



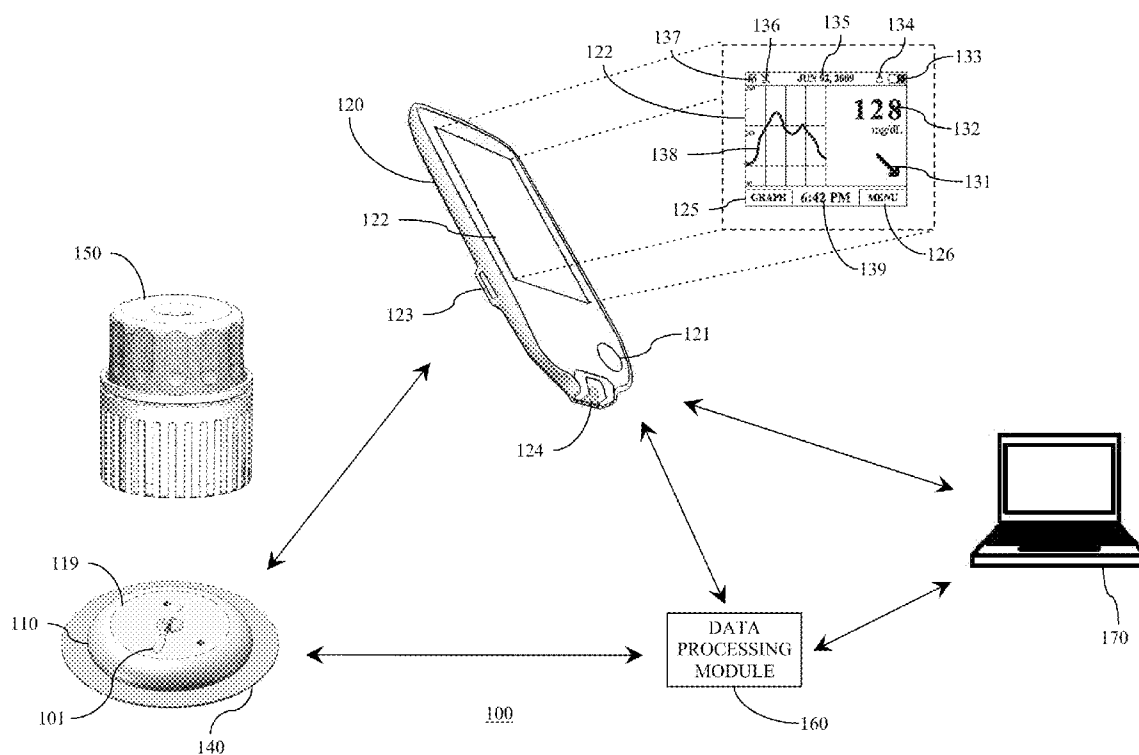
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(19) **United States**(12) **Patent Application Publication**
Stafford(10) **Pub. No.: US 2011/0191044 A1**(43) **Pub. Date: Aug. 4, 2011**(54) **INTERCONNECT FOR ON-BODY ANALYTE MONITORING DEVICE****Publication Classification**(76) Inventor: **Gary A. Stafford, Hayward, CA (US)**(51) **Int. Cl.**
G06F 19/00 (2011.01)
G01R 1/20 (2006.01)(21) Appl. No.: **12/895,015**(52) **U.S. Cl.** **702/65; 324/126**(22) Filed: **Sep. 30, 2010**(57) **ABSTRACT**

Disclosed herein are systems and methods for providing a compressible interconnect for allowing electrical communication between an electronics unit and an analyte sensor in an on-body analyte monitoring device. In other embodiments, systems and methods are provided for reducing the Z-height of an on-body analyte monitoring device by utilizing novel interconnects.

Related U.S. Application Data

(60) Provisional application No. 61/247,516, filed on Sep. 30, 2009.



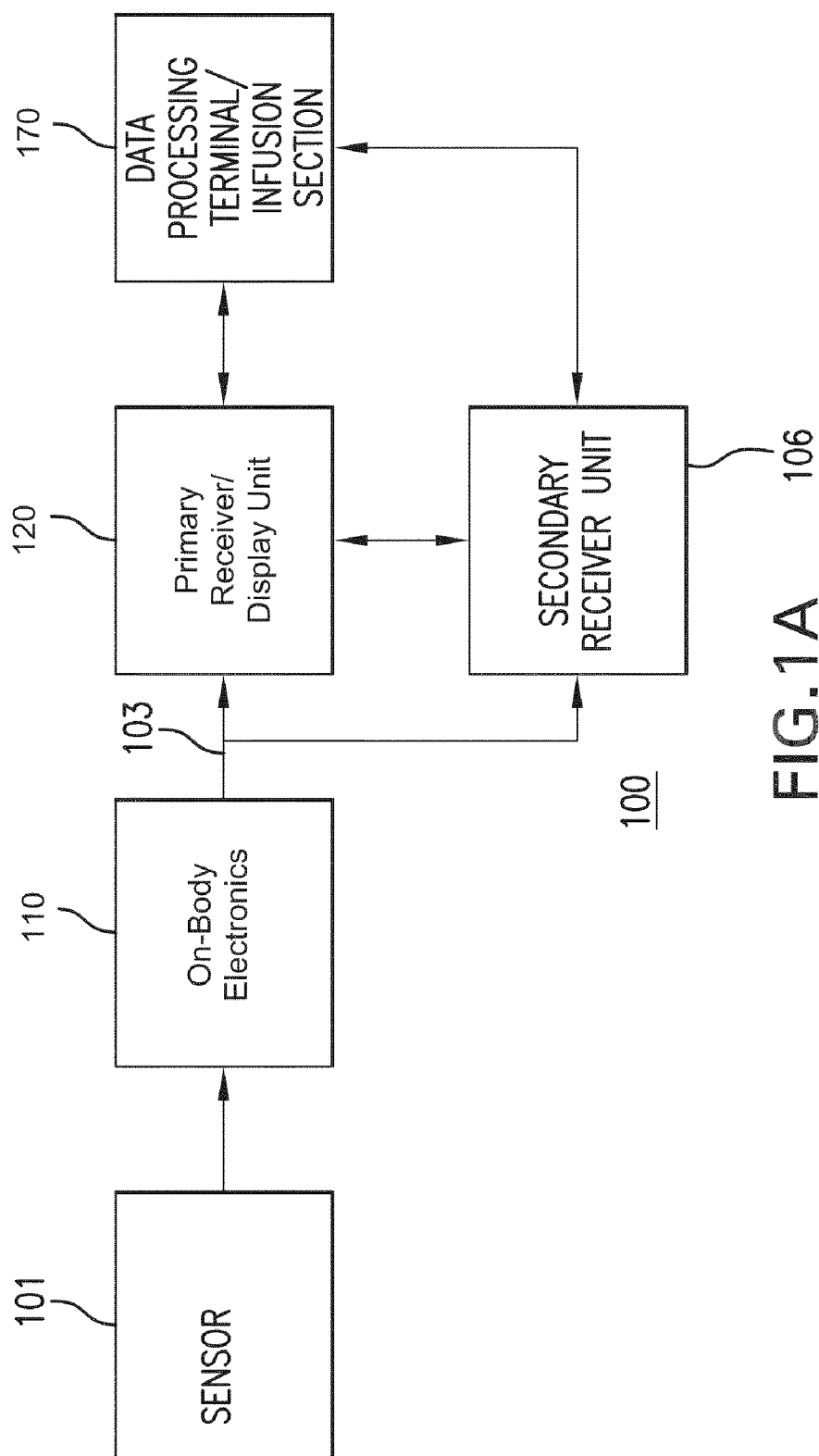
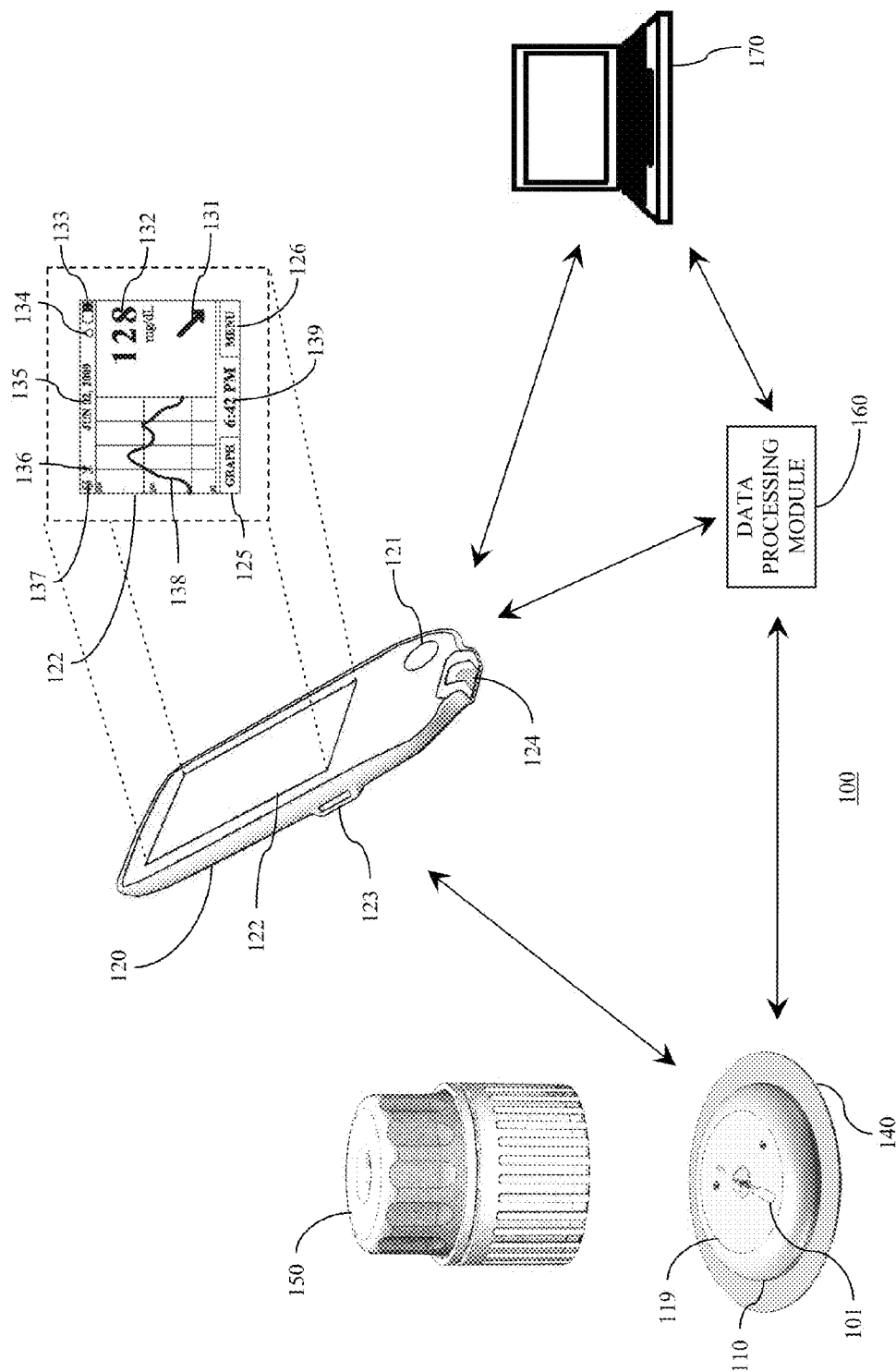


FIG. 1A



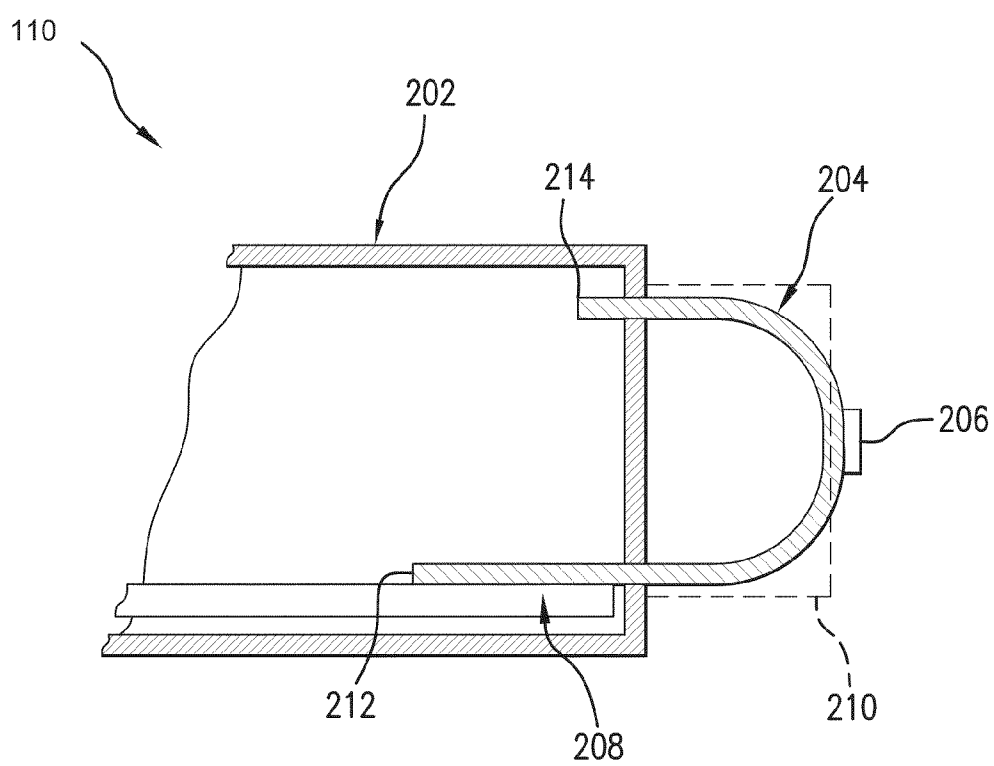


FIG. 2

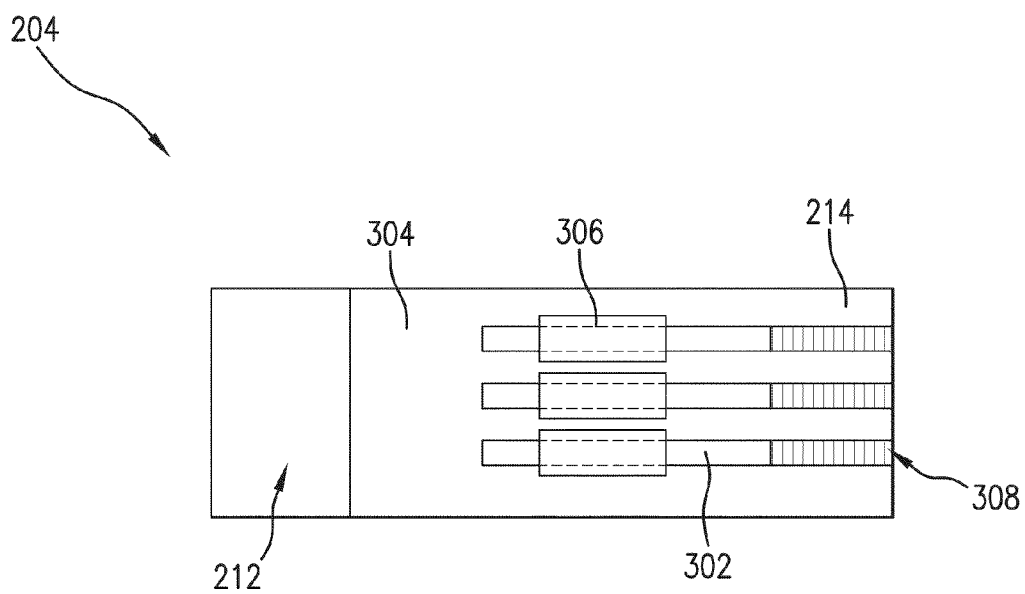


FIG.3

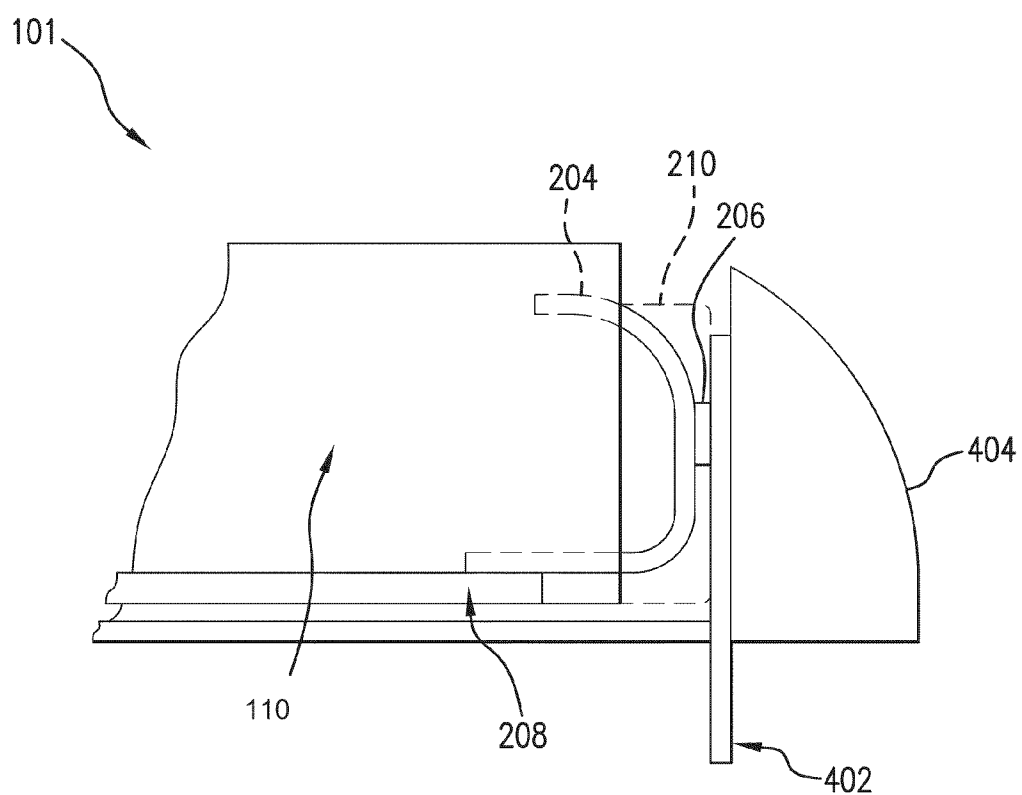


FIG. 4

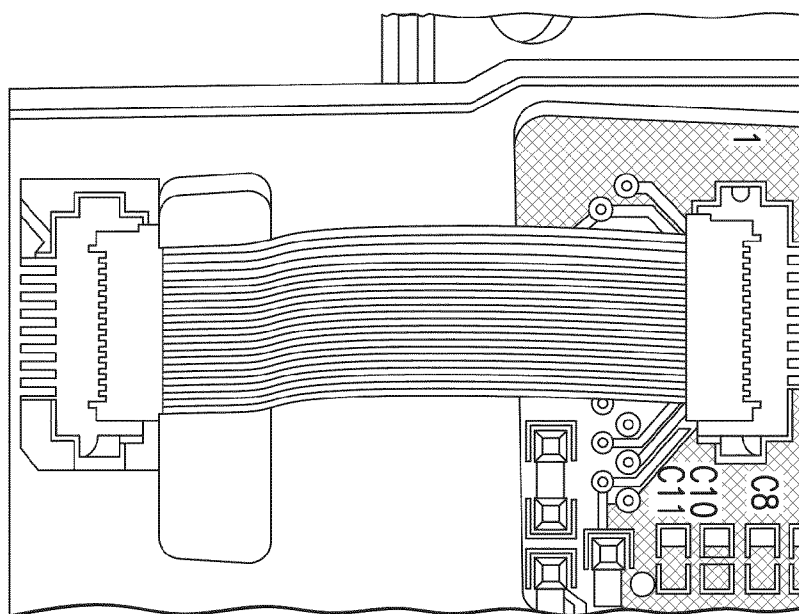


FIG. 5A

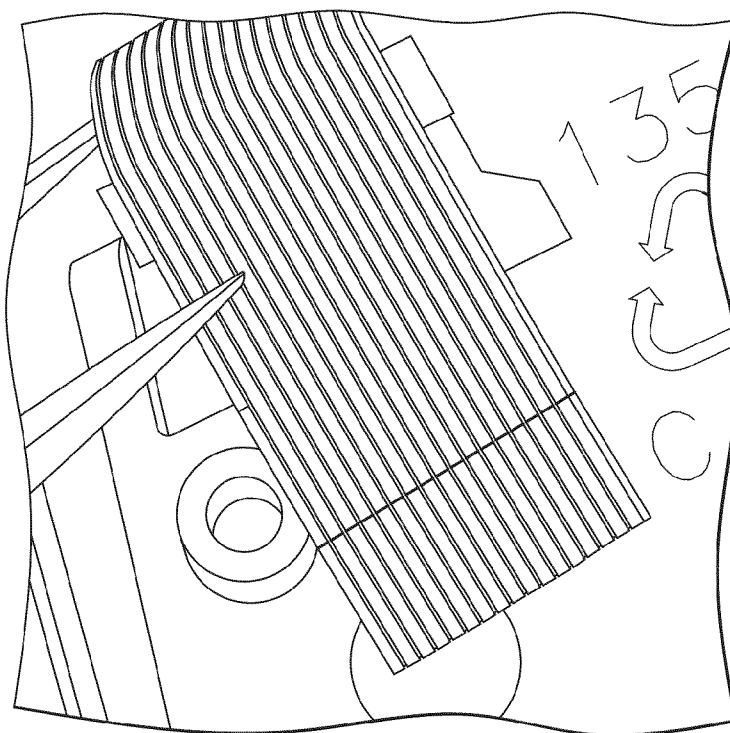


FIG. 5B

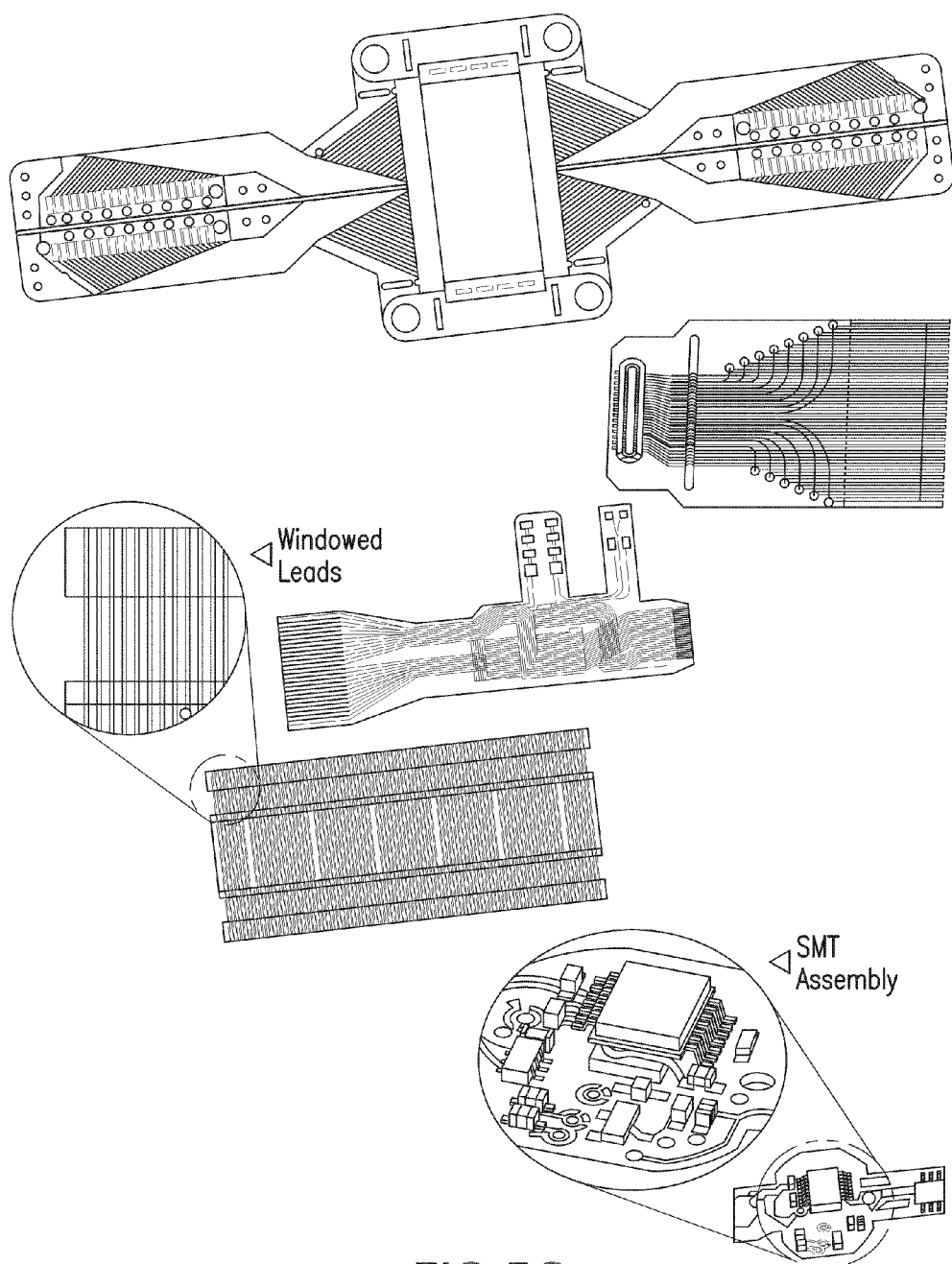


FIG. 5C

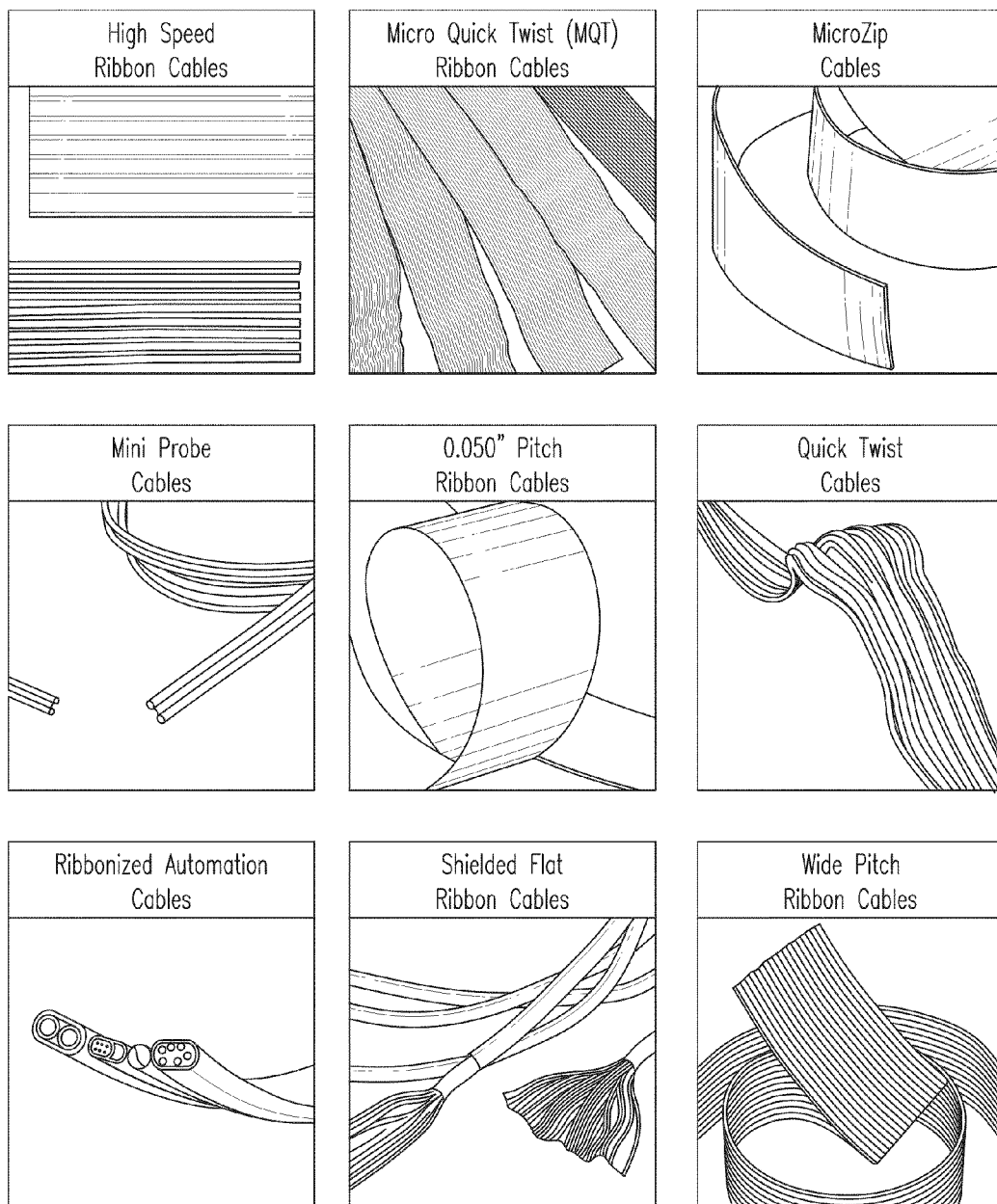


FIG.5D

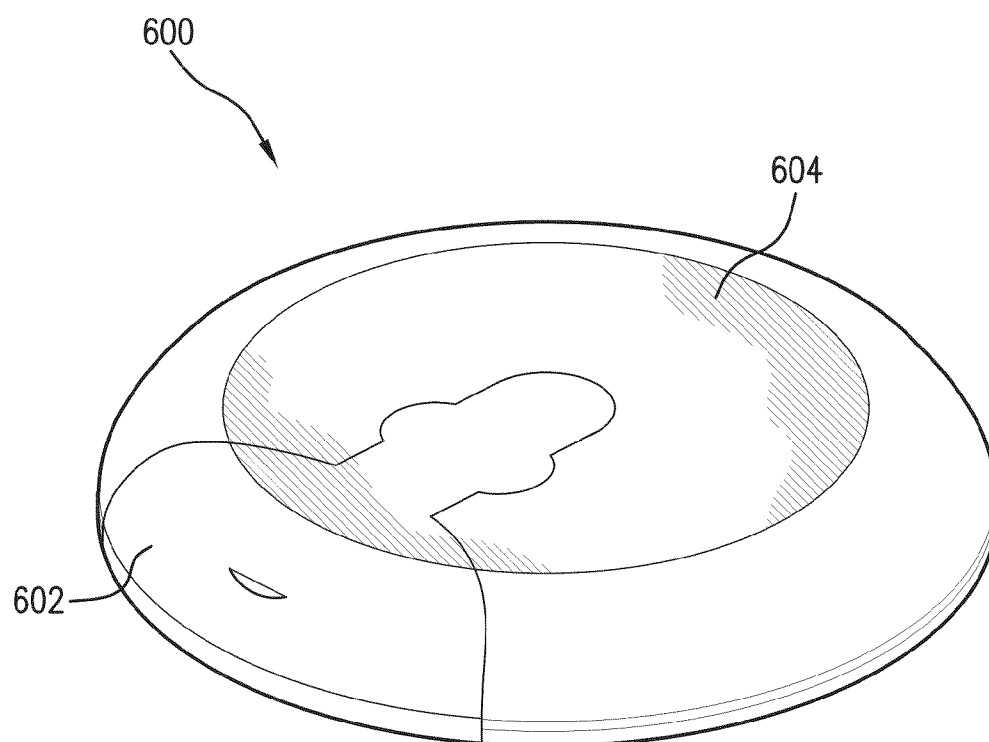


FIG.6

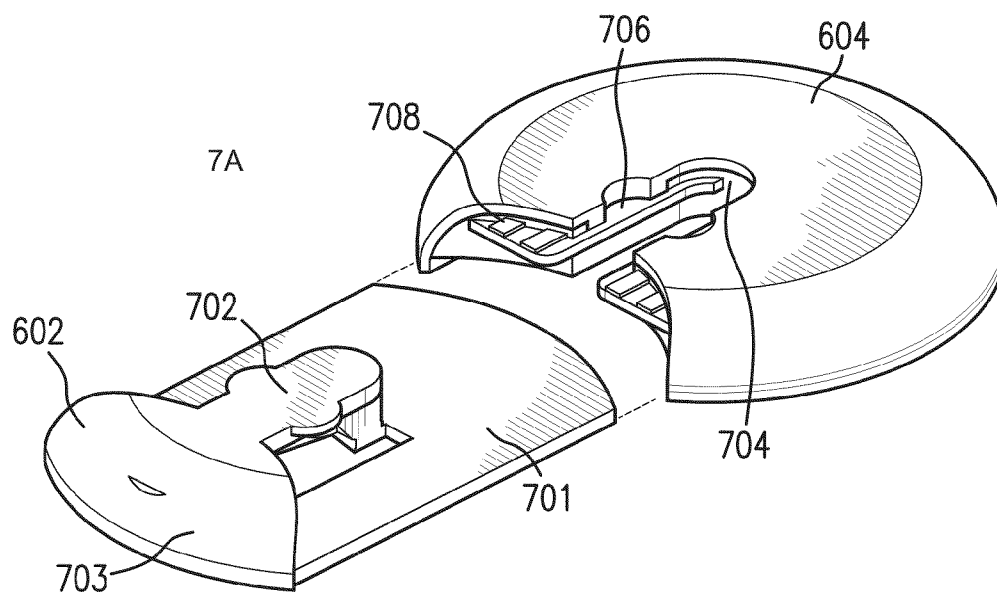


FIG. 7A

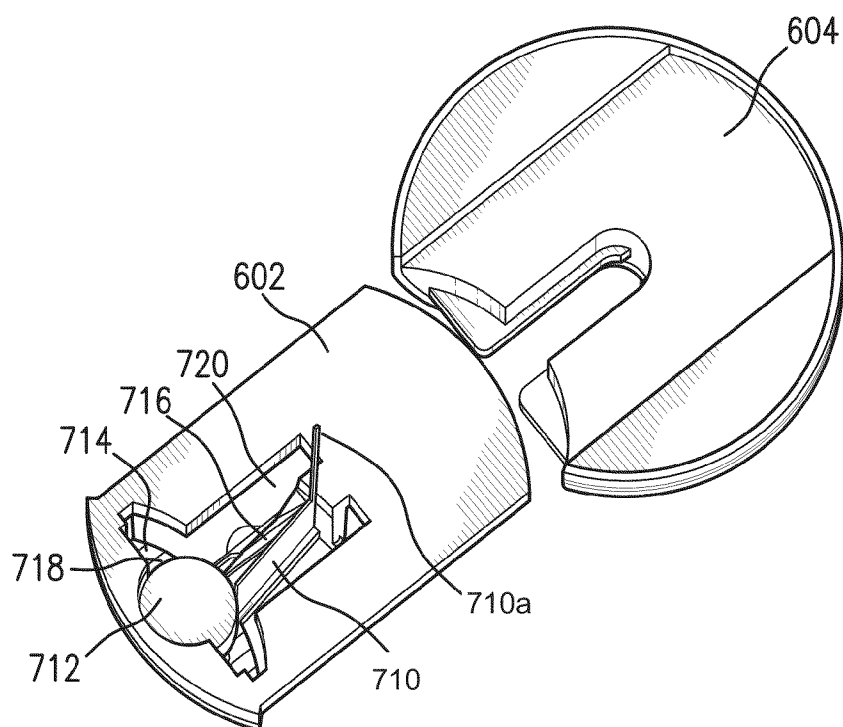


FIG. 7B

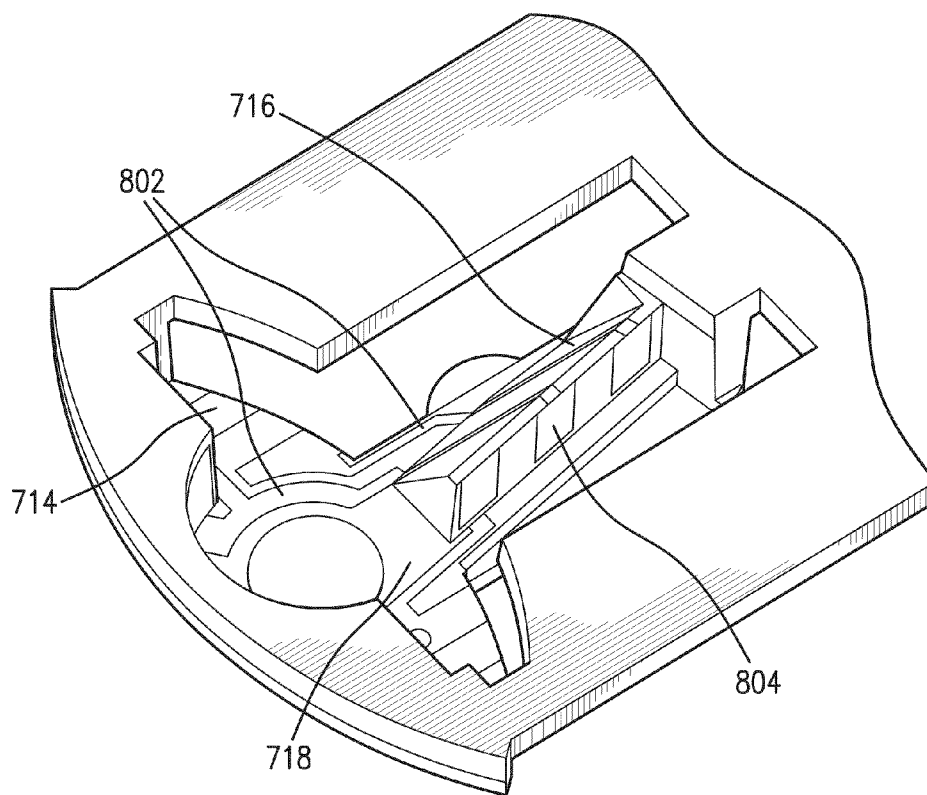


FIG.8

INTERCONNECT FOR ON-BODY ANALYTE MONITORING DEVICE

RELATED APPLICATIONS

[0001] The present application claims the benefit of U.S. Provisional Application No. 61/247,516, filed Sep. 30, 2009, the disclosure of which is incorporated herein by reference for all purposes.

FIELD OF THE INVENTION

[0002] The present invention relates to an analyte monitoring system. More particularly, the present invention relates to apparatus for establishing electrical communication between an analyte sensor and an electronics unit in an on-body analyte monitoring device.

BACKGROUND OF THE INVENTION

[0003] The detection and/or monitoring of glucose levels or other analytes, such as lactate, oxygen, A1C, or the like, in certain individuals is vitally important to their health. For example, the monitoring of glucose is particularly important to individuals with diabetes. Diabetics generally monitor glucose levels to determine if their glucose levels are being maintained within a clinically safe range, and may also use this information to determine if and/or when insulin is needed to reduce glucose levels in their bodies or when additional glucose is needed to raise the level of glucose in their bodies.

[0004] Growing clinical data demonstrates a strong correlation between the frequency of glucose monitoring and glycemic control. Despite such correlation, many individuals diagnosed with a diabetic condition do not monitor their glucose levels as frequently as they should due to a combination of factors including convenience, testing discretion, pain associated with glucose testing, and cost.

[0005] Devices have been developed for the automatic monitoring of analyte(s), such as glucose, in bodily fluid such as in the blood stream or in interstitial fluid ("ISF"), or other biological fluid. Some of these analyte measuring devices are configured so that at least a portion of the devices are positioned below a skin surface of a user, e.g., in a blood vessel or in the subcutaneous tissue of a user, so that the monitoring is accomplished in vivo.

[0006] With the continued development of analyte monitoring devices and systems, there is a need for such analyte monitoring devices, systems, and methods, as well as for processes for manufacturing analyte monitoring devices and systems that are cost effective, convenient, and with reduced pain, provide discreet monitoring to encourage frequent analyte monitoring to improve glycemic control.

[0007] Typically, a glucose monitor consists of an analyte sensor that is implanted in a patient and an electronics unit adapted to establish electrical communication with the analyte sensor. The electrical communication may be accomplished utilizing a number of different interconnects. For example, some electronics units utilize pogo pins, polymer pins, solid pins, or springs as interconnects. However, each of these known interconnects has potential drawbacks. For example, pogo pins are not durable and moisture can seep into the spring mechanism, thereby degrading their performance. Similarly, polymer pins can degrade and wear after multiple cleanings. Solid pins generally require extensive modification of existing systems, leading to higher costs for the patient. Spring connections are delicate, and may be prone to failure

after extended use. Therefore, there clearly exists a need for a low-cost, waterproof, flexible interconnect that allows for efficient and reliable electrical communication between an analyte sensor and an electronics unit.

[0008] In other instances, a user may need to wear an on-body analyte monitoring device for an extended period of time. Generally, the on-body monitoring device includes a mounting unit housing an analyte sensor and an electronics unit. However, such devices can be bulky and uncomfortable due to the size and vertical height ("Z-height") of the electronics unit and the size of the mounting unit, which is should be sufficiently large to house the electronics unit. Therefore, there exists a need for an on-body analyte monitoring device having a streamlined body and low profile (e.g., reduced Z-height) for a more comfortable wear and patient compliance.

SUMMARY OF INVENTION

[0009] Generally, the present invention relates to an interconnect configured to establish electrical communication between an analyte sensor and an electronics unit. The analyte sensor, interconnect, and the electronics unit define an on-body analyte monitoring device having a low profile. The on-body analyte monitoring device can be used with analyte monitoring system, such as for example, a continuous glucose monitoring system or analyte measurement system which provides analyte levels on demand. An analyte monitoring system generally includes an on-body analyte monitoring device and one or more receiver/display units. Optionally, the analyte monitoring system can further include a data processing unit, such as for example a CPU. Thus, in one embodiment, the on-body analyte monitoring device comprises an analyte sensor for measuring analyte levels, an electronics unit adapted to process the signals relating to the analyte levels generated by the analyte sensor, and an interconnect adapted to establish electrical conductivity between the electronics unit and the analyte sensor.

[0010] In one embodiment, the electronics unit includes a processor disposed within the body of the electronics unit. The processor can comprise an application specific integrated circuit (ASIC). In some embodiments, an elongate interconnect is coupled to the body of the electronics unit, such as for example the sidewall of the electronics unit proximate an analyte sensor. In some embodiments, the elongate interconnect can extend laterally from the electronics unit so as to contact an analyte sensor disposed adjacent the electronics unit.

[0011] The elongate interconnect comprises conductive material, such as but not limited to conductive cables, such as ribbon cables. In some embodiments, the conductive material can be embedded or etched in a flexible material, such as a flexible strip of thermoplastic material. The flexible strip may be formed from any suitable thermoplastic material. For example, the thermoplastic material includes polyimides such as Apical, Kapton, UPILEX, VTEC PI, Norton TH, polyester, mylar, and Kaptrex. However, in other embodiments, the conductive material can be encapsulated in a flexible sheath.

[0012] In some embodiments, the elongate interconnect is coupled to the electronics unit, for example, to a circuit board disposed in the body of the electronics unit, to establish electrical communication between the electronics unit and interconnect. Additionally, the elongate interconnect can establish electrical communication with an analyte sensor. In

some embodiments, the elongate interconnect can include a conductive material such as a conductive contact to contact or otherwise couple to the analyte sensor, thereby establishing electrical communication between the interconnect and the analyte sensor. In some embodiments, the elongate interconnect is formed of a flexible material such that the extended length of the interconnect can collapse or otherwise deform when the electronics unit is coupled to the analyte sensor. Upon disengagement of the analyte sensor and the electronics unit, the elongate interconnect can return to its non-collapsed configuration.

[0013] The analyte sensor, for example, in some embodiments, includes a substrate having conductive material, such as one or more electrodes and one or more conductive contacts. In some embodiments, the conductive material comprises gold, which can be formed using ablation techniques (e.g., laser ablation). The analyte sensor can be configured to monitor glucose levels or any other analyte of interest, including drugs.

[0014] In some embodiments, the electronics unit may further comprise a seal disposed proximate the elongate interconnect. The seal may be an individual molded component made of low durometer silicone, rubber or some other material TPE. In some embodiments, the interconnect extends approximately 1 mm beyond the face of the seal. When the electronics unit is locked into position, the interconnect compresses and makes contact with the conductive pads on the sensor. The seal also compresses to form a barrier around the perimeter of the interconnect/sensor connection. The interconnect may work without the seal, however once liquid or dust got in, the interconnect/sensor interface may be compromised and fail.

[0015] In some embodiments, the seal includes an opening to permit direct contact of a conductive contact disposed on the interconnect to the analyte sensor. In this manner, the analyte sensor and the electronics unit can establish electrical conductivity via the closed circuit provided by the interconnect.

[0016] In another aspect of the invention, an on-body analyte monitoring device having a reduced vertical height is provided. In one embodiment, the interconnect includes a top surface and a bottom surface adapted to engage, for example, interlock, with the body of the electronics unit. The interconnect includes conductive material, which establishes electrical communication with and between both an analyte sensor and an electronics unit. In some embodiments, the electronics unit may comprise a circuit board for interfacing with a conductive area of the interconnect thereby establishing electrical communication between the interconnect and the electronics unit. Thus, when interconnect is engaged to the electronics unit, the conductive material or areas of the interconnect form a closed circuitry with the electronics unit and the analyte sensor, thereby establishing electrical communication between the analyte sensor and the electronics unit.

[0017] In some embodiments, the conductive material includes a conductive film, such as an anisotropic film or an elastomeric connector, such as a Zebra® style connector. Alternatively, the first and second conductive material can include clips.

[0018] In one embodiment, the conductive surfaces can further include an adhesive for adhering the electronics unit and analyte sensor to the interconnect. The adhesive can be a UV curable adhesive or any other suitable adhesive. Other examples include a multi-adhesive system, such as a silver

loaded epoxy, which allows for the electronics unit and analyte sensor to be adhered together while also placing the electronics unit and analyte sensor in electrical communication.

[0019] The interconnect can also include a power source, such as a battery to power the electronics unit. In this manner, the electronics unit can be configured without its own internal power supply.

[0020] In some embodiments, the bottom surface of the interconnect includes an adhesive surface capable of bonding with human skin. Accordingly, the interconnect can also serve as a mounting unit to adhere the on-body device to a subject, such that a separate mounting unit component is not required.

[0021] In some embodiments, the interconnect is configured to engage the electronics unit to define a two-component on-body monitoring device. In other embodiments, the interconnect, sensor, and electronics unit are integrated to define a single component on-body monitoring device.

BRIEF DESCRIPTION OF THE DRAWINGS

[0022] FIG. 1A illustrates a block diagram of a data monitoring and management system for practicing one or more embodiments of the present invention;

[0023] FIG. 1B illustrates a schematic diagram of the elements of FIG. 1A;

[0024] FIG. 2 illustrates a schematic view of an electronics unit according to one or more embodiments of the present invention;

[0025] FIG. 3 illustrates a schematic view of the elongate interconnect of the electronics unit of FIG. 2 in a flat position;

[0026] FIG. 4 illustrates a schematic view of the electronics unit of FIG. 2 when it is in contact with an analyte sensor;

[0027] FIGS. 5A-5D depict various elongate interconnects compatible with one or more embodiments of the present invention;

[0028] FIG. 6 depicts a pictorial view of an analyte monitoring device according to another embodiment of the present invention;

[0029] FIG. 7A depicts a pictorial view of the analyte monitoring device of FIG. 6 when it is disassembled;

[0030] FIG. 7B depicts a bottom view of the on-body analyte monitoring device of FIG. 7A;

[0031] FIG. 8 depicts the interconnect of FIG. 7B with the battery and analyte sensor removed.

DETAILED DESCRIPTION OF THE EMBODIMENTS

[0032] Before the present disclosure is described in detail, it is to be understood that this disclosure is not limited to particular embodiments described, as such may, of course, vary. It is also to be understood that the terminology used herein is for the purpose of describing particular embodiments only, and is not intended to be limiting, since the scope of the present disclosure will be limited only by the appended claims.

[0033] Where a range of values is provided, it is understood that each intervening value, to the tenth of the unit of the lower limit unless the context clearly dictates otherwise, between the upper and lower limit of that range and any other stated or intervening value in that stated range, is encompassed within the disclosure. The upper and lower limits of these smaller ranges may independently be included in the smaller ranges is also encompassed within the disclosure, subject to any spe-

cifically excluded limit in the stated range. Where the stated range includes one or both of the limits, ranges excluding either or both of those included limits are also included in the disclosure.

[0034] Unless defined otherwise, all technical and scientific terms used herein have the same meaning as commonly understood by one of ordinary skill in the art to which this disclosure belongs. Although any methods and materials similar or equivalent to those described herein can also be used in the practice or testing of the present disclosure, the preferred methods and materials are now described. All publications mentioned herein are incorporated herein by reference to disclose and describe the methods and/or materials in connection with which the publications are cited.

[0035] It must be noted that as used herein and in the appended claims, the singular forms “a”, “an”, and “the” include plural referents unless the context clearly dictates otherwise.

[0036] The publications discussed herein are provided solely for their disclosure prior to the filing date of the present application. Nothing herein is to be construed as an admission that the present disclosure is not entitled to antedate such publication by virtue of prior disclosure.

[0037] Further, the dates of publication provided may be different from the actual publication dates which may need to be independently confirmed.

[0038] As will be apparent to those of skill in the art upon reading this disclosure, each of the individual embodiments described and illustrated herein has discrete components and features which may be readily separated from or combined with the features of any of the other several embodiments without departing from the scope or spirit of the present disclosure.

[0039] The figures shown herein are not necessarily drawn to scale, with some components and features being exaggerated for clarity.

[0040] Generally, embodiments of the present disclosure relate to in vivo methods and devices for detecting at least one analyte such as glucose in body fluid. Accordingly, embodiments include in vivo analyte sensors configured so that at least a portion of the sensor is positioned in the body of a user (e.g., within the ISF), to obtain information about at least one analyte of the body, e.g., transcutaneously positioned in user's body. In certain embodiments, an in vivo analyte sensor is coupled to an electronics unit that is maintained on the body of the user such as on a skin surface, where such coupling provides on body, in vivo analyte sensor electronics assemblies.

[0041] In certain embodiments, analyte information is communicated from a first device such as an on body electronics unit to a second device which may include user interface features, including a display, and/or the like. Information may be communicated from the first device to the second device automatically and/or continuously when the analyte information is available, or may not be communicated automatically and/or continuously, but rather stored or logged in a memory of the first device. Accordingly, in many embodiments of the system, analyte information derived by the sensor/on body electronics (for example, on body electronics assembly) is made available in a user-usable or viewable form only when queried by the user such that the timing of data communication is selected by the user.

[0042] In this manner, analyte information is only provided or evident to a user (provided at a user interface device) when

desired by the user even though an in vivo analyte sensor automatically and/or continuously monitors the analyte level in vivo, i.e., the sensor automatically monitors analyte such as glucose on a pre-defined time interval over its usage life. For example, an analyte sensor may be positioned in vivo and coupled to on body electronics for a given sensing period, e.g., about 14 days. In certain embodiments, the sensor-derived analyte information is automatically communicated from the sensor electronics assembly to a remote monitor device or display device for output to a user throughout the 14 day period according to a schedule programmed at the on body electronics (e.g., about every 1 minute or about every 5 minutes or about every 10 minutes, or the like). In certain embodiments, sensor-derived analyte information is only communicated from the sensor electronics assembly to a remote monitor device or display device at user-determined times, e.g., whenever a user decides to check analyte information. At such times, a communications system is activated and sensor-derived information is then sent from the on body electronics to the remote device or display device.

[0043] In still other embodiments, the information may be communicated from the first device to the second device automatically and/or continuously when the analyte information is available, and the second device stores or logs the received information without presenting or outputting the information to the user. In such embodiments, the information is received by the second device from the first device when the information becomes available (e.g., when the sensor detects the analyte level according to a time schedule). However, the received information is initially stored in the second device and only output to a user interface or an output component of the second device (e.g., display) upon detection of a request for the information on the second device.

[0044] Accordingly, in certain embodiments once a sensor electronics assembly is placed on the body so that at least a portion of the in vivo sensor is in contact with bodily fluid such as ISF and the sensor is electrically coupled to the electronics unit, sensor derived analyte information may be communicated from the on body electronics to a display device on-demand by powering on the display device (or it may be continually powered), and executing a software algorithm stored in and accessed from a memory of the display device, to generate one or more request commands, control signal or data packet to send to the on body electronics. The software algorithm executed under, for example, the control of the microprocessor or application specific integrated circuit (ASIC) of the display device may include routines to detect the position of the on body electronics relative to the display device to initiate the transmission of the generated request command, control signal and/or data packet.

[0045] Display devices may also include programming stored in memory for execution by one or more microprocessors and/or ASICs to generate and transmit the one or more request command, control signal or data packet to send to the on body electronics in response to a user activation of an input mechanism on the display device such as depressing a button on the display device, triggering a soft button associated with the data communication function, and so on. The input mechanism may be alternatively or additionally provided on or in the on body electronics which may be configured for user activation. In certain embodiments, voice commands or audible signals may be used to prompt or instruct the microprocessor or ASIC to execute the software routine(s) stored in the memory to generate and transmit the one or more request

command, control signal or data packet to the on body device. In the embodiments that are voice activated or responsive to voice commands or audible signals, on body electronics and/or display device includes a microphone, a speaker, and processing routines stored in the respective memories of the on body electronics and/or the display device to process the voice commands and/or audible signals. In certain embodiments, positioning the on body device and the display device within a predetermined distance (e.g., close proximity) relative to each other initiates one or more software routines stored in the memory of the display device to generate and transmit a request command, control signal or data packet.

[0046] Different types and/or forms and/or amounts of information may be sent for each on demand reading, including but not limited to one or more of current analyte level information (i.e., real time or the most recently obtained analyte level information temporally corresponding to the time the reading is initiated), rate of change of an analyte over a predetermined time period, rate of the rate of change of an analyte (acceleration in the rate of change), historical analyte information corresponding to analyte information obtained prior to a given reading and stored in memory of the assembly. Some or all of real time, historical, rate of change, rate of rate of change (such as acceleration or deceleration) information may be sent to a display device for a given reading. In certain embodiments, the type and/or form and/or amount of information sent to a display device may be preprogrammed and/or unchangeable (e.g., preset at manufacturing), or may not be preprogrammed and/or unchangeable so that it may be selectable and/or changeable in the field one or more times (e.g., by activating a switch of the system, etc). Accordingly, in certain embodiments, for each on demand reading, a display device will output a current (real time) sensor-derived analyte value (e.g., in numerical format), a current rate of analyte change (e.g., in the form of an analyte rate indicator such as an arrow pointing in a direction to indicate the current rate), and analyte trend history data based on sensor readings acquired by and stored in memory of on body electronics (e.g., in the form of a graphical trace). Additionally, the on skin or sensor temperature reading or measurement associated with each on demand reading may be communicated from the on body electronics to the display device. The temperature reading or measurement, however, may not be output or displayed on the display device, but rather, used in conjunction with a software routine executed by the display device to correct or compensate the analyte measurement output to the user on the display device.

[0047] As described, embodiments include in vivo analyte sensors and on body electronics that together provide body wearable sensor electronics assemblies. In certain embodiments, in vivo analyte sensors are fully integrated with on body electronics (fixedly connected during manufacture), while in other embodiments they are separate but connectable post manufacture (e.g., before, during or after sensor insertion into a body). On body electronics may include an in vivo glucose sensor, electronics, battery, and antenna encased (except for the sensor portion that is for in vivo positioning) in a waterproof housing that includes or is attachable to an adhesive pad. In certain embodiments, the housing withstands immersion in about one meter of water for up to at least 30 minutes. In certain embodiments, the housing withstands continuous underwater contact, e.g., for longer than about 30 minutes, and continues to function properly according to its

intended use, e.g., without water damage to the housing electronics where the housing is suitable for water submersion.

[0048] Embodiments include sensor insertion devices, which also may be referred to herein as sensor delivery units, or the like. Insertion devices may retain on body electronics assemblies completely in an interior compartment, i.e., an insertion device may be “pre-loaded” with on body electronics assemblies during the manufacturing process (e.g., on body electronics may be packaged in a sterile interior compartment of an insertion device). In such embodiments, insertion devices may form sensor assembly packages (including sterile packages) for pre-use or new on body electronics assemblies, and insertion devices configured to apply on body electronics assemblies to recipient bodies.

[0049] Embodiments include portable handheld display devices, as separate devices and spaced apart from an on body electronics assembly, that collect information from the assemblies and provide sensor derived analyte readings to users. Such devices may also be referred to as meters, readers, monitors, receivers, human interface devices, companions, or the like. Certain embodiments may include an integrated in vitro analyte meter. In certain embodiments, display devices include one or more wired or wireless communications ports such as USB, serial, parallel, or the like, configured to establish communication between a display device and another unit (e.g., on body electronics, power unit to recharge a battery, a PC, etc). For example, a display device communication port may enable charging a display device battery with a respective charging cable and/or data exchange between a display device and its compatible informatics software.

[0050] Compatible informatics software in certain embodiments include, for example, but not limited to stand alone or network connection enabled data management software program, resident or running on a display device, personal computer, a server terminal, for example, to perform data analysis, charting, data storage, data archiving and data communication as well as data synchronization. Informatics software in certain embodiments may also include software for executing field upgradable functions to upgrade firmware of a display device and/or on body electronics unit to upgrade the resident software on the display device and/or the on body electronics unit, e.g., with versions of firmware that include additional features and/or include software bugs or errors fixed, etc.

[0051] Embodiments may include a haptic feedback feature such as a vibration motor or the like, configured so that corresponding notifications (e.g., a successful on-demand reading received at a display device), may be delivered in the form of haptic feedback.

[0052] Embodiments include programming embedded on a computer readable medium, i.e., computer-based application software (may also be referred to herein as informatics software or programming or the like) that processes analyte information obtained from the system and/or user self-reported data. Application software may be installed on a host computer such as a mobile telephone, PC, an Internet-enabled human interface device such as an Internet-enabled phone, personal digital assistant, or the like, by a display device or an on body electronics unit. Informatics programming may transform data acquired and stored on a display device or on body unit for use by a user.

[0053] Embodiments of the subject disclosure are described primarily with respect to glucose monitoring devices and systems, and methods of glucose monitoring, for convenience only and such description is in no way intended

to limit the scope of the disclosure. It is to be understood that the analyte monitoring system may be configured to monitor a variety of analytes at the same time or at different times.

[0054] For example, analytes that may be monitored include, but are not limited to, acetyl choline, amylase, bilirubin, cholesterol, chorionic gonadotropin, creatine kinase (e.g., CK-MB), creatine, DNA, fructosamine, glucose, glutamine, growth hormones, hormones, ketones, lactate, oxygen, peroxide, prostate-specific antigen, prothrombin, RNA, thyroid stimulating hormone, and troponin. The concentration of drugs, such as, for example, antibiotics (e.g., gentamicin, vancomycin, and the like), digitoxin, digoxin, drugs of abuse, theophylline, and warfarin, may also be monitored. In those embodiments that monitor more than one analyte, the analytes may be monitored at the same or different times, with a single sensor or with a plurality of sensors which may use the same on body electronics (e.g., simultaneously) or with different on body electronics.

[0055] As described in detail below, embodiments include devices, systems, kits and/or methods to monitor one or more physiological parameters such as, for example, but not limited to, analyte levels, temperature levels, heart rate, user activity level, over a predetermined monitoring time period. Also provided are methods of manufacturing. Predetermined monitoring time periods may be less than about 1 hour, or may include about 1 hour or more, e.g., about a few hours or more, e.g., about a few days or more, e.g., about 3 or more days, e.g., about 5 days or more, e.g., about 7 days or more, e.g., about 10 days or more, e.g., about 14 days or more, e.g., about several weeks, e.g., about 1 month or more. In certain embodiments, after the expiration of the predetermined monitoring time period, one or more features of the system may be automatically deactivated or disabled at the on body electronics assembly and/or display device.

[0056] For example, a predetermined monitoring time period may begin with positioning the sensor in vivo and in contact with a body fluid such as ISF, and/or with the initiation (or powering on to full operational mode) of the on body electronics. Initialization of on body electronics may be implemented with a command generated and transmitted by a display device in response to the activation of a switch and/or by placing the display device within a predetermined distance (e.g., close proximity) to the on body electronics, or by user manual activation of a switch on the on body electronics unit, e.g., depressing a button, or such activation may be caused by the insertion device, e.g., as described in U.S. patent application Ser. No. 12/698,129 filed on Feb. 1, 2010 and U.S. Provisional Application Nos. 61/238,646, 61/246,825, 61/247,516, 61/249,535, 61/317,243, 61/345,562, and 61/361,374, the disclosures of each of which are incorporated herein by reference for all purposes.

[0057] When initialized in response to a received command from a display device, the on body electronics retrieves and executes from its memory software routine to fully power on the components of the on body electronics, effectively placing the on body electronics in full operational mode in response to receiving the activation command from the display device. For example, prior to the receipt of the command from the display device, a portion of the components in the on body electronics may be powered by its internal power supply such as a battery while another portion of the components in the on body electronics may be in powered down or low power including no power, inactive mode, or all components may be in an inactive mode, powered down mode. Upon

receipt of the command, the remaining portion (or all) of the components of the on body electronics is switched to active, fully operational mode.

[0058] Embodiments of on body electronics may include one or more circuit boards with electronics including control logic implemented in ASIC, microprocessors, memory, and the like, and transcutaneously positionable analyte sensors forming a single assembly. On body electronics may be configured to provide one or more signals or data packets associated with a monitored analyte level upon detection of a display device of the analyte monitoring system within a predetermined proximity for a period of time (for example, about 2 minutes, e.g., 1 minute or less, e.g., about 30 seconds or less, e.g., about 10 seconds or less, e.g., about 5 seconds or less, e.g., about 2 seconds or less) and/or until a confirmation, such as an audible and/or visual and/or tactile (e.g., vibratory) notification, is output on the display device indicating successful acquisition of the analyte related signal from the on body electronics. A distinguishing notification may also be output for unsuccessful acquisition in certain embodiments.

[0059] In certain embodiments, the monitored analyte level may be correlated and/or converted to glucose levels in blood or other fluids such as ISF. Such conversion may be accomplished with the on body electronics, but in many embodiments will be accomplished with display device electronics. In certain embodiments, glucose level is derived from the monitored analyte level in the ISF.

[0060] Analyte sensors may be insertable into a vein, artery, or other portion of the body containing analyte. In certain embodiments, analyte sensors may be positioned in contact with ISF to detect the level of analyte, where the detected analyte level may be used to infer the user's glucose level in blood or interstitial tissue.

[0061] Embodiments include transcutaneous sensors and also wholly implantable sensors and wholly implantable assemblies in which a single assembly including the analyte sensor and electronics are provided in a sealed housing (e.g., hermetically sealed biocompatible housing) for implantation in a user's body for monitoring one or more physiological parameters.

Embodiments of In Vivo Analyte Monitoring Systems

[0062] FIGS. 1A and 1B show an exemplary in vivo-based analyte monitoring system **100** in accordance with embodiments of the present disclosure. As shown, in certain embodiments, analyte monitoring system **100** includes on body electronics **110** electrically coupled to in vivo analyte sensor **101** and attached to adhesive layer **140** for attachment on a skin surface on the body of a user. On body electronics **110** includes on body housing **119**, that defines an interior compartment. Also shown in FIG. 1B is insertion device **150** that, when operated, transcutaneously positions a portion of analyte sensor **101** through a skin surface and in fluid contact with interstitial fluid, and positions on body electronics **110** and adhesive layer **140** on a skin surface. In certain embodiments, on body electronics **110**, analyte sensor **101** and adhesive layer **140** are sealed within the housing of insertion device **150** before use, and in certain embodiments, adhesive layer **140** is also sealed within the housing or itself provides a terminal seal of the insertion device **150**. Devices, systems and methods that maybe used with embodiments herein are described, e.g., in U.S. patent application Ser. No. 12/698,129 and U.S. Provisional Application Nos. 61/238,646, 61/246,

825, 61/247,516, 61/249,535, 61/317,243, 61/345,562, and 61/361,374, the disclosures of each of which are incorporated herein by reference for all purposes.

[0063] Referring back to the FIG. 1B, analyte monitoring system **100** includes display device **120** which includes a display **122** to output information to the user, an input component **121** such as a button, actuator, a touch sensitive switch, a capacitive switch, pressure sensitive switch, jog wheel or the like, to input data or command to display device **120** or otherwise control the operation of display device **120**. It is noted that some embodiments may include display-less devices or devices without any user interface components. These devices may be functionalized to store data as a data logger and/or provide a conduit to transfer data from on body electronics and/or a display-less device to another device and/or location. Embodiments will be described herein as display devices for exemplary purposes which are in no way intended to limit the embodiments of the present disclosure. It will be apparent that display-less devices may also be used in certain embodiments.

[0064] In certain embodiments, on body electronics **110** may be configured to store some or all of the monitored analyte related data received from analyte sensor **101** in a memory during the monitoring time period, and maintain it in memory until the usage period ends. In such embodiments, stored data is retrieved from on body electronics **110** at the conclusion of the monitoring time period, for example, after removing analyte sensor **101** from the user by detaching on body electronics **110** from the skin surface where it was positioned during the monitoring time period. In such data logging configurations, real time monitored analyte level is not communicated to display device **120** during the monitoring period or otherwise transmitted from on body electronics **110**, but rather, retrieved from on body electronics **110** after the monitoring time period.

[0065] In certain embodiments, input component **121** of display device **120** may include a microphone and display device **120** may include software configured to analyze audio input received from the microphone, such that functions and operation of the display device **120** may be controlled by voice commands. In certain embodiments, an output component of display device **120** includes a speaker for outputting information as audible signals. Similar voice responsive components such as a speaker, microphone and software routines to generate, process and store voice driven signals may be provided to on body electronics **110**.

[0066] In certain embodiments, display **122** and input component **121** may be integrated into a single component, for example a display that can detect the presence and location of a physical contact touch upon the display such as a touch screen user interface. In such embodiments, the user may control the operation of display device **120** by utilizing a set of pre-programmed motion commands, including, but not limited to, single or double tapping the display, dragging a finger or instrument across the display, motioning multiple fingers or instruments toward one another, motioning multiple fingers or instruments away from one another, etc. In certain embodiments, a display includes a touch screen having areas of pixels with single or dual function capacitive elements that serve as LCD elements and touch sensors.

[0067] Display device **120** also includes data communication port **123** for wired data communication with external devices such as remote terminal (personal computer) **170**, for example. Example embodiments of the data communication

port **123** include USB port, mini USB port, RS-**232** port, Ethernet port, Firewire port, or other similar data communication ports configured to connect to the compatible data cables. Display device **120** may also include an integrated in vitro glucose meter, including in vitro test strip port **124** to receive an in vitro glucose test strip for performing in vitro blood glucose measurements.

[0068] Referring still to FIG. 1A, display **122** in certain embodiments is configured to display a variety of information—some or all of which may be displayed at the same or different time on display **122**. In certain embodiments the displayed information is user-selectable so that a user can customize the information shown on a given display screen. Display **122** may include but is not limited to graphical display **138**, for example, providing a graphical output of glucose values over a monitored time period (which may show important markers such as meals, exercise, sleep, heart rate, blood pressure, etc, numerical display **132**, for example, providing monitored glucose values (acquired or received in response to the request for the information), and trend or directional arrow display **131** that indicates a rate of analyte change and/or a rate of the rate of analyte change, e.g., by moving locations on display **122**.

[0069] As further shown in FIG. 1B, display **222** may also include date display **135** providing for example, date information for the user, time of day information display **139** providing time of day information to the user, battery level indicator display **133** which graphically shows the condition of the battery (rechargeable or disposable) of the display device **120**, sensor calibration status icon display **134** for example, in monitoring systems that require periodic, routine or a predetermined number of user calibration events, notifying the user that the analyte sensor calibration is necessary, audio/vibratory settings icon display **136** for displaying the status of the audio/vibratory output or alarm state, and wireless connectivity status icon display **137** that provides indication of wireless communication connection with other devices such as on body electronics, data processing module **160**, and/or remote terminal **170**. As additionally shown in FIG. 1, display **122** may further include simulated touch screen button **125**, **126** for accessing menus, changing display graph output configurations or otherwise for controlling the operation of display device **120**.

[0070] Referring back to FIG. 1B, in certain embodiments, display **122** of display device **120** may be additionally, or instead of visual display, configured to output alarms notifications such as alarm and/or alert notifications, glucose values etc, which may be audible, tactile, or any combination thereof. In one aspect, the display device **120** may include other output components such as a speaker, vibratory output component and the like to provide audible and/or vibratory output indication to the user in addition to the visual output indication provided on display **122**. Further details and other display embodiments can be found in, e.g., U.S. patent application Ser. No. 12/871,901, U.S. provisional application Nos. 61/238,672, 61/247,541, 61/297,625, the disclosures of each of which are incorporated herein by reference for all purposes.

[0071] After the positioning of on body electronics **110** on the skin surface and analyte sensor **101** in vivo to establish fluid contact with interstitial fluid (or other appropriate body fluid), on body electronics **110** in certain embodiments is configured to wirelessly communicate analyte related data (such as, for example, data corresponding to monitored ana-

lyte level and/or monitored temperature data, and/or stored historical analyte related data) when on body electronics **110** receives a command or request signal from display device **120**. In certain embodiments, on body electronics **110** may be configured to at least periodically broadcast real time data associated with monitored analyte level which is received by display device **120** when display device **120** is within communication range of the data broadcast from on body electronics **110**, i.e., it does not need a command or request from a display device to send information.

[0072] For example, display device **120** may be configured to transmit one or more commands to on body electronics **110** to initiate data transfer, and in response, on body electronics **110** may be configured to wirelessly transmit stored analyte related data collected during the monitoring time period to display device **120**. Display device **120** may in turn be connected to a remote terminal **170** such as a personal computer and functions as a data conduit to transfer the stored analyte level information from the on body electronics **110** to remote terminal **170**. In certain embodiments, the received data from the on body electronics **110** may be stored (permanently or temporarily) in one or more memory of the display device **120**. In certain other embodiments, display device **120** is configured as a data conduit to pass the data received from on body electronics **110** to remote terminal **170** that is connected to display device **120**.

[0073] Referring still to FIG. 1B, also shown in analyte monitoring system **100** are data processing module **160** and remote terminal **170**. Remote terminal **170** may include a personal computer, a server terminal a laptop computer or other suitable data processing devices including software for data management and analysis and communication with the components in the analyte monitoring system **100**. For example, remote terminal **170** may be connected to a local area network (LAN), a wide area network (WAN), or other data network for uni-directional or bi-directional data communication between remote terminal **170** and display device **120** and/or data processing module **160**.

[0074] Remote terminal **170** in certain embodiments may include one or more computer terminals located at a physician's office or a hospital. For example, remote terminal **170** may be located at a location other than the location of display device **120**. Remote terminal **170** and display device **120** could be in different rooms or different buildings. Remote terminal **170** and display device **120** could be at least about one mile apart, e.g., at least about **10** miles apart, e.g., at least about **100** miles apart. For example, remote terminal **170** could be in the same city as display device **120**, remote terminal **170** could be in a different city than display device **120**, remote terminal **170** could be in the same state as display device **120**, remote terminal **170** could be in a different state than display device **120**, remote terminal **170** could be in the same country as display device **120**, or remote terminal **170** could be in a different country than display device **120**, for example.

[0075] In certain embodiments, a separate, optional data communication/processing device such as data processing module **160** may be provided in analyte monitoring system **100**. Data processing module **160** may include components to communicate using one or more wireless communication protocols such as, for example, but not limited to, infrared (IR) protocol, Bluetooth protocol, Zigbee protocol, and 802.11 wireless LAN protocol. Additional description of communication protocols including those based on Bluetooth proto-

col and/or Zigbee protocol can be found in U.S. Patent Publication No. 2006/0193375 incorporated herein by reference for all purposes. Data processing module **160** may further include communication ports, drivers or connectors to establish wired communication with one or more of display device **120**, on body electronics **110**, or remote terminal **170** including, for example, but not limited to USB connector and/or USB port, Ethernet connector and/or port, FireWire connector and/or port, or RS-232 port and/or connector.

[0076] In certain embodiments, data processing module **160** is programmed to transmit a polling or query signal to on body electronics **110** at a predetermined time interval (e.g., once every minute, once every five minutes, or the like), and in response, receive the monitored analyte level information from on body electronics **110**. Data processing module **160** stores in its memory the received analyte level information, and/or relays or retransmits the received information to another device such as display device **120**. More specifically in certain embodiments, data processing module **160** may be configured as a data relay device to retransmit or pass through the received analyte level data from on body electronics **110** to display device **120** or a remote terminal (for example, over a data network such as a cellular or WiFi data network) or both.

[0077] In certain embodiments, on body electronics **110** and data processing module **160** may be positioned on the skin surface of the user within a predetermined distance of each other (for example, about 1-12 inches, or about 1-10 inches, or about 1-7 inches, or about 1-5 inches) such that periodic communication between on body electronics **110** and data processing module **160** is maintained. Alternatively, data processing module **160** may be worn on a belt or clothing item of the user, such that the desired distance for communication between the on body electronics **110** and data processing module **160** for data communication is maintained. In a further aspect, the housing of data processing module **160** may be configured to couple to or engage with on body electronics **110** such that the two devices are combined or integrated as a single assembly and positioned on the skin surface. In further embodiments, data processing module **160** is detachably engaged or connected to on body electronics **110** providing additional modularity such that data processing module **160** may be optionally removed or reattached as desired.

[0078] Referring again to FIG. 1, in certain embodiments, data processing module **160** is programmed to transmit a command or signal to on body electronics **110** at a predetermined time interval such as once every minute, or once every 5 minutes or once every 30 minutes or any other suitable or desired programmable time interval to request analyte related data from on body electronics **110**. When data processing module **160** receives the requested analyte related data, it stores the received data. In this manner, analyte monitoring system **100** may be configured to receive the continuously monitored analyte related information at the programmed or programmable time interval, which is stored and/or displayed to the user. The stored data in data processing module **160** may be subsequently provided or transmitted to display device **120**, remote terminal **170** or the like for subsequent data analysis such as identifying frequency of periods of glycemic level excursions over the monitored time period, or the frequency of the alarm event occurrence during the monitored time period, for example, to improve therapy related decisions. Using this information, the doctor, healthcare pro-

vider or the user may adjust or recommend modification to the diet, daily habits and routines such as exercise, and the like.

[0079] In another embodiment, data processing module **160** transmits a command or signal to on body electronics **110** to receive the analyte related data in response to a user activation of a switch provided on data processing module **160** or a user initiated command received from display device **120**. In further embodiments, data processing module **160** is configured to transmit a command or signal to on body electronics **110** in response to receiving a user initiated command only after a predetermined time interval has elapsed. For example, in certain embodiments, if the user does not initiate communication within a programmed time period, such as, for example about 5 hours from last communication (or 10 hours from the last communication, or 24 hours from the last communication), the data processing module **160** may be programmed to automatically transmit a request command or signal to on body electronics **110**. Alternatively, data processing module **160** may be programmed to activate an alarm to notify the user that a predetermined time period of time has elapsed since the last communication between the data processing module **160** and on body electronics **110**. In this manner, users or healthcare providers may program or configure data processing module **160** to provide certain compliance with analyte monitoring regimen, so that frequent determination of analyte levels is maintained or performed by the user.

[0080] In certain embodiments, when a programmed or programmable alarm condition is detected (for example, a detected glucose level monitored by analyte sensor **101** that is outside a predetermined acceptable range indicating a physiological condition which requires attention or intervention for medical treatment or analysis (for example, a hypoglycemic condition, a hyperglycemic condition, an impending hyperglycemic condition or an impending hypoglycemic condition), the one or more output indications may be generated by the control logic or processor of the on body electronics **110** and output to the user on a user interface of on body electronics **110** so that corrective action may be timely taken. In addition to or alternatively, if display device **120** is within communication range, the output indications or alarm data may be communicated to display device **120** whose processor, upon detection of the alarm data reception, controls the display **122** to output one or more notification.

[0081] In certain embodiments, control logic or microprocessors of on body electronics **110** include software programs to determine future or anticipated analyte levels based on information obtained from analyte sensor **101**, e.g., the current analyte level, the rate of change of the analyte level, the acceleration of the analyte level change, and/or analyte trend information determined based on stored monitored analyte data providing a historical trend or direction of analyte level fluctuation as function time during monitored time period. Predictive alarm parameters may be programmed or programmable in display device **120**, or the on body electronics **110**, or both, and output to the user in advance of anticipating the user's analyte level reaching the future level. This provides the user an opportunity to take timely corrective action.

[0082] Information, such as variation or fluctuation of the monitored analyte level as a function of time over the monitored time period providing analyte trend information, for example, may be determined by one or more control logic or microprocessors of display device **120**, data processing module **160**, and/or remote terminal **170**, and/or on body electron-

ics **110**. Such information may be displayed as, for example, a graph (such as a line graph) to indicate to the user the current and/or historical and/or and predicted future analyte levels as measured and predicted by the analyte monitoring system **100**. Such information may also be displayed as directional arrows (for example, see trend or directional arrow display **131**) or other icon(s), e.g., the position of which on the screen relative to a reference point indicated whether the analyte level is increasing or decreasing as well as the acceleration or deceleration of the increase or decrease in analyte level. This information may be utilized by the user to determine any necessary corrective actions to ensure the analyte level remains within an acceptable and/or clinically safe range. Other visual indicators, including colors, flashing, fading, etc., as well as audio indicators including a change in pitch, volume, or tone of an audio output and/or vibratory or other tactile indicators may also be incorporated into the display of trend data as means of notifying the user of the current level and/or direction and/or rate of change of the monitored analyte level. For example, based on a determined rate of glucose change, programmed clinically significant glucose threshold levels (e.g., hyperglycemic and/or hypoglycemic levels), and current analyte level derived by an in vivo analyte sensor, the system **100** may include an algorithm stored on computer readable medium to determine the time it will take to reach a clinically significant level and will output notification in advance of reaching the clinically significant level, e.g., 30 minutes before a clinically significant level is anticipated, and/or 20 minutes, and/or 10 minutes, and/or 5 minutes, and/or 3 minutes, and/or 1 minute, and so on, with outputs increasing in intensity or the like.

[0083] Referring again back to FIG. 1B, in certain embodiments, software algorithm(s) for execution by data processing module **160** may be stored in an external memory device such as an SD card, microSD card, compact flash card, XD card, Memory Stick card, Memory Stick Duo card, or USB memory stick/device including executable programs stored in such devices for execution upon connection to the respective one or more of the on body electronics **110**, remote terminal **170** or display device **120**. In a further aspect, software algorithms for execution by data processing module **160** may be provided to a communication device such as a mobile telephone including, for example, WiFi or Internet enabled smart phones or personal digital assistants (PDAs) as a downloadable application for execution by the downloading communication device.

[0084] Examples of smart phones include Windows®, Android™, iPhone® operating system, Palm® WebOS™, Blackberry® operating system, or Symbian® operating system based mobile telephones with data network connectivity functionality for data communication over an internet connection and/or a local area network (LAN). PDAs as described above include, for example, portable electronic devices including one or more microprocessors and data communication capability with a user interface (e.g., display/output unit and/or input unit, and configured for performing data processing, data upload/download over the internet, for example. In such embodiments, remote terminal **170** may be configured to provide the executable application software to the one or more of the communication devices described above when communication between the remote terminal **170** and the devices are established.

[0085] In still further embodiments, executable software applications may be provided over-the-air (OTA) as an OTA

download such that wired connection to remote terminal 170 is not necessary. For example, executable applications may be automatically downloaded as software download to the communication device, and depending upon the configuration of the communication device, installed on the device for use automatically, or based on user confirmation or acknowledgement on the communication device to execute the installation of the application. The OTA download and installation of software may include software applications and/or routines that are updates or upgrades to the existing functions or features of data processing module 160 and/or display device 120.

[0086] Referring back to remote terminal 170 of FIG. 1B, in certain embodiments, new software and/or software updates such as software patches or fixes, firmware updates or software driver upgrades, among others, for display device 120 and/or on body electronics 110 and/or data processing module 160 may be provided by remote terminal 170 when communication between the remote terminal 170 and display device 120 and/or data processing module 160 is established. For example, software upgrades, executable programming changes or modification for on body electronics 110 may be received from remote terminal 170 by one or more of display device 120 or data processing module 160, and thereafter, provided to on body electronics 110 to update its software or programmable functions. For example, in certain embodiments, software received and installed in on body electronics 110 may include software bug fixes, modification to the previously stalled software parameters (modification to analyte related data storage time interval, resetting or adjusting time base or information of on body electronics 110, modification to the transmitted data type, data transmission sequence, or data storage time period, among others). Additional details describing field upgradability of software of portable electronic devices, and data processing are provided in U.S. application Ser. Nos. 12/698,124, 12/794,721, 12/699,653, and 12/699,844, and U.S. Provisional Application Nos. 61,359,265, and 61/325,155 the disclosure of which is incorporated by reference herein for all purposes.

[0087] Referring to FIGS. 1A and 1B, an analyte monitoring system 100 can generally include, in accordance with one embodiment, an on-body analyte monitoring device 101, 110, a receiver 104, data processing terminal 105, and secondary receiver unit 106. Generally, analyte sensor 101 operatively contacts an analyte to be monitored in a biological fluid, such as but not limited to blood or interstitial fluid, and converts the contacted analyte level into data signals relating to the amount or concentration of the analyte. The data signals are communicated to the on body electronics 110, which is in electrical communication with analyte sensor 101. The electronics unit can be a separate and distinct component, or can be integrated with the analyte sensor to define a single component. The on body electronics 110 processes the data signals (e.g., encodes signals) received from analyte sensor 101 and transmits the processed data signals to receiver 104, e.g., a primary receiver, along a communication link 103. The communication between on body electronics 110 and receiver 104 can be either unidirectional or bidirectional.

[0088] In one aspect of the invention, an interconnect is provided to establish electrical communication with a transmitter, transceiver, communications circuit or other electronics. For example, as illustrated in FIG. 2, on-body electronics unit 110 comprises a body including housing 202. The housing includes a top wall connected to a bottom wall by a

sidewall. An elongate interconnect 204 can be coupled to the on body electronics 110. The elongate interconnect 204 comprises conductive material disposed at least partially along a body having a first end 212 coupled, e.g., permanently affixed or removably fixed, to housing 202. In one embodiment, the first end 212 can be secured to a printed circuit board 208 disposed in the body of the on body electronics 110. The elongate interconnect can further include a second end 214 engaged to the on body electronics body, for example, the second end 214 in some embodiments, can be engaged to the housing 202, such as slidingly engaged, for example at an end opposite the first end 212. Alternatively, the second end of interconnect 204 may be permanently affixed to the opposite side of housing 202.

[0089] As shown in FIG. 2, a length of the elongate interconnect body 204 can be configured to extend laterally from a sidewall of the housing 202. In one embodiment, the elongate interconnect 204 body can include a generally U-shaped configuration along its length. As such, the interconnect can be configured to physically contact an analyte sensor disposed proximate the on body electronics body.

[0090] In some embodiments, a conductive contact 206 can be located along a length of the elongate interconnect 204. The contact plate is configured to contact an analyte sensor and establish electrical conductivity between the on body electronics and the analyte sensor. (See FIG. 4). As described, the elongate interconnect comprises conductive material. In one embodiment, the conductive material defines one or more conductive areas along the body of the interconnect. The conductive areas can include one or more conductive contacts and one or more conductive traces disposed between conductive contacts along at least a portion of the length of the elongate interconnect body. Thus, when in direct contact with the electronic circuitry of the on body electronics and/or a sensor, electrical communications can be established.

[0091] For example, referring now to FIG. 3, one embodiment of elongate interconnect 204 includes the one or more conductive areas defined by conductive material 302, 306, 308. As shown, conductive traces 302 extend between conductive contacts 306 and 308. In this manner, the elongate interconnect includes a conductive surface attachable to the on body electronics, which can establish electrical communication with the on body electronics during contact.

[0092] In some embodiments, the conductive material of elongate interconnect includes conductive traces 302 embedded in a flexible material, such as a flexible strip 304, which generally can be formed from a thermoplastic material. Suitable thermoplastic materials include polyimides such as Apical, Kapton, UPILEX, VTEC PI, Norton TH and Kaptrex. In other embodiments, conductive traces 302 are encapsulated in a flexible sheath. The elongate interconnect can further include conductive films and tapes as described infra.

[0093] Suitable elongate interconnects 204 include those depicted in FIGS. 5A-5D. As illustrated, the elongate interconnect can comprise conductive material including conductive cables, including but not limited to high speed ribbon cables, microquick twist ribbon cables, microZip cables, mini probe cables, quick twist cables, ribbonized automation cables, shielded flat ribbon cables, or wide pitch ribbon cables, as illustrated in FIGS. 5A to 5D. In addition, other suitable elongate interconnects include All Flex®, Molex®, Tech-Etch®, and Teknoflex®.

[0094] The conductive material associated with the interconnect, as well as the on body electronics and/or analyte

sensor, can comprise a non-corroding metal or carbon wire. Suitable conductive materials include, for example, vitreous carbon, graphite, silver, silver-chloride, platinum, palladium, or gold. The conductive material disposed on the component part, e.g., interconnect, sensor, or on body electronics, can comprise a combination of conductive metals, alloys and polymers. In this regard, for example, the electrodes and the conductive traces and/or conductive contacts can be formed from different conductive materials. The conductive material can be applied to the substrate by various techniques including laser ablation, printing, etching, and photolithography. However, any suitable conductive material may be utilized.

[0095] Referring back to FIG. 3, conductive contact 306, which is located proximate first end 212, can establish electrical communication with the on body electronics 110, for example, the printed circuit board. The electrical communication in the form of electrical signals can travel towards or from the analyte sensor (not shown) via the conductive traces 302 and conductive contacts 308. Similarly, conductive area 308, located along a length of elongate member 204, allows conductive traces 302 to be in electrical communication with conductive contact 206 (not shown) such that a closed circuit is established between the analyte sensor, interconnect and on body electronics.

[0096] In one embodiment, on body electronics 110 includes a temperature sensor. For each sampled signal from analyte sensor 101, the temperature sensor can provide measured temperature information. In another embodiment, on body electronics 110 includes a low-temperature monitor that disables communication from on body electronics 110 if the measured temperature falls below a predefined threshold (e.g., below 5° C.). This is done to protect the on body electronics from over-stressing the energy source of the on body electronics under low-temperature conditions. If the temperature rises above the predefined threshold, the low-temperature monitor enables communication from on body electronics 110.

[0097] In accordance with another aspect of the invention, on body electronics 110 includes a low battery voltage monitor that disables the energy source of the on body electronics if the voltage level is too low to reliably transmit communication. The temperature sensor, low-temperature monitor, and the low battery voltage monitor may be controlled via a processor located in on body electronics 110. In a preferred embodiment, the processor is an application specific integrated circuit (ASIC).

[0098] In another aspect, as shown in FIG. 4, an on-body analyte monitoring device 100 is provided. The on-body analyte monitoring device includes on body electronics 110 coupled to analyte sensor (not shown). In one embodiment, the analyte sensor and on body electronics are housed in a mounting unit 404. The mounting unit includes adhesive applied to the bottom surface to attach the on-body unit to a user.

[0099] As illustrated in FIG. 4, elongate interconnect conductive contact 206 can be in direct contact with analyte sensor 402 to establish electrical communication between the on body electronics 110 and sensor 402. When analyte sensor 402 is into contact with on body electronics 110, elongate member 204 can be compressed or collapsed and seal 210 forms a protective barrier around the connection from harmful elements (e.g., dust, liquid, dirt) between the on body electronics and sensor. In one embodiment, seal 210 is formed from a flexible polymer.

[0100] Seal 210 may be an individual molded component made of a flexible polymer, low durometer silicone, rubber or some other material TPE. In some embodiments, the interconnect extends approximately 1 mm beyond the face of seal 210. When on body electronics 110 is locked into position, elongate interconnect 204 compresses and makes contact with the conductive pads on analyte sensor 402. The seal also compresses to form a barrier around the perimeter of the interconnect/sensor connection. Interconnect 204 may function without the seal, however once liquid or dust got in, the interconnect/sensor interface may be compromised and fail.

[0101] In some embodiments, the seal 210 includes an opening to permit direct contact of a conductive contact disposed on the interconnect to the analyte sensor. In this manner, the analyte sensor and the on body electronics can establish electrical conductivity via the closed circuit provided by the interconnect.

[0102] In another embodiment, the elongate member 204 returns to its original configuration after analyte sensor 402 is disengaged from on body electronics 110. The signals generated by the analyte sensor relating to the measured analyte levels from biological fluid can be processed by the on body electronics 110 by the electrical contact between sensor 402 and on body electronics via contact plate 206 of interconnect.

[0103] The analyte sensor 402 employed in the on-body device, in some embodiments, comprises a substrate, one or more electrodes, a sensing layer and a barrier layer, as described below and disclosed in U.S. Pat. Nos. 6,284,478 and 6,990,366, the disclosures of which are incorporated herein by reference. As the sensor is employed by insertion and/or implantation into a user's body for a period of days, in some embodiments, the substrate is formed from a relatively flexible material to improve comfort for the user and reduce damage to the surrounding tissue of the insertion site, e.g., by reducing relative movement of the sensor with respect to the surrounding tissue.

[0104] Suitable materials for a flexible substrate include, for example, non-conducting plastic or polymeric materials and other non-conducting, flexible, deformable materials. Suitable plastic or polymeric materials include thermoplastics such as polycarbonates, polyesters (e.g., Mylar® and polyethylene terephthalate (PET)), polyvinyl chloride (PVC), polyurethanes, polyethers, polyamides, polyimides, or copolymers of these thermoplastics, such as PETG (glycol-modified polyethylene terephthalate). In other embodiments, the sensor includes a relatively rigid substrate. Suitable examples of rigid materials that may be used to form the substrate include poorly conducting ceramics, such as aluminum oxide and silicon dioxide. Further, the substrate can be formed from an insulating material. Suitable insulating materials include polyurethane, teflon (fluorinated polymers), polyethyleneterephthalate (PET, Dacron) or polyimide.

[0105] The sensor can include a distal end and a proximal end having different widths. In such embodiments, the distal end of the substrate may have a relatively narrow width. Moreover, sensors intended to be transcutaneously positioned into the tissue of a user's body can be configured to have narrow distal end or distal point to facilitate the insertion of the sensor. For example, for insertable sensors designed for continuous or periodic monitoring of the analyte during normal activities of the patient, a distal end of the sensor which is to be implanted into the user has a width of 2 mm or less, preferably 1 mm or less, and more preferably 0.5 mm or less.

[0106] A plurality of electrodes is disposed near the distal end of the sensor. The electrodes can include a working electrode, counter electrode and reference electrode. Other embodiments, however, can include less or more electrodes. For example, as noted, a two electrode sensor can be utilized. Each of the electrodes is formed from conductive material, for example, a non-corroding metal or carbon wire. Suitable conductive materials include, for example, vitreous carbon, graphite, silver, silver-chloride, platinum, palladium, or gold. The conductive material can be applied to the substrate by various techniques including laser ablation, printing, etching, and photolithography. In one embodiment, each of the electrodes is formed from gold by a laser ablation technique. As further illustrated, the sensor can include conductive traces and extending from the one or more electrodes to respective contacts. In one embodiment, an insulating substrate (e.g., dielectric material) and electrodes can be arranged in a stacked orientation (i.e., insulating substrate disposed between electrodes. Alternatively, the electrodes can be arranged in a side by side orientation, as described in U.S. Pat. No. 6,175,752, the disclosure of which is incorporated herein by reference.

[0107] The sensor can include a sensing layer to facilitate the electrolysis of the analyte of interest. For example, the sensing layer can be an immobilized sensing layer comprising a catalyst and an electron transfer agent. Examples of immobilized sensing layers are described in U.S. Pat. Nos. 5,262,035, 5,264,104, 5,264,105, 5,320,725, 5,593,852, and 5,665,222, each of which is incorporated herein by reference. In some embodiments, the sensor can further include a barrier layer to act as a diffusion-limiting barrier to reduce the rate of mass transport of the analyte into the region around the working electrode. Examples of suitable barrier layers are described in U.S. Pat. Nos. 6,990,366 and 6,175,752, each of which is incorporated herein by reference.

[0108] In some embodiments, the sensor is a self-powered analyte sensor, which is capable of spontaneously passing a current directly proportional to analyte concentration in the absence of an external power source. Any exemplary sensor is described in U.S. patent application Ser. No. 12/393,921, filed Feb. 26, 2009, entitled "Self-Powered Analyte Sensor," which is hereby incorporated by reference in its entirety herein for all purposes.

[0109] FIG. 6, 7A-7B and 8 illustrate on body electronics including a module interconnect in certain embodiments, with FIGS. 8 and 7A illustrating top perspective views, while FIGS. 7B and 8 illustrating bottom perspective views. Referring to FIGS. 6 and 7A, on body electronics 600 includes modular sensor assembly 604 which includes analyte sensor 710 (see e.g., FIG. 7B), for engageably coupling with electronics component 604. As illustrated, the modular sensor assembly 602 may be configured to interlock or otherwise engage with the electronics component 604. Accordingly, upon engagement of modular sensor assembly 602 and electronics component 604, on body electronics 600 with analyte sensor 710 may be provided.

[0110] In certain embodiments, modular sensor assembly 602 may be a molded device, such as for example, formed by injection molding techniques. As illustrated in FIG. 7A, modular sensor assembly 602 includes bottom surface 701 connected to top surface 702 by sidewall 703. As can be seen in the perspective views of FIGS. 7B and 8, in certain embodiments, top surface 702 includes conductive material 714 disposed thereon. Further, top surface 702 may include a vertical

surface extending downwardly, which may include conductive material 716 disposed thereon. In certain embodiments, conductive material 716 includes conductive traces and/or conductive contacts.

[0111] Still referring to the figures, on body electronics 600 in certain embodiments include modular sensor assembly 602 and electronics component 604 configured for a slidable engagement. As illustrated in FIG. 7A, the bottom of electronics component 604 may include a surface configured to slidably receive modular sensor assembly 602. Further, in certain embodiments, top surface 702 of modular sensor assembly 602 may be configured to define a tongue to interlock with a corresponding groove 704 defined in electronics component 604 to define the shape of on body electronics 600.

[0112] Electronics component 604 in certain embodiments may include one or more PCBs including conductive material 708 disposed thereon, such as one or more conductive traces and/or conductive contacts. During engagement of electronics component 604 with modular sensor assembly 602, the conductive material 708 can interface with interconnect conductive material 714. Thus, during engagement, the electronics component 604 and modular sensor assembly 602 establishes electrical communication.

[0113] As illustrated in FIG. 7B, modular sensor assembly 602 includes analyte sensor 710 secured or otherwise coupled to a surface of the modular sensor assembly 602. For example, analyte sensor 710 may be coupled to the vertical surface extending from the top surface of the modular sensor assembly 602. In this manner, the vertical surface includes conductive material, such as conductive contacts 816 that connect with the one or more conductive contacts of analyte sensor 710 to establish an electrical communication between analyte sensor 710 and modular sensor assembly 602.

[0114] In certain embodiments, as best illustrated in FIGS. 7B and 8, analyte sensor 710 may be mounted to sidewall 716 of modular sensor assembly 602. In this embodiment, distal portion 710a of analyte sensor 710 is inserted perpendicular to the skin (not shown). In this regard, the bottom surface of the modular sensor assembly 602 includes an aperture 720 (FIGS. 7B) to permit the distal portion 710a of analyte sensor 710 to extend from the bottom of on body electronics 600 such that distal portion 710a of analyte sensor 710 may be implanted into the body of a user when in use. In certain embodiments, modular sensor assembly 602 may also include a power source 712, such as a battery. Power source 712 may provide power via conductive traces 714 to the electronics component 604. In this manner, the electronics component 604 may be powered by power source 412 of modular sensor assembly 602 such that the electronics component 806 does not need an internal power source.

[0115] The conductive material disposed on the modular sensor assembly 602 and/or the electronics component 604 and analyte sensor 710 may include conductive film, such as but not limited to, an anisotropic film. Conductive material, such as the conductive film and/or the Zebra style connector, can provide both a mechanical and electrical connection between modular sensor assembly 602 and sensor 710 or electronics component 604. Modular sensor assembly 602, analyte sensor 710, and electronics component 604 may also be bonded together utilizing an adhesive, such as a UV curable adhesive, or a multi-adhesive, such as a silver loaded epoxy can be used. Other adhesives can alternatively be employed.

[0116] The sensor and the on body electronics can establish electrical communication by way of the interconnect. In this manner, the one or more electrodes of the analyte sensor generate a signal relative to the analyte levels depicted in the bodily fluid of the user, the conductive traces permit the signal to travel to the conductive contacts of the sensor which is in electrical communication with the conductive material, e.g., conductive contacts **804** of the interconnect. By way of the conductive traces **716** and **802**, which establish electrical communication with the on body electronics **602**, the signals relative to the analyte levels are communicated to the on body electronics **600** and/or modular sensor assembly **602** can include an adhesive to attach to the skin of the user. Thus, the interconnect can serve as a mounting unit for the on-body monitoring device to be worn by a user. The on-body analyte monitoring device, as described above, can be employed as a component of an analyte monitoring system, such as the systems illustrated in FIGS. 1A and 1B.

[0117] On body electronics **600** may be mounted to the user as one component or separately. For example, with reference to FIG. 7A, the modular sensor assembly **602** may be first mounted on the skin such that the distal portion **710a** (not shown) of the sensor **710** is at least partially inserted in to the skin. An adhesive (not shown) is used to fix modular sensor assembly **602** to the skin. Subsequently, the electronics component **604** may be attached to modular sensor assembly, for example, by sliding the electronics component **604** in the direction of arrow **7A**, such that the modular sensor assembly **602** and electronics component **604** are secured together. In some embodiments, the electronics component **604** is mounted first and the modular sensor assembly **602** is mounted subsequently.

[0118] In some embodiments, the modular sensor assembly **602** and electronics **604** component are secured together, and then subsequently mounted onto the patient as a single unit **600**. Insertion of electronics unit **600** by an inserter, such as inserter **150** (FIG. 1B) is further described in insertion device, e.g., as described in U.S. patent application Ser. No. 12/698,129 filed on Feb. 1, 2010 and U.S. Provisional Application Nos. 61/238,646, 61/246,825, 61/247,516, 61/249,535, 61/317,243, 61/345,562, and 61/361,374, the disclosures of each of which are incorporated herein by reference for all purposes.

[0119] In some embodiments, the analyte monitoring system **100** can include a secondary receiver **106** which is operatively coupled to the communication link and configured to receive data transmitted from the on body electronics **110**. Moreover, the secondary receiver **106** can be configured to communicate with the display unit **120** as well as a data processing terminal **170**. The secondary receiver **106** may be configured for bi-directional wireless communication with each or one of the display unit **104** and the data processing terminal **105**.

[0120] In one embodiment, the secondary receiver **106** may be configured to include a limited number of functions and features as compared with the display unit **104**. As such, the secondary receiver **106** may be configured substantially in a smaller compact housing or embodied in a device such as a wrist watch, pager, mobile phone, PDA, for example. Alternatively, the secondary receiver **106** may be configured with the same or substantially similar functionality as the display unit **104**. The receiver unit may be configured to be used in conjunction with a docking cradle unit, for example for one or

more of the following or other functions: placement by bedside, for re-charging, for data management, for night time monitoring, and/or bi-directional communication device.

[0121] Various other modifications and alterations in the structure and method of operation of this invention will be apparent to those skilled in the art without departing from the scope and spirit of the invention. Although the invention has been described in connection with specific preferred embodiments, it should be understood that the invention as claimed should not be unduly limited to such specific embodiments. It is intended that the following claims define the scope of the present invention and that structures and methods within the scope of these claims Additional detailed description of embodiments of the disclosed subject matter are provided in but not limited to: U.S. Pat. No. 7,299,082; U.S. Pat. No. 7,167,818; U.S. Pat. No. 7,041,468; U.S. Pat. No. 6,942,518; U.S. Pat. No. 6,893,545; U.S. Pat. No. 6,881,551; U.S. Pat. No. 6,773,671; U.S. Pat. No. 6,764,581; U.S. Pat. No. 6,749,740; U.S. Pat. No. 6,746,582; U.S. Pat. No. 6,736,957; U.S. Pat. No. 6,730,200; U.S. Pat. No. 6,676,816; U.S. Pat. No. 6,618,934; U.S. Pat. No. 6,616,819; U.S. Pat. No. 6,600,997; U.S. Pat. No. 6,592,745; U.S. Pat. No. 6,591,125; U.S. Pat. No. 6,560,471; U.S. Pat. No. 6,540,891; U.S. Pat. No. 6,514,718; U.S. Pat. No. 6,514,460; U.S. Pat. No. 6,503,381; U.S. Pat. No. 6,461,496; U.S. Pat. No. 6,377,894; U.S. Pat. No. 6,338,790; U.S. Pat. No. 6,299,757; U.S. Pat. No. 6,284,478; U.S. Pat. No. 6,270,455; U.S. Pat. No. 6,175,752; U.S. Pat. No. 6,161,095; U.S. Pat. No. 6,144,837; U.S. Pat. No. 6,143,164; U.S. Pat. No. 6,121,009; U.S. Pat. No. 6,120,676; U.S. Pat. No. 6,071,391; U.S. Pat. No. 5,918,603; U.S. Pat. No. 5,899,855; U.S. Pat. No. 5,822,715; U.S. Pat. No. 5,820,551; U.S. Pat. No. 5,628,890; U.S. Pat. No. 5,601,435; U.S. Pat. No. 5,593,852; U.S. Pat. No. 5,509,410; U.S. Pat. No. 5,320,715; U.S. Pat. No. 5,264,014; U.S. Pat. No. 5,262,305; U.S. Pat. No. 5,262,035; U.S. Pat. No. 4,711,245; U.S. Pat. No. 4,545,382; U.S. Pat. No. 5,356,786; U.S. Pat. No. 5,543,326; U.S. Pat. No. 6,103,033; U.S. Pat. No. 6,134,461; U.S. Pat. No. 6,143,164; U.S. Pat. No. 6,144,837; U.S. Pat. No. 6,161,095; U.S. Pat. No. 6,579,690; U.S. Pat. No. 6,605,200; U.S. Pat. No. 6,605,201; U.S. Pat. No. 6,618,934; U.S. Pat. No. 6,654,625; U.S. Pat. No. 6,676,816; U.S. Pat. No. 6,730,200; U.S. Pat. No. 6,736,957; U.S. Pat. No. 6,932,892; U.S. Publication No. 2004/0186365; U.S. Publication No. 2005/0182306; U.S. Publication No. 2006/0025662; U.S. Publication No. 2006/0091006; U.S. Publication No. 2007/0056858; U.S. Publication No. 2007/0068807; U.S. Publication No. 2007/0095661; U.S. Publication No. 2007/0108048; U.S. Publication No. 2007/0199818; U.S. Publication No. 2007/0227911; U.S. Publication No. 2007/0233013; U.S. Publication No. 2008/0066305; U.S. Publication No. 2008/0081977; U.S. Publication No. 2008/0102441; U.S. Publication No. 2008/0148873; U.S. Publication No. 2008/0161666; U.S. Publication No. 2008/0267823; U.S. Publication No. 2009/0054748; U.S. patent application Ser. No. 10/745,878, filed Dec. 26, 2003 and entitled "Continuous Glucose Monitoring System and Methods of Use"; U.S. patent application Ser. No. 12/143,731, filed Jun. 20, 2008 and entitled "Health Management Devices And Methods"; U.S. patent application Ser. No. 12/143,734, filed Jun. 20, 2008 and entitled "Health Monitor"; U.S. Provisional Patent Application No. 61/149,639, filed Feb. 3, 2009 and entitled "Compact On-Body Physiological Monitoring Devices And Methods Thereof"; U.S. Provisional Application No. 61/291,326 filed Dec. 30, 2009, and U.S. Provisional Application No. 61/299,924 filed Jan.

29, 2010; U.S. patent application Ser. No. 11/461,725; U.S. patent application Ser. No. 12/131,012; U.S. patent application Ser. No. 12/242,823; U.S. patent application Ser. No. 12/363,712; U.S. patent application Ser. No. 12/698,124; U.S. patent application Ser. No. 12/698,129; U.S. patent application Ser. No. 12/714,439; U.S. patent application Ser. No. 12/794,721; U.S. patent application Ser. No. 12/842,013; U.S. Patent Application Ser. No. 61/238,646; U.S. Patent Application Ser. No. 61/345,562; U.S. Patent Application Ser. No. 61/361,374; and elsewhere, the disclosures of each are incorporated by reference in their entirety herein for all purposes.

What is claimed is:

1. An electronics unit for receiving one or more signals from an analyte sensor, the electronics unit comprising:

a body having a top surface, an opposing bottom surface and a sidewall defined therebetween,
a processor and a circuit board disposed within the body of the electronics unit, and

an elongate interconnect comprising conductive material defining a body of the interconnect, the body having a first end secured to the circuit board and a second end engaged to the body of the electronics unit, and a length extending laterally from the sidewall of the body of the electronics unit.

2. The electronics unit of claim 1, wherein the processor is an application specific integrated circuit (ASIC).

3. The electronics unit of claim 1, wherein the conductive material defines a conductive area.

4. The electronics unit of claim 3, wherein the conductive area contacts the circuit board disposed in the body of the electronics unit.

5. The electronics unit of claim 4, wherein the conductive area establishes electrical communication between the elongate interconnect and the circuit board.

6. The electronics unit of claim 1, wherein the elongate interconnect further comprises a contact plate disposed along a length of the interconnect body.

7. The electronics unit of claim 6, wherein the conductive plate is configured to contact or engage the analyte sensor, and further wherein such contact establishes electrical communication between the interconnect and the analyte sensor.

8. The electronics unit of claim 1, wherein the elongate interconnect is substantially U-shaped.

9. The electronics unit of claim 1, wherein the elongate interconnect comprises material sufficiently flexible to collapse upon engagement with an analyte sensor.

10. The electronics unit of claim 1, wherein the conductive material comprises gold.

11. The electronics unit of claim 1, wherein the conductive material defines conductive traces, and further wherein the conductive traces are embedded in flexible material.

12. The electronics unit of claim 11, wherein the flexible material is formed from a thermoplastic material.

13. The electronics unit of claim 12, wherein the thermoplastic material includes polyimide.

14. The electronics unit of claim 13, wherein the polyimide is Kapton®.

15. The electronics unit of claim 1, wherein the conductive material includes a plurality of conductive cables, and further wherein the plurality of conductive cables is encapsulated within a flexible sheath.

16. The electronics unit of claim 1, wherein the conductive material includes ribbon cables.

17. The electronics unit of claim 16, wherein the ribbon cables are embedded in a flexible material.

18. An on-body analyte monitoring device comprising:

a mounting unit having a bottom surface adapted to attach to skin of a subject;

an analyte sensor configured to detect and monitor an analyte, the analyte sensor being disposed in the mounting unit;

an electronics unit for receiving one or more signals from the analyte sensor, the electronics unit comprising a body having a top surface, and opposing bottom surface and a sidewall defined therebetween, a processor and a PCB disposed within the body of the electronics unit; and

an elongate interconnect comprising conductive material defining a body of the interconnect, the body having a first end secured to the circuit board and a second end engaged to the body of the electronics unit, and a length extending laterally from the sidewall of the body of the electronics unit, wherein at least a section of the length directly contact the analyte sensor.

19. The on-body analyte monitoring device of claim 18, wherein the analyte sensor comprises one or more electrodes.

20. The on-body analyte monitoring device of claim 19, wherein the electrodes comprise gold.

21. The on-body analyte monitoring device of claim 20, wherein the gold electrodes are formed by at least ablation techniques.

22. The on-body analyte monitoring device of claim 21, wherein the ablation technique is laser ablation.

23. The on-body analyte monitoring device of claim 18, wherein the body of the electronics unit has a substantially circular shape.

24. The on-body analyte monitoring device of claim 18, wherein the body of the electronics unit has a substantially rectangular shape.

25. The on-body analyte monitoring device of claim 18, wherein the electronics unit is configured to communicate with a receiver unit.

26. The on-body analyte monitoring device of claim 25, wherein the communication between the electronics unit and receiver includes unidirectional or bidirectional communication.

27. The on-body analyte monitoring device of claim 18, wherein the analyte is glucose.

28. The on-body analyte monitoring device of claim 18, wherein the electronics unit further comprises a seal disposed proximate the elongate interconnect, and further wherein the seal encapsulate at least a portion of the elongate interconnect.

29. The on-body analyte monitoring device of claim 28, wherein the seal includes an opening to permit direct contact of the contact plate and the analyte sensor.

30. The on-body analyte monitoring device of claim 29, wherein the elongate interconnect is configured to collapse during engagement of the electronics unit and the analyte sensor.

31. The on-body analyte monitoring device of claim 30, wherein the elongate interconnect is configured to return to its non-collapsed configuration upon disengagement of the analyte sensor and the electronics unit.

32. The on-body analyte monitoring device of claim 18, wherein the processor is an application specific integrated circuit (ASIC).

33. The on-body analyte monitoring device of claim 18, wherein the conductive material includes a first conductive area defined by one or more conductive traces and conductive contacts.

34. The on-body analyte monitoring device of claim 33, wherein the first conductive area contacts the circuit board and establishes an electrical communication between the circuit board and the interconnect.

35. The on-body analyte monitoring device of claim 18, wherein the elongate interconnect includes a second conductive area defined by one or more contact traces and one or more conductive contacts, wherein the second conductive area is contacts the analyte sensor to establish electrical communication between the interconnect and the analyte sensor.

36. The on-body analyte monitoring device of claim 18, wherein the elongate interconnect is substantially U-shaped.

37. The on-body analyte monitoring device of claim 18, wherein the elongate interconnect comprises collapsible material.

38. The on-body analyte monitoring device of claim 18, wherein the conductive material comprises gold.

39. The on-body analyte monitoring device of claim 38, wherein the conductive material is embedded in a flexible material.

40. The on-body analyte monitoring device of claim 39, wherein the flexible material is formed from a thermoplastic material.

41. The on-body analyte monitoring device of claim 40, wherein the thermoplastic material includes polyimide.

42. The on-body analyte monitoring device of claim 41, wherein the polyimide is Kapton®.

43. The on-body analyte monitoring device of claim 18, wherein the conductive material includes a plurality of conductive cables, and further wherein the plurality of conductive cables is encapsulated in a flexible sheath.

44. The on-body analyte monitoring device of claim 18, wherein the conductive material includes ribbon cables.

45. The on-body analyte monitoring device of claim 18, wherein the on-body device further includes a seal formed of a flexible polymer, wherein the seal encapsulates at least a portion of the elongate interconnect.

46. The on-body analyte monitoring device of claim 18, wherein the second end of the elongate interconnect is slidably engaged to the body of the electronics unit.

47. The on-body analyte monitoring device of claim 18, wherein the second end of the elongate interconnect is permanently affixed to the body of the electronics unit.

48. A molded interconnect device for an on-body analyte monitoring device comprising:

a body including a bottom surface connected to a top surface by a sidewall, the top surface including conductive material disposed thereon and a vertical surface extending downwardly from the top surface, the vertical surface including conductive material disposed thereon, wherein at least one of the top or vertical surfaces is adapted to establish an electrical communication with an analyte sensor, and further wherein the body is configured to interconnect with an electronics unit to define an on-body analyte monitoring device.

49. The interconnect of claim 48, wherein the conductive material disposed on the top surface or the vertical surface includes conductive film.

50. The interconnect of claim 49, wherein the conductive film is a Z-conductive film.

51. The interconnect of claim 49, wherein the conductive film is an anisotropic film.

52. The interconnect of claim 49, wherein at least one of the conductive materials disposed on the top surface or the vertical surface includes an elastomeric connector.

53. The interconnect of claim 52, wherein the elastomeric connector is a Zebra® style connector.

54. The interconnect of claim 49, wherein at least one of the conductive materials disposed on the top surface or the vertical surface is adapted to interface a circuit board (PCB) located on the electronics unit.

55. The interconnect of claim 48, wherein the body further includes conductive traces extending from the conductive material disposed on the top surface to the conductive material disposed on the vertical surface.

56. The interconnect of claim 48, further comprising an analyte sensor secured to the vertical surface of the interconnect body.

57. The interconnect of claim 56, wherein the interconnect is engaged to the electronics unit, and further wherein the conductive material disposed on the top surface of the interconnect body is in communication with the electronics unit.

58. The interconnect of claim 57, wherein the conductive material is in electrical communication with a PCB disposed within the electronics unit.

59. The interconnect of claim 58, wherein electrical communication is established between the analyte sensor and the electronics unit through the interconnect body.

60. The interconnect of claim 48, wherein the conductive material disposed on at least one of the top or vertical surface includes an adhesive.

61. The interconnect of claim 60, wherein the adhesive is a UV curable adhesive.

62. The interconnect of claim 60, wherein the adhesive is a multi-adhesive system.

63. The interconnect of claim 62, wherein the multi-adhesive system is a silver loaded epoxy.

64. The interconnect of claim 48, wherein the bottom surface of the interconnect includes adhesive to attach to human skin.

65. The interconnect of claim 48, wherein the interconnect body is formed from a thermoplastic material.

66. The interconnect of claim 48, wherein the conductive material comprises gold.

67. The interconnect of claim 66, wherein the gold conductive material is formed by ablation techniques.

68. The interconnect of claim 67, wherein the ablation technique is laser ablation.

69. An on-body analyte monitoring device comprising:
an analyte sensor configured to measure analyte levels;
an electronics unit configured to process signals generated by the analyte sensor relating to the analyte levels; and
an interconnect comprising a body including a bottom surface connected to a top surface by a sidewall, the top surface a vertical surface extending downwardly from the top surface, the vertical surface coupled to the analyte sensor and the interconnect body engaged to the electronics unit, wherein the interconnect is in electrical communication with the analyte sensor and the electronics unit.

70. The on-body analyte monitoring device of claim 69, wherein the interconnect includes conductive material disposed on at least the top and vertical surfaces.

71. The on-body analyte monitoring device of claim 70, wherein the conductive material includes conductive film

72. The on-body analyte monitoring device of claim 71, wherein the conductive film is a Z-conductive film.

73. The on-body analyte monitoring device of claim 71, wherein the conductive film is an anisotropic film.

74. The on-body analyte monitoring device of claim 70, wherein the conductive material includes an elastomeric connector.

75. The on-body analyte monitoring device of claim 74, wherein the elastomeric connector is a Zebra® style connector.

76. The on-body analyte monitoring device of claim 69, wherein the interconnect includes conductive material interfaced with a PCB located within the electronics unit.

77. The on-body analyte monitoring device of claim 69, wherein the interconnect further includes conductive traces extending from the conductive material disposed on the vertical surface to the conductive material disposed on the horizontal surface.

78. The on-body analyte monitoring device of claim 69, wherein the analyte sensor and electronics unit are in electrical communication.

79. The on-body analyte monitoring device of claim 69, wherein at least the conductive material disposed on the top surface or the vertical surface of the interconnect comprises an adhesive.

80. The on-body analyte monitoring device of claim 79, wherein the adhesive is a UV curable adhesive.

81. The on-body analyte monitoring device of claim 79, wherein the adhesive comprises a multi-adhesive system.

82. The on-body analyte monitoring device of claim 81, wherein the multi-adhesive system is a silver loaded epoxy.

83. The on-body analyte monitoring device of claim 69, wherein the conductive material comprises gold.

84. The on-body analyte monitoring device of claim 83, wherein the gold conductive material is formed by ablation techniques.

85. The on-body analyte monitoring device of claim 84, wherein the ablation technique is laser ablation.

86. The on-body analyte monitoring device of claim 69, wherein the bottom surface of the interconnect comprises adhesive to attach to human skin.

87. The on-body analyte monitoring device of claim 69, wherein the interconnect is formed from a thermoplastic material.

88. The on-body analyte monitoring device of claim 69, wherein the analyte sensor and the vertical surface of the interconnect are joined by a conductive film.

89. The on-body analyte monitoring device of claim 88, wherein the conductive film is an anisotropic film.

90. The on-body analyte monitoring device of claim 69, wherein the electronics unit and interconnect are adapted to be slidably engageable.

91. The on-body analyte monitoring device of claim 69, wherein the circuit board comprises gold contacts.

92. The on-body analyte monitoring device of claim 91, wherein the gold contacts are formed by ablation techniques.

93. The on-body analyte monitoring device of claim 92, wherein the ablation technique is laser ablation.

94. The on-body analyte monitoring device of claim 69, wherein the sensor includes one or more electrodes, and further wherein one or more of the electrodes comprise gold.

95. The on-body analyte monitoring device of claim 94, wherein the one or more gold electrodes are formed by ablation techniques.

96. The on-body analyte monitoring device of claim 95, wherein the ablation technique is laser ablation.

97. The on-body analyte monitoring device of claim 69, wherein the interconnect further comprises a battery.

98. The on-body analyte monitoring device of claim 97, wherein the battery is adapted to provide power to the electronics unit.

99. The on-body analyte monitoring device of claim 97, wherein the electronics unit does not require an internal power source.

100. The electronics unit of claim 16, wherein the conductive material is formed from molded plastic using MID (molded interconnect device) techniques.

101. The electronics unit of claim 100, wherein the MID techniques utilize a LDS (laser direct structuring) process to form the conductive material.

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