday applications.

The patient's comfort and the range of activities that can be performed while the sensor is implanted are important considerations in designing extended-use sensors for continuous or automatic in vivo monitoring of the level of an analyte, such as glucose. There is a need for a small, comfortable device which can continuously monitor the level of an analyte, such as glucose, while still permitting the patient to engage in normal activities. Continuous and/or automatic monitoring of the analyte can provide a warning to the patient when the level of the analyte is at or near a threshold level. For example, if glucose is the analyte, then the monitoring device might be configured to warn the patient of current or impending hyperglycemia or hypoglycemia. The patient can then take appropriate actions.

### SUMMARY

[0006] The present invention is, in general, directed to devices and methods for the in vivo monitoring of an analyte, such as glucose or lactate, using a sensor to provide information to a patient about the level of the analyte. More particularly, the present invention relates to devices and methods for inserting a subcutaneously implantable electrochemical sensor in a patient for such monitoring.

[0007] Generally, the present invention relates to methods and devices for the continuous and/or automatic in vivo monitoring of the level of an analyte using a subcutaneously implantable sensor. Many of these devices are small and comfortable when used, thereby allowing a wide range of activities. One embodiment includes a sensor control unit having a housing adapted for placement on skin. The housing is also adapted to receive a portion of an electrochemical sensor. The sensor control unit includes two or more conductive contacts disposed on the housing and configured for coupling to two or more contact pads on the sensor. A transmitter is disposed in the housing and coupled to the plurality of conductive contacts for transmitting data obtained using the sensor. The sensor control unit may also include a variety of optional components, such as, for example, adhesive for adhering to the skin, a mounting unit, a receiver, a processing circuit, a power supply (e.g., a battery), an alarm system, a data storage unit, a watchdog circuit, and a measurement circuit. The sensor itself has at least one working electrode and at least one contact pad coupled to the working electrode or electrodes. The sensor may also include optional components, such as, for example, a counter electrode, a counter/reference electrode, a reference electrode, and a temperature probe. The analyte monitoring system also includes a display unit that has a receiver for receiving data from the sensor control unit and a display coupled to the receiver for displaying an indication of the level of an analyte. The display unit may optionally include a variety of components, such as, for example, a transmitter, an analyzer, a data storage unit, a watchdog circuit, an input device, a power supply, a clock, a lamp, a pager, a telephone interface, a computer interface, an alarm or alarm system, a radio, and a calibration unit. In addition, the analyte monitoring system or a component of the analyte monitoring system may optionally include a processor capable of determining a drug or treatment protocol and/or a drug delivery system.

[0008] According to one aspect of the invention, an insertion kit is disclosed for inserting an electrochemical sensor into a patient. The insertion kit includes an introducer. A portion of the introducer has a sharp, rigid, planar structure adapted to support the sensor during insertion of the electro-

chemical sensor. The insertion kit also includes an insertion gun having a port configured to accept the electrochemical sensor and the introducer. The insertion gun has a driving mechanism for driving the introducer and electrochemical sensor into the patient, and a retraction mechanism for removing the introducer while leaving the sensor within the patient. [0009] According to another aspect of the invention, a method of using an electrochemical sensor is disclosed. A mounting unit is adhered to the skin of a patient. An insertion gun is aligned with a port on the mounting unit. The electrochemical sensor is disposed within the insertion gun and then the electrochemical sensor is inserted into the skin of the patient using the insertion gun. The insertion gun is removed and a housing of the sensor control unit is mounted on the mounting base. A plurality of conductive contacts disposed on the housing is coupled to a plurality of contact pads disposed on the electrochemical sensor to prepare the sensor for use.

[0010] The above summary of the present invention is not intended to describe each disclosed embodiment or every implementation of the present invention. The Figures and the detailed description which follow more particularly exemplify these embodiments.

#### BRIEF DESCRIPTION OF THE DRAWINGS

[0011] The invention may be more completely understood in consideration of the following detailed description of various embodiments of the invention in connection with the accompanying drawings, in which:

[0012] FIG. 1 is a block diagram of one embodiment of a subcutaneous analyte monitor using a subcutaneously implantable analyte sensor, according to the invention.

[0013] FIG. 2 is a top view of one embodiment of an analyte sensor, according to the invention.

[0014] FIG. 3 is an expanded side view of one embodiment of a sensor and an introducer, according to the invention.

[0015] FIGS. 4A, 4B, 4C are cross-sectional views of three embodiments of the introducer of FIG. 3.

[0016] FIG. 5 is a cross-sectional view of one embodiment of an on-skin sensor control unit, according to the invention.

[0017] FIG. 6 is a top view of a base of the on-skin sensor control unit of FIG. 5.

[0018] FIG. 7 is a bottom view of a cover of the on-skin sensor control unit of FIG. 5.

[0019] FIG. 8 is a perspective view of the on-skin sensor control unit of FIG. 5 on the skin of a patient.

[0020] FIG. 9 is a perspective view of the internal structure of an insertion gun, according to the invention.

[0021] FIG. 10A is a top view of one embodiment of an on-skin sensor control unit, according to the invention.

[0022] FIG. 10B is a top view of one embodiment of a mounting unit of the on-skin sensor control unit of FIG. 10A.

[0023] FIG. 11A is a top view of another embodiment of an on-skin sensor control unit after insertion of an introducer and a sensor, according to the invention.

[0024] FIG. 11B is a top view of one embodiment of a mounting unit of the on-skin sensor control unit of FIG. 11A.

[0025] FIG. 11C is a top view of one embodiment of a housing for at least a portion of the electronics of the on-skin sensor control unit of FIG. 11A.

[0026] FIG. 11D is a bottom view of the housing of FIG. 11C.

[0027] FIG. 11E is a top view of the on-skin sensor control unit of FIG. 11A with a cover of the housing removed.

[0028] FIG. 12 depicts an introducer, sensor, insertion gun and mounting unit, which can be assembled and sold together in an insertion kit.

[0029] FIG. 13 is a perspective view showing a preferred commercial embodiment of a sensor inserter and adhesive mount constructed according to the invention.

[0030] FIG. 14 is a perspective view of the adhesive mount and sensor attached to the patient's skin.

[0031] FIG. 15 is a perspective view of the transmitter attached to the adhesive mount.

[0032] FIG. 16 is an exploded perspective view of the preferred commercial embodiment of FIG. 13.

[0033] FIG. 17 is a side elevation view of the preferred commercial embodiment of FIG. 13.

[0034] FIG. 18 is an end elevation view of the preferred commercial embodiment of FIG. 13.

[0035] FIG. 19 is a cross-sectional view taken along line 19-19 in FIG. 18.

[0036] FIG. 20 is a cross-sectional view taken along line 20-20 in FIG. 17.

[0037] FIG. 21 is a broken away view similar to FIG. 20, showing the shuttle in the neutral position.

[0038] FIG. 22 is a broken away view similar to FIG. 20, showing the shuttle in the cocked position.

[0039] FIG. 23 is a broken away view similar to FIG. 20, showing the shuttle in the insertion position.

[0040] FIG. 24 is a cross-sectional view taken along line 24-24 in FIG. 17.

[0041] FIG. 25 is a perspective view of a transcutaneously implantable sensor.

[0042] FIG. 26A is a perspective view of a sensor introducer.

[0043] FIG. 26B is a bottom view of the introducer shown in FIG. 26A.

[0044] FIG. 27 is a perspective view of a shuttle member.

[0045] FIG. 28 is a top plan view of an oversized adhesive tape.

[0046] FIG. 29 is a perspective view of the transmitter attached to the adhesive mount and showing the sensor sandwiched therebetween.

[0047] FIG. 30 is a perspective view of the interconnect on one end of the transmitter.

[0048] FIG. 31 is an enlarged perspective view of the interconnect of FIG. 30 with the seal and one spring removed for clarity.

[0049] FIG. 32 is an enlarged perspective view of the interconnect seal.

[0050] FIG. 33A is a perspective view of an alternative embodiment of a sensor inserter kit.

[0051] FIG. 33B is an exploded view of some of the components shown assembled in FIG. 33A.

[0052] While the invention is amenable to various modifications and alternative forms, specifics thereof have been shown by way of example in the drawings and will be described in detail. It should be understood, however, that the intention is not to limit the invention to the particular embodiments described. On the contrary, the intention is to cover all modifications, equivalents, and alternatives falling within the spirit and scope of the invention.

#### DETAILED DESCRIPTION

[0053] The present invention is applicable to an analyte monitoring system using an implantable sensor for the in vivo determination of a concentration of an analyte, such as glu-

cose or lactate, in a fluid. The sensor can be, for example, subcutaneously implanted in a patient for the continuous or periodic monitoring of an analyte in a patient's interstitial fluid. This can then be used to infer the glucose level in the patient's bloodstream. Other in vivo analyte sensors can be made, according to the invention, for insertion into a vein, artery, or other portion of the body containing fluid. The analyte monitoring system is typically configured for monitoring the level of the analyte over a time period which may range from days to weeks or longer.

**[0054]** The analyte monitoring systems of the present invention can be utilized under a variety of conditions. The particular configuration of a sensor and other units used in the analyte monitoring system may depend on the use for which the analyte monitoring system is intended and the conditions under which the analyte monitoring system will operate. One embodiment of the analyte monitoring system includes a sensor configured for implantation into a patient or user. For example, implantation of the sensor may be made in the arterial or venous systems for direct testing of analyte levels in blood. Alternatively, a sensor may be implanted in the interstitial tissue for determining the analyte level in interstitial fluid. This level may be correlated and/or converted to analyte levels in blood or other fluids. The site and depth of implantation may affect the particular shape, components, and configuration of the sensor. Subcutaneous implantation may be preferred, in some cases, to limit the depth of implantation of the sensor. Sensors may also be implanted in other regions of the body to determine analyte levels in other fluids. Examples of suitable sensor for use in the analyte monitoring systems of the invention are described in U.S. patent application Ser. No. 09/034,372 and Ser. No. 09/753,746 (the complete parent application to this CIP), both incorporated herein by reference.

**[0055]** One embodiment of the analyte monitoring system **40** for use with an implantable sensor **42**, and particularly for use with a subcutaneously implantable sensor, is illustrated in block diagram form in FIG. 1. The analyte monitoring system **40** includes, at minimum, a sensor **42**, a portion of which is configured for implantation (e.g., subcutaneous, venous, or arterial implantation) into a patient, and a sensor control unit **44**. The sensor **42** is coupled to the sensor control unit **44** which is typically attached to the skin of a patient. The sensor control unit **44** operates the sensor **42**, including, for example, providing a voltage across the electrodes of the sensor **42** and collecting signals from the sensor **42**. The sensor control unit **44** may evaluate the signals from the sensor **42** and/or transmit the signals to one or more optional receiver/display units **46**, **48** for evaluation. The sensor control unit **44** and/or the receiver/display units **46**, **48** may display or otherwise communicate the current level of the analyte. Furthermore, the sensor control unit **44** and/or the receiver/display units **46**, **48** may indicate to the patient, via, for example, an audible, visual, or other sensory-stimulating alarm, when the level of the analyte is at or near a threshold level. In some embodiments, an electrical shock can be delivered to the patient as a warning through one of the electrodes or the optional temperature probe of the sensor. For example, if glucose is monitored then an alarm may be used to alert the patient to a hypoglycemic or hyperglycemic glucose level and/or to impending hypoglycemia or hyperglycemia.

**[0056]** A sensor **42** includes at least one working electrode **58** formed on a substrate **50**, as shown in FIG. 2. The sensor **42** may also include at least one counter electrode **60** (or

counter/reference electrode) and/or at least one reference electrode **62**. The substrate **50** of the sensor may be formed using a variety of non-conducting materials, including, for example, polymeric or plastic materials and ceramic materials. Suitable materials for a particular sensor **42** may be determined, at least in part, based on the desired use of the sensor **42** and properties of the materials.

**[0057]** In some embodiments, the substrate is flexible. For example, if the sensor **42** is configured for implantation into a patient, then the sensor **42** may be made flexible (although rigid sensors may also be used for implantable sensors) to reduce pain to the patient and damage to the tissue caused by the implantation of and/or the wearing of the sensor **42**. A flexible substrate **50** often increases the patient's comfort and allows a wider range of activities. Suitable materials for a flexible substrate **50** include, for example, non-conducting plastic or polymeric materials and other non-conducting, flexible, deformable materials. Examples of useful plastic or polymeric materials include thermoplastics such as polycarbonates, polyesters (e.g., Mylar™ and polyethylene terephthalate (PET)), polyvinyl chloride (PVC), polyurethanes, polyethers, polyamides, polyimides, or copolymers of these thermoplastics, such as PETG (glycol-modified polyethylene terephthalate).

**[0058]** In other embodiments, the sensor **42** is made using a relatively rigid substrate **50** to, for example, provide structural support against bending or breaking. Examples of rigid materials that may be used as the substrate **50** include poorly conducting ceramics, such as aluminum oxide and silicon dioxide. One advantage of an implantable sensor **42** having a rigid substrate is that the sensor **42** may have a sharp point and/or a sharp edge to aid in implantation of a sensor **42** without an additional introducer.

**[0059]** It will be appreciated that for many sensors **42** and sensor applications, both rigid and flexible sensors will operate adequately. The flexibility of the sensor **42** may also be controlled and varied along a continuum by changing, for example, the composition and/or thickness of the substrate **50**.

**[0060]** In addition to considerations regarding flexibility, it is often desirable that implantable sensors **42** should have a substrate **50** which is non-toxic. Preferably, the substrate **50** is approved by one or more appropriate governmental agencies or private groups for in vivo use.

**[0061]** Although the substrate **50** in at least some embodiments has uniform dimensions along the entire length **57** of the sensor **42**, in other embodiments, the substrate **50** has a distal end **67** and a proximal end **65** with different widths **53**, **55**, respectively, as illustrated in FIG. 2. In these embodiments, the distal end **67** of the substrate **50** may have a relatively narrow width **53**. For sensors **42** which are implantable into the subcutaneous tissue or another portion of a patient's body, the narrow width **53** of the distal end **67** of the substrate **50** may facilitate the implantation of the sensor **42**. Often, the narrower the width of the sensor **42**, the less pain the patient will feel during implantation of the sensor and afterwards. The sensor **42** is designed to be a replaceable component in an implantable analyte monitor. Typically, the sensor **42** is capable of operation over a period of days. Preferably, the period of operation is at least three days. The sensor **42** can then be removed and replaced with a new sensor.

**[0062]** An introducer **120** can be used to subcutaneously insert the sensor **42** into the patient, as illustrated in FIG. 3.

The introducer **120** is typically formed using structurally rigid materials, such as metal or rigid plastic. Preferred materials include stainless steel and ABS (acrylonitrile-butadiene-styrene) plastic. In some embodiments, the introducer **120** is pointed and/or sharp at the tip **121** to facilitate penetration of the skin of the patient. A sharp, thin introducer may reduce pain felt by the patient upon insertion of the sensor **42**. In other embodiments, the tip **121** of the introducer **120** has other shapes, including a blunt or flat shape. These embodiments may be particularly useful when the introducer **120** does not penetrate the skin but rather serves as a structural support for the sensor **42** as the sensor **42** is pushed into the skin.

[0063] The introducer **120** may have a variety of cross-sectional shapes, as shown in FIGS. 4A, 4B, and 4C. The introducer **120** illustrated in FIG. 4A is a flat, planar, pointed strip of rigid material which may be attached or otherwise coupled to the sensor **42** to ease insertion of the sensor **42** into the skin of the patient, as well as to provide structural support to the sensor **42** during insertion. The introducers **120** of FIGS. 4B and 4C are U- or V-shaped implements that support the sensor **42** to limit the amount that the sensor **42** may bend or bow during insertion. The cross-sectional width **124** of the introducers **120** illustrated in FIGS. 4B and 4C is typically 1 mm or less, preferably 700  $\mu\text{m}$  or less, more preferably 500  $\mu\text{m}$  or less, and most preferably 300  $\mu\text{m}$  or less. The cross-sectional height **126** of the introducer **120** illustrated in FIGS. 4B and 4C is typically about 1 mm or less, preferably about 700  $\mu\text{m}$  or less, and more preferably about 500  $\mu\text{m}$  or less.

[0064] The sensor **42** itself may include optional features to facilitate insertion. For example, the sensor **42** may be pointed at the tip **123** to ease insertion, as illustrated in FIG. 3. In addition, the sensor **42** may include a barb **125** which helps retain the sensor **42** in the subcutaneous tissue of the patient. The barb **125** may also assist in anchoring the sensor **42** within the subcutaneous tissue of the patient during operation of the sensor **42**. However, the barb **125** is typically small enough that little damage is caused to the subcutaneous tissue when the sensor **42** is removed for replacement. The sensor **42** may also include a notch **127** that can be used in cooperation with a corresponding structure (not shown) in the introducer to apply pressure against the sensor **42** during insertion, but disengage as the introducer **120** is removed. One example of such a structure in the insertion device is a rod (not shown) between two opposing sides of an introducer **120** and at an appropriate height of the introducer **120**.

[0065] In operation, the sensor **42** is placed within or next to the introducer **120** and then a force is provided against the introducer **120** and/or sensor **42** to carry the sensor **42** into the skin of the patient. In one embodiment, the force is applied to the sensor **42** to push the sensor into the skin, while the introducer **120** remains stationary and provides structural support to the sensor **42**. Alternatively, the force is applied to the introducer **120** and optionally to the sensor **42** to push a portion of both the sensor **42** and the introducer **120** through the skin of the patient and into the subcutaneous tissue. The introducer **120** is optionally pulled out of the skin and subcutaneous tissue with the sensor **42** remaining in the subcutaneous tissue due to frictional forces between the sensor **42** and the patient's tissue. If the sensor **42** includes the optional barb **125**, then this structure may also facilitate the retention of the sensor **42** within the interstitial tissue as the barb catches in the tissue.

[0066] The force applied to the introducer **120** and/or the sensor **42** may be applied manually or mechanically. Preferably, the sensor **42** is reproducibly inserted through the skin of the patient. In one embodiment, an insertion gun is used to insert the sensor. One example of an insertion gun **200** for inserting a sensor **42** is shown in FIG. 9. The insertion gun **200** includes a housing **202** and a carrier **204**. The introducer **120** is typically mounted on the carrier **204** and the sensor **42** is pre-loaded into the introducer **120**. The carrier **204** drives the sensor **42** and, optionally, the introducer **120** into the skin of the patient using, for example, a cocked or wound spring, a burst of compressed gas, an electromagnet repelled by a second magnet, or the like, within the insertion gun **200**. In some instances, for example, when using a spring, the carrier **204** and introducer **120** may be moved, cocked, or otherwise prepared to be directed towards the skin of the patient.

[0067] After the sensor **42** is inserted, the insertion gun **200** may contain a mechanism which pulls the introducer **120** out of the skin of the patient. Such a mechanism may use a spring, electromagnet, or the like to remove the introducer **120**.

[0068] The insertion gun may be reusable. The introducer **120** is often disposable to avoid the possibility of contamination. Alternatively, the introducer **120** may be sterilized and reused. In addition, the introducer **120** and/or the sensor **42** may be coated with an anticlotting agent to prevent fouling of the sensor **42**.

[0069] In one embodiment, the sensor **42** is injected between 2 to 12 mm into the interstitial tissue of the patient for subcutaneous implantation. Preferably, the sensor is injected 3 to 9 mm, and more preferably 5 to 7 mm, into the interstitial tissue. Other embodiments of the invention, may include sensors implanted in other portions of the patient, including, for example, in an artery, vein, or organ. The depth of implantation varies depending on the desired implantation target.

[0070] Although the sensor **42** may be inserted anywhere in the body, it is often desirable that the insertion site be positioned so that the on-skin sensor control unit **44** can be concealed. In addition, it is often desirable that the insertion site be at a place on the body with a low density of nerve endings to reduce the pain to the patient. Examples of preferred sites for insertion of the sensor **42** and positioning of the on-skin sensor control unit **44** include the abdomen, thigh, leg, upper arm, and shoulder.

[0071] An insertion angle is measured from the plane of the skin (i.e., inserting the sensor perpendicular to the skin would be a 90° insertion angle). Insertion angles usually range from 10 to 90°, typically from 15 to 60°, and often from 30 to 45°.

#### On-Skin Sensor Control Unit

[0072] The on-skin sensor control unit **44** is configured to be placed on the skin of a patient. The on-skin sensor control unit **44** is optionally formed in a shape that is comfortable to the patient and which may permit concealment, for example, under a patient's clothing. The thigh, leg, upper arm, shoulder, or abdomen are convenient parts of the patient's body for placement of the on-skin sensor control unit **44** to maintain concealment. However, the on-skin sensor control unit **44** may be positioned on other portions of the patient's body. One embodiment of the on-skin sensor control unit **44** has a thin, oval shape to enhance concealment, as illustrated in FIGS. 5-7. However, other shapes and sizes may be used.

[0073] The particular profile, as well as the height, width, length, weight, and volume of the on-skin sensor control unit

**44** may vary and depends, at least in part, on the components and associated functions included in the on-skin sensor control unit **44**, as discussed below. For example, in some embodiments, the on-skin sensor control unit **44** has a height of 1.3 cm or less, and preferably 0.7 cm or less. In some embodiments, the on-skin sensor control unit **44** has a weight of 90 grams or less, preferably 45 grams or less, and more preferably 25 grams or less. In some embodiments, the on-skin sensor control unit **44** has a volume of about 15 cm<sup>3</sup> or less, preferably about 10 cm<sup>3</sup> or less, more preferably about 5 cm<sup>3</sup> or less, and most preferably about 2.5 cm<sup>3</sup> or less.

[0074] The on-skin sensor control unit **44** includes a housing **45**, as illustrated in FIGS. 5-7. The housing **45** is typically formed as a single integral unit that rests on the skin of the patient. The housing **45** typically contains most or all of the electronic components, described below, of the on-skin sensor control unit **44**. The on-skin sensor control unit **44** usually includes no additional cables or wires to other electronic components or other devices. If the housing includes two or more parts, then those parts typically fit together to form a single integral unit.

[0075] In some embodiments, conductive contacts **80** are provided on the exterior of the housing **45**. In other embodiments, the conductive contacts **80** are provided on the interior of the housing **45**, for example, within a hollow or recessed region.

[0076] In some embodiments, the housing **45** of the on-skin sensor control unit **44** is a single piece. The conductive contacts **80** may be formed on the exterior of the housing **45** or on the interior of the housing **45** provided there is a port **78** in the housing **45** through which the sensor **42** can be directed to access the conductive contacts **80**.

[0077] In other embodiments, the housing **45** of the on-skin sensor control unit **44** is formed in at least two separate portions that fit together to form the housing **45**, for example, a base **74** and a cover **76**, as illustrated in FIGS. 5-7. The two or more portions of the housing **45** may be entirely separate from each other. Alternatively, at least some of the two or more portions of the housing **45** may be connected together, for example, by a hinge, to facilitate the coupling of the portions to form the housing **45** of the on-skin sensor control unit **44**.

[0078] These two or more separate portions of the housing **45** of the on-skin sensor control unit **44** may have complementary, interlocking structures, such as, for example, interlocking ridges or a ridge on one component and a complementary groove on another component, so that the two or more separate components may be easily and/or firmly coupled together. This may be useful, particularly if the components are taken apart and fit together occasionally, for example, when a battery or sensor **42** is replaced. However, other fasteners may also be used to couple the two or more components together, including, for example, screws, nuts and bolts, nails, staples, rivets, or the like. In addition, adhesives, both permanent or temporary, may be used including, for example, contact adhesives, pressure sensitive adhesives, glues, epoxies, adhesive resins, and the like.

[0079] Typically, the housing **45** is at least water resistant to prevent the flow of fluids into contact with the components in the housing, including, for example, the conductive contacts **80**. Preferably, the housing is waterproof. In one embodiment, two or more components of the housing **45**, for example, the base **74** and the cover **76**, fit together tightly to form a hermetic, waterproof, or water resistant seal so that

fluids cannot flow into the interior of the on-skin sensor control unit **44**. This may be useful to avoid corrosion currents and/or degradation of items within the on-skin sensor control unit **44**, such as the conductive contacts, the battery, or the electronic components, particularly when the patient engages in such activities as showering, bathing, or swimming.

[0080] Water resistant, as used herein, means that there is no penetration of water through a water resistant seal or housing when immersed in water at a depth of one meter at sea level. Waterproof, as used herein, means that there is no penetration of water through the waterproof seal or housing when immersed in water at a depth of ten meters, and preferably fifty meters, at sea level. It is often desirable that the electronic circuitry, power supply (e.g., battery), and conductive contacts of the on-skin sensor control unit, as well as the contact pads of the sensor, are contained in a water resistant, and preferably, a waterproof, environment.

[0081] The on-skin sensor control unit **44** is typically attached to the skin **75** of the patient, as illustrated in FIG. 8. The on-skin sensor control unit **44** may be attached by a variety of techniques including, for example, by adhering the on-skin sensor control unit **44** directly to the skin **75** of the patient with an adhesive provided on at least a portion of the housing **45** of the on-skin sensor control unit **44** which contacts the skin **75**, by suturing the on-skin sensor control unit **44** to the skin **75** through suture openings (not shown) in the sensor control unit **44**, or by strapping the on-skin sensor control unit **44** to the skin **75**.

[0082] Another method of attaching the housing **45** of the on-skin sensor control unit **44** to the skin **75** includes using a mounting unit **77**. The mounting unit **77** is often a part of the on-skin sensor control unit **44**. One example of a suitable mounting unit **77** is a double-sided adhesive strip, one side of which is adhered to a surface of the skin of the patient and the other side is adhered to the on-skin sensor control unit **44**. In this embodiment, the mounting unit **77** may have an optional opening **79** which is large enough to allow insertion of the sensor **42** through the opening **79**. Alternatively, the sensor may be inserted through a thin adhesive and into the skin.

[0083] A variety of adhesives may be used to adhere the on-skin sensor control unit **44** to the skin **75** of the patient, either directly or using the mounting unit **77**, including, for example, pressure sensitive adhesives (PSA) or contact adhesives. Preferably, an adhesive is chosen which is not irritating to all or a majority of patients for at least the period of time that a particular sensor **42** is implanted in the patient. Alternatively, a second adhesive or other skin-protecting compound may be included with the mounting unit so that a patient, whose skin is irritated by the adhesive on the mounting unit **77**, can cover his skin with the second adhesive or other skin-protecting compound and then place the mounting unit **77** over the second adhesive or other skin-protecting compound. This should substantially prevent the irritation of the skin of the patient because the adhesive on the mounting unit **77** is no longer in contact with the skin, but is instead in contact with the second adhesive or other skin-protecting compound.

[0084] Returning to FIG. 8, when the sensor **42** is changed, the on-skin sensor control unit **44** may be moved to a different position on the skin **75** of the patient, for example, to avoid excessive irritation. Alternatively, the on-skin sensor control unit **44** may remain at the same place on the skin of the patient until it is determined that the unit **44** should be moved.

[0085] Another embodiment of a mounting unit 77 used in an on-skin sensor control unit 44 is illustrated in FIGS. 10A and 10B. The mounting unit 77 and a housing 45 of an on-skin sensor control unit 44 are mounted together in, for example, an interlocking manner, as shown in FIG. 10A. The mounting unit 77 is formed, for example, using plastic or polymer materials, including, for example, polyvinyl chloride, polyethylene, polypropylene, polystyrene, ABS polymers, and copolymers thereof. The mounting unit 77 may be formed using a variety of techniques including, for example, injection molding, compression molding, casting, and other molding methods.

[0086] The mounting unit 77 typically includes an adhesive on a bottom surface of the mounting unit 77 to adhere to the skin of the patient or the mounting unit 77 is used in conjunction with, for example, double-sided adhesive tape or the like. The mounting unit 77 typically includes an opening 79 through which the sensor 42 is inserted, as shown in FIG. 10B. The mounting unit 77 may also include a support structure 220 for holding the sensor 42 in place and against the conductive contacts 80 on the on-skin sensor control unit 42. The mounting unit 77, also, optionally, includes a positioning structure 222, such as an extension of material from the mounting unit 77, that corresponds to a structure (not shown), such as an opening, on the sensor 42 to facilitate proper positioning of the sensor 42, for example, by aligning the two complementary structures.

[0087] In another embodiment, a coupled mounting unit 77 and housing 45 of an on-skin sensor control unit 44 is provided on an adhesive patch 204 with an optional cover 206 to protect and/or confine the housing 45 of the on-skin sensor control unit 44, as illustrated in FIG. 11A. The optional cover may contain an adhesive or other mechanism for attachment to the housing 45 and/or mounting unit 77. The mounting unit 77 typically includes an opening 49 through which a sensor 42 is disposed, as shown in FIG. 11B. The opening 49 may optionally be configured to allow insertion of the sensor 42 through the opening 49 using an introducer 120 or insertion gun 200 (see FIG. 9). The housing 45 of the on-skin sensor control unit 44 has a base 74 and a cover 76, as illustrated in FIG. 11C. A bottom view of the housing 45, as shown in FIG. 11D, illustrates ports 230 through which conductive contacts (not shown) extend to connect with contact pads on the sensor 42. A board 232 for attachment of circuit components may optionally be provided within the on-skin sensor control unit 44, as illustrated in FIG. 11E.

[0088] In some embodiments, the adhesive on the on-skin sensor control unit 44 and/or on any of the embodiments of the mounting unit 77 is water resistant or waterproof to permit activities such as showering and/or bathing while maintaining adherence of the on-skin sensor control unit 44 to the skin 75 of the patient and, at least in some embodiments, preventing water from penetrating into the sensor control unit 44. The use of a water resistant or waterproof adhesive combined with a water resistant or waterproof housing 45 protects the components in the sensor control unit 44 and the contact between the conductive contacts 80 and the sensor 42 from damage or corrosion. An example of a non-irritating adhesive that repels water is Tegaderm™ (3M™, St. Paul, Minn.).

[0089] In one embodiment, the on-skin sensor control unit 44 includes a sensor port 78 through which the sensor 42 enters the subcutaneous tissue of the patient, as shown in FIGS. 5 to 7. The sensor 42 may be inserted into the subcutaneous tissue of the patient through the sensor port 78. The

on-skin sensor control unit 44 may then be placed on the skin of the patient with the sensor 42 being threaded through the sensor port 78. If the housing 45 of the sensor 42 has, for example, a base 74 and a cover 76, then the cover 76 may be removed to allow the patient to guide the sensor 42 into the proper position for contact with the conductive contacts 80.

[0090] Alternatively, if the conductive contacts 80 are within the housing 45 the patient may slide the sensor 42 into the housing 45 until contact is made between the contact pads 49 and the conductive contacts 80. The sensor control unit 44 may have a structure which obstructs the sliding of the sensor 42 further into the housing once the sensor 42 is properly positioned with the contact pads 49 in contact with the conductive contacts 80.

[0091] In other embodiments, the conductive contacts 80 are on the exterior of the housing 45 (see e.g., FIGS. 10A-10B and 11A-11E). In these embodiments, the patient guides the contact pads 49 of the sensor 42 into contact with the conductive contacts 80. In some cases, a guiding structure may be provided on the housing 45 which guides the sensor 42 into the proper position. An example of such a structure includes a set of guiding rails extending from the housing 45 and having the shape of the sensor 42.

[0092] In some embodiments, when the sensor 42 is inserted using an introducer 120 (see FIG. 3), the tip of the introducer 120 or optional insertion gun 200 (see FIG. 9) is positioned against the skin or the mounting unit 77 at the desired insertion point. In some embodiments, the introducer 120 is positioned on the skin without any guide. In other embodiments, the introducer 120 or insertion gun 200 is positioned using guides (not shown) in the mounting unit 77 or other portion of the on-skin sensor control unit 44. In some embodiments, the guides, opening 79 in the mounting unit 77 and/or sensor port 78 in the housing 45 of the on-skin sensor control unit 44 have a shape which is complementary to the shape of the tip of the introducer 120 and/or insertion gun 200 to limit the orientation of the introducer 120 and/or insertion gun 200 relative to the opening 79 and/or sensor port 78. The sensor can then be subcutaneously inserted into the patient by matching the complementary shape of the opening 79 or sensor port 78 with the introducer 120 and/or insertion gun 200.

[0093] In some embodiments, the shapes of a) the guides, opening 79, or sensor port 78, and b) the introducer 120 or insertion gun 200 are configured such that the two shapes can only be matched in a single orientation. This aids in inserting the sensor 42 in the same orientation each time a new sensor is inserted into the patient. This uniformity in insertion orientation may be required in some embodiments to ensure that the contact pads 49 on the sensor 42 are correctly aligned with appropriate conductive contacts 80 on the on-skin sensor control unit 44. In addition, the use of the insertion gun, as described above, may ensure that the sensor 42 is inserted at a uniform, reproducible depth.

[0094] An exemplary on-skin sensor control unit 44 can be prepared and used in the following manner. A mounting unit 77 having adhesive on the bottom is applied to the skin. An insertion gun 200 (see FIG. 9) carrying the sensor 42 and the introducer 120 is positioned against the mounting unit 77. The insertion gun 200 and mounting unit 77 are optionally designed such that there is only one position in which the two properly mate. The insertion gun 200 is activated and a portion of the sensor 42 and optionally a portion of the introducer 120 are driven through the skin into, for example, the subcu-

taneous tissue. The insertion gun 200 withdraws the introducer 120, leaving the portion of the sensor 42 inserted through the skin. The housing 45 of the on-skin control unit 44 is then coupled to the mounting unit 77. Optionally, the housing 45 and the mounting unit 77 are formed such that there is only one position in which the two properly mate. The mating of the housing 45 and the mounting unit 77 establishes contact between the contact pads 49 (see e.g., FIG. 2) on the sensor 42 and the conductive contacts 80 on the on-skin sensor control unit 44. Optionally, this action activates the on-skin sensor control unit 44 to begin operation.

[0095] The introducer, sensor, insertion gun and mounting unit can be manufactured, marketed, or sold as a unit. For example, FIG. 12 depicts an introducer 270, sensor 272, insertion gun 274 and mounting unit 276, which can be assembled (as indicated by the arrows) and sold together in an insertion kit. In such an embodiment of an insertion kit, the insertion gun 274 can be packaged in a pre-loaded fashion, with an introducer 270 and sensor 272 mated or otherwise coupled, the mated sensor 272 and introducer 270 loaded upon the carrier 278 of the insertion gun, and with a mounting unit 276 already mated with the end of the insertion gun 274.

[0096] In one embodiment, the insertion gun 274 is packaged in a state where it is ready to thrust the sensor 272 (and perhaps introducer 270) into subcutaneous tissue. For example, the insertion gun 274 can be packaged in a “cocked” state, such that the thrusting force used to introduce the sensor 272 into the subcutaneous tissue is stored in the device as potential energy (in the case of the embodiment depicted in FIG. 12, the insertion gun 274 would be “cocked” by compressing its spring 280, thus storing potential energy within the coils of the spring). Preferably, an insertion gun 274 packaged in such a manner employs a “safety”, a barrier to prevent the release of the stored potential energy. The barrier is removed in order to permit the potential energy to be released. Within the context of the embodiment presented in FIG. 12, an example of a safety is a pin (not pictured) that impedes the spring from expanding, once compressed. Thus, an insertion kit so embodied can be obtained at a place of purchase, removed from its package, and used after removal of the safety, without necessitating additional steps. Alternatively, the insertion gun 274 can be packaged in the above-described pre-loaded configuration, but without being “cocked”. Thus, an insertion kit with an “uncocked” insertion gun 274 can be obtained at a place of purchase, removed from its package, cocked, and used. To facilitate the insertion kit being ready to use with minimal user-exercised steps, the insertion kit can be sterilized prior to packaging. Examples of acceptable sterilizing techniques include exposing the elements of the insertion kit to gamma radiation or an e-beam.

[0097] Referring to FIGS. 13-33B, preferred commercial embodiments of a sensor inserter constructed according to the invention will now be described. FIG. 13 shows an overall perspective view of a sensor inserter kit 300 comprising a single-use sensor inserter 310 and a single-use adhesive mount 312 removably attached to the bottom thereof.

[0098] As an overview of the operation of inserter kit 300, the kit comes packaged generally as shown in FIG. 13 with a sensor 314 (best seen in FIGS. 16 and 25) preloaded within inserter 310 and with inserter 310 in a “cocked” state. After preparing an insertion site on the skin, typically in the abdominal region, the patient removes upper liner 316 and lower liner 318 from adhesive mount 312 to expose the bottom surface and a portion of the top surface of an adhesive

tape 320 (best seen in FIG. 16) located beneath mount 312. Mount 312, with inserter 310 attached, is then applied to the patient’s skin at the insertion site. Safety lock tabs 322 are squeezed together to allow actuator button 324 to be pressed causing inserter 310 to fire, thereby inserting sensor 314 into the patient’s skin with a predetermined velocity and force. Once sensor 314 has been inserted into the skin, the patient removes inserter 310 from mount 312 by pressing release tabs 326 on opposite sides of inserter 310 and lifting inserter 310 away from mount 312.

[0099] Referring to FIG. 14, mount 312 is shown adhered to a patient’s skin 328 with sensor 314 already inserted. Once inserter 310 is removed from mount 312, transmitter 330 can be slid into place. The circuitry of transmitter 330 makes electrical contact with the contact pads on sensor 314 after transmitter 330 is fully seated on mount 312. Once initialization and synchronization procedures are completed, electrochemical measurements from sensor 314 can be sent wirelessly from transmitter 330 to a portable receiver 332, as shown in FIG. 15. Sensor 314, mount 312 and transmitter 330 remain in place on the patient for a predetermined period, currently envisioned to be three days. These components are then removed so that sensor 314 and mount 312 can be properly discarded. The entire procedure above can then be repeated with a new inserter 310, sensor 314 and mount 312, reusing transmitter 330 and receiver 332.

[0100] Referring to FIG. 16, the preferred inserter kit 300 is assembled as shown from the following components: housing 334, actuator button 324, drive spring 336, shuttle 338, introducer sharp 340, sensor 314, retraction spring 342, inserter base 344, upper liner 316, adhesive mount 312, adhesive tape 320, and lower liner 318.

[0101] Sensor 314 has a main surface 346 slidably mounted between U-shaped rails 348 of introducer sharp 340 and releasably retained there by sensor dimple 350 which engages introducer dimple 352. Introducer sharp 340 is mounted to face 354 of shuttle 338, such as with adhesive, heat stake or ultrasonic weld. Sensor 314 also has a surface 356 that extends orthogonally from main surface 346 and just beneath a driving surface 358 of shuttle 338 when mounted thereon (details of these features are better shown in FIGS. 19 and 25-27.)

[0102] Shuttle 338 is slidably and non-rotatably constrained on base 344 by arcuate guides 360. As best seen in FIGS. 19, 24 and 27, shuttle 338 is generally formed by an outer ring 362 and an inner cup-shaped post 364 connected by two bridges 366. Bridges 366 slide between the two slots 368 formed between guides 360 and allow shuttle 338 to travel along guides 360 without rotating. Retraction spring 342 is captivated at its outer circumference by guides 360, at its bottom by the floor 370 of base 344, at its top by bridges 366, and at its inner circumference by the outer surface of shuttle post 364. Drive spring 336 is captivated at its bottom and outer circumference by the inside surface of shuttle post 364, at its top by the ceiling 372 inside actuator button 324, and at its inner circumference by stem 374 depending from ceiling 372. When drive spring 336 is compressed between actuator button 324 and shuttle 338 it urges shuttle 338 towards base 344. When retraction spring 342 is compressed between shuttle 338 and base 344, it urges shuttle 338 towards actuator button 324.

[0103] Actuator button 324 is slidably received within housing 334 from below and resides in opening 376 at the top of housing 334 with limited longitudinal movement. Arms

**378** on each side of actuator button **324** travel in channels **380** along the inside walls of housing **334**, as best seen in FIG. 20. Longitudinal movement of actuator button **324** is limited in one direction by the base of arms **378** contacting the edge of opening **376** at the top of housing **334**, and in the other direction by the distal ends **384** of arms **378** contacting stops **386** in channels **380**. Slots **388** are preferably provided in the top of housing **334** for ease of housing manufacture and so tools can be inserted to inwardly compress arms **378** beyond stops **386** to allow actuator button **324** to be removed from housing **334** if needed.

[0104] When sensor **314**, introducer sharp **340**, shuttle **338**, retraction spring **342**, drive spring **336** and actuator button **324** are assembled between base **344** and housing **334** as shown in FIG. 16 and described above, housing **334** is snapped into place on base **344**. Base **344** is held onto housing **334** by upper base barbs **390** that engage upper openings **392** in housing **334**, and lower base barbs **394** (best seen in FIG. 17) that engage lower openings **396** in housing **334**. Slots **398** and **400** are provided for ease of manufacture of housing **334**, and base **344** is preferably removable from housing **334** with tools if needed.

[0105] Referring to FIG. 19, actuator button **324** is preferably provided with safety lock tabs **322** hingedly formed on opposite ends. Tabs **322** can be urged from a relaxed outward position to a flexed inward position. When in the normal outward position, shoulders **402** on the outer surfaces of tabs **322** engage the rim **404** of opening **376** to prevent the actuator button **324** from being depressed, thereby avoiding accidental firing of inserter **310**. Tabs **322** can be squeezed inward just enough to clear the rim **404** of opening **376** while pressing the actuator button **324** down to fire the inserter. Alternatively, tabs **322** can be squeezed further inward so that barbs **406** on the inside edges can engage catches **408** located on a center portion of actuator button **324**, thereby defeating the safety lock to allow later firing by simply pressing down on the actuator button **324**. Preferably, upwardly extending grips are provided on tabs **322** for better visual indication of safety lock status and actuation control.

[0106] Referring to FIG. 20, shuttle **338** is provided with laterally extending barbed fingers **412** which travel in channels **380** along the inside walls of housing **334**. When shuttle **338** is inserted up into housing **334** far enough, barbed fingers **412** momentarily deflect inward and then snap outward again to catch on stops **386**. In this “cocked” position as shown, drive spring **336** is compressed and urging shuttle **338** towards base **344**, but barbed fingers **412** catching on stops **386** prevent such travel.

[0107] Referring to FIGS. 21-23, the sequence of loading, cocking, arming, firing, and automatic retraction of inserter **310** will be described. It is envisioned that in production, inserters **310** will be fabricated and fully assembled by one vendor except for sensor **314**, which will be supplied and installed by a second vendor in a sterile environment. Accordingly, inserter **310** will be manufactured and shipped to the sensor vendor in a neutral state, as shown in FIG. 21. A hole **414** provided through the center of actuator button **324** allows the sensor vendor to insert a pin (manually or by automated machinery, not shown) through hole **414** to drive shuttle **338** towards base **344** in a controlled fashion and hold it there against the force of retraction spring **342**. This will cause introducer sharp **340** to be extended through base **344** (as shown in FIG. 23) so that sensor **314** can be loaded into introducer **340**. When the pin is removed, shuttle **338**, intro-

ducer **340** and sensor **314** will retract to the neutral position. The sensor vendor can then cock the loaded inserter **310** before shipment by pushing another pin (not shown) from the opposite direction through a central hole **416** in base **344** (with mount **312** removed) until the pin contacts dimple **418** formed in the bottom of shuttle **338**. By pushing shuttle **338** towards actuator button **324** until barbed fingers **412** clear stops **386**, the inserter **310** is cocked (as shown in FIG. 22.)

[0108] Referring to FIG. 22, inserter **310** is preferably received by the patient in the cocked position as shown. To use inserter **310**, the patient applies mount **312** to the mounting site and disables the safety mechanism as previously described, and then pushes actuator button **324** against the force of drive spring **336**. As actuator button **324** travels toward base **344**, drive cam surfaces **420** on arms **378** contact ramped surfaces **422** of barbed fingers **412** and urge them inward. When fingers **412** are driven inward enough to clear stops **386**, shuttle **338** is driven by drive spring **336** with a predetermined speed and force to an insertion position, as shown in FIG. 23.

[0109] Referring to FIG. 23, inserter **310** is shown in the insertion position with the tail **424** of introducer sharp **340** extending through base **344** and mount **312** into the skin of the patient. FIG. 23 shows shuttle **338** in a fully extended position with its lower surface **426** bottomed out on base **344**. However, the lower orthogonal surface **356** of sensor **314** will contact an exposed sensor contact portion **428** (best seen in FIG. 16) on top of adhesive tape **320** supported from below by the patient’s skin, and therefore will typically stop traveling before reaching the fully bottomed out position shown. Tail **424** of introducer sharp **340** provides rigidity and a skin piercing edge **430** for allowing the flexible tail **431** of sensor **314** to be implanted in the patient’s skin. After providing this function, introducer sharp **340** is immediately removed from the patient and retracted into a safe position inside housing **334** as retraction spring **342** (which has been compressed by the travel of the shuttle) pushes shuttle **338** back towards actuator cap. Sensor **314** is pulled from introducer sharp **340** and held in place by the sensor contact portion **428** on top of adhesive tape **320** adhering to orthogonal surface **356** of sensor **314**. The geometries of sensor dimple **350** and mating introducer dimple **352** are chosen to create a separation force between them that is less than the adhesion force of tape **320** on orthogonal surface **356**, but great enough to retain sensor **314** in introducer sharp **340** during typical shipping and product handling shock loads. Driving surface **358** beneath shuttle **338** presses down on top of orthogonal surface **356** to ensure good contact with adhesive tape **320** before shuttle **338** retracts with introducer sharp **340**. As discussed above with previous embodiments, barb(s) on sensor tail **431** can be employed to further anchor the sensor in its operating position.

[0110] Referring again to FIG. 21, retraction spring **342** will return shuttle **338** to the neutral position as shown after firing, but without sensor **314** which remains inserted in patient’s skin (not still in introducer sharp **340** as shown). Drive spring **336** is preferably designed to be stiffer than retraction spring **342** so that shuttle **338** oscillations are quickly dampened out, and so introducer sharp **340** does not return to sensor **314** or the patient to cause injury. With sensor **314** now inserted in the patient’s skin, inserter **310** can be removed from mount **312** by inwardly flexing release tabs **326** on opposite sides of inserter **310** to remove latch hooks **432** from mount channels **434** and then lifting inserter **310**

away from mount 312. Introducer sharp 340 remains protected inside housing 334 during disposal of inserter 310. Transmitter 330 can now be slid into place on mount 312 as previously described.

[0111] Referring to FIG. 28, an alternative embodiment of adhesive tape 320' is shown. This oversized tape 320' has the advantage of holding transmitter 330 in place even when fairly large forces are placed on it. In this embodiment adhesive tape 320' has a double-sided portion 436 (adhesive on both top and bottom sides) residing between mount 312 and the patient's skin, and a single-sided portion 438 outwardly extending from the double-sided portion 436, preferably in all directions, for adhering just to the patient's skin. In the previous embodiment, it is difficult to separate mount 312 from the skin merely with tension forces, but applying a force to just one side of mount 312 results in a high peeling force being applied to that edge of the adhesive tape 320 which causes tape 320 to peel off of the skin. In contrast, any force applied to transmitter 330 in this alternative embodiment results in a tension force rather than a peeling force being applied to tape 320', inhibiting inadvertent removal until an edge of tape 320' is intentionally peeled up. Preferably, single-sided portion 438 has a width roughly double the width of double-sided portion 436. In the preferred embodiment, these widths are 2.14 and 1.14 inches, respectively. Preferably, the length that single-sided portion 438 extends beyond double-sided portion 436 is roughly equivalent to the combined height of transmitter 330 attached to mount 312, in this case about 0.5 inches.

[0112] In the preferred embodiment, sensor 314 is made from a 0.005 inch thick Mylar® substrate, such as Dupont Melinex ST-505, print treated both sides, heat stabilized and bi-axially oriented. Main surface 346 is 0.315 tall by 0.512 wide, and orthogonal surface 356 is 0.374 wide by 0.202 deep. Sensor tail 431 is 0.230 long by 0.023 wide. Semi-spherical sensor dimple 350 is 0.050 inches wide and 0.026 inches deep. Introducer sharp 340 is made from SUS 301 medical grade stainless steel, 0.004 inches thick, having a surface roughness less than or equal to 0.5 micrometers. The height of the main portion of introducer sharp 340 is 0.614 inches, and the inside width is 0.513 inches. The overall thickness of rolled rails 348 is 0.026 inches. The length and width of introducer tail 424 are 0.354 and 0.036 inches, respectively. The preferred angle of the introducer sharp 340 is 21 degrees. Preferably, semispherical introducer dimple 352 has a radius of 0.024 inches. In the preferred embodiment, shuttle 338 has an average speed of at least 1 meter/second, and has a momentum at its end of travel of about 2.65 lb-m/sec.

[0113] Preferably, housing 334, button 324, shuttle 338, base 344 and mount 312 are all injection molded from G.E. Lexan PC. Inside and outside working surfaces of arms 378 on button 324 are preferably lubricated with Dow Corning 360 Medical Fluid. Drive spring 336 has a free length of 1.25 inches, a working length of 1.00 inch, and a rate between 20 and 30 pounds per inch. Retraction spring 342 has a free length of 1.5 inches, a working length of 0.35 inches, and a rate between 0.15 and 0.35 pounds per inch. Adhesive tape 320 preferably is medical grade acrylic adhesive on polyester film (such as Acutek 0396013) with a semi-bleached kraft liner having silicon release.

[0114] Referring to FIG. 29, an interconnect 440 is shown for providing waterproof electrical connections between sensor 314 and transmitter 330. Interconnect 440 includes a seal

442 mounted on an end of transmitter 330 that contacts one side of sensor 314 when transmitter 330 is slid onto mount 312. When transmitter 330 is locked into place on mount 312, seal 442 is compressed between transmitter 330 and sensor 314 and urges sensor 314 against raised end stop 444 of mount 312.

[0115] Referring to FIG. 30, further details of interconnect 440 are shown. Seal 442 has an exterior wall 446 for surrounding electrical contacts 448 (in this case four), and interior walls 450 for isolating electrical contacts 448 from each other. Rim 452 formed on the transmitter housing 330 surrounds the base 454 of seal 442 to prevent it from collapsing outward when compressed (see FIGS. 31-32).

[0116] Referring to FIG. 31, an enlarged partial view of FIG. 30 is shown with seal 442 and one spring removed for clarity. Electrical contacts 448 are preferably constructed from compression springs 456 mounted on connector lugs 458. Lugs 458 are stamped rearward on their edges to form protrusions that retain springs 456. Alternately or in conjunction with this stamping, plastic rings (not shown) can be melted over the base of each spring 456 for attaching it to its respective lug 458. Connector lugs 458 can protrude through slots in transmitter 330, or be insert molded integral with the plastic housing when it is molded.

[0117] Referring to FIG. 32, an enlarged perspective view of the seal 442 is shown. It has been discovered through experimentation that two lips 462 of equal height along the distal edge of exterior wall 446 provide the best seal from exterior elements. Good isolation between electrical contacts 448 is best achieved by having interior walls 450 with a height equal to that of lips 462. Recesses 464 should be sized large enough so that seal 442 does not interfere with the movement of springs 456 when seal 442 and springs 456 are compressed. In the preferred embodiment, the distal face of seal 442 defined by lips 462 is formed at a 1 degree angle to match the draft angle of mount end stop 444.

[0118] Seal 442 is preferably made of shore A 30 durometer compression molded silicone. It is envisioned that seal 442 can be shortened in the axial direction (parallel to springs 456) to reduce the force required to compress it when attaching transmitter 330 to mount 312. Best results for fastening seal 442 to transmitter 330 have been achieved with double sided adhesive tape 320, silicone adhesive on one side and acrylic adhesive on the other for sticking to the PC-ABS blend of the transmitter 330, such as product number 9731 manufactured by 3M Company of St. Paul, Minn. Springs 456 are preferably made from gold-plated beryllium copper so as to deter galvanic current effects. Preferably, main surface 346 of sensor 314 that contacts seal 442 has a uniform thickness dielectric coating with a window in it (i.e. no dielectric) where springs 456 contact sensor 314. An interconnect 440 constructed as described above remains water proof when submerged to a depth of at least 1 meter for 45 minutes.

[0119] To increase the reliability of sensor insertion, the following enhancements can be added to the inserter kit 300 described above. First, a sensor flap can be formed along the top edge of sensor 314. When sensor 314 reaches the extended, delivered position as shown in FIG. 23, the flap catches on the bottom edge of base 344 to ensure that sensor 314 separates from introducer sharp 340 as shuttle 338 returns upward to the retracted position. Adhesive can also be located on the bottom of orthogonal sensor surface 356 to

ensure that sensor **314** adheres to the sensor contact portion **428** on the top of adhesive mount tape **320**, as shown in FIG. 16.

[0120] Referring to FIGS. 33A and 33B, actuator button **324'** can be made easier for elderly patients to push by anchoring the upper end of drive spring **336** on a housing bridge **470** instead of button **324**. This change also makes the insertion force of inserter **310** more consistent, and allows stronger spring forces to be used if desired. Bridge **470** spans across opening **376'** and divides it into two openings **472** in the top of housing **334'**. The top portion of button **324'** is bifurcated into two protrusions **474** that each extend through an opening **472**. A clearance hole (not shown) is provided through the center of button **324'** to allow drive spring **336** to pass through and secure around a post (not shown) depending from the bottom center of bridge **470**.

[0121] Safety lock key **476** can be provided to prevent actuator button **324'** from being pressed until key **476** is removed. Aperture **478** is provided in the top center of bridge **470** for receiving boss **480** located at the bottom of key **476**, thereby allowing key **476** to rotate. When key handle **482** is rotated perpendicular to button protrusions **474** as shown, two opposing perpendicular fins **484** on key **476** swing into inwardly facing slots (not shown) on the inside of protrusions **474** and prevent button **324'** from being actuated. When key handle **482** and fins **484** are rotated parallel to button protrusions **474** such that fins **484** disengage therefrom, key **476** can be removed and button **324'** can then be actuated. Other than these modifications, this inserter kit **300'** functions the same as the embodiment previously described.

[0122] To provide an easier and more consistent release of shuttle **338** by actuator button **324** or **324'**, it is envisioned that less aggressive finger engagement with stops **386** can be employed, or the above designs can be modified to have a single, more centrally located shuttle release finger (not shown) instead of the two outboard fingers **412** shown.

[0123] The present invention should not be considered limited to the particular examples described above. Various modifications, equivalent processes, as well as numerous structures to which the present invention may be applicable and which fall within the general scope of the invention will be readily apparent to those of skill in the art to which the present invention is directed upon review of the instant specification.

1. (canceled)
2. A method of applying an on-skin sensor assembly to a host, comprising:

attaching an applicator to a skin of a host, the applicator comprising a sensor insertion mechanism, a trigger, and a base;

a housing secured to the applicator, wherein the housing is configured to receive an electronics unit;

activating the trigger, thereby causing the sensor insertion mechanism to insert a sensor into the host and to cause the housing to detach from the base;

removing the applicator from the skin of the host, whereby the housing and the inserted sensor remain on the skin of the host; and

inserting the electronics unit into the housing, wherein the electronics unit is configured to generate analyte information based on a signal from the sensor, and wherein the electronics unit is secured to the housing such that the sensor electrically contacts the electronics unit, whereby an on-skin sensor assembly comprising the housing, the electronics unit, and the inserted sensor is obtained.

3. The method of claim 2, wherein a time between the sensor insertion into the host and the electronics unit securing the sensor is less than about 1 second.

4. The method of claim 2, wherein the sensor assembly further comprises a trigger lock configured to prevent activation of the trigger.

5. The method of claim 2, wherein the housing is configured to adhere to a host's skin, wherein, in use, the sensor is configured to extend through the housing and into the host's skin; and

wherein the electronics unit is configured to operably connect to the sensor and generate analyte information based on a signal from the sensor when the electronics unit is secured within the housing, wherein operable connection of the electronics unit to the sensor comprises pressing the sensor against one or more electrical contacts of the electronics unit, and wherein the sensor is configured to be held in the assembly with a retention force.

6. The method of claim 5, wherein the sensor is configured such that connection of the electronics unit to the sensor causes the sensor to bend, whereby the sensor is configured to conform to the shape of the one or more electrical contacts.

7. The method of claim 2, wherein the electronics unit is inserted into the housing after the applicator is removed from the skin of the host.

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