

**RING TYPE WEARABLE TERMINAL AND METHOD FOR MANUFACTURING THE
RING TYPE WEARABLE TERMINAL**

[0001] The present invention relates to a ring type
5 wearable terminal and a method for manufacturing the ring
type wearable terminal.

[0002] When getting close to a reader-writer, IC cards
wirelessly communicate with the reader-writer and transmit
and/or receive various types of data. Since IC cards are
10 easy to handle, IC cards are widely used as access management
cards, employee cards, boarding cards for transportation
systems, credit cards, etc.

[0003] Rings are known that are provided with the same
features as those of IC cards. Patent document No. 1
15 discloses a ring-shaped decoration that houses an IC chip
between a ring-shaped main body portion and a ring-shaped
accompanying portion that is set on the outer side of the
main body portion. This ring is convenient since wearing
this ring no longer requires IC cards to be taken out from a
20 bag or clothes when going through an automatic ticket gate
for a railroad or when paying for a purchase.

[0004] [Patent document No. 1] JP 2016-131758

[0005] In a ring-shaped decoration according to Patent
document No. 1, the strength thereof needs to be increased so
25 that an accompanying portion does not come off from a main
body portion or an internal IC chip does not get broken due
to the ring-shaped decoration coming into contact with a
reader, etc. The inventors of the present invention have
reached the view that there is room for improvement for an
30 increase in the strength in a ring type wearable terminal
that houses a communication unit including an IC chip.

[0006] In this background, a purpose of the present
invention is to provide a ring type wearable terminal with
improved strength.

[0007] An embodiment of the present invention relates to a ring type wearable terminal. This ring type wearable terminal includes: a first ring that has a recessed portion formed on a side surface thereof; a second ring that is
5 bonded to the first ring and that covers the recessed portion; and a communication unit that is housed in the recessed portion, and the recessed portion is filled with an adhesive agent.

[0008] According to the present embodiment, the bonding
10 strength between the first ring and the second ring is improved by the adhesive agent filling the recessed portion. Also, the communication unit is tightly fixed to the recessed portion and protected by the adhesive agent. This configuration allows the strength of the ring type wearable
15 terminal to be improved.

[0009] Another embodiment of the present invention relates to a method for manufacturing the ring type wearable terminal. This method for manufacturing includes: putting a communication unit in a recessed portion formed on a side
20 surface of a first ring; applying an adhesive agent to the recessed portion in a heaped manner; bonding a second ring covering the recessed portion to the first ring; and performing polishing such that respective outer peripheral surfaces of the first ring and the second ring become
25 smoothly continuous.

[0010] According to the present embodiment, the bonding strength between the first ring and the second ring can be improved by the adhesive agent filling the recessed portion. Also, the communication unit can be tightly fixed to the
30 recessed portion and can be also protected by the adhesive agent. This configuration allows a ring type wearable terminal with improved strength to be provided.

[0011] According to the present invention, a ring type wearable terminal with improved strength can be provided.

[0012] Embodiments will now be described, by way of example only, with reference to the accompanying drawings which are meant to be exemplary, not limiting, and wherein like elements are numbered alike in several Figures, in which:

Fig. 1 is a perspective view of a ring type wearable terminal according to a first embodiment;

Fig. 2 is a lateral view of a ring type wearable terminal according to the first embodiment;

10 Fig. 3 is a cross sectional view along A-A of Fig. 2;

Fig. 4 is a partial enlarged view of Fig. 3;

Fig. 5 is a perspective view of a communication unit according to the first embodiment;

15 Fig. 6 is a plan view showing a condition before a flexible substrate according to the first embodiment is formed into a ring shape;

Fig. 7 is a cross sectional view of a ring type wearable terminal according to a second embodiment; and

Fig. 8 is a partial enlarged view of Fig. 7.

20 **[0013]** In the following embodiments, like numerals represent like constituting elements, and duplicative explanations will be omitted. For the sake of ease of explanation, some constituting elements are appropriately omitted in the figures.

25 **[0014]** [First embodiment]

A ring type wearable terminal according to a first embodiment is provided with a first ring that has a recessed portion formed on a side surface thereof, a second ring that is bonded to the first ring and that covers the recessed portion, and a communication unit that is housed in the recessed portion of the first ring. The communication unit is an IC tag that includes an IC chip and an antenna. The first ring and the second ring are bonded by an adhesive agent that fills the recessed portion. Compared to a case

where the adhesive agent is applied such that bonding surfaces come into contact at the surfaces, the bonding strength between the first ring and the second ring can be improved by increasing the amount of the adhesive agent.

5 Also, the communication unit is tightly fixed to the recessed portion and protected by the adhesive agent. This configuration allows the strength of the ring type wearable terminal to be improved.

[0015] Fig. 1 is a perspective view of a ring type wearable terminal 10 according to the first embodiment, and Fig. 2 is a lateral view of the ring type wearable terminal 10. The ring type wearable terminal 10 is provided with a first ring 12 and a second ring 14 that is bonded to the outside of the first ring 12. The first ring 12 and the second ring 14 are formed of high-strength ceramics made of zirconia to which yttrium oxide is added. The first ring 12 and the second ring 14 are set to have a width $W1$ of 7.8 mm. The first ring 12 is set to have an internal diameter $R1$ of 20.2 mm and an outer diameter $R2$ of 23.2 mm. The second ring 14 is set to have an internal diameter $R3$ of 23.2 mm and an outer diameter $R4$ of 26.0 mm. The respective diameters of the first ring 12 and the second ring 14 are changed in accordance with the size of the rings.

[0016] Fig. 3 is a cross sectional view along A-A of Fig. 2, and Fig. 4 is a partial enlarged view of Fig. 3. On the outer peripheral surface of the first ring 12, a recessed portion 16 is formed on the whole circumference. The recessed portion 16 houses a communication unit 26, which is described later, and is covered by the second ring 14. The recessed portion 16 is set to have a width $W2$ of 6 mm and a depth D of 1.2 mm. The recessed portion 16 is filled with an adhesive agent 24. The adhesive agent 24 filling the recessed portion 16 bonds the first ring 12 and the second ring 14 and fixes the communication unit 26 to the recessed

portion 16. Also, the adhesive agent 24 absorbs an impact caused by coming into contact with a reader-writer or the like so as to protect the communication unit 26. The adhesive agent 24 is an epoxy resin-based adhesive agent.

5 **[0017]** Fig. 5 is a perspective view of the communication unit 26 according to the embodiment. The communication unit 26 is provided with a flexible substrate 30 and an IC chip 32 provided in the flexible substrate 30. The end portions of the flexible substrate 30 are connected to each other to form
10 a ring shape. An antenna 28 is formed on each surface of the flexible substrate 30. The IC chip 32 includes a CPU, a memory, a reception unit, and a transmission unit and is connected to the antenna 28. The IC chip 32, using prior arts, operates by electrical power generated by the antenna
15 28 that has received a radio wave from the reader-writer and transmits and/or receives various types of data to/from the reader-writer.

[0018] Fig. 6 is a plan view showing a condition before the flexible substrate 30 according to the first embodiment
20 is formed into a ring shape. The flexible substrate 30 is set to have a width W3 of 5.9 mm and a length L1 of 75 mm. On a first surface of the flexible substrate 30 on the side where the IC chip 32 is provided, a plurality of linear patterns 28a through 28i that form the antenna 28 are formed.
25 On a second surface of the flexible substrate 30, linear patterns of almost the same shape are formed at a position where the patterns overlap with the patterns on the first surface when viewed in a plan view. The linear patterns on both surfaces are connected through a plurality of connection
30 holes 29 formed in the flexible substrate 30. The linear patterns 28a and 28i located at the ends in the width direction extend in the longitudinal direction from respective end portions of the flexible substrate 30 to the central part thereof and are connected to the IC chip 32.

The linear patterns 28b through 28h located between these two linear patterns are formed such that the linear patterns 28b extend in a parallel manner from one end to the other end of the flexible substrate 30 while being shifted by one linear pattern at a central portion of the flexible substrate 30.

[0019] An end portion of each linear pattern is referred to as a bonding portion 38, which is bonded to another linear pattern. At each end portion of the flexible substrate 30 in the longitudinal direction, a positioning portion 34

projecting toward the outside from a side edge in the width direction is formed. A positioning portion 34 on the side of one end 30a is set to have a length L2 of 7 mm and forms five positioning holes 36 lines up in the longitudinal direction. A positioning portion 34 on the side of the other end 30b is set to have a length L3 of 2 mm and forms one positioning hole 36.

[0020] When the ends of the flexible substrate 30 are bonded, both of the positioning portions 34 are overlapped with each other such that the flexible substrate 30 has a circumference that matches the size of the ring and are fixed with a pin passing through the positioning holes 36. Under this condition, the bonding portions 38 at the ends are soldered to form the flexible substrate 30 into a ring shape. The linear pattern 28a is bonded, on the side of the other end 30b, to the linear pattern 28b on the side of the end 30a so as to form a single loop. In the same way, the linear patterns 28b through 28h are bonded, on the side of the other end 30b, to the linear patterns 28c through 28i, respectively, so as to form a plurality of loops. Such a structure allows the linear patterns 28a through 28i to form a single loop antenna where both ends of the linear patterns are connected to the IC chip 32 being wound in a coil shape while the flexible substrate 30 is in a ring shape. When the pin inserted in the positioning holes 36 is removed and the

positioning portions 34 are detached from the flexible substrate 30 after both of the ends are bonded, a condition shown in Fig. 5 is obtained.

[0021] On the positioning portion 34 on the side of the end 30a of the flexible substrate 30, positioning holes 36 are formed side by side at a center-to-center distance of 1.2 mm in the longitudinal direction. This allows the circumference of the flexible substrate 30 to be adjusted at intervals of 1.2 mm in accordance with the size of the ring by changing the positioning holes 36 to be overlapped at the time of bonding. Since a single flexible substrate 30 can adapt to rings of multiple sizes, the manufacturing cost of a ring type wearable terminals of different sizes, compared to a case of manufacturing a flexible substrate 30 where the pattern of an antenna 28 and the entire length vary depending on a size. An adaptable size can be changed by changing the length L1 of the flexible substrate 30, the lengths L2 and L3 of the positioning portions 34, the number of the positioning holes 36, or the like.

[0022] An explanation will be given of a method for manufacturing the ring type wearable terminal 10. First, a rod-like jig whose outer diameter becomes larger gradually from one end to the other end is prepared. This jig is inserted into a first ring 12, and the first ring 12 is fixed to the jig at a position where the diameters match. Then, a communication unit 26 including a ring-shaped flexible substrate 30 where a bonding portion 38 is bonded in accordance with the size of the ring is put in a recessed portion 16 of the first ring 12. Under this condition, an adhesive agent 24 is applied to the entire outer side of the first ring 12 in a heaped manner, and the recessed portion 16 is filled with the adhesive agent 24. Then, a second ring 14 is placed on the outer side of the first ring 12. Once the

adhesive agent 24 is hardened, the first ring 12 and the second ring 14 become bonded, and the communication unit 26 becomes fixed to the recessed portion 16. The adhesive agent 24 of the recessed portion 16 covers the entirety of the communication unit 26 and absorbs an impact received by coming into contact with a reader-writer or the like so as to protect the communication unit 26.

[0023] After the adhesive agent 24 is hardened, the first ring 12 and the second ring 14 are removed from the jig, and the respective outer peripheral surfaces are polished. At this time, the polishing is performed such that a part of the adhesive agent 24 that has leaked from between the first ring 12 and the second ring 14 is removed and the respective outer peripheral surfaces of the first ring 12 and the second ring 14 become smoothly continuous. Through these steps, the first ring 12 and the second ring become tightly bonded, and the ring type wearable terminal 10 smoothly finished without bumps on the surface can be manufactured.

[0024] The actual usage and effects brought by the above configuration are as shown in the following. A user wears a ring type wearable terminal 10 in his/her finger. By putting a hand with the finger wearing the ring type wearable terminal 10 closer to a reader-writer, reading at an automatic ticket gate, payment for a purchase, etc., can be easily performed. Also, manufactures of ring type wearable terminals 10 are able to allow a single flexible substrate 30 to be adaptable to multiple ring sizes and thus able to reduce the manufacturing cost when offering a size range of multiple sizes.

[0025] Shown below is a variation of the first embodiment. The recessed portion 16 is formed in the first ring 12. Alternatively, a recessed portion may be formed in the second ring 14. Alternatively, a recessed portion may be formed on each of the first ring 12 and the second ring 14.

In either case, the first ring 12 and the second ring 14 are tightly bonded as in the same way as in the embodiment. The color of the first ring 12 and the color of the second ring 14 can be obviously any color. From the fashion's

5 perspective, the colors may be the same color or, conversely, a combination of greatly different colors as those in a complementary color relationship.

[0026] [Second embodiment]

A ring type wearable terminal according to a second
10 embodiment is different from that of the first embodiment in that a notch to be filled with an adhesive agent 24 is formed in at least either one of a first ring 12 and a second ring 14.

[0027] Fig. 7 is a cross sectional view of a ring type
15 wearable terminal 40 according to the second embodiment, and Fig. 8 is a partial enlarged view of Fig. 7. On each side edge portion of the first ring 12, an inner side notch 18 is formed on the whole circumference. The inner side notch 18 includes an inclined surface formed such that the outer
20 diameter of the first ring 12 becomes smaller toward the side edge. On each side edge portion of the second ring 14, an outer side notch 20 is formed on the whole circumference. The outer side notch 20 includes an inclined surface formed such that the inner diameter of the second ring 14 becomes
25 larger toward the side edge. When the first ring 12 and the second ring 14 are bonded, the inner side notch 18 and the outer side notch 20 form a notched portion 22 whose cross section is triangle-shaped. The first ring 12 and the second ring 14 are bonded by an adhesive agent 24 that fills the
30 recessed portion 16 and the notched portion 22. Since the notched portion 22, as well as the recessed portion 16, is also filled with the adhesive agent 24, the first ring 12 and the second ring 14 can be more tightly bonded. In the manufacturing of the ring type wearable terminal 40, after

the first ring 12 and the second ring 14 are bonded,
polishing is performed such that the surface of the adhesive
agent 24 filling the notched portion 22 becomes smoothly
continuous with the respective outer peripheral surfaces of
5 the first ring 12 and the second ring 14.

[0028] Shown below is a variation of the second
embodiment. A clear adhesive agent may be used as the
adhesive agent 24. Alternatively, an adhesive agent colored
in the same color as that of the first ring 12 and that of
10 the second ring 14 may be used to conceal the notched portion
22. From the fashion's perspective, an adhesive agent
colored in a color that is different from the color of the
first ring 12 and the color of the second ring 14 may be used.
The inner side notch 18 is formed on the first ring 12, and
15 the outer side notch 20 is formed on the second ring 14.
Alternatively, either one of the inner side notch 18 and the
outer side notch 20 may be applied. Also, the inner side
notch 18 and the outer side notch 20 may not be formed on the
whole circumference of the rings and may be formed on at
20 least a part of the respective rings. In either case, a
notched portion to be filled with the adhesive agent 24 can
be formed between the first ring 12 and the second ring 14 so
as to bond the first ring 12 and the second ring 14 more
tightly.

25 **[0029]** Described above is an explanation of the present
invention based on the embodiments. These embodiments are
intended to be illustrative only, and it will be obvious to
those skilled in the art that various modifications to
constituting elements and processes could be developed and
30 that such modifications are also within the scope of the
present invention.

[0030] For example, an explanation has been made
regarding a ring type wearable terminal used as a ring.
However, the example given is non-limiting. The diameter of

the ring and the diameter of an inner diameter correction member may be increased to be used as a bracelet.

CLAIMS

1. A ring type wearable terminal (10) comprising:
a first ring (12) that has a recessed portion (16) formed on a side surface thereof;
a second ring (14) that is bonded to the first ring (12) and that covers the recessed portion (16); and
a communication (26) unit that is housed in the recessed portion (16),
wherein the recessed portion (16) is filled with an adhesive agent (24).

2. The ring type wearable terminal (10) according to claim 1 wherein a notch that is filled with the adhesive agent (24) is formed on a side edge portion of at least one of the first ring (12) and the second ring (14).

3. The ring type wearable terminal (10) according to claim 2 wherein an outer peripheral surface of the adhesive agent (24) filling the notch is smoothly continuous with respective outer peripheral surfaces of the first ring (12) and the second ring (14).

4. A method for manufacturing a ring type wearable terminal (10) comprising:
putting a communication unit in a recessed portion (16) formed on a side surface of a first ring (12);
applying an adhesive agent (24) to the recessed portion (16) in a heaped manner;
bonding a second ring (14) covering the recessed portion (16) to the first ring (12); and
performing polishing such that respective outer peripheral surfaces of the first ring (12) and the second ring (14) become smoothly continuous.