US009865185B2

(12) **United States Patent**
Lee

(10) **Patent No.: US 9,865,185 B2**
(45) **Date of Patent: Jan. 9, 2018**

(54) **LED MATRIX LIGHTING DEVICE**

(71) Applicant: **Bitro Group, Inc.**, Hackensack, NJ (US)

(72) Inventor: **Ki S. Lee**, Palisades Park, NJ (US)

(73) Assignee: **Bitro Group, Inc.**, Hackensack, NJ (US)

(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 624 days.

(21) Appl. No.: **14/460,603**

(22) Filed: **Aug. 15, 2014**

(65) **Prior Publication Data**

US 2015/0049483 A1 Feb. 19, 2015

Related U.S. Application Data

(60) Provisional application No. 61/866,287, filed on Aug. 15, 2013.

(51) **Int. Cl.**
F21V 1/00 (2006.01)
G09F 13/22 (2006.01)

(52) **U.S. Cl.**
CPC ***G09F 13/22*** (2013.01); *Y10T 29/4913* (2015.01)

(58) **Field of Classification Search**
CPC G09F 13/22
USPC 362/235
See application file for complete search history.

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(Continued)

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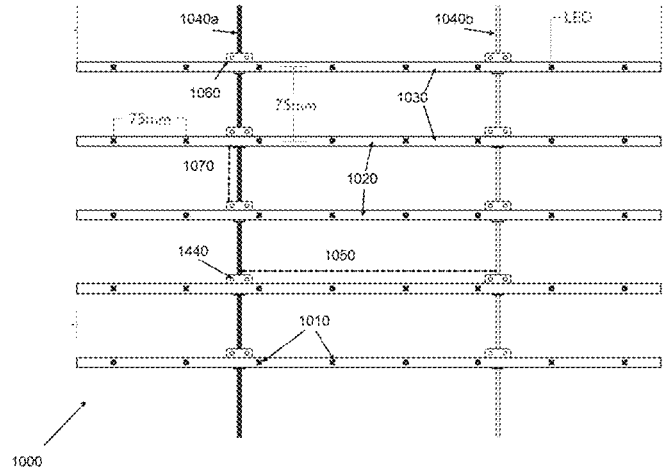
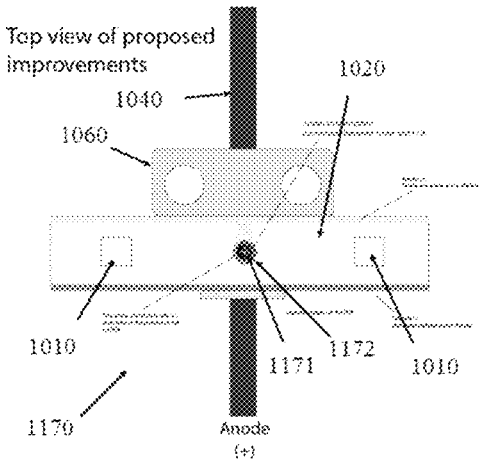
Primary Examiner — Bryon T Gyllstrom
(74) *Attorney, Agent, or Firm* — Myers Wolin, LLC.

(57) **ABSTRACT**

One embodiment of a light emitting diode (LED) lighting device comprises multiple LED light sources disposed on multiple elongated circuit boards, with each LED light source being electrically connected to one of the circuit boards. The elongated circuit boards are electrically coupled using electrical passageways to provide power to the circuit boards at intervals along the length of the elongated circuit boards, and the light sources disposed on the circuit boards emit light in the same direction perpendicular to the elongated circuit boards. The electrical passageways can be wires or groups of wires.

18 Claims, 33 Drawing Sheets





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Bitro Group Inc., "The Lattice LED Carpet System", copyright 2010.

* cited by examiner

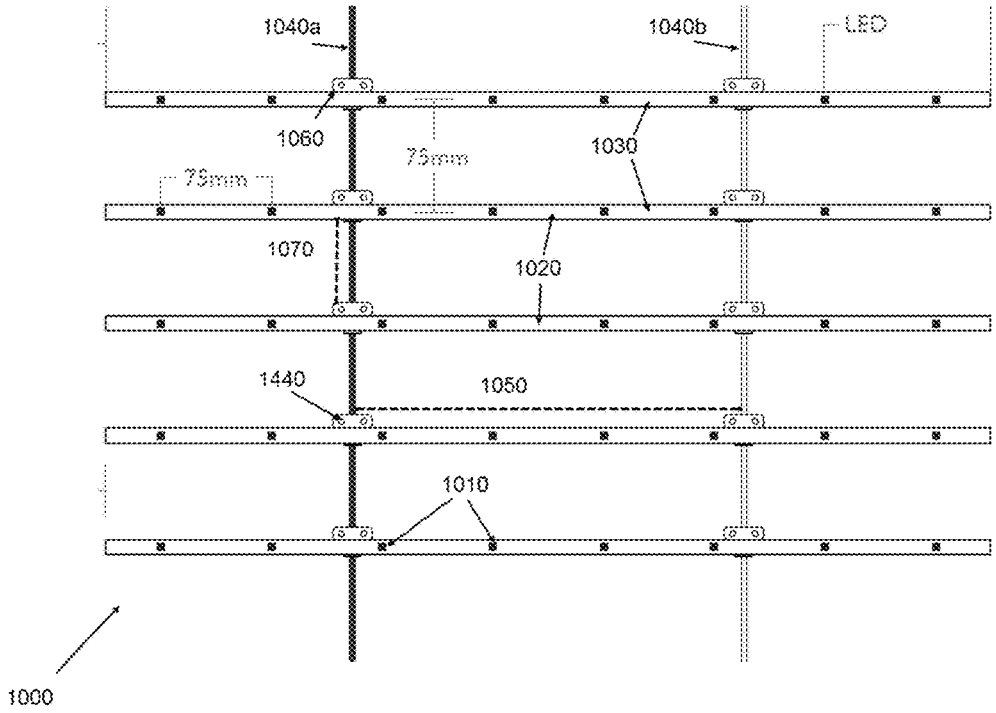

1040a
1040b
LED
1060
75mm
1030
75mm
1070
1020
1440
1050
1010
1000

FIG. 1

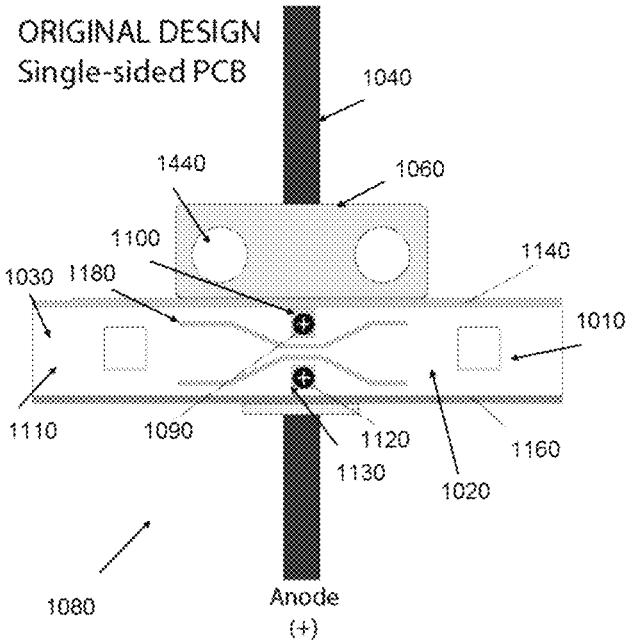

ORIGINAL DESIGN
Single-sided PCB
1040
1440
1060
1100
1140
1030
1180
1010
1110
1090
1120
1130
1160
1020
1080
Anode
(+)

FIG. 2A

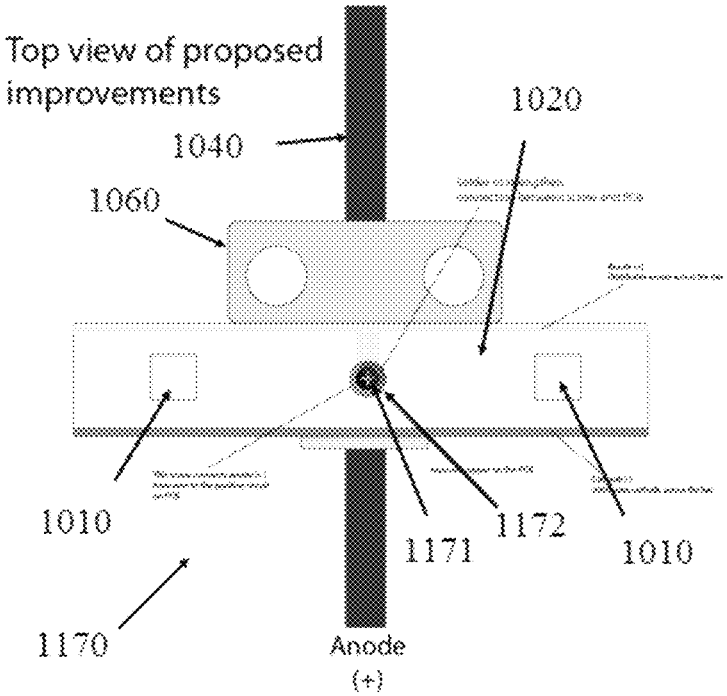

Top view of proposed
improvements
1020
1040
1060
1010
1171
1172
1010
1170
Anode
(+)

FIG. 2B

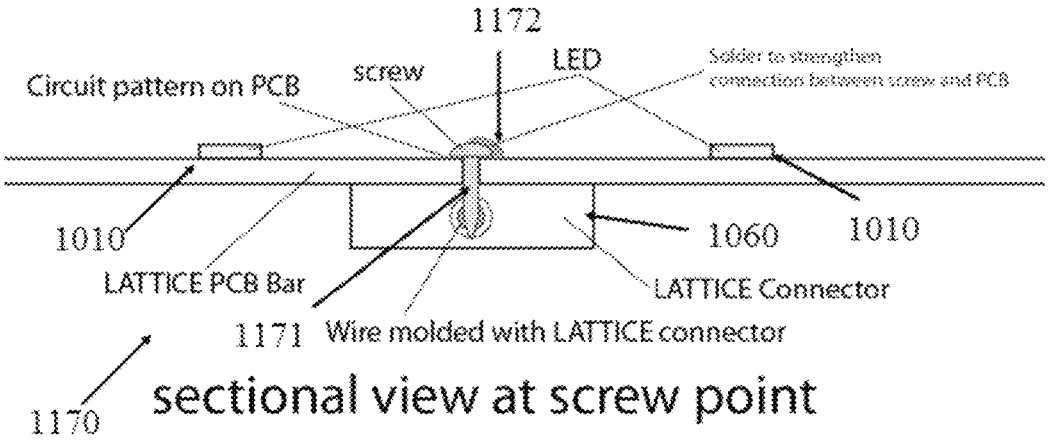

1172
Circuit pattern on PCB
screw
LED
Solder to strengthen connection between screw and PCB
1010
1060
1010
LATTICE PCB Bar
LATTICE Connector
1171
Wire molded with LATTICE connector
1170
sectional view at screw point

FIG. 2C

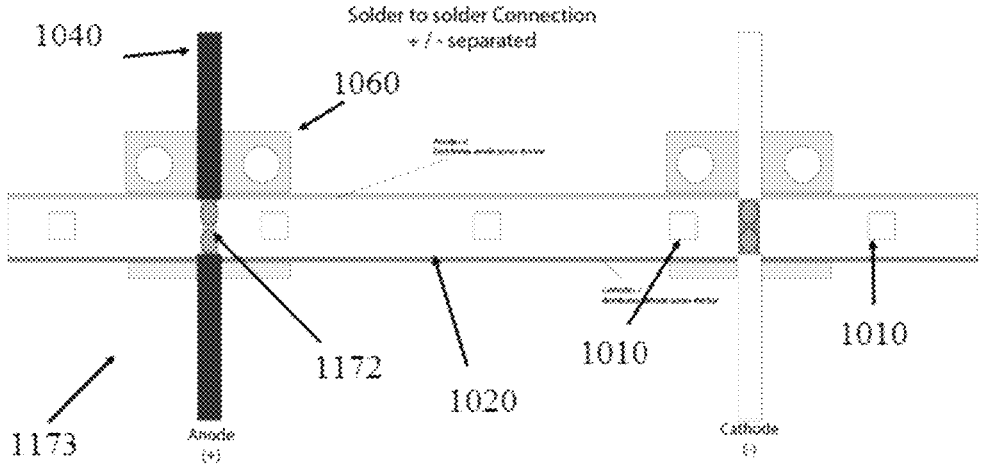

1040
Solder to solder Connection
+ / - separated
1060
1172
1020
1010
1010
1173
Anode
(+)
Cathode
(-)

FIG.2D

FIG. 3A

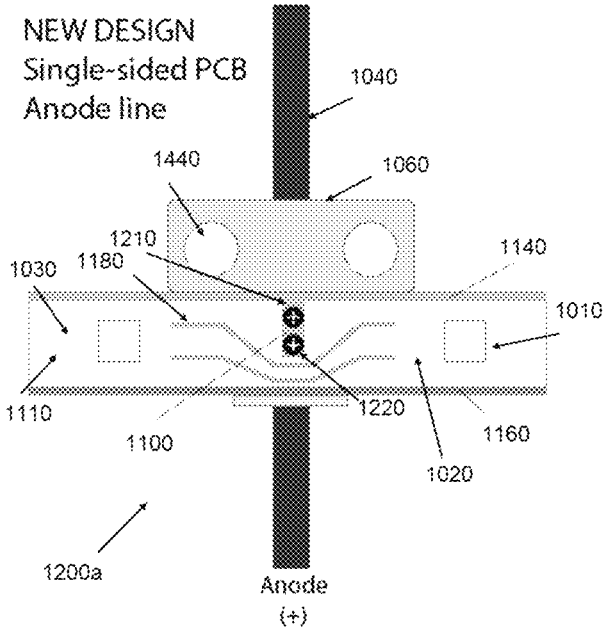

NEW DESIGN
Single-sided PCB
Anode line
1040
1440
1060
1210
1180
1030
1140
1010
1110
1100
1220
1160
1020
1200a
Anode
(+)

FIG. 3B

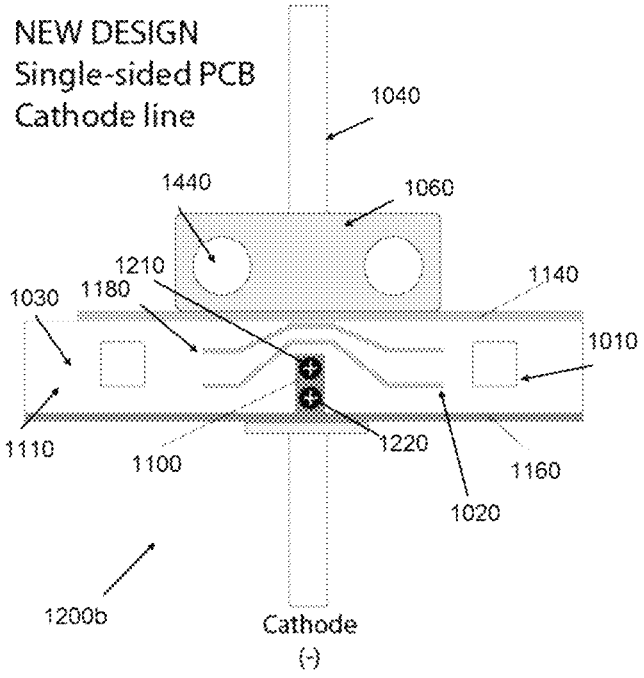

NEW DESIGN
Single-sided PCB
Cathode line
1040
1440
1060
1210
1180
1030
1140
1010
1110
1100
1220
1160
1020
1200b
Cathode
(-)

FIG. 4

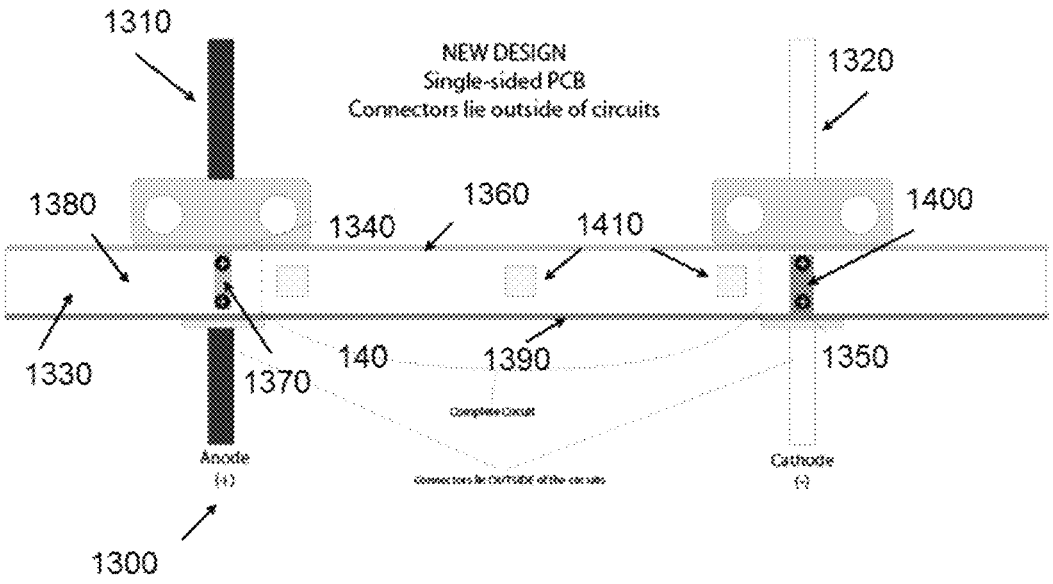

1310
NEW DESIGN
Single-sided PCB
Connectors lie outside of circuits
1320
1380
1340
1360
1410
1400
1330
1370
140
1390
1350
Anode
(+)
Cathode
(-)
1300

FIG. 5

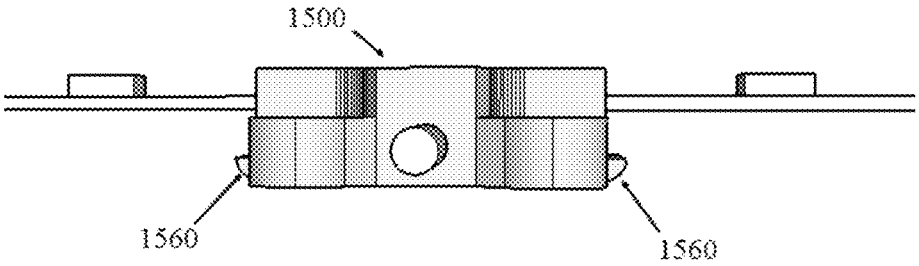


FIG. 6

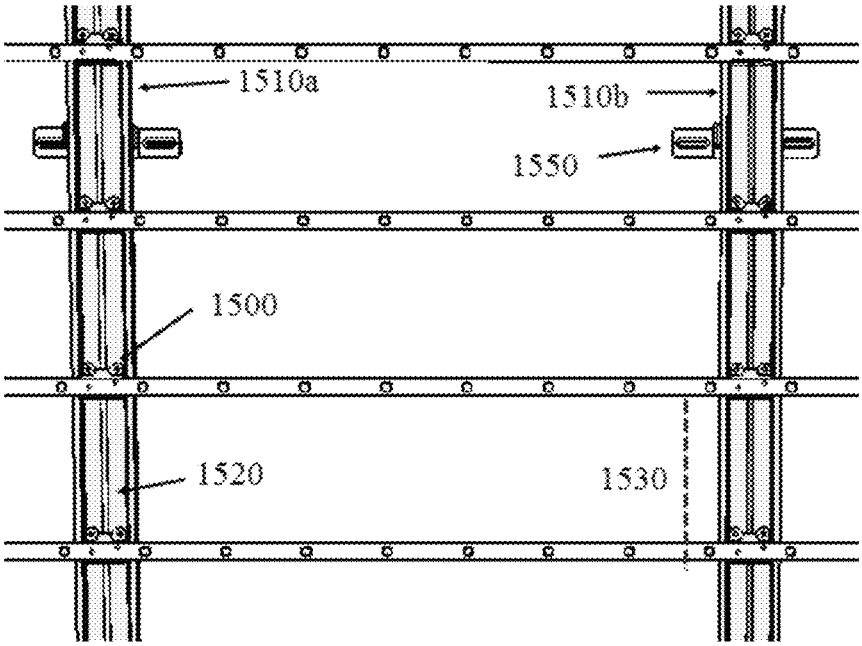


FIG. 7

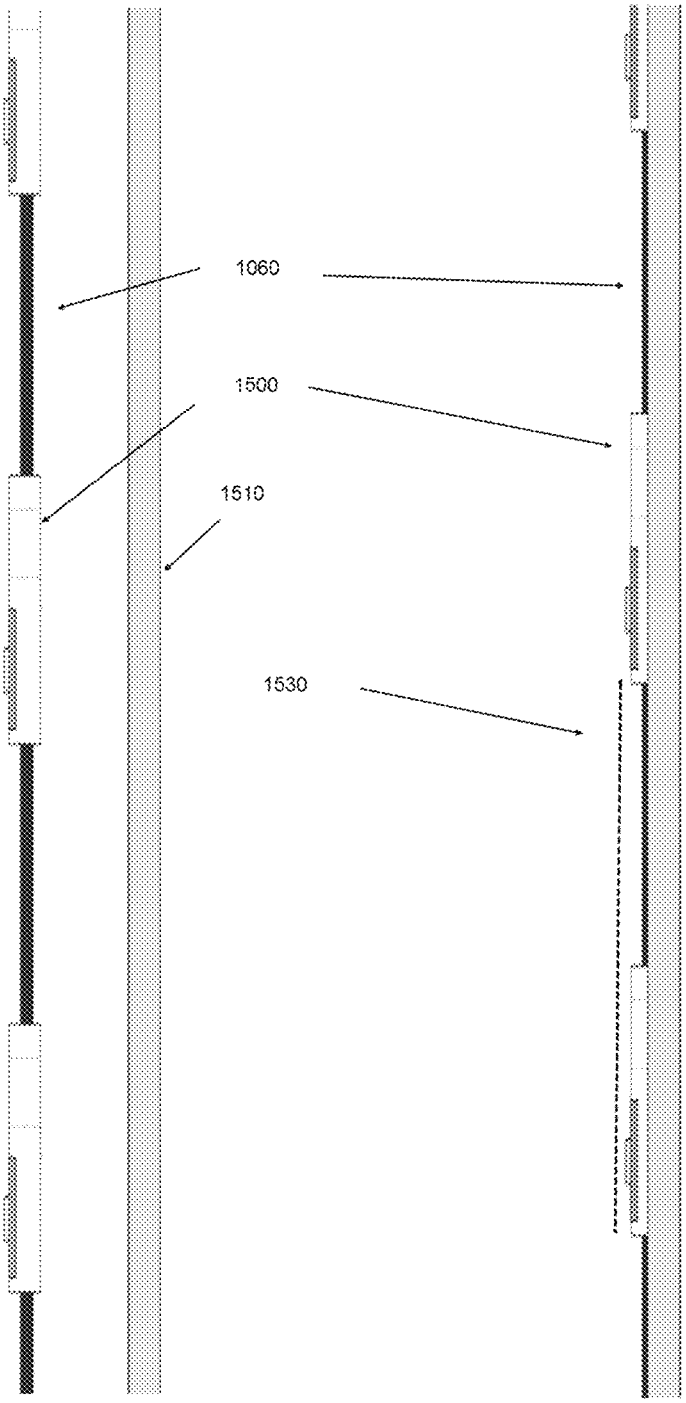


FIG. 8

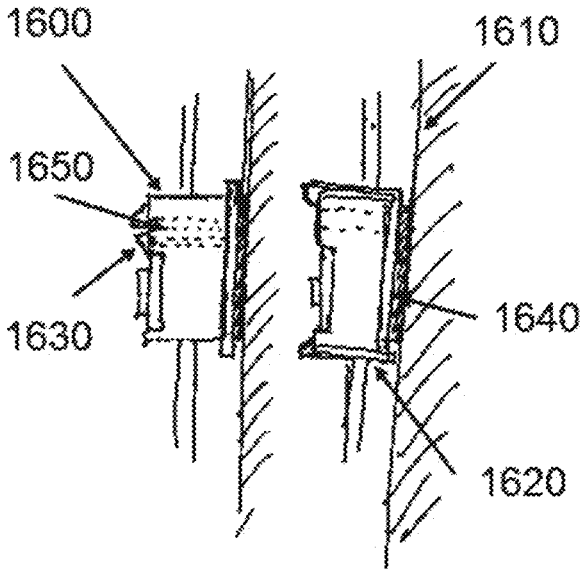


FIG. 9

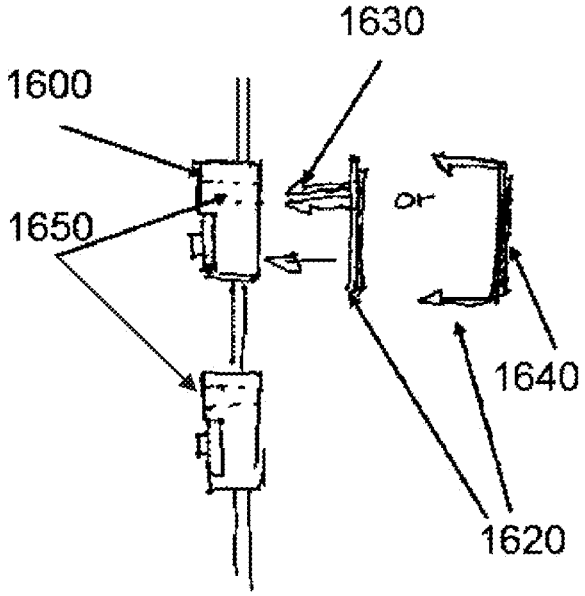


FIG. 10

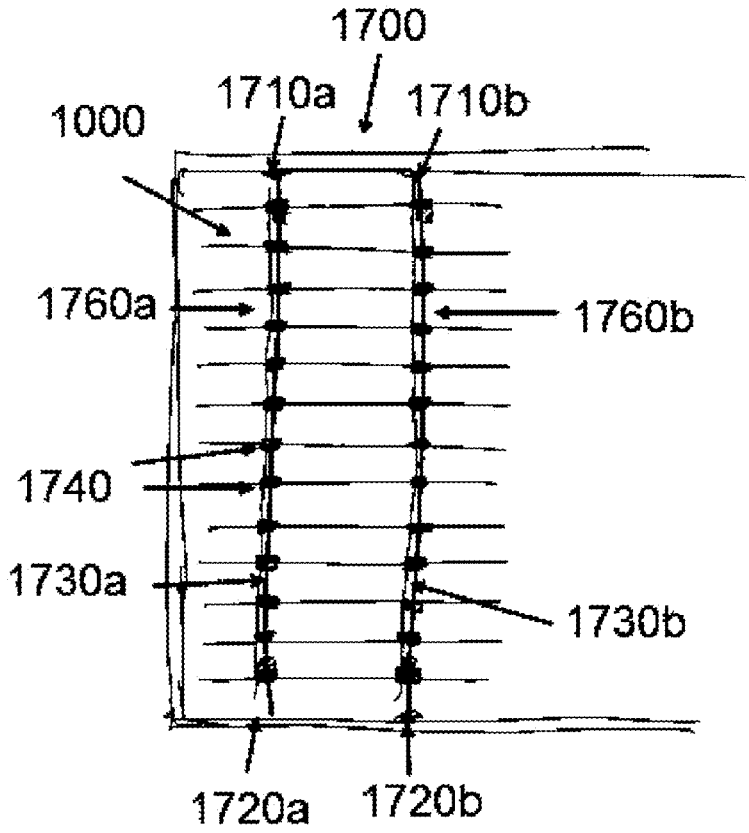

1700
1710a
1710b
1000
1760a
1760b
1740
1730a
1730b
1720a
1720b

FIG. 11A

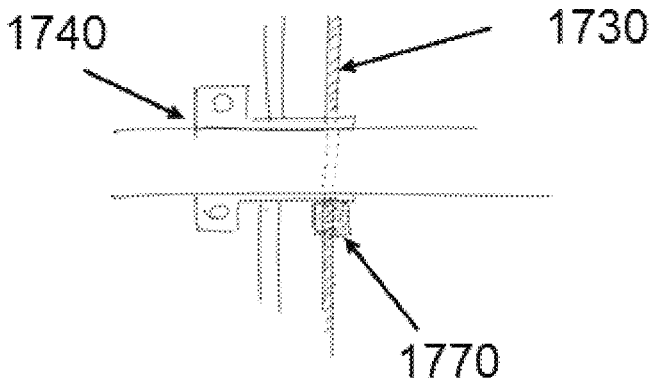


FIG. 11B

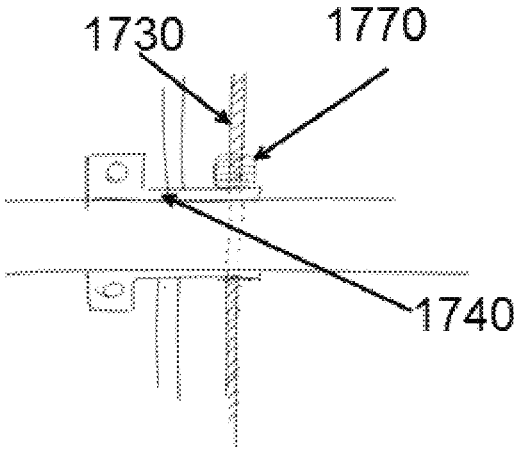


FIG. 11C

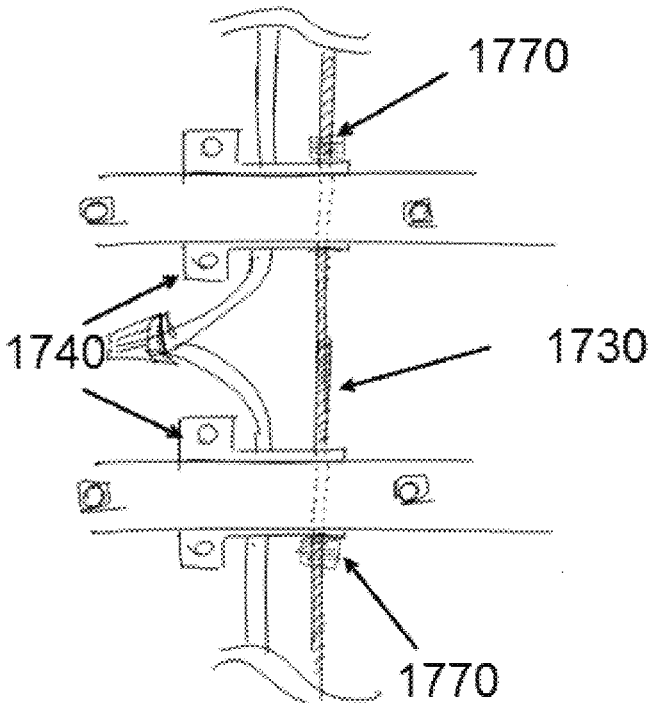


FIG. 12A

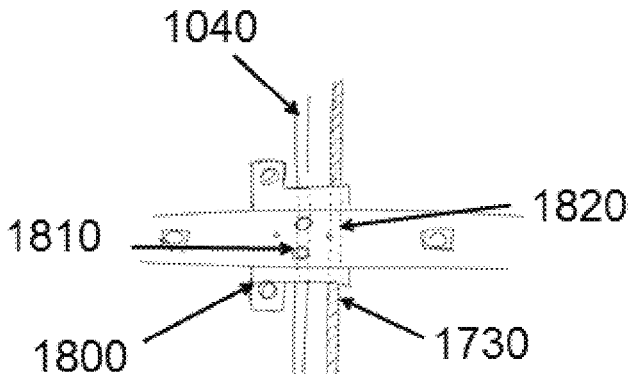


FIG. 12B

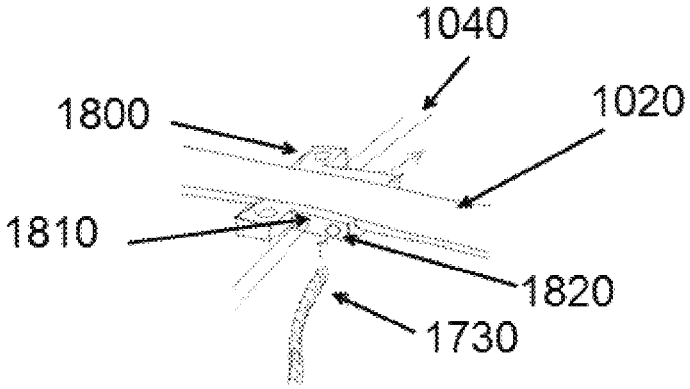


FIG. 13

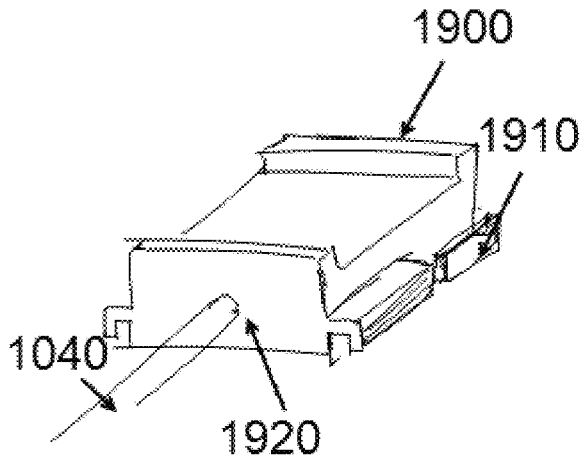


FIG. 14

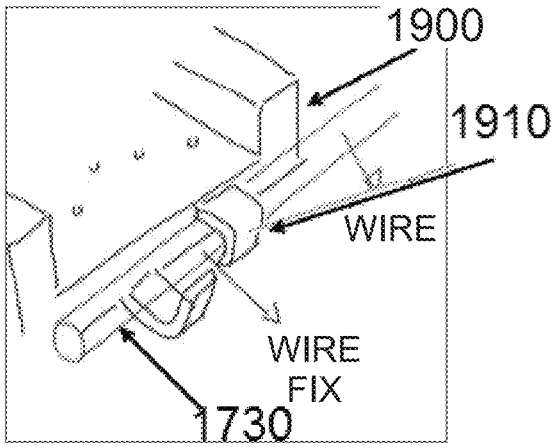


FIG. 15

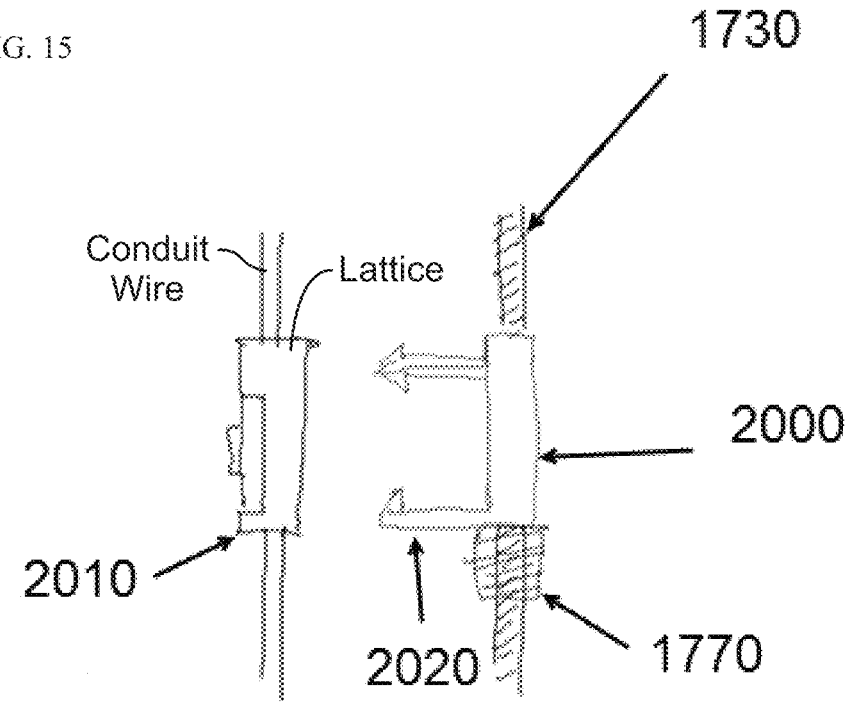


FIG. 16

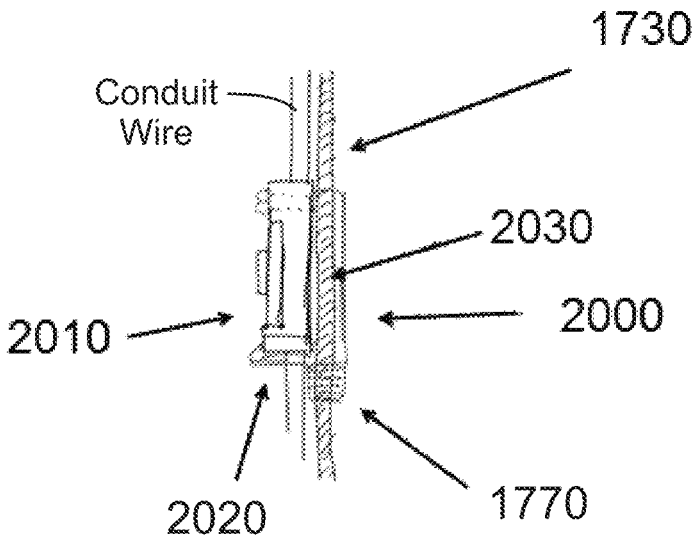


FIG. 17

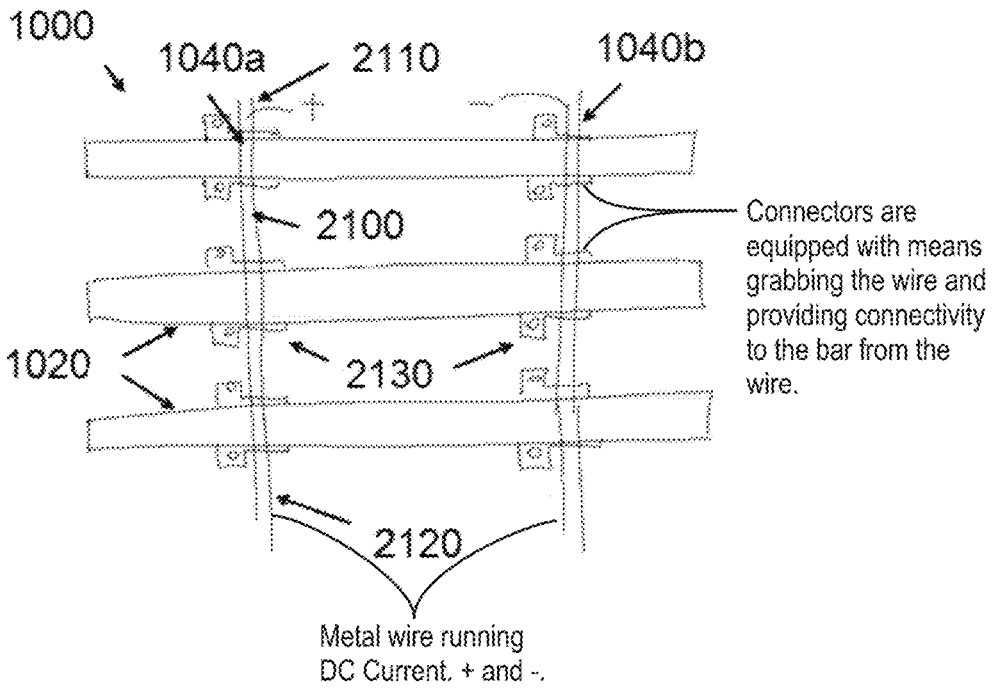

1000
1040a
2110
1040b
2100
Connectors are equipped with means grabbing the wire and providing connectivity to the bar from the wire.
1020
2130
2120
Metal wire running DC Current. + and -.

FIG. 18

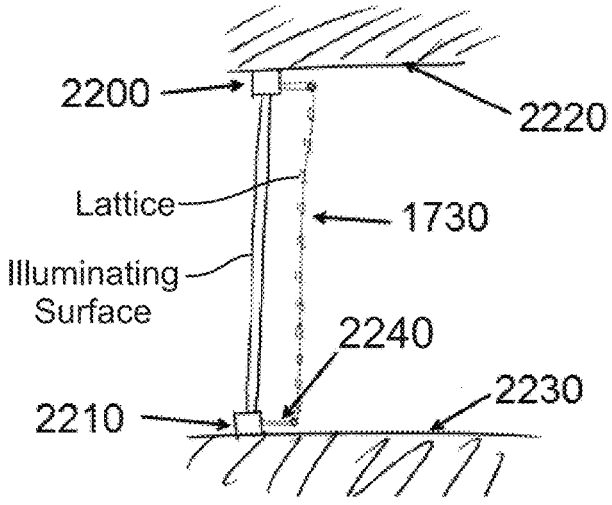

2200
2220
Lattice
1730
Illuminating Surface
2240
2230
2210

FIG. 19A

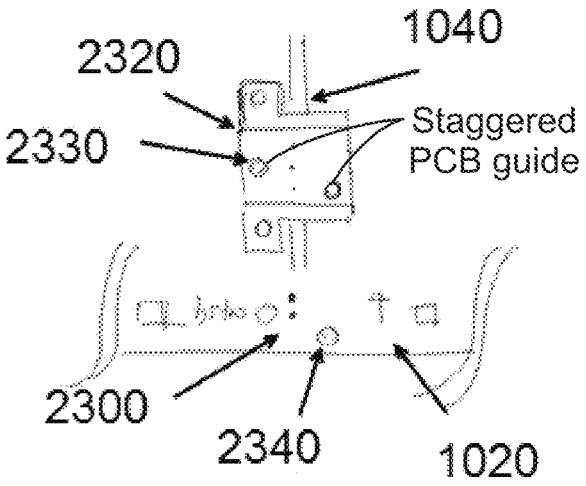


FIG. 19B

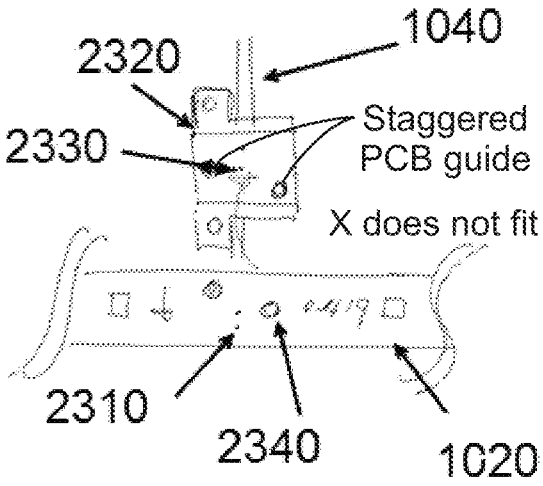


FIG. 20A

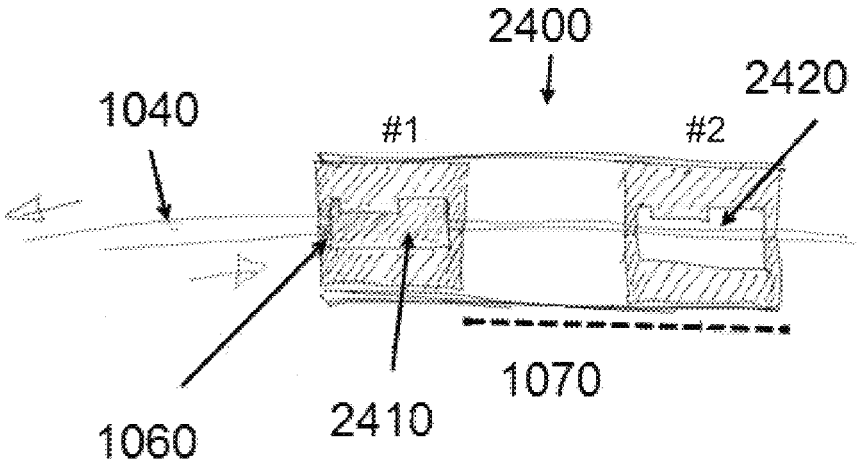


FIG. 20B

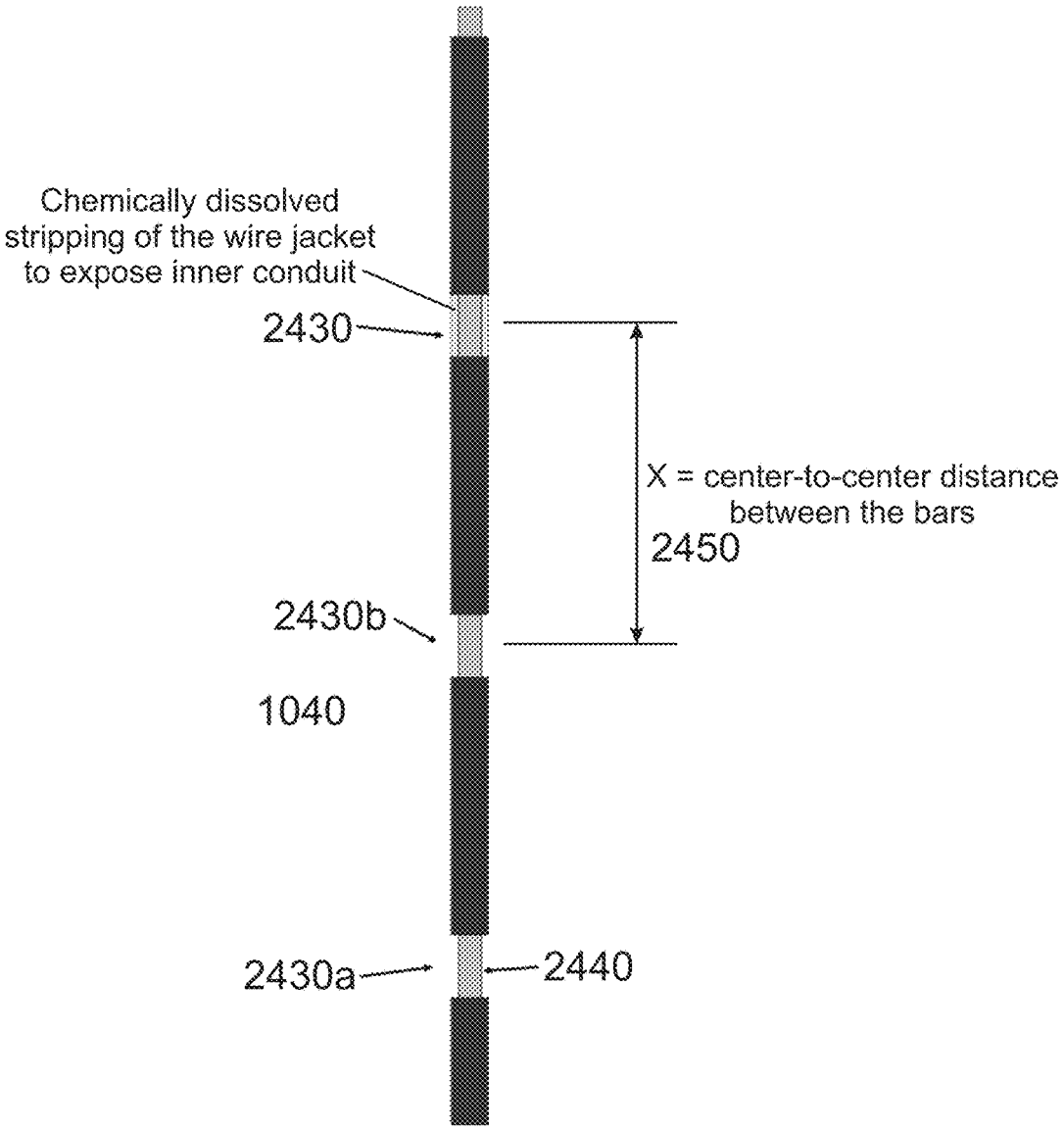

Chemically dissolved
stripping of the wire jacket
to expose inner conduit
2430
X = center-to-center distance
between the bars
2450
2430b
1040
2430a
2440

FIG. 20C

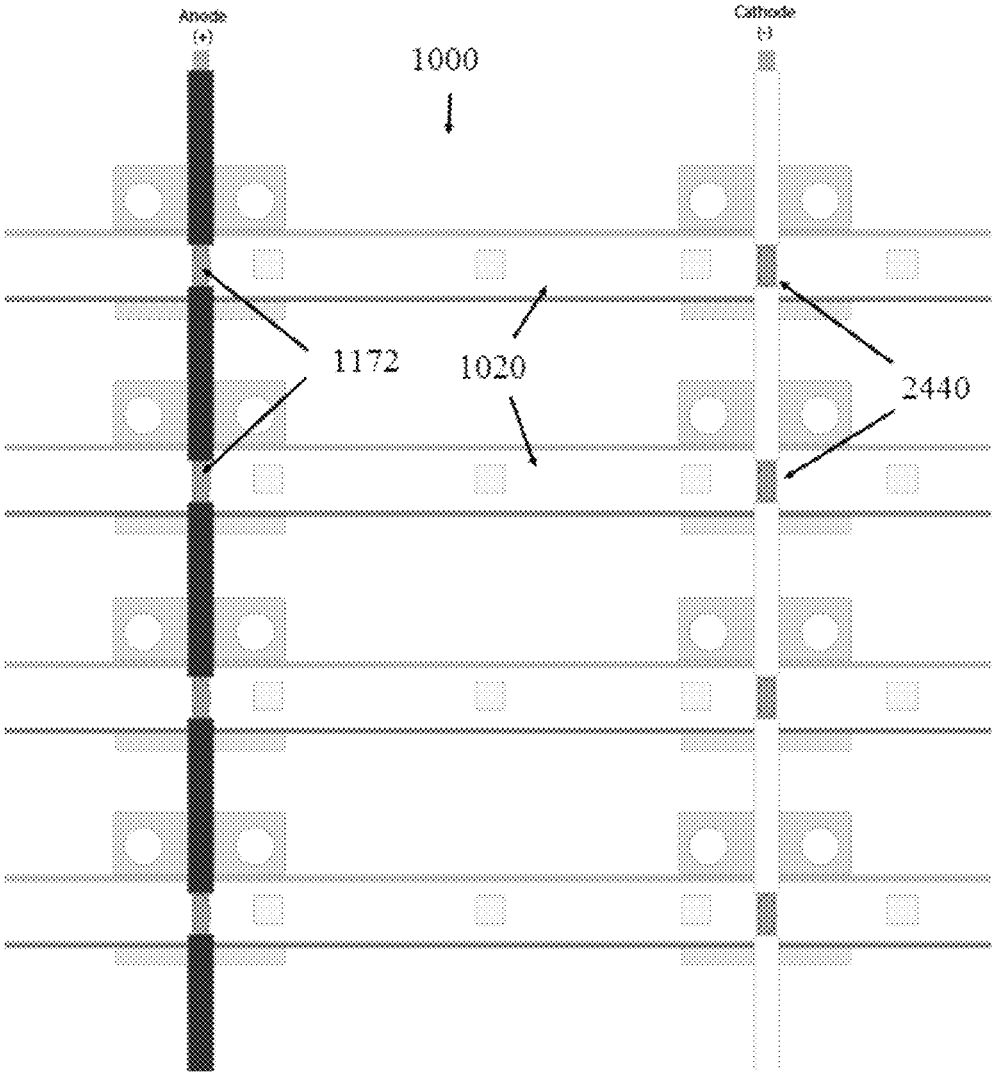


FIG. 21A

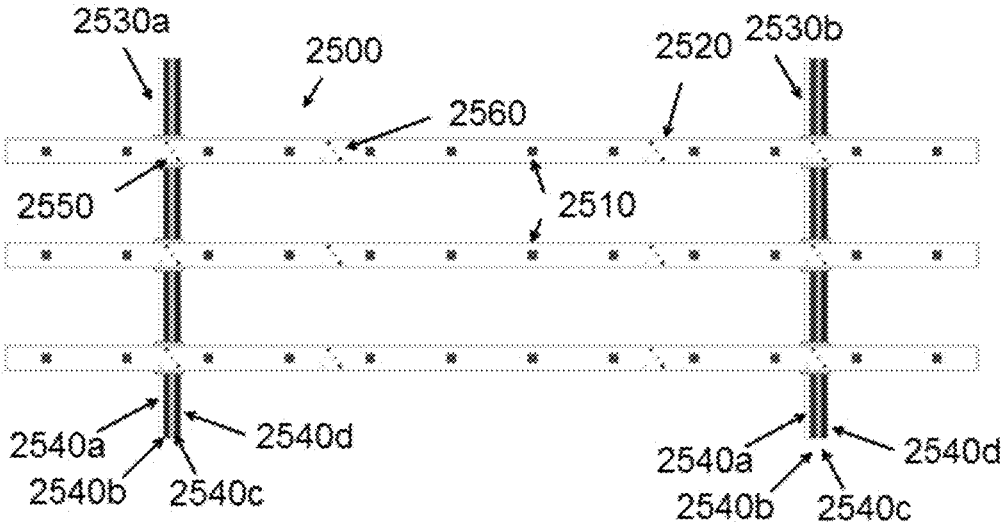


FIG. 21B

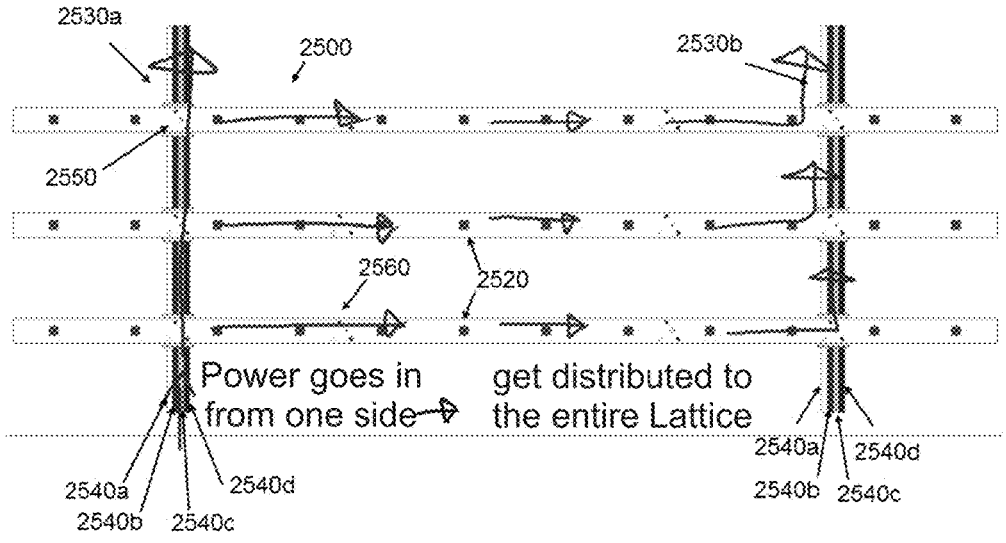


FIG. 21C

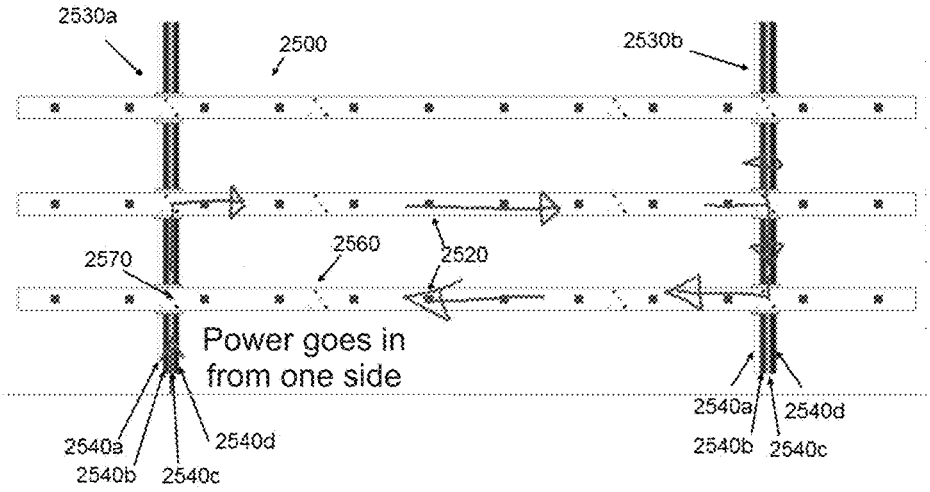


FIG. 22

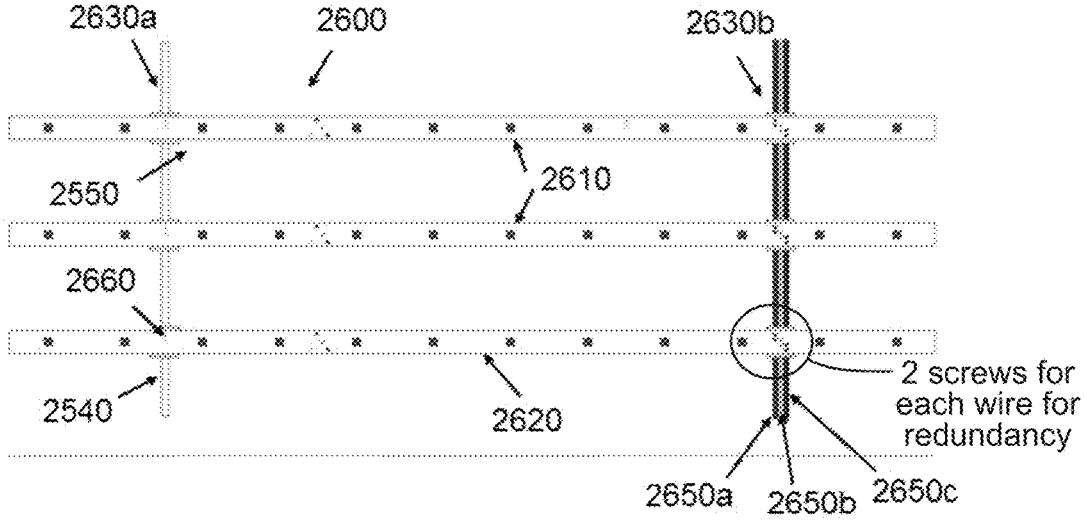


FIG. 23A

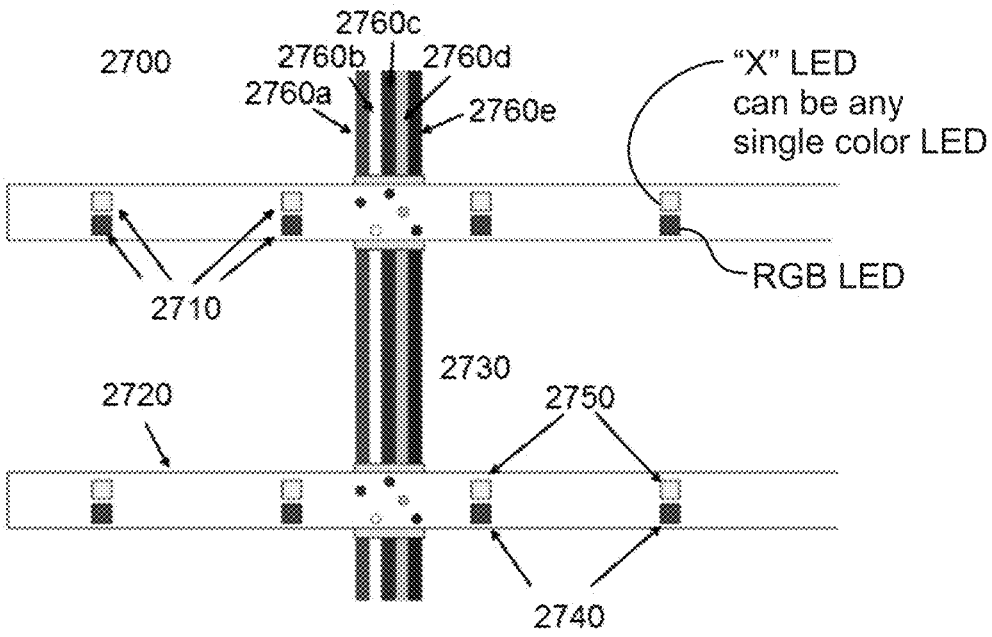


FIG. 23B

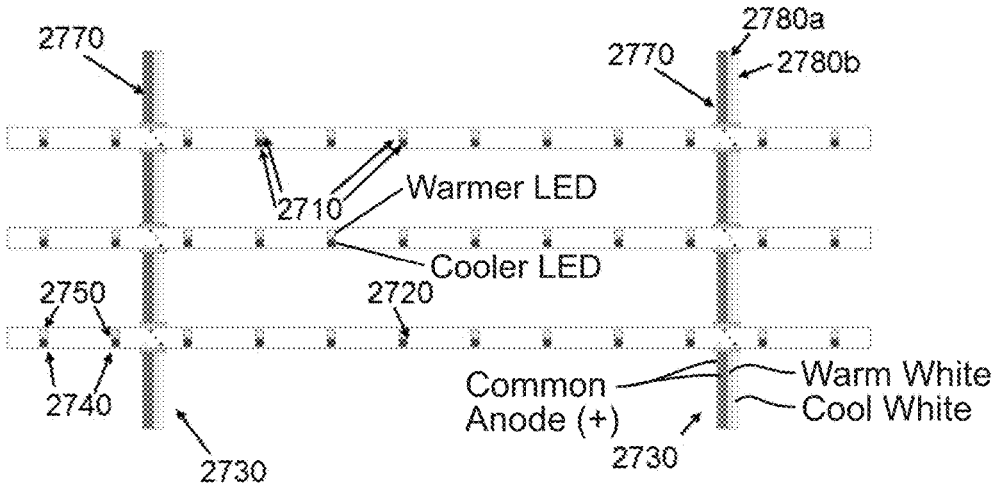


FIG. 23C

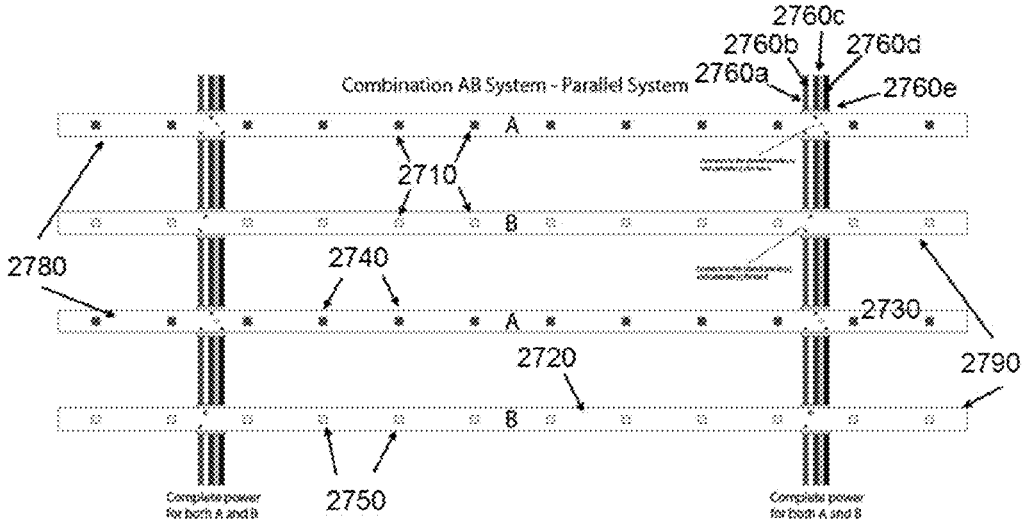

2760c
2760b
2760d
2760a
2760e
Combination A&B System - Parallel System
A
2710
B
2780
2740
A
2730
2720
2790
B
2750
Complete power for both A and B
Complete power for both A and B

FIG. 24A

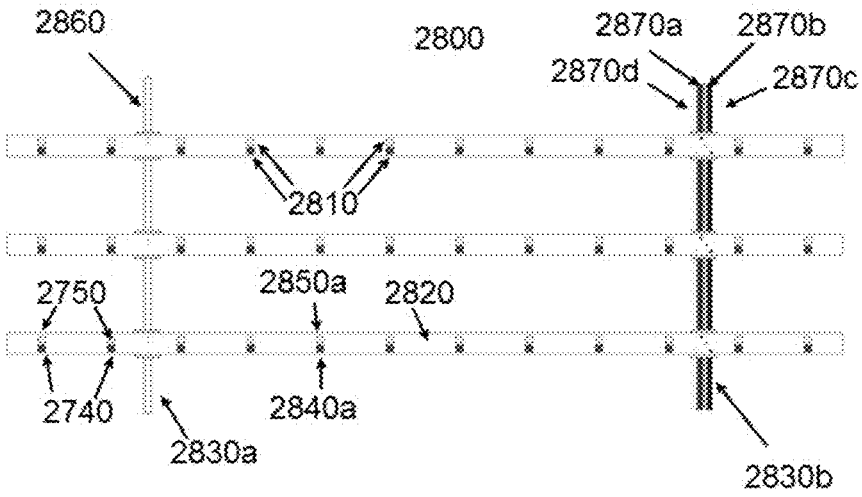


FIG. 24B

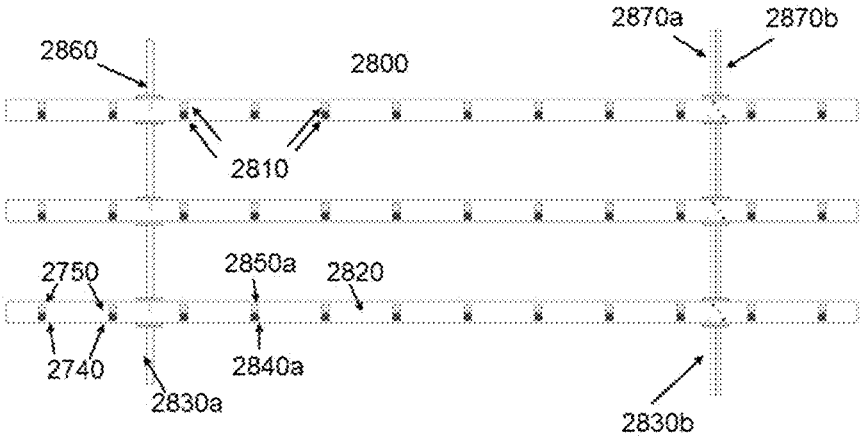


FIG. 24C

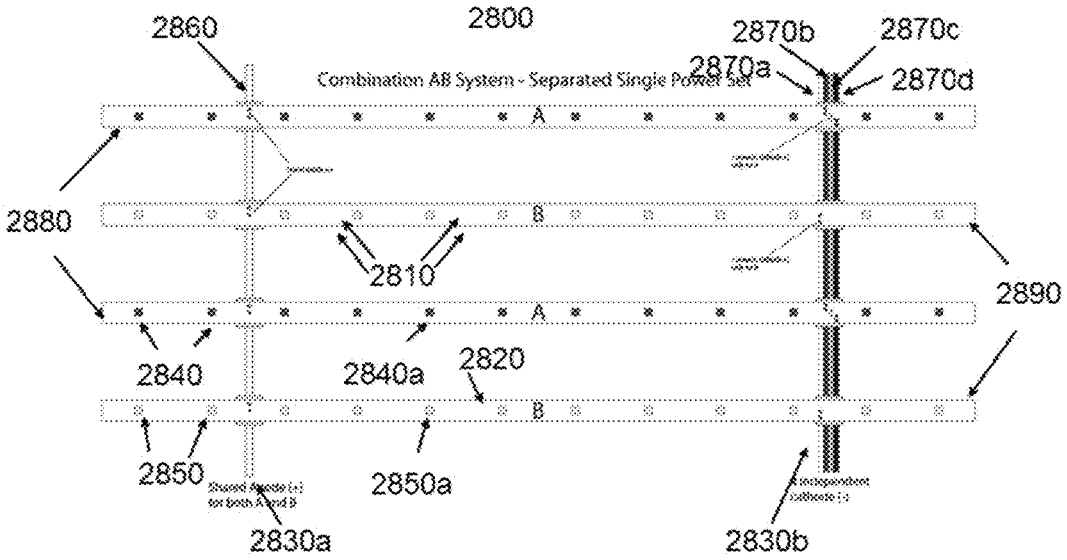


FIG. 24D

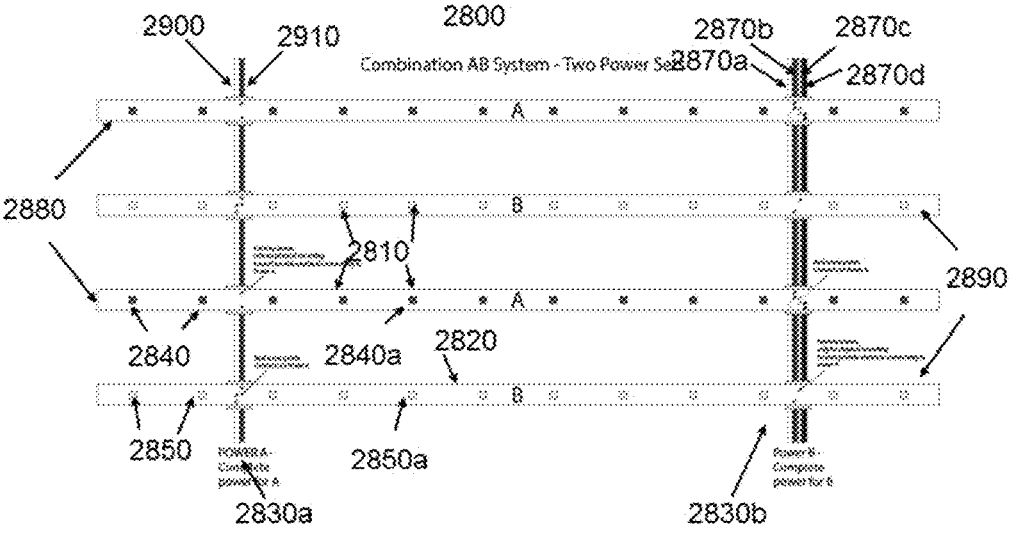


FIG. 25A

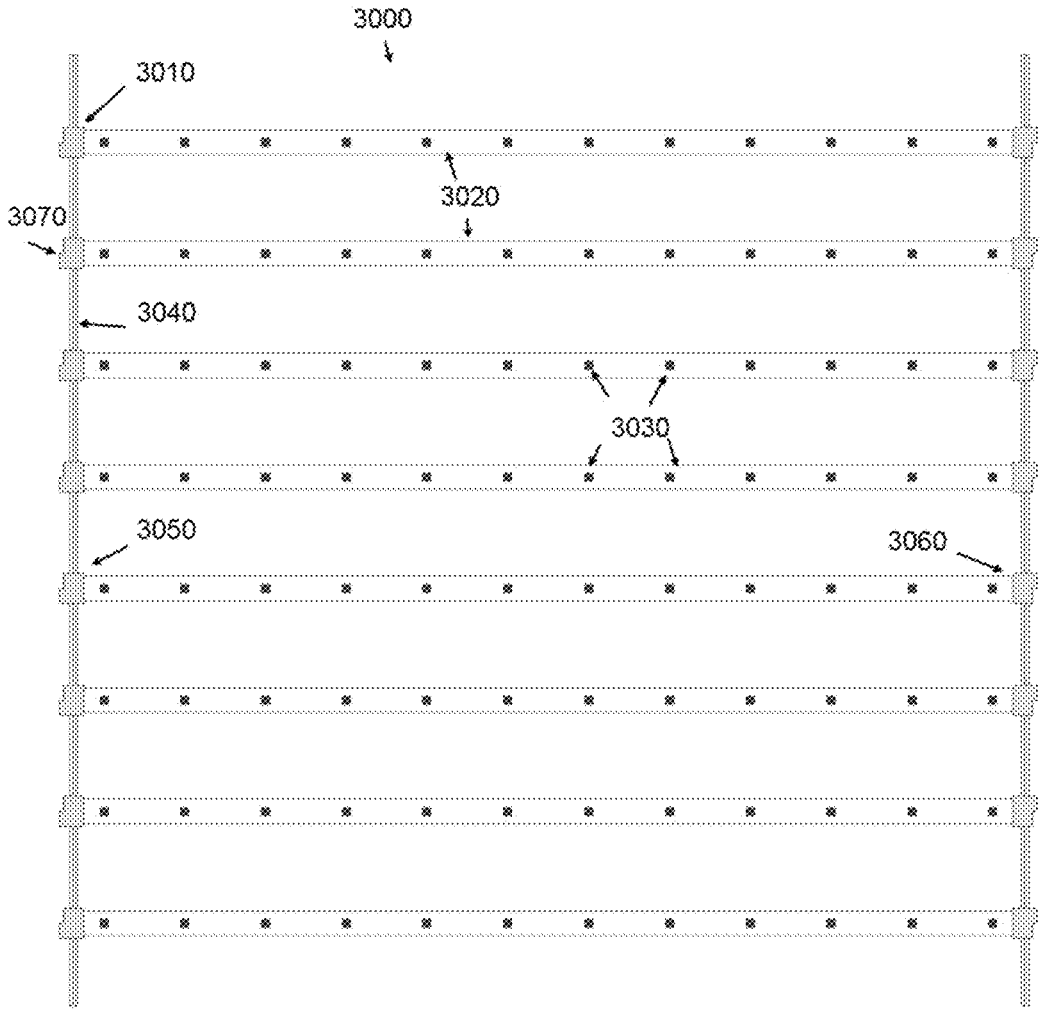


FIG. 25B

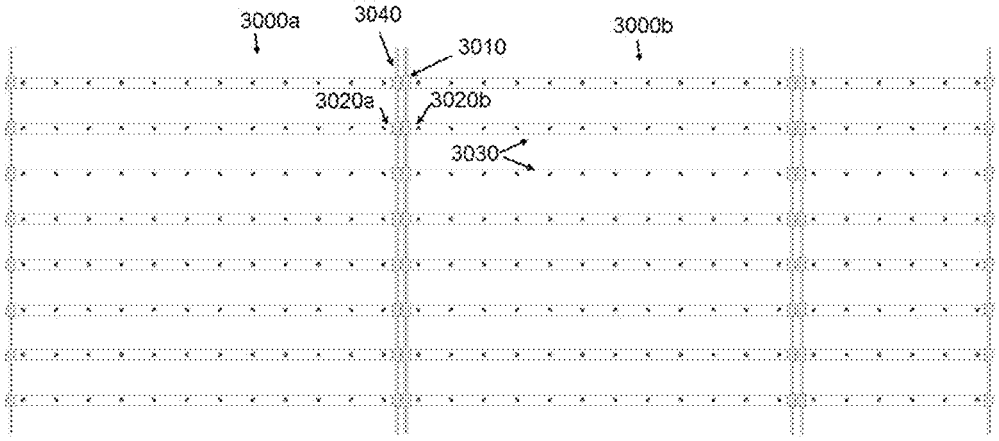


FIG. 25C

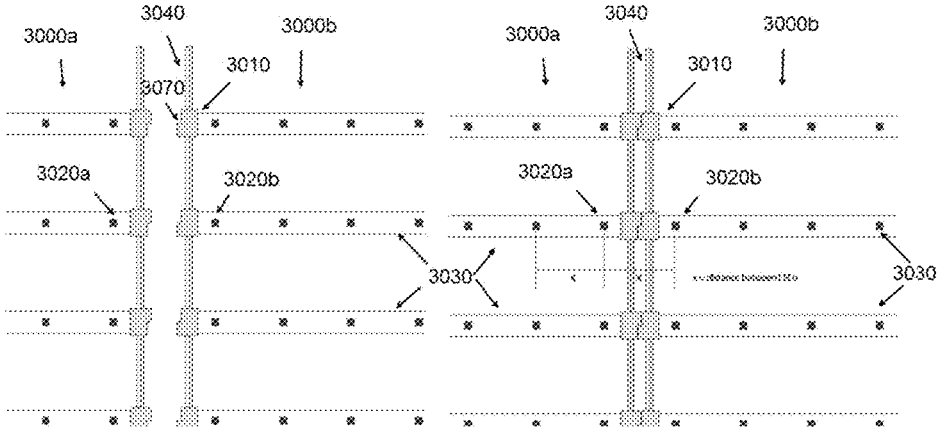


FIG. 26A

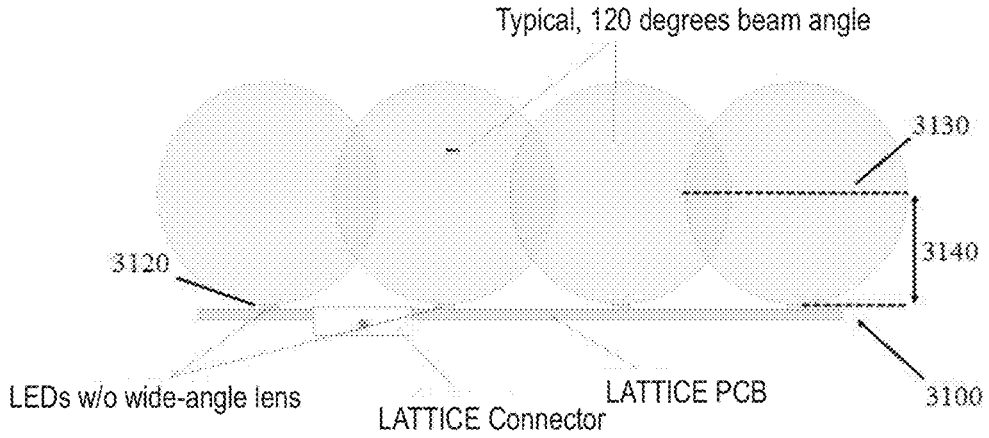


FIG. 26B

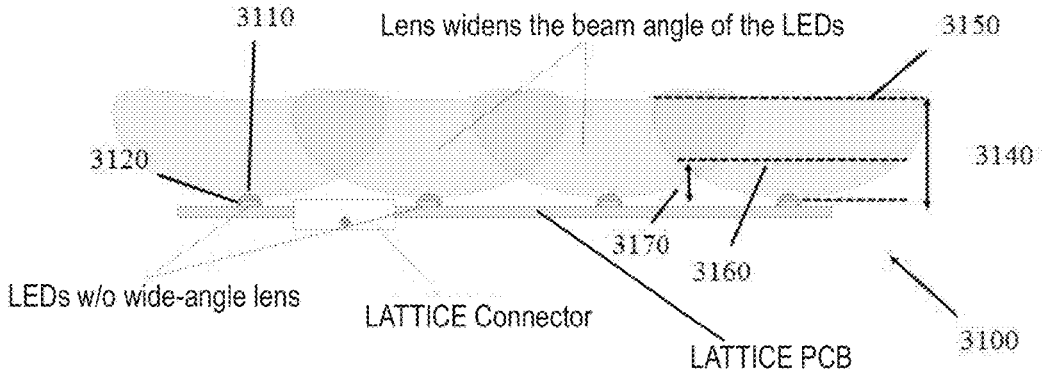


FIG. 27A

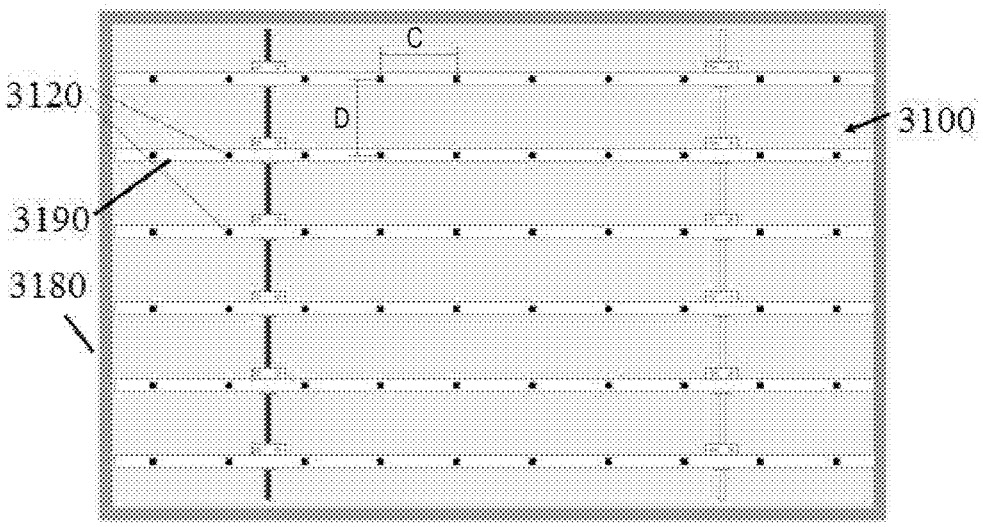


FIG. 27B

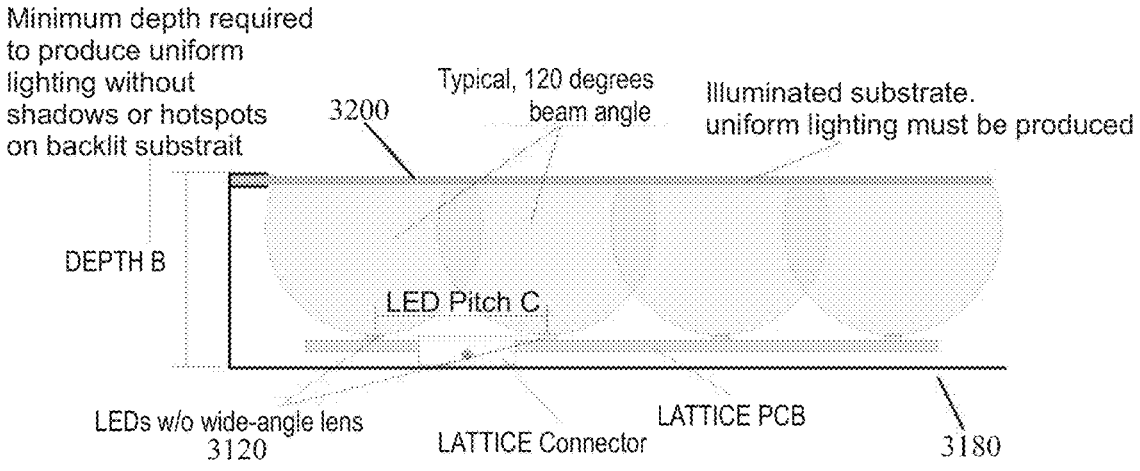


FIG. 27C

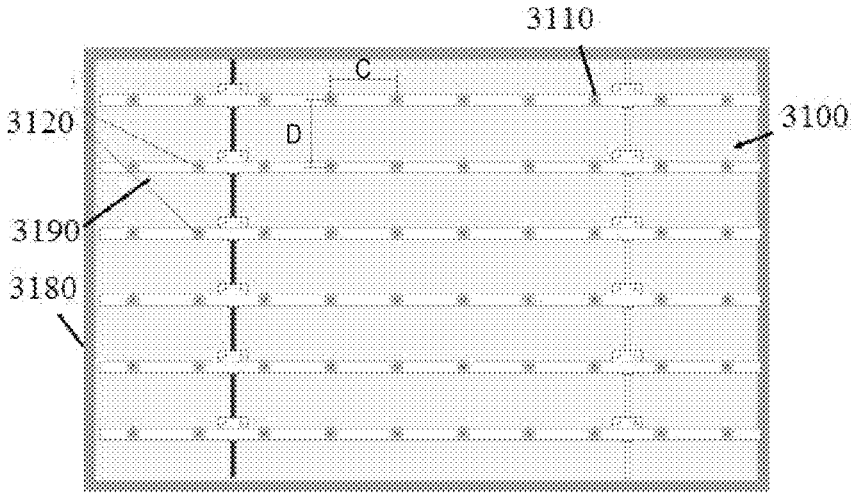


FIG. 27D

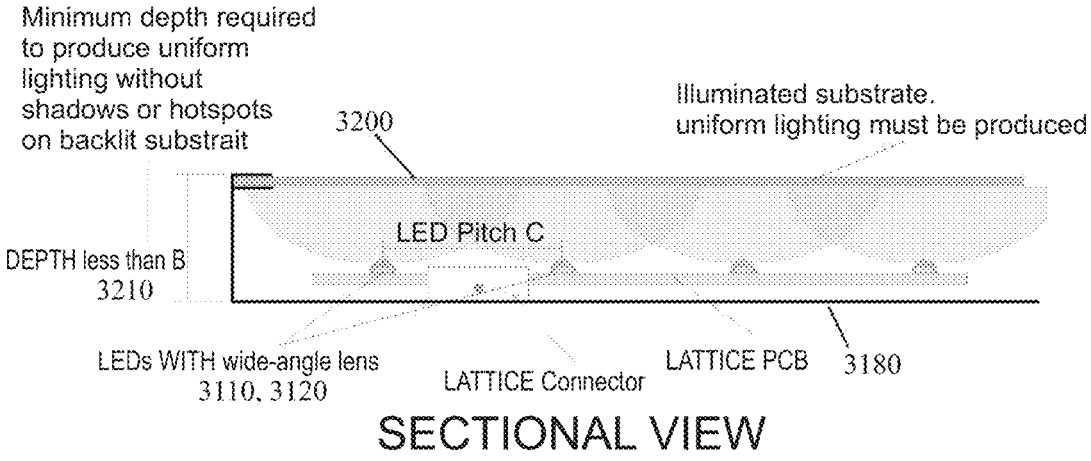


FIG. 27E

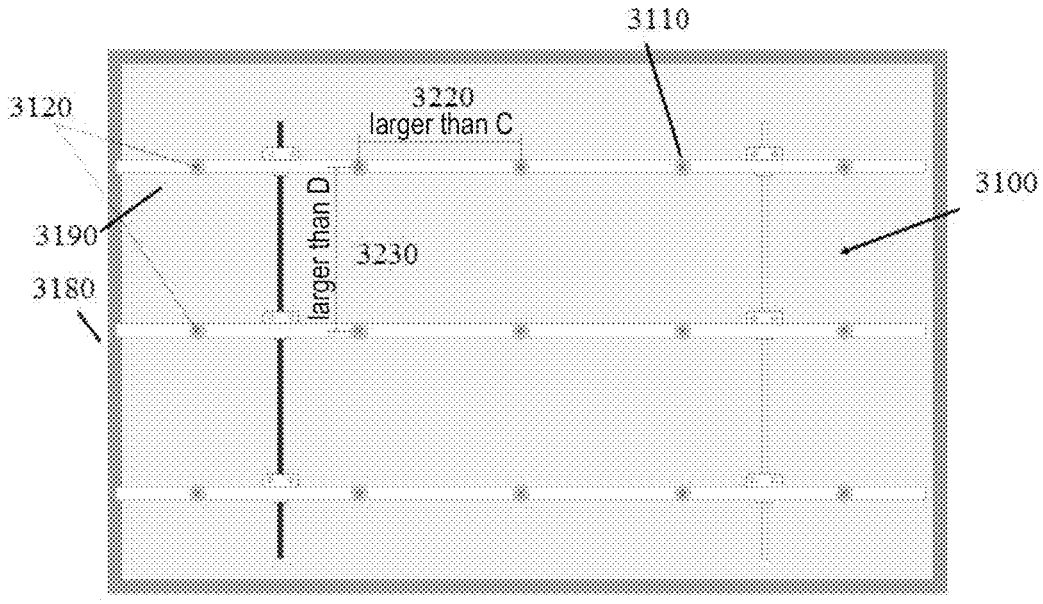


FIG. 27F

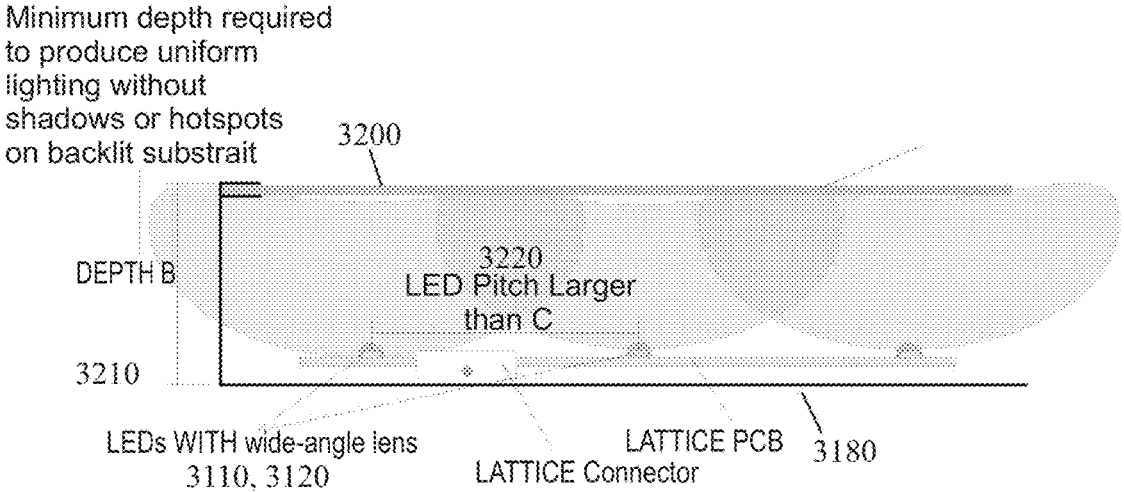


FIG. 28

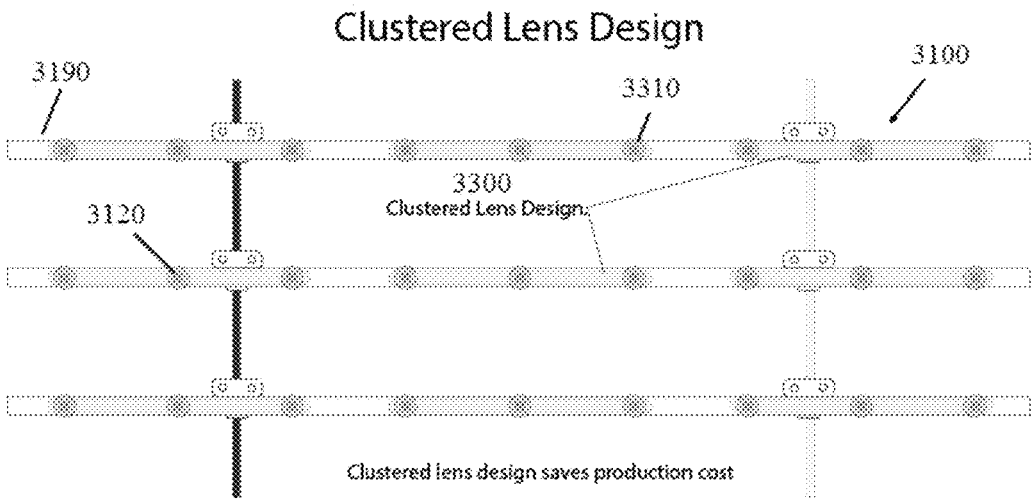
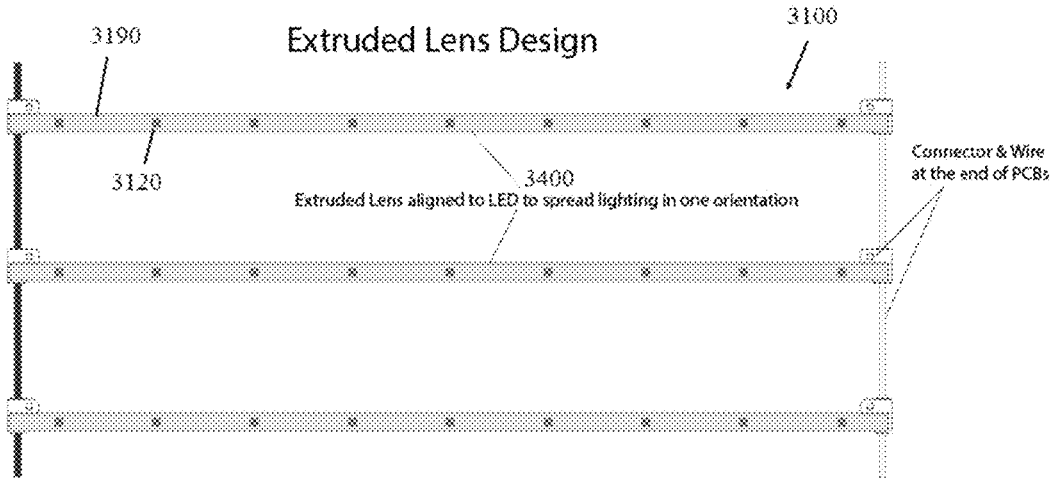

Clustered Lens Design
3190
3310
3100
3300
Clustered Lens Design
3120
Clustered lens design saves production cost

FIG. 29


3190
Extruded Lens Design
3100
3120
3400
Extruded Lens aligned to LED to spread lighting in one orientation
Connector & Wire
at the end of PCBs

LED MATRIX LIGHTING DEVICE

CROSS-REFERENCE TO RELATED APPLICATIONS

This application claims the benefit of U.S. Provisional Application No. 61/866,287, filed Aug. 15, 2013, the contents of which are incorporated by reference herein.

FIELD OF THE INVENTION

This disclosure relates to an LED matrix lighting device for providing substantially even lighting across a large area.

BACKGROUND

Often, it is desirable to evenly light a large surface area. This is required, for example, when backlighting a light box for displaying a poster or the like. Traditionally, these types of lighting applications have used fluorescent light bulbs or a large number of LED light sources fixed to a surface containing necessary circuitry. Fluorescent bulbs tend to light such surfaces unevenly, and existing LED assemblies require a substantial amount of material for fixing LED light sources and circuitry in place. Additionally, they are often resource intensive in terms of materials, installation, preparation, and fixation of electrical connections.

Some lightweight assemblies designed to address these issues exist, but contain issues with consistent production, quality control during assembly, and a lack of redundant electrical connections for securing electrical connectivity. Further, it is easy to make damaging mistakes during installation of such assemblies.

Existing assemblies are often limited to a single color of LED light sources. Further, existing assemblies are often difficult to install. Existing installation contingencies are limited, and installation therefore often requires substantial time and effort.

There is a need for a lightweight, easy to install LED lighting device that allows a user to easily place an array of LED light sources across a large area while providing even lighting. There is a further need that such an LED lighting device be robust, provide a variety of installation methods, allow for full color installations, and allow for consistent and efficient production.

SUMMARY

In one embodiment, there is provided a light emitting diode (LED) lighting device comprising a plurality of LED light sources disposed on multiple elongated circuit boards, with each LED light source being electrically connected to one of the circuit boards. The elongated circuit boards are electrically coupled using electrical passageways to provide power to the circuit boards at intervals along the length of the elongated circuit boards, and the light sources disposed on the circuit boards emit light in the same direction perpendicular to the elongated circuit boards. The electrical passageways can be wires or groups of wires.

The elongated circuit boards may be electrically coupled to the electrical passageways using electrically conductive screws, pins, or solder that passes through the circuit board and connects a portion of an electrically conductive layer to an electrical wire on the opposite side of a substrate of the circuit board.

The elongated circuit boards may be single sided printed circuit board (PCB) and may be provided with a first electrical passageway to provide an anode and a second electrical passageway to provide a cathode.

In some embodiments the electrical passageways are a plurality of wires for providing multiple cathodes or anodes for connecting to different LED light sources on different circuit boards, or for activating different colors in the LED light sources.

In some embodiments the LED lighting device further comprises mounting elements for fixing the electrical passageways to the elongated circuit boards, and for fixing the assembly to a wall, track, or tensioned cable for mounting.

In some embodiments, the LED lighting device is assembled using a jig to apply mounting elements to the elongated circuit boards at consistent intervals.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. **1** is a generic embodiment of a light emitting diode (LED) lighting device according to the disclosure.

FIGS. **2**A-D show segmented portions of embodiments of an LED lighting device according to the disclosure.

FIGS. **3**A-B show segmented portions and of an embodiment of an LED lighting device according to the disclosure.

FIG. **4** shows a segmented portion of an alternative embodiment of an LED lighting device according to the disclosure.

FIGS. **5-7** show a mounting element and associated mounting rails in accordance with one embodiment of the LED lighting device.

FIGS. **8-9** show alternative embodiments of mounting elements and systems for mounting the LED lighting device.

FIG. **10** shows a general view of further embodiments of a system for mounting the LED lighting device.

FIGS. **11**A-C show gripping accessories for use with the mounting system of FIG. **10**.

FIGS. **12**A-B show one embodiment of a mounting element configured to mount on a cable according to FIG. **10**.

FIGS. **13-14** show an alternate embodiment of a mounting element configured to mount on a cable according to FIG. **10**.

FIGS. **15-16** show a clip for gripping a mounting element designed to be mounted on a cable according to FIG. **10**.

FIG. **17** shows an embodiment of an LED lighting device that may be mounted by tensioning the electrical passageways of the device.

FIG. **18** illustrates an alternative embodiment of a tensioned LED lighting device having offset cable mounts.

FIGS. **19**A-B illustrate a mounting element containing an orientation element for preventing fixation to an inappropriate connection point.

FIGS. **20**A-C illustrate a jig and alternative production processes for consistently manufacturing LED lighting devices.

FIGS. **21**A-C illustrate additional embodiments of LED lighting devices.

FIG. **22** illustrates an additional embodiment of an LED lighting device.

FIGS. **23**A-C illustrate additional embodiments of LED lighting devices.

FIGS. **24**A-D illustrate additional embodiments of LED lighting devices.

FIGS. **25**A-C illustrate an LED lighting device having connectable mounting elements.

FIGS. **26**A-B illustrate top views of embodiments of LED lighting devices with and without wide angle lenses.

FIGS. **27**A-F illustrate the use of LED lighting devices in light boxes.

FIG. **28** illustrates an alternative embodiment of an LED lighting device with wide angle lenses.

FIG. **29** illustrates an alternative embodiment of an LED lighting device with wide angle lenses.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

The description of illustrative embodiments according to principles of certain embodiments is intended to be read in connection with the accompanying drawings, which are to be considered part of the entire written description. In the description of certain embodiments disclosed herein, any reference to direction or orientation is merely intended for convenience of description and is not intended in any way to limit the scope of the present invention. Relative terms such as "lower," "upper," "horizontal," "vertical," "above," "below," "up," "down," "top" and "bottom" as well as derivative thereof (e.g., "horizontally," "downwardly," "upwardly," etc.) should be construed to refer to the orientation as then described or as shown in the drawing under discussion. These relative terms are for convenience of description only and do not require that the apparatus be constructed or operated in a particular orientation unless explicitly indicated as such. Terms such as "attached," "affixed," "connected," "coupled," "interconnected," and similar refer to a relationship wherein structures are secured or attached to one another either directly or indirectly through intervening structures, as well as both movable or rigid attachments or relationships, unless expressly described otherwise. Moreover, the features and benefits of certain embodiments are illustrated by reference to the exemplified embodiments. Accordingly, every embodiment expressly should not be limited to such exemplary embodiments illustrating some possible non-limiting combination of features that may exist alone or in other combinations of features.

This disclosure describes the best mode or modes of practicing certain embodiments as presently contemplated. This description is not intended to be understood in a limiting sense, but provides examples solely for illustrative purposes by reference to the accompanying drawings to advise one of ordinary skill in the art of the advantages and construction of certain embodiments. In the various views of the drawings, like reference characters designate like or similar parts.

FIG. **1** shows a generic embodiment of a light emitting diode (LED) lighting device **1000**. The LED lighting device **1000** may be used to provide a plane of relatively even lighting, and may be placed, for example, within an LED light box to backlight a surface or image. Alternatively, the LED lighting device **1000** may be applied in any other situation where a substantially even distribution of light emitting diodes is desired.

The LED lighting device of the illustrated embodiment comprises a plurality of LED light sources **1010** disposed on two or more elongated circuit boards **1020**. Each LED light source **1010** is electrically connected to one of the two or more elongated circuit boards **1020**. In the embodiment shown, each LED light source **1010** is disposed on a surface **1030** of one of the two or more elongated circuit boards **1020**, and each LED light source **1010** distributes light in a direction substantially perpendicular to the surface **1030** on which it is disposed. The two or more elongated circuit boards **1020** are printed circuit boards (PCBs), with each of the PCBs electrically coupled to other PCBs by a plurality of electrical passageways **1040** at intervals **1050** along its length. Preferably, the elongated circuit boards **1020** have a width of 11 mm or less.

In the embodiment shown, the elongated circuit boards **1020** are electrically coupled by two electrical passageways **1040***a* and **1040***b*, each of which carries an electrical current or voltage and connects to circuitry on each elongated circuit board **1020** to which it is electrically coupled. In some embodiments, the LED lighting device comprises more than two elongated circuit boards **1020**, and the plurality of electrical passageways **1040** selectively electrically couples the elongated circuit boards **1020**, such that different electric currents or voltages are provided to different elongated circuit boards. In some embodiments, the electrical passageways **1040** carry a plurality of sub-passageways, such as individual wires, with different wires carrying different currents or voltages. In such embodiments, some elongated circuit boards **1020** may be selectively coupled to some sub-passageways but not others within each electrical passageway **1040**. Some such embodiments are discussed more fully below.

In certain embodiments each electrical passageway **1040** is mechanically coupled to each elongated circuit board **1020** at a mounting element **1060**, and each mounting element is configured to be either removably or permanently fixed to both an elongated circuit board **1020** and an electrical passageway **1040**. When assembled, mounting elements **1060** are fixed at locations at intervals **1050** along the length of each elongated circuit board **1020** and intervals **1070** along the length of each electrical passageway **1040**.

When assembled, the LED lighting device **1000** may provide LED light sources **1010** substantially evenly spaced across a grid, such that each LED light source, other than those at an end of an elongated circuit board **1020**, is equidistant from its neighboring LED light sources along the elongated circuit board. Similarly, each LED light source **1010** is the same distance from any neighboring LED light sources on a neighboring elongated circuit board **1020** to which the corresponding elongated circuit board is coupled to by an electrical passageway **1040**. In alternate embodiments, the distance between LED light sources **1010** on a single elongated circuit board **1020** is different than the distance between LED light sources **1010** on different elongated circuit boards.

FIG. **2**A shows a segmented portion **1080** of an embodiment of an LED lighting device **1000**. Two LED light sources **1010** are shown on a segment of a single elongated circuit board **1020** with a single electrical passageway **1040** connected to the elongated circuit board **1020** at a mounting element **1060**. Also shown are two connections **1090**, **1120** between the elongated circuit board **1020**, the electrical passageway **1040**, and the mounting element **1060**.

A first screw **1090** is both an electrical and mechanical connection, fixing the mounting element **1060** mechanically to the elongated circuit board **1020** and electrically to the electrical passageway **1040**. In a preferred embodiment, the first screw **1090** is of an electrically conductive material, such as a conductive metal, and is in electrical contact with both the electrical passageway **1040** and a first portion **1100** of an electrically conductive layer **1110** on the elongated circuit board **1020**. It will be understood that the electrical and mechanical connections need not be a screw, but may be any other element or groupings of elements, such as clips, welds, or other connections that may combine to connect the electrical passageway **1040** mechanically and electrically to the elongated circuit board **1020**.

A second screw **1120** fixes the mounting element **1060** mechanically to the elongated circuit board **1020**. In the embodiment shown, the second screw **1120** is connected in a similar fashion as the first screw **1100**, and electrically connects the electrical passage **1040** to a second portion **1130** of the electrically conductive layer **1100**. It will be understood that this electrical connection is unnecessary, and that other embodiments may not contain such a connection. Similarly, the screw may be replaced by other elements that can mechanically fix the elongated circuit board **1020** to the mounting element **1060**. In other embodiments, a second screw **1120** is unnecessary, and the stability of the segment **1080** of the LED lighting device **1000** may be ensured by the first screw **1090** or any fixation elements replacing the first screw or second screw.

Circuitry **1180** (shown only generally) is disposed on, or near, the surface **1030** of the elongated circuit board **1020** and lies between a parallel anode **1140** and cathode **1160**. The circuitry may be a third portion of the electrically conductive layer **1110** of the elongated circuit board **1020**.

The electronic circuit board **1020** of the embodiment is a single sided PCB, having a single electrically conductive layer **1110**. The circuitry **1180** electrically connects the anode **1140**, each of the LED light sources **1010** on the surface **1030** of the elongated circuit board **1020**, and the cathode **1160**. Current may then flow from the anode **1140** through the LED light sources **1010** and to the cathode **1160** to provide power to the LED light sources. In the embodiment shown, the circuitry **1180** may pass between the first screw **1090** and the second screw **1110**, such that a single circuit may power all LED light sources **1010** along the length of the elongated circuit board **1020**. Such a single circuit may be provided with redundancies, and may connect to the Anode and Cathode in multiple places.

It will be understood that while the segment **1080** shown illustrates the connection between the elongated circuit board **1020** and the electrical passageway **1040** and provides a positive current or voltage to the anode **1140**, a separate segment of such an embodiment may have equivalent circuitry such that an electrical connection is made to the cathode **1160**.

FIGS. **2**B-C show a segmented portion **1170** of an alternative embodiment of the LED lighting device **1000**. Two LED light sources **1010** are shown on a segment of a single elongated circuit board **1020** with a single electrical passageway **1040** connected to the elongated circuit board at a mounting element **1060**. In the embodiment shown, a single screw **1171** provides both electrical and mechanical connections to the elongated circuit board **1020**. Instead of reinforcing the mechanical connection with a second screw, the connection is reinforced by applying solder **1172** on top of and around the edge of the screw. This strengthens the mechanical connection and renders it permanent, and can provide electrical redundancy in the connection between the screw and the circuitry on the surface of the elongated circuit board **1020** as well.

The connections shown in FIGS. **2**B-C can be implemented in a single connection as shown, or solder **1172** can be used to reinforce a variety of embodiments of the LED lighting device **1000**, including when multiple screws are used for each connection.

FIG. **2**D shows a segmented portion **1173** of an alternative embodiment of the LED lighting device **1000**. In the embodiment shown, solder **1172** is used in place of screws as both an electrical and mechanical connection. In these embodiments, solder **1172** may be applied using through-hole soldering techniques or other solder-to-solder methods. These methods may be applied to various configurations of the LED lighting device **1000**, including those discussed below, to connect any number of wires at each electrical passageway in the assembly.

In these embodiments, a plastic cover can be placed on top of the PCB and the solder points to protect and cover the solder points. Silicone, epoxy, and other conformal materials can be used to create weather protection around the solder points.

FIGS. **3**A and **3**B show segmented portions **1200**A and **1200**B of an embodiment of an LED lighting device **1000**. As in the embodiment of FIG. **2**A, there are two connections, a third screw **1210**, and a fourth screw **1220** between the elongated circuit board **1020**, the electrical passageway **1040**, and the mounting element **1060**.

The embodiment shown differs from that of FIG. **2**A, in that the screws **1210**, **1220** are both electrical and mechanical connections, fixing the elongated circuit board **1020** mechanically to the mounting element **1060** and electrically to the electrical passageway **1040**. In a preferred embodiment, the screws **1210**, **1220** are both of an electrically conductive material, such as a conductive metal, and are in electrical contact with both the electrical passageway **1040** and a first portion **1100** of an electrically conductive layer **1110** on the elongated circuit board **1020**.

Because both screws **1210**, **1220** are in electrical contact with the electrical passageway **1040**, an electrical redundancy is formed such that if either of the connections formed using the screws **1210**, **1220** are broken, a secondary connection remains. The first portion **1100** of the electrically conductive layer **1110** is electrically connected to the anode **1140** or cathode **1160**, providing a positive or negative current or voltage to circuitry **1180**. It will be understood that while segment **1200**A illustrates the connection between the elongated circuit board **1020** and the electrical passageway **1040** and provides a positive current or voltage to the anode **1140**, a separate segment **1200**B of the embodiment will have equivalent circuitry such that an electrical connection is made to the cathode **1160**.

As in the embodiment of FIG. **2**A, Circuitry **1180** is disposed on, or near, the surface **1030** of the elongated circuit board **1020** and lies between the parallel anode **1140** and cathode **1160**.

The electronic circuit board **1020** of the embodiment is a single sided PCB, having a single electrically conductive layer **1110**. The circuitry **1180** electrically connects the anode **1140**, each of the LED light sources **1010** on the surface **1030** of the elongated circuit board **1020**, and the cathode **1160**. Current may then flow from the anode **1140** through the LED light sources **1010** and to the cathode **1160** to provide power to the LED light sources. In the embodiment shown, the circuitry **1180** may pass between the pair of screws **1210**, **1220**, and the cathode **1160**, such that a single circuit may power all LED light sources **1010** along the length of the elongated circuit board **1020**. Similarly, where an electrical connection is made between an electrical passageway **1040** and a cathode **1160**, the circuitry may pass between an equivalent pair of screws and the anode **1140**. Such a single circuit may be provided with redundancies, and may connect to the Anode **1140** and Cathode **1160** in multiple places.

FIG. **4** shows a segmented portion **1300** of an alternative embodiment of an LED lighting device **1000**. The segmented portion **1300** includes a first electrical passageway **1310** and a second electrical passageway **1320** fixed to an elongated circuit board **1330** by a first pair of screws **1340** and a second pair of screws **1350** respectively. The first pair

of screws **1340** provides a current or voltage to an anode **1360** by electrically connecting the first electrical passageway **1310** to a first portion **1370** of a conducting layer **1380**. The second pair of screws **1350** electrically connects a cathode **1390** to the second electrical passageway **1320** via a second portion **1400** of the conducting layer.

In the embodiment shown, three LED light sources **1410** are disposed on a surface **1420** of the elongated circuit board **1330**, and are powered by circuitry (not shown) disposed on or near the surface of the elongated circuit board. The elongated circuit board is a single sided PCB, with all circuitry providing power to the LED light sources **1410** lying on or near the surface of the PCB between the anode **1360**, the cathode **1390**, the first portion **1370** of the conducting layer **1380** and the second portion **1400** of the conducting layer.

The device of FIG. **1** incorporates mounting elements **1060** for mounting the LED lighting device **1000**. The mounting elements **1060** are fixed, either permanently or removably, to the elongated circuit boards **1020** at regular intervals along the length of each elongated circuit board, and are fixed at regular intervals **1050** along the length of each electrical passageway **1040** at regular intervals **1070** Using the mounting elements **1060**, the device **1000** may be fixed using nails or screws or other fixation devices to fix the mounting elements to a surface external to the device at the mounting holes **1440** in the mounting element. In some embodiments, rather than using the mounting holes **1440**, the mounting elements **1060** are fixed to the surface using an adhesive fixed to the back surface of the mounting element, or some other fixation device. Additional details related to mounting the LED lighting device **1000** using the mounting elements are provided in FIGS. **5-19**.

FIGS. **5-7** show a mounting element **1500** and an associated at least two mounting rails **1510** in accordance with one embodiment of the LED lighting device. The mounting rails **1510** provide a track **1520** for engaging each of the mounting elements **1500**. Each mounting rail **1510** may be, for example, a strip of extruded material, such as metal. Alternatively, the mounting rails **1510** may be molded, or formed by some other manufacturing process. The mounting rails **1510** may, for example, be extruded as a single strip and then cut to length for a specific application.

Each mounting rail **1510** may contain a channel for retaining the individual mounting elements, which may, for example, have a T shaped cross-section, with the T formed by a back surface, two side walls extending from the back surface, and two front surfaces extending from the two side surfaces respectively. The channel may then securely retain some portion of the mounting elements **1500** such that a remaining portion of the mounting element may extend from between the two front surfaces (forming the leg of the T shaped cross section) and be fixed to the elongated circuit boards **1020**.

In some embodiments, the mounting elements **1500** may contain connectors, or wings **1540**, designed to be retained by the cross section of the channel of the mounting rails **1510**.

Each mounting rail **1510** may contain a single channel running the length of the rail. Installation of such a system may then be performed by first mounting a pair of mounting rails **1510** substantially parallel to each other on an external surface using, for example, mounting holes in the rail **1510** or wall mounts **1550** mounted on the rails. Alternatively, the mounting rails **1510** may be installed using alternative fixation elements or adhesives, much as the mounting elements **1060** of earlier embodiments were mounted. Once both mounting rails **1510** are installed, at least two elongated circuit boards **1020**, each of which have at least two mounting elements **1500** having wings **1540** are provided. The mounting elements **1500** are then inserted consecutively into the channels of the two mounting rails **1510** such that the wings **1540** are retained by the T shaped cross section of each channel and such that electrical passageways **1040** linking the mounting elements **1500** are substantially parallel to the corresponding channel. Once installed, the mounting elements **1500** are retained at intervals **1530** along the electrical passageways **1040** within the channels, and each of the elongated circuit boards **1020** is maintained substantially perpendicular to the two mounting rails **1510** and substantially parallel to each other.

In some embodiments, there are gaps in the two front surfaces of each mounting rail **1510** such that mounting elements **1500** may be inserted at the gaps and shifted such that they are retained by the channels. Mounting rails may then be installed parallel to each other such that each mounting rail **1510** has gaps at corresponding locations. The gaps may be at the intervals **1070** along the electrical passageway **1040**, and the mounting elements may then be installed by simultaneously inserting each mounting element into a corresponding gap and shifting the entire assembly slightly such that each mounting element is retained by the channels.

It will be understood that various installation procedures may be applied for installing the mounting rails and the remainder of the LED lighting device **1000**. An installer may, for example, first insert mounting elements within the channels of the mounting rails and then later mount the mounting rails on an external surface.

FIGS. **8** and **9** show alternative embodiments of mounting elements **1600** and systems for mounting the LED lighting device on an external surface **1610**. In the embodiments shown, a plurality of clips **1620** are provided, and are configured with at least one tab **1630** for engaging with one of mounting elements **1600** and at least one fixation surface **1640** for fixing to the external surface **1610** in any of the manners discussed above in reference to the mounting elements **1060**. Each clip **1620** may then be fixed to external surface **1610** at the fixation surface **1640** prior to mounting the rest of the LED lighting device **1000**. Once mounted, each clip **1620** may then be mated to a corresponding mounting element **1600** at the at least one tab **1630**. The tabs **1630** may be spring loaded tabs for grasping outer edges of the mounting elements **1600**, or alternatively, may be spring loaded tabs for mating with a mounting hole **1650** of the corresponding mounting element **1600**.

It will be understood that other arrangements may be provided for fixing the mounting elements **1600** to the clips **1620** provided. In some embodiments, the LED lighting device **1000** may be provided with fewer clips **1620** than mounting elements **1600**, and only certain mounting elements may require fixation to clips in order to securely mount the device **1000**. The device **1000** may, for example, be mounted only at extremities of the LED lighting device in embodiments where more than two elongated circuit boards **1020** are provided and/or more than two mounting elements **1600** are provided for each elongated circuit board **1020**.

FIG. **10** shows a general view of further embodiments of a system **1700** for mounting the LED lighting device **1000** that will be described in more detail in FIGS. **11-18**. The system shown comprises at least one top cable mount **1710** fixed to a top fixation point on a surface external to the mounting system **1700**, at least one bottom cable mount

1720 fixed to a bottom fixation point on a surface external to the mounting system, and cables 1730 for tensioning, with each cable running from a top cable mount to a bottom cable mount. As shown, a set of elongated circuit boards 1020, each of which has mounting elements 1740 at regular intervals, are connected with electrical passageways 1750 (each element shown schematically only). When arranged as such, the mounting elements 1740 form two parallel columns 1760. A first of the cables 1730*a* is fixed to a first of the top mounting elements 1710*a* and bottom mounting elements 1720*a* and retains a first column 1760*a* of mounting elements 1740 and a second of the cables 1730*b* is fixed to a second of the top mounting elements 1710*b* and bottom mounting elements 1720*b* and retains a second column 1760*b* of mounting elements 1740. The LED lighting system 1000 may thereby be suspended on tensioned cables 1730.

It will be understood that while multiple cable mounts 1710, 1720 at the top and bottom of the LED lighting device 1000 are discussed, the device may be provided with a single top cable mount and a single bottom cable mount providing multiple connection points for mounting multiple tensioned cables. Similarly, the top and bottom cable mounts may be combined into a single chassis for tensioning a cable, such that the chassis may, for example, act as a stand, obviating the need for a top and bottom mounting surface.

FIGS. 11A-C show gripping accessories 1770 for use with the mounting system of FIG. 10. The cables 1730 may be provided with gripping accessories 1770, which may be placed below a corresponding mounting element 1740 to provide support and prevent the mounting element from sliding along the corresponding cable 1730. Similarly, a gripping accessory 1770 may be placed above a mounting element 1740 to prevent the mounting element from riding up along the corresponding cable 1730. In some embodiments, only two gripping accessories 1770 are provided for each cable 1730 provided. Such gripping accessories are provided below the top mounting element 1740 and above the bottom mounting element. In other embodiments, additional gripping accessories 1770 are provided for additional stability, such as in the embodiment shown in FIG. 11C, where an electrical passageway is not available to ensure consistent spacing. Gripping accessories 1770 may be, for example, rubber grips, or they may be clips that may be fixed to the tensioned cable once all mounting elements are in place.

Several variations of mounting elements for use with the tensioned cable 1730 mounting system shown in FIG. 10. While certain variations, configurations, and methods for installing are discussed explicitly, it will be understood that alternatives are contemplated. For example, while mounting elements may be threaded onto the cable 1730 prior to installing the cable, the elongated circuit boards 1020 may be fixed to those mounting elements before or after the tensioning of the cables.

FIGS. 12A-B show one embodiment of a mounting element 1800 configured to mount on a cable 1730 according to FIG. 10. The mounting element 1800 may contain a first bore 1810 for an electrical passageway 1040, configured such that electrical connections may be made between the electrical passageway and the elongated circuit board 1020, and a second bore 1820 for the cable 1730. The bores 1810, 1820 may be parallel to each other such that the electrical passageway 1040 and the cable run parallel to each other. The mounting elements 1800 may be mounted on the cable 1730 prior to tensioning the cable between the top and bottom cable mounts 1710, 1720 by threading the tensioned cable 1730 through the second bore 1820 of each mounting element, along with any required gripping accessories 1770, as shown in FIG. 12. After all mounting elements are threaded onto the cable 1730, it may be tensioned between the corresponding top cable mount 1710 and bottom cable mount 1720 to suspend the corresponding mounting elements 1800.

FIGS. 13-14 show an alternate embodiment of a mounting element 1900 configured to mount on a cable 1730 according to FIG. 10. The mounting element may be provided with side hooks 1910 designed to grip the cable 1730. While two side hooks 1910 are shown, it will be understood that in some embodiments only a single hook will be required to grip the cable 1730. Further, various gripping systems are contemplated, such that the hook may be, for example, a clip designed to grasp the cable. Mounting elements may then have only a single bore 1920 for retaining the electrical passage 1040, and the system may be installed by first tensioning the cable 1730 as needed, and only then mounting the mounting elements 1900 on the cable by way of the hooks 1910.

FIGS. 15-16 show a clip 2000 for gripping a mounting element 2010 mounted on a cable 1730 according to FIG. 10. A plurality of clips 2000 may be provided, and are configured with at least one tab 2020 for engaging with a mounting element 2100 as well as a bore 2030 for retaining the cable 1730. Each clip 2000 may further be provided with a gripping accessory 1770, as provided above, for maintaining the clips position along the cable 1730. Each clip 2000 may then be fixed to a cable 1730 prior to mounting the rest of the LED lighting device 1000. Once mounted, each clip 2000 may be mated to a corresponding mounting element 2010 at the at least one tab 2020. The tabs 2020 may be spring loaded tabs for grasping outer edges of the mounting elements 2010, or alternatively, may be spring loaded tabs for mating with a mounting hole of the corresponding mounting element. It will be understood that the clip 2000 may be similar to the clips 1620 discussed above, and adaptable variations may be applied to the present clips as well.

To install the LED lighting device 1000 using the clips 2000, the clips are either threaded or preinstalled onto the cables. Where necessary, gripping accessories 1720 are applied to position the clips 2000 along the cable 1730. The cable 1730 are then tensioned between top and bottom cable mounts 1710, 1720, and the mounting elements 2010 are mated to corresponding clips 2000. It will be understood that not every mounting element 2010 must be mated to a clip 2000, but rather, a smaller number of clips may be provided for retaining mounting elements only, for example, at extremities of the LED lighting device 1000.

FIG. 17 shows an embodiment of an LED lighting device 1000 that may be mounted by tensioning the electrical passageways 1040. In the embodiment shown, a first electrical passage 1040*a* carries a positive current or voltage and a second electrical passage 1040*b* carries a negative current or voltage, for completing a circuit through the elongated circuit boards 1020. Each of the electrical passageways 1040 comprise at least one wire 2100 having a heavy enough gage to tension the electrical passageways 1040 by fixing a top end of the wire 2110 to a top cable mount 1710 and a bottom end 2120 of the wire to a bottom cable mount 1720. The electrical passageways are in electrical contact with a power source or drain at one or both of the top cable mount 1710 and the bottom cable mount 1720, thereby providing electrical power to the LED lighting device 1000. It will be understood that although the device is shown having a single positive electrical passage 1040 and a single negative elec-

trical passage, any combination of conduits may be provided within the electrical passage, as discussed elsewhere in this disclosure, so long as at least one wire or combination of wires from each electrical passage is of a thick enough gage to support tensioning.

In order to install the LED lighting device **1000** of FIG. **17**, the mounting elements **2130** may first be fixed to corresponding electrical passageways **1040** at intervals **2140** along the passageway. Once all mounting elements **2130** are placed along a corresponding electrical passageway **1040**, the top end of the wire **2110** may be mechanically and electrically connected to a corresponding top cable mount **1710**, and the bottom end of the wire **2120** may be physically connected, and electrically connected, if necessary, to a corresponding bottom cable mount **1720**, and the electrical passageway may then be tensioned between the two mounts. Once all electrical passageways **1040** are in place, providing substantially parallel columns of mounting elements **2130**, elongated circuit boards **1020** may be fixed to corresponding mounting elements.

In some implementations, the LED lighting device **1000** may be required in a location without a top or bottom surface for fixation of cable mounts **1710**, **1720** according to FIG. **10**. FIG. **18** illustrates an alternative embodiment of a tensioned LED lighting device **1000** having offset cable mounts **2200**, **2210**. A top cable mount **2200** is fixed to a surface, such as a ceiling **2220** or a wall, at the top of the installation of the LED lighting device **1000**, and a bottom cable mount **2210** may be fixed to a surface, such as a floor **2230** or a wall, at the bottom of the installation of the LED lighting device. Each cable mount is provided with at least one offset arm **2240**, which in turn grips the cable **1730** or electrical passageway **1040** to be tensioned between the cable mounts **2200**, **2210**.

In some embodiments, the elongated circuit board may be provided with multiple potential connection points for mechanically connecting to mounting elements **1060**, and electrically connecting to electrical passageways **1040**. The electrical passageways **1040** may carry different currents or voltages, such as a first electrical passageway **1040***a* carrying a positive current for connecting with an anode **1140** at one of a first set of connection points **2300** and a second electrical passageway **1040***b* carrying a negative current to connect with a cathode **1160** at one of a second set of connection points **2310**. If electrical passageways **1040** are connected to an improper one of the connection points **2300**, **2310**, the LED lighting device may form a short across an elongated circuit board **1020**, destroying the circuit board.

FIG. **19** illustrates a mounting element **2320** containing an orientation element **2330** for preventing fixation to an inappropriate connection point **2300**, **2310**. The orientation element **2330** may be, for example, one or more pins for mating with corresponding bores **2340** in the elongated circuit board **1020**, such that each mounting element **2320** may only be fixed to the elongated circuit board in an appropriate location and with an appropriate orientation and positioning.

FIG. **20**A illustrates a jig **2400** for manufacturing LED lighting devices **1000**. When fixing mounting elements **1060** to electrical passageways **1040** at regular intervals **1070**, the intervals are preferably consistent. Because several mounting elements **1060** are fixed to each electrical passageway **1040**, and each mounting element supports an elongated circuit board **1020** in conjunction with a corresponding mounting element **1060** on a second electrical passageway **1040**, even a slight variation between the intervals **1070** used on the first electrical passageway and those intervals used on the second electrical passageway are cumulative. For example, if 20 elongated circuit boards **1020** are provided in an LED lighting device **1000** and each mounting element **1060** has an error of 10 mm, the cumulative error would be 0.2 meters across the device. The jig **2400** provides a molding cavity **2410** and a gripping cavity **2420**, each separated by the interval **1070** between two mounting elements **1060**. In order to form the first mounting element **1060***a*, the electrical passageway is placed within the molding cavity **2410**, and tensioned a known amount, and the first mounting element **1060***a* is formed around it. The first mounting element **1060***a* is then removed from the molding cavity **2410** and placed within the gripping cavity **2420**. The electrical passageway then passes through the first mounting element **1060***a* and the molding cavity **2420**, and is tensioned to the same amount as when forming the first mounting element **1060***a* while a second mounting element **1060***b* forms around it. The process is then repeated along the length of the electrical passageway **1040**, with the second mounting element **1060***b* being placed in the gripping cavity **2420**, the electrical passageway being passed through the molding cavity and tensioned a known amount, and additional mounting elements being formed.

The process is then repeated along a second electrical passageway, such that the intervals **1070** along the second electrical passageway are substantially identical as those along the first electrical passageway.

FIG. **20**B illustrates an alternative method for ensuring consistent installation of the mounting elements **1060** on the electrical passageway **1040** by designating, in advance, exposed wire segments **2430** upon which the mounting elements **1060** are to be mounted. By accurately spacing the exposed wire segments **2430** prior to applying mounting elements **1060**, the mounting elements can be installed only in the appropriate locations upon the electrical passageway **1040**. This method is particularly effective where the mounting elements **1060** are to be fixed to the electrical passageway **1040** using solder **1172**. In such an embodiment, a first wire segment **2430***a* is left exposed by stripping the wire jacket to expose the inner conduit **2440**, and then measuring a center to center distance **2450** before stripping the wire jacket from a second wire segment **2430***b*.

FIG. **20**C illustrates an LED lighting device **1000** assembled using the method described in **20**B. The exposed inner conduits **2440** are soldered to the elongated circuit boards **1020**, resulting in equally spaced circuit boards. Alternatively, such a device can be assembled using a jig, such as that illustrated in FIG. **20**A.

FIGS. **21**A-C illustrate embodiments of an LED lighting system **2500** comprising a plurality of LED light sources **2510** disposed on each of a plurality of elongated circuit boards **2520**, with the circuit boards coupled via electrical passageways **2530** to provide power. The electrical passageways **2530** each comprise four individual wires **2540** or groupings of wires, with a first wire **2540***a* from each set electrically connected to an anode on the elongated circuit board **2520** and with each of the three remaining wires **2540***b, c*, and *d*, connected to cathodes on the elongated circuit board, and each corresponding to a different color. Each wire **2540** on a first electrical passageway **2530***a* has a corresponding wire on a second electrical passageway **2530***b*

Each wire **2540** of each electrical passageway **2530** is electrically connected to the elongated circuit board **2520** at a corresponding connection point **2550***a-d*. The elongated circuit board may be provided with additional potential connection points **2560***a-d* to provide flexibility in assem-

bling LED lighting system **2500**. It will be understood that while two electrical passageways **2530** each containing four wires **2540** are shown, the LED lighting device **2500** may be provided with additional electrical passageways **2530** and/or additional wires **2540** for connecting to additional cathodes, or providing additional redundancy.

The use of at least two electrical passageways **2530** provides a redundancy for each wire **2540**. Because corresponding wires **2540***a-d* are connected to each other across corresponding anodes or cathodes on each elongated circuit board, the LED lighting device **2500** may be powered by applying power to any one of the electrical passageways, as shown in the power distribution diagram shown in FIG. **21**B. Once each anode and cathode of any of the elongated circuit boards **2520** is provided with power, any additional electrical passageways **2530** in electrical connection with the anode and cathodes may receive power from the connection points **2550**.

Further, the redundancy provided by multiple electrical passageways **2530** with corresponding wires **2540***a-d* further allows the Led lighting device to continue to function in the event of a failed electrical connection at one of the connection points **2550**. As shown in FIG. **21**C, if a failed connection **2570** between a wire **2540***c* in the first elongated passageway **2530***a* and a first elongated circuit board **2520***a* is present in the system, power may still be carried by the corresponding wire **2540***c* to a second elongated circuit board **2520***b* to a corresponding wire **2540***c* in the second electrical passageway **2530***b*, which may in turn provide power to the corresponding cathode in the first elongated circuit board **2520***a*.

In the embodiment shown, the elongated circuit boards **2520** may be two sided PCBs, and each preferably has a width of less than 15 mm.

FIG. **22** illustrates an embodiment of an LED lighting system **2600** comprising a plurality of LED light sources **2610** disposed on each of a plurality of elongated circuit boards **2620**, with the circuit boards coupled via electrical passageways **2630** to provide power. The first electrical passageway **2630***a* comprises a single wire **2640** electrically connected to an anode on each of the elongated circuit boards **2620** and the second electrical passageway **2630***b* comprises three individual wires **2650** or groupings of wires, with each of the three wires **2650***a-c* electrically connected to cathodes on each elongated circuit board, and each corresponding to a different color.

Contrary to the embodiments of FIG. **21**, the first electrical passageway **2630***a* comprises wiring distinct from that contained in the second electrical passageway **2630***b*. The wire **2640** of the first electrical passageway **2630***a* is a common anode wire, providing power to the anode on each elongated circuit board **2620** of the embodiment. Similarly, the second electrical passageway **2630***b* provides power to each of three cathodes on each elongated circuit board. Separating the anode wire **2640** from the cathode wires **2650** dramatically reduces the possibility of a short circuit between the anode and a cathode.

Redundant connections **2660** are provided for each wire **2640**, **2650** where the wire electrically connects to the elongated circuit boards **2620**. In some embodiments, a third and fourth electrical passageway are provided, and are identical to and provide redundancies for the first and second electrical passageways **2630***a* and *b* respectively. It will be understood that additional electrical passageways may be provided, and that additional wires may be provided alongside the wires **2650** of the electrical passageways **2630** in order to provide electrical connections for additional cathodes in the system or to provide redundancies for the connections already described.

FIGS. **23**A-C illustrate embodiments of an LED lighting device **2700** comprising a plurality of LED light sources **2710** disposed on each of a plurality of elongated circuit boards **2720**, with the circuit boards coupled via electrical passageways **2730** to provide power. The LED light sources **2710** comprise a first set of LED light sources **2740** and a second set of LED light sources **2750**, where each LED light source from the first set **2740***a* has a corresponding LED light source from the second set **2750***a*. As shown in FIG. **23**A, the electrical passageways **2730** each comprise five individual wires **2760** or groupings of wires, with a first wire **2760***a* from each set electrically connected to an anode on the elongated circuit board **2720** and with each of three of the remaining wires **2760***b-d* connected to cathodes on the elongated circuit board, and each corresponding to a different color. The anode is connected to the three cathodes across the LED light sources **2710** from the first set **2740**. The fifth wire **2760***e* connects to a fourth cathode on the elongated circuit board **2720** and the anode is connected to the fourth cathode across the LED light sources **2710** from the second set **2750**. Each wire **2760***a-e* on a first electrical passageway **2730***a* has a corresponding wire on a second electrical passageway **2730***b*.

The LED light sources **2710** from the first set **2740** may be lit in a variety of colors by modifying the power provided to the three cathodes through wires **2760***b-d*. The LED light sources **2710** from the second set **2750** are configured to be lit in only a single color, such as a white light. When the LED lighting device **2700** is in use, LED light sources **2710** of one of the first set **2740** and the second set **2750** may be activated at different times, or in a programmed pattern, such that at any given time the lights in the first set or the lights from the second set are activated. The first set **2740** and the second set **2750** may be independently controlled, and may be lit simultaneously, consecutively, or independently.

As shown in FIG. **23**B, the LED lighting device may be provided, at each electrical passageway **2730** with a common anode wire **2770** and two cathode wires **2780***a-b* connecting to a first cathode and a second cathode respectively. The anode on each elongated circuit board **2720** is electrically connected to the first cathode across an LED light source from the first set **2740** and connected to the second cathode across an LED light source from the second set **2750**. The first set **2740** comprises LED light sources **2710** for providing a cool white light and the second set **2750** comprises LED light sources for providing a warm white light, compared to the LED light sources of the first set.

As shown in FIG. **23**C, the plurality of elongated circuit boards **2720** may comprise a first set **2780** and a second set **2790**. A first set **2740** of LED light sources **2710** may then be disposed on a first set **2780** of elongated circuit boards **2720** and a second set **2750** of LED light sources may then be disposed on a second set **2790** of elongated circuit boards. In such an embodiment, any cathodes associated with a first set **2740** of LED light sources are on only the first set **2780** of elongated circuit boards **2720** and any cathodes associated with the second set **2750** of LED light sources are on only the second set **2790** of elongated circuit boards.

It will be understood that the first electrical passageway **2730***a* and the second electrical passageways **2730***b* provide substantially identical wiring, thereby providing the redundancy benefits discussed above with respect to FIG. **21**, and that the number and arrangement of wires **2760** may be modified in a similar manner.

FIGS. **24**A-D illustrate embodiments of an LED lighting device **2800** comprising a plurality of LED light sources **2810** disposed on each of a plurality of elongated circuit boards **2820**, with the circuit boards coupled via electrical passageways **2830** to provide power. The LED light sources **2810** comprise a first set of LED light sources **2840** and a second set of LED light sources **2850**, where each LED light source from the first set **2840***a* has a corresponding LED light source from the second set **2850***a*.

The first electrical passageway **2830***a* comprises a single wire **2860** electrically connected to an anode on each of the elongated circuit boards **2820** and the second electrical passageway **2830***b* comprises four individual wires **2870** or groupings of wires, with each of a first three of the wires **2870***a-c* electrically connected to cathodes on each elongated circuit board, and each corresponding to a different color, and a fourth of the wires **2870***d* connected to a fourth cathode.

The anode is connected to the three cathodes electrically connected to the first three wires **2870***a-c* across the LED light sources **2810** from the first set **2840**. The fourth **2870***d* wire in the second electrical passageway **2830***b* connects to a fourth cathode on the elongated circuit board **2820** and the anode is connected to the fourth cathode across the LED light sources **2810** from the second set **2850**.

FIG. **24**B provides a first electrical passageway **2830***a* comprising a first wire **2860** electrically connected to an anode on each elongated circuit board **2820**, as in FIG. **24**A, and a second electrical passageway **2830***b* comprising two wires **2870***a-b*, each electrically connected to a different cathode. The anode is connected to the first cathode across the LED light sources **2810** from the first set **2840** and the second cathode across the LED light sources **2810** from the second set **2850**. In the embodiment shown, the two LED light sources provide light in two shades of white. In some alternative embodiments, the LED light sources may provide light in any other two colors. Similarly, where multiple colors are provided by different currents or voltages carried by anodes or cathodes, multiple shades of white may be provided as well. The first set **2840** comprises LED light sources **2810** for providing a cool white light and the second set **2850** comprises LED light sources for providing a warm white light, compared to the LED light sources of the first set.

As shown in FIG. **24**C, the plurality of elongated circuit boards **2820** may comprise a first set **2880** and a second set **2890**. A first set **2840** of LED light sources **2810** may then be disposed on a first set **2880** of elongated circuit boards **2820** and a second set **2850** of LED light sources may then be disposed on a second set **2890** of elongated circuit boards. In such an embodiment, any cathodes associated with a first set **2840** of LED light sources are on only the first set **2880** of elongated circuit boards **2820** and any cathodes associated with the second set **2850** of LED light sources are on only the second set **2890** of elongated circuit boards.

The advantages and features provided by separating the anode wire **2860** from the cathode wires **2870** are similar to those described in relation to FIG. **22**, and similar variations are contemplated. The advantages and features provided by providing and powering two sets of wires **2840**, **2850** are similar to those described in relation to FIG. **23**, and similar variations are contemplated.

As shown in FIG. **24**D, the first electrical passageway **2830***a* may be modified to contain two wires **2900**, **2910**. Rather than a common anode, a first wire **2900** connects to an anode on each elongated circuit board **2820** of a second set **2890** and a second wire **2910** connects to a cathode on each elongated circuit board of a second set **2890**. A first set **2840** of LED light sources **2810** may then be disposed on the first set **2880** of elongated circuit boards **2820** and a second set **2850** of LED light sources may then be disposed on the second set **2890** of elongated circuit boards. The two wires in the first electrical passageway **2830***a* thereby provide a complete circuit for the second set **2890** of elongated circuit boards **2820**.

Similarly, the wires in the second electrical passageway **2830***b* complete a circuit for the first set **2880** of elongated circuit boards **2820**. A first wire **2870***a* from the second electrical passageway **2830***b* connects to an anode on the first set of elongated circuit boards **2820** and the remaining wires **2870***b-d* connect to cathodes, thereby completing a circuit across any LED light sources **2810** from the first set **2840** disposed on the corresponding elongated circuit board.

In such an embodiment, the anode associated with each elongated circuit board **2820** connects to any cathodes associated with that elongated circuit board across any LED light sources disposed on the associated elongated circuit board. In these embodiments, electrical connections with appropriate wires may be made using screws formed of conducting materials, as discussed above, and mechanical connections may be made with mounting elements where electrical connections are unwanted using dummy screws made of non-conducting materials.

FIG. **25**A-C illustrate an LED lighting device **3000** having connectable mounting elements **3010**. The LED lighting system **3000** comprises a plurality of LED light sources **3020** disposed on each of a plurality of elongated circuit boards **3030**, with the circuit boards coupled via electrical passageways **3040** to provide power. Each elongated circuit board **3030** has a first end **3050** and a second end **3060**, and is electrically connected to each of the electrical passageways **3040** at one of the first end and the second end using a connectable mounting element **3010**. The connectable mounting element may be fixed to an end of the elongated circuit board in any of the methods discussed elsewhere in this disclosure in relation to other mounting elements **1060**.

Each connectable mounting element **3010** is provided with a clipping section **3070** configured to mate with a second connectable mounting element **3010** with a compatible clipping section **3070**. As shown in FIGS. **25**B and C, the connectable mounting element may be used to mate two or more LED lighting devices **3000** such that the distance from the last LED light source **3020***a* on a first LED lighting device **3000***a* is the same distance from the first LED light source **3020***b* on a second LED lighting device **3000***b* as it is from its neighboring LED light source along its corresponding elongated circuit board **3030**.

It will be understood that each connectable mounting element **3010** may be mounted onto an external surface in any of the methods discussed relative to other mounting elements **1060** elsewhere in this disclosure. Similarly, the electrical passageways **3040** passing through each of the connectable mounting elements **3010** may be any of the electrical passageways in any of the configurations discussed elsewhere in this disclosure.

The clipping section **3070** of each connectable mounting element **3010** may be a friction fit, a clip, or any other fixation system for connecting two connectable mounting elements. In some embodiments, the connectable mounting element **3010** is fitted with electrical contacts for providing power from the first LED lighting device **3000***a* to the second LED lighting device **3000***b*. In such an embodiment, each electrical contact is associated with a corresponding wire within the corresponding electrical passageway **3040**.

FIGS. **26**A-B illustrate a top view of an LED lighting device **3100** with and without wide angle lenses **3110** applied to each LED light source **3120**. In an LED lighting device **3100** without the wide angle lenses **3110** applied, as shown in FIG. **26**A, light emitted from the LED light sources **3120** has a certain maximum beam angle, and they therefore provide a first beam coverage **3130** at a first distance **3140** from the LED light source. The beam angle of an LED light source **3120** is defined by the manufacturer of the LED package. A typical Surface Mounted Device (SMD) LED package has a 120 degree beam angle without any optics applied.

When an LED lighting device **3100** is provided with wide angle lenses **3110** for each LED light source **3120**, as shown in FIG. **26**B, a second beam coverage **3150** at the first distance **3140** is possible, with the second beam coverage being greater than the first beam coverage **3130** for each LED light source **3120**. Additionally, the beam angle is increased so that the LED light source **3120** can provide a third beam coverage **3160** equal to the first beam coverage **3130** at a second distance **3170** shorter than the first distance **3140**. Accordingly, when the wide angle lenses **3110** are applied, either the beam coverage may be expanded or the distance may be decreased. Accordingly, the application of the lenses may increase the uniformity of light distributed.

FIG. **27**A-F illustrate the use of an LED lighting device **3100** in a light box **3180** configured to utilize each of the advantages discussed above with respect to FIGS. **26**A-B. FIG. **27**A shows a front view of an implementation of the LED lighting device **3100** in a light box **3180** without the wide angle lenses **3110** applied. In this embodiment, the LED light sources **3120** are spaced apart by an LED pitch C, or distance, along each elongated circuit board **3190**. The LED light sources are spaced out by a bar to bar pitch D between the elongated circuit boards **3190**. FIG. **27**B shows a top view of the lighting device **3100** in the light box **3180**, with the light box having an illuminated substrate **3200**. The LED lighting device **3100**, or in some cases, a reference relative to the LED lighting device, such as a surface for mounting, is separated from the illuminated substrate **3200** by a depth B. The depth B, the LED pitch C, and the bar to bar pitch D are each selected to provide a certain level of lighting uniformity on the illuminated substrate **3200**. Accordingly, depth B is generally selected as the minimum depth to produce uniform lighting without shadows or hotspots.

FIG. **27**C-D show an implementation of the LED lighting device **3100** in a light box **3180** with wide angle lenses **3110** applied. In this embodiment, the LED light sources have the same LED pitch C and bar to bar pitch D as in the embodiment shown in FIG. **27**A. However, because the lenses are applied, the depth **3210** is less than the depth B shown in FIG. **27**B. Accordingly, the application of wide angle lenses **3110** allows the depth of a light box to be reduced.

FIG. **27**E-F show an alternative implementation of the LED lighting device **3100** in a light box **3180** with wide angle lenses **3110** applied. In the embodiment shown, the depth B is the same as in FIG. **27**B. However, the LED pitch **3220** and the bar to bar pitch **3230** are greater than the LED pitch B and the bar to bar pitch C shown in FIG. **27**A. Accordingly, the wide angle lenses **3110** allow the spacing between LED light sources **3120** to be increased without sacrificing uniformity at depth B. In this way, the number of LED light sources **3120** required, and the associated cost of manufacturing, may be reduced.

The embodiment shown in FIG. **27**E-F allows for the use of fewer LED light sources and fewer elongated circuit boards to achieve the same level of uniformity in a given light box. In order to maintain the brightness level previously provided by additional LEDs, brighter LED light sources may be used.

As shown in FIG. **26-27**, the application of wide angle lenses **3110** to LED light sources **3120** may be done by applying the lenses to each LED light source on the elongated circuit **3190** board individually. This may be done using a pick-and-place method, and the lenses may be bonded to the elongated circuit board **3190** using resin or a bonding chemical, or other permanent adhesion techniques. Using individual lenses allows for a variety of configurations without incurring multiples of the tooling costs for the lenses.

FIG. **28** illustrates an alternative embodiment of the application of wide angle lenses **3300** to an elongated circuit board **3190** of the LED lighting device **3100**. As shown, each of the wide angle lenses **3300** is configured to cover multiple LED light sources **3120**, and provide a lens segment **3310** for each light source. To optimize the cost of the lenses and reduce assembly time, the wide angle lenses **3300** may then provide efficiently manufactured clusters of lens segments **3310**.

FIG. **29** illustrates an alternative embodiment of the application of wide angle lenses **3400** to an elongated circuit board **3190** of the LED lighting device **3100**. As shown, each of the wide angle lenses **3400** covers multiple LED light sources **3120**. Further, providing a single elongated lens **3400** allows the lens to be produced by an extrusion process, which allows the lenses to be inexpensively manufactured for a variety of elongated circuit board **3190** lengths.

In the embodiment shown in FIG. **29**, the lens may only widen the distribution of light in a single dimension, as the lens would be an extrusion of a two dimensional cross section. Accordingly, in some embodiments, the bar to bar pitch in some embodiments may be extended, but the LED pitch may remain the same as would be provided without the lens.

In some embodiments, the elongated circuit boards are provided with an aluminum profile base design, and the elongated circuit boards and the LED light sources are placed in an aluminum channel. Connecters required for the circuits are then placed on the edges.

While certain embodiments have been described at some length and with some particularity, it is not intended that it should be limited to any such particulars or embodiments or any particular embodiment, but it is to be construed with references to the appended claims so as to provide the broadest possible interpretation of such claims in view of the prior art and, therefore, to effectively encompass the intended scope.

What is claimed is:

1. A light emitting diode (LED) lighting device comprising:

a plurality of LED light sources disposed on each of two or more elongated circuit boards, each LED light source of the plurality of LED light sources being electrically connected to one of the two or more elongated circuit boards, the two or more elongated circuit boards electrically coupled to provide power to the circuit boards,

a plurality of mounting elements fixed to each of the two or more electrical passageways at regular intervals, the plurality of mounting elements configured for connecting to the two or more elongated circuit boards, and

a track for engaging the plurality of mounting elements, the track containing a channel surrounded by back, side, and front surfaces, wherein the channel is substantially T-shaped in cross section,

wherein the two or more elongated circuit boards are electrically coupled at intervals along the length of the elongated circuit boards using two or more electrical passageways each connected to power or ground, the two or more elongated circuit boards electrically coupled at intervals along the electrical passageways, and

wherein the plurality of LED light sources disposed on each of two or more elongated circuit boards emit light in the same direction perpendicular to the elongated circuit boards.

2. The device of claim **1** wherein each of the two or more electrical passageways is connected to each of the two or more elongated circuit boards by at least one electrically conductive screw or pin that passes through the circuit board and connects a portion of a first electrically conductive layer to an electrical wire on the opposite side of a substrate on each elongated circuit board.

3. The device of claim **2** wherein each of the two or more elongated circuit boards is a single sided printed circuit board and a first electrical wire in a first of the two or more electrical passageways connects to a cathode on each elongated circuit board and a second electrical wire in a second of the two or more electrical passageways connects to an anode on each elongated circuit board.

4. The device of claim **1** wherein each of the plurality of mounting elements further comprises wings for engaging the track.

5. The device of claim **1** further comprising a plurality of secondary mounting clips for fixing the device to fixation points external to the device, each mounting clip comprising an engagement element for engaging one of the plurality of mounting elements.

6. The device of claim **1** further comprising:

a top cable mount;

a bottom cable mount; and

a plurality of tensioned cables each fixed to both the top cable mount and the bottom cable mount,

wherein each of the plurality of mounting elements further comprises a channel for retaining one of the plurality of tensioned cables, the channel substantially parallel to the corresponding electrical passageway of the two or more electrical passageways for the mounting element.

7. The device of claim **1** further comprising:

a top cable mount; and

a bottom cable mount,

and wherein the two or more electrical passageways are tensioned and fixed to the top cable mount and the bottom cable mount.

8. The device of claim **1**, each mounting element of the plurality of mounting elements further comprising at least one mount orientation element for mating with a corresponding circuit board orientation element on one of the two or more elongated circuit boards and limiting the connection between the mounting element and the corresponding elongated circuit board to one or more predetermined configurations.

9. A plurality of LED light sources disposed on each of two or more elongated circuit boards, each LED light source of the plurality of LED light sources being electrically connected to one of the two or more elongated circuit boards, the two or more elongated circuit boards electrically coupled to provide power to the circuit boards,

wherein the two or more elongated circuit boards are electrically coupled at intervals along the length of the elongated circuit boards using two or more electrical passageways each connected to power or ground, the two or more elongated circuit boards electrically coupled at intervals along the electrical passageways,

wherein the plurality of LED light sources disposed on each of two or more elongated circuit boards emit light in the same direction perpendicular to the elongated circuit boards, and

wherein a first electrical passageway of the two or more electrical passageways comprises a plurality of wires and a second electrical passageway of the two or more electrical passageways comprises a plurality of wires, wherein each of the first electrical passageway and the second electrical passageway comprises a single anode wire and a plurality of cathode wires.

10. The device of claim **9** wherein each wire of the plurality of wires from the first electrical passageway is in electrical communication with a corresponding wire from the second electrical passageway by way of a second electrically conductive layer of the two or more elongated circuit boards such that the first electrical passageway and the second electrical passageway form a redundancy for each wire.

11. The device of claim **9** wherein the plurality of cathode wires comprise a first wire associated with a single color and a plurality of wires, each associated with a different color, and wherein the plurality of LED light sources disposed on each of the two or more elongated circuit boards comprise a first set of LED light sources associated with the anode and the first wire associated with a single color and a second set of LED light sources associated with the anode and the plurality of wires, each associated with a different color.

12. The device of claim **11** wherein the first set of LED light sources comprises an identical number of LED light sources to that of the second set of LED light sources, and wherein each LED light source from the first set of LED light sources is adjacent to an LED light source from the second set of LED light sources on the two or more elongated circuit boards.

13. The device of claim **9** wherein the two or more elongated circuit boards comprise a first set of two or more circuit boards and a second set of two or more circuit boards, and wherein the first set of two or more circuit boards is electrically connected to the anode and one or more of the plurality of cathodes of the plurality of cathode wires, and the second set of two or more circuit boards is electrically connected to the anode and one or more of the plurality of cathodes, and wherein the one or more cathodes electrically connected to the first set of two or more circuit boards is different than the one or more cathodes electrically connected to the second set of two or more circuit boards.

14. A plurality of LED light sources disposed on each of two or more elongated circuit boards, each LED light source of the plurality of LED light sources being electrically connected to one of the two or more elongated circuit boards, the two or more elongated circuit boards electrically coupled to provide power to the circuit boards,

wherein the two or more elongated circuit boards are electrically coupled at intervals along the length of the elongated circuit boards using two or more electrical passageways each connected to power or ground, the two or more elongated circuit boards electrically coupled at intervals along the electrical passageways,

wherein the plurality of LED light sources disposed on each of two or more elongated circuit boards emit light in the same direction perpendicular to the elongated circuit boards, and

wherein a first electrical passageway of the two or more electrical passageways comprises a plurality of cathodes and a second electrical passageway of the two or more electrical passageways is an anode and wherein the anode is a common anode and supplies power for the plurality of cathodes.

15. The device of claim **14** wherein each cathode of the plurality of cathodes is associated with a different color.

16. A plurality of LED light sources disposed on each of two or more elongated circuit boards, each LED light source of the plurality of LED light sources being electrically connected to one of the two or more elongated circuit boards, the two or more elongated circuit boards electrically coupled to provide power to the circuit boards, and

a plurality of mounting elements fixed to each of the two or more electrical passageways at intervals, the mounting elements configured for connecting to the two or more elongated circuit boards at each end of each of the elongated circuit boards,

wherein the two or more elongated circuit boards are electrically coupled at intervals along the length of the elongated circuit boards using two or more electrical passageways each connected to power or ground, the two or more elongated circuit boards electrically coupled at intervals along the electrical passageways,

wherein the plurality of LED light sources disposed on each of two or more elongated circuit boards emit light in the same direction perpendicular to the elongated circuit boards, and

wherein each of the plurality of mounting elements of the device is configured to mate with an identical mounting element on a second device such that when mated by way of the mounting elements, the distance between two LED light sources of the plurality of LED light sources adjacent to each other on the elongated circuit boards is substantially similar to the distance between at least one LED light source on the device and at least one LED light source on the substantially identical device.

17. The device of claim **16**, the plurality of mounting elements providing electrical connectivity between the device and the second device when mated.

18. A method for manufacturing a light emitting diode (LED) lighting device having two or more elongated circuit boards, a plurality of LED light sources disposed on each of the elongated circuit boards, two or more electrical passageways, each of the two or more electrical passageways electrically connected to the two or more elongated circuit boards and a power source or drain, the method comprising:

forming a first mounting element disposed on a first of the one of the two or more electrical passageways;

providing a jig configured to hold the first mounting element;

placing the first mounting element formed in the jig provided;

tensioning the first electrical passageway relative to the jig provided;

forming a second mounting element disposed on the first electrical passageway at a location selected relative to the jig;

removing the first mounting element from the jig provided;

placing the most recently formed mounting element in the jig provided;

repeating the procedure a plurality of times to form mounting elements along the length of the first electrical passageway; and

repeating the procedure for each of the two or more electrical passageways,

wherein the two or more elongated circuit boards, when mounted on the mounting elements formed are substantially parallel to each other and are electrically connected to the two or more electrical passageways at regular intervals.

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