

MULTI-LAYERED SUPPORT STRUCTURE

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BACKGROUND OF THE INVENTION

[0001] This application claims priority to both of U.S. Provisional Patent Application No. 61/135,997, filed July 25, 2008, titled MULTI-LAYERED SUPPORT STRUCTURE, and U.S. Provisional Patent Application No. 61/175,670, filed May 5, 2009, titled MULTI-LAYERED SUPPORT STRUCTURE, which are incorporated herein by reference.

BACKGROUND OF THE INVENTION

1. Technical Field.

[0002] The invention relates to load support structures. In particular, the invention relates to multi-layered seating structures.

2. Related Art.

[0003] Most people spend a significant amount of time sitting each day. Inadequate support can result in reduced productivity, body fatigue, or even adverse health conditions such as chronic back pain. Extensive resources have been devoted to the research and development of chairs, benches, mattresses, sofas, and other load support structures.

[0004] In the past, for example, chairs have encompassed designs ranging from cushions to more complex combinations of individual load bearing elements. These past designs have improved the general comfort level provided by seating structures, including providing form-fitting comfort for a user's general body shape. Some discomfort, however, may still arise even from the improved seating structures. For example, a seating structure, though tuned to conform to a wide variety of general body shapes, may resist conforming to a protruding wallet, butt bone, or other local irregularity in body shape. This may result in discomfort as the seating structure presses the wallet or other body shape irregularity up into the seated person's backside.

[0005] Thus, while some progress has been made in providing comfortable seating structures, there remains a need for improved seating structures tuned to fit and conform to a wide range of body shapes and sizes.

SUMMARY

[0006] A multi-layered support structure may include a global layer, a local layer, and a top mat layer. The global layer provides controlled deflection of the seating structure upon application of a load. The global layer includes multiple support rails which also support the local layer. The global layer may also include multiple aligned regions which may include an aligned material to facilitate deflection of the global layer when a load is imposed.

[0007] The local layer facilitates added and independent deflection upon application of a load to the multi-layered support structure. The local layer includes multiple spring elements supported by the multiple support rails. The multiple spring elements each include a top and a deflection member. Each of the multiple spring elements may independently deflect under a load based upon a variety of factors, including the spring type, relative position of the spring element within the multi-layered support structure, spring material, spring dimensions, connection type to other elements of the multi-layered support structure, and other factors.

[0008] The top mat layer may be the layer upon which a load is applied. The top mat layer includes multiple pixels and bull nose extension fingers positioned above the multiple spring elements. The multiple pixels and bull nose extension fingers contact with the tops of the multiple spring elements. Like the multiple spring elements, the multiple pixels and multiple bull nose extension fingers may also provide a response to an applied load substantially independent of the responses of an adjacent pixel.

[0009] Accordingly, the multi-layered support structure includes cooperative yet independent layers, with each layer including cooperative yet independent elements, to provide maximized global support and comfort to an applied load while also adapting to and supporting localized load irregularities. Further, the load support independence provided by the multi-layered support structure allows specific regions to adapt to any load irregularity without substantially affecting the load support provided by adjacent regions.

[0010] Other systems, methods, features and advantages will be, or will become, apparent to one with skill in the art upon examination of the following figures and detailed description. It is intended that all such additional systems, methods, features and advantages be included within this description, be within the scope of the invention, and be protected by the following claims.

BRIEF DESCRIPTION OF THE DRAWINGS

[0011] The system may be better understood with reference to the following drawings and description. The components in the figures are not necessarily to scale, emphasis instead being placed upon illustrating the principles of the invention. Moreover, in the figures, like referenced numerals designate corresponding parts throughout the different views.

[0012] Figure 1 shows a portion of a layered support structure.

[0013] Figure 2 shows a broader view of the support structure shown in Figure 1.

[0014] Figure 3 shows a top view of a global layer.

[0015] Figure 4 shows a portion of the support rail including the node connected between two straps.

[0016] Figure 5 shows a top view of a local layer.

[0017] Figure 6 shows a portion of the spring attachment member.

5 [0018] Figure 7 shows a top view of an exemplary local layer.

[0019] Figure 8 shows a top view of a top mat layer.

[0020] Figure 9 shows the underside of a pixel within the top mat layer.

[0021] Figure 10 is a process for manufacturing a layered support structure.

[0022] Figure 11 shows a global layer stretched by an assembly apparatus.

10 [0023] Figure 12 shows a pre-aligned global layer.

[0024] Figure 13 shows a close-up view of a portion of a pre-aligned global layer.

[0025] Figure 14 shows a top view of a global layer cavity mold and hot drop channel for forming a pre-aligned global layer.

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DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0026] The layered support structure generally refers to an assembly of multiple cooperative layers for implementation in or as a load bearing structure, such as a chair, bed, bench, or other load bearing structures. The cooperative layers include multiple elements, including multiple independent elements, to maximize the support and comfort provided. The extent of the independence exhibited by the multiple elements may depend on, or be tuned to, individual characteristics of each element, the connection type used to interconnect the multiple elements, or other structural or design characteristics of the layered support structure. The multiple elements described below may be individually designed, positioned, or otherwise configured to suit the load support needs for a particular individual or application. The dimensions discussed below with reference to the various multiple elements are examples only and may vary widely depending on the particular desired implementation and on the factors noted below.

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[0027] Figure 1 shows a portion of a layered support structure 100. The layered support structure 100 includes a global layer 102, a local layer 104, and a top mat layer 106.

[0028] The global layer 102 includes multiple support rails 108 and a frame attachment 110. Each support rail 108 may include one or more straps 112 and multiple nodes 114 connected between the straps 112. Each strap may include aligned regions 116 and unaligned regions 118 defined along the length of the strap 112. The nodes 114 may connect to adjacent straps between the unaligned regions 118 of the adjacent straps 112.

[0029] The local layer 104 includes multiple spring elements 120 above (e.g., supported by or resting on) the multiple support rails 108. Each of the multiple spring elements 120 includes a top, a deflectable member 122, and one or more node attachment members 124. In Figure 1, the deflectable member 122 includes two spiral arms 126. The spring elements 120 may alternatively include a variety of spring types, such as those disclosed in U.S. Application Serial No. 11/433,891, filed May 12, 2006, which is incorporated herein by reference.

[0030] The top mat layer 106 includes multiple pixels and bull nose extension fingers 128. Each of the multiple pixels includes an upper surface and a lower surface. The lower surface of each pixel may include a stem which contacts the top of at least one of the spring elements 120. Each of the bull nose extension fingers 128 may also include an upper surface 130 and a lower surface. The lower surface of each bull nose extension finger 128 may include one or more stems that each contact with the top of at least one of the spring elements 120.

[0031] The global layer 102 may be injection molded from a flexible material such as a thermal plastic elastomer (TPE), including Arnitel EM400 or 460, a polypropylene (PP), a thermoplastic polyurethane (TPU), or other soft, flexible materials.

[0032] The global layer 102 connects to a frame 132 via the frame attachment 110. The frame attachment 110 may be connected to the end of the straps 112 of the support rails 108 and oriented substantially perpendicular to the straps 112. Figure 1 shows a frame attachment 110 that includes discrete segments 134. The frame attachment 110 may define by a gap 136 between each segment

134. Each of the discrete segments 134 may connect to the ends of two or more adjacent straps 112. The frame attachment 110 may include a single segment extending along an entire side of the global layer 102, such as the frame attachment shown in Figure 3.

5 **[0033]** In Figure 1, each support rail 108 includes two cylindrical straps 112 extending substantially in parallel. The support rails 108, however, may include alternative configurations. For example, the support rails 108 may include a single strap, or multiple straps. The support rails 108 of the global layer 102 may include a varying number of straps 112 tailored to various factors, such as the
10 location of the support rail 108 within the global layer 102. The support rails 108 may include alternative geometries. For example, the straps 112 of the support rails 108 may include four sides with multiple ends. An example of such straps is disclosed in U.S. Application Serial No. 11/433,891.

15 **[0034]** A strap 112 may include multiple aligned regions 116 and multiple unaligned regions 118 defined along the strap 112. The strap 112 may include alternating aligned and unaligned regions 116 and 118. Each of the aligned and unaligned regions may be defined by a cross-sectional area. The cross-sectional area of each aligned region defined along a strap may vary and be tailored to the position of the aligned region along the strap. The cross-sectional area may be
20 proportional to the position of the aligned region relative to a gate location of the mold. For example, the gate location corresponds to the middle of the strap, where the aligned regions have a greater cross-sectional area the more distant they are from the middle. As shown in Figure 1, the cross-sectional area of the unaligned regions may be greater than that of the adjacent aligned regions. The
25 aligned regions defined along the straps of the support rails may be aligned using a variety of methods including compression and/or tension aligning methods.

30 **[0035]** The unaligned region 118 and aligned region 116 of the adjacent straps 112 may substantially line up with each other. As shown in Figure 1, the nodes 114 may connect between adjacent unaligned regions 118 of adjacent straps 112. Each node 114 may include a spring connection for connecting to a spring element 120 of the local layer. The spring connection may be an opening

defined in the node 114 for receiving a corresponding spring element 120, such as shown in Figure 4.

[0036] The global layer 102 may or may not be pre-loaded. For example, prior to securing the global layer 102 to the frame, the global layer 102 may be formed, such as through the injection molding process, with a shorter length than is needed to secure the global layer 102 to the frame. Before securing the global layer 102 to the frame, the global layer 102 may be stretched or compressed to a length greater than its original length. As the global layer 102 recovers down after being stretched, the global layer 102 may be secured to the support structure frame when the global layer 102 settles to a length that matches the width of the frame.

[0037] As another alternative, the global layer 102 may recover down and then be repeatedly re-stretched until the settled down length of the global layer 102 matches the width of the frame. The global layer 102 may be pre-loaded in multiple directions, such as along its length or its width. In addition, different pre-loads may be applied to different regions of the global layer 102. Applying different pre-loads according to region may be done in a variety of ways, such as by varying the amount of stretching or compression at different regions and/or varying the cross-sectional area of different regions.

[0038] The multiple spring elements 120 of the local layer 104 may include a variety of dimensions according to a variety of factors, including the spring element's relative location in the support structure 100, the needs of a specific application, or according to a number of other considerations. For example, the heights of the spring elements 120 may be varied to provide a three-dimensional counter to the support structure 100, such as by providing a dish-like appearance to the support structure 100. In this example, the height of the spring elements 120 positioned at a center portion of the local layer 104 may be less than the height of spring elements 120 positioned at outer portions of the local layer 104, with a gradual or other type of increase in height between the center and outer portions of the local layer 104.

[0039] The local layer 104 may include a variety of other spring types. Examples of other spring types, as well as how they may be implemented in a

support structure, are described in U.S. App. Ser. No 11/433,891, filed May 12, 2006, which is incorporated herein by reference. The spring types used in the local layer 104 may include alternative orientations. For example, the spring types may be oriented upside-down, relative to their orientation described in this application. In this example, the portion of the spring described in this application as the top would be oriented towards and connect to the global layer 102. Further, in this example the deflectable members 122 may connect to the top mat layer 106. The deflectable members 122 may connect to the top mat layer 106 via multiple spring attachment members 124. However, the examples discussed in this application do not constitute an exhaustive list of the spring types, or possible orientations of spring types, that may be used to form the local layer 104. The spring elements 120 may exhibit a range of spring rates, including linear, non-linear decreasing, non-linear increasing, or constant rate spring rates.

[0040] The local layer 104 connects to the global layer 102. In particular, the spring attachment members 124 connect on the nodes 114 positioned between the unaligned regions 118 of adjacent straps 112. This connection may be an integral molding, a snap fit connection, or other connection method. The multiple spring elements 120 may be injection molded from a POM, such as Ultraform N 2640 Z6 UNC Acetal or Uniform N 2640 Z4 UNC Acetal, from a TPE, such as Arnitel EM 460, EM550, or EL630, a TPU, a PP, or from other flexible materials. The multiple spring elements 120 may be injection molded individually or as a sheet of multiple spring elements.

[0041] As the local layer 104 includes multiple substantially independent deflectable elements, i.e., the multiple spring elements, adjacent portions of the local layer 104 may exhibit substantially independent responses to a load. In this manner, the support structure 100 not only deflects and conforms under the “macro” characteristics of the applied load, but also provides individual, adaptable deflection to “micro” characteristics of the applied load.

[0042] The local layer 104 may also be tuned to exhibit varying regional responses in any particular zone, area, or portion of the support structure to provide specific support for specific parts of an applied load. The regional response zones may differ in stiffness or any other load support characteristic, for

example. Certain portions of the support structure may be tuned with different deflection characteristics. One or more individual pixels which form a regional response zone, for example, may be specifically designed to a selected stiffness for any particular portion of the body. These different regions of the support structure may be tuned in a variety of ways. Variation in the spacing between the lower surface of each pixel and the local layer 104 (referring to the spacing measured when no load is present) may vary the amount of deflection exhibited under a load. The regional deflection characteristics of the support structure 100 may be tuned using other methods as well, including using different materials, spring types, thicknesses, cross-sectional areas, geometries, or other spring characteristics for the multiple spring elements 120 depending on their relative locations in the support structure.

[0043] The top mat layer 106 connects to the local layer 104. The lower surface of each pixel is secured to the top of a corresponding spring element 120. The lower surface of each bull nose extension finger 128 may also be secured to the top of one or more corresponding spring elements 120. These connections may be an integral molding, a snap fit connection, or other connection method. The lower surface of the pixel and/or bull nose extension finger 128 may connect to the top of the spring element 120, or may include one or more stems or other extensions for resting upon or connecting to the spring element 120. The top of each spring element 120 may define an opening for receiving the stem of the corresponding pixel or bull nose extension finger 128. Alternatively, the top of each spring element 120 may include a stem or post for connecting to an opening defined in the corresponding pixel or bull nose extension finger 128.

[0044] When a load presses down on the top mat layer 106, the multiple pixels press down on the tops of the multiple spring elements 120. In response, the multiple spring elements 120 deflect downward to accommodate the load. The amount of deflection exhibited by an individual spring element 120 under a load may be affected by a spring deflection level associated with that spring element 120. As the multiple spring elements 120 deflect downward, the lower surfaces of the multiple pixels and/or multiple bull nose extension fingers 128 move toward the global layer 104. Relative to the ground, however, the spring

elements 120 may deflect further in that the local layer 104 may deflect downward under a load as the global layer 102 deflects under the load. As such, the spring elements 120 may individually deflect under a load according to the spring deflection level, and may also, as part of the local layer 104 as a whole, deflect further as the global layer 102 bends downward under the load.

[0045] The spring deflection level may be determined before manufacture and designed into the support structure 100. For example, the support structure 100 may be tuned to exhibit an approximately 25 mm of spring deflection level. In other words, the support structure 100 may be designed to allow the multiple spring elements 120 to deflect up to approximately 25 mm. Thus, where the local layer 104 includes spring elements of 16 mm height (i.e., the distance between the top of the global layer 102 and the top of the spring element), the lower surfaces of the multiple pixels may include a 9 mm stem. As another example, where the local layer 104 includes spring elements of 25 mm height, the lower surfaces of the multiple pixels may omit stems, but may connect to the tops of the multiple spring elements. As explained above, the height of each spring element 120 may vary according to a number of factors, including its relative position within the support structure 100.

[0046] The multiple pixels of the top mat layer 106 may be interconnected with multiple pixel connectors, as shown in Figure 8 and described below. The top mat layer 106 may include a variety of pixel connectors, such as planar or non-planar connectors, recessed connectors, bridged connectors, or other elements for interconnecting the multiple pixels, as described below. The multiple pixel connectors may be positioned at a variety of locations with reference to the multiple pixels. For example, the multiple pixel connectors may be positioned at the corners, sides, or other positions in relation to the multiple pixels. The multiple pixel connectors provide an increased degree of independence as between adjacent pixels, as well as enhanced flexibility to the top mat layer 106. For example, the multiple pixel connectors may allow for flexible downward deflection, as well as for individual pixels to move or rotate laterally with a significant amount of independence.

[0047] The top mat layer 106 may be injection molded from a flexible material such as a TPE, PP, TPU, or other flexible material. In particular, the top mat layer 106 may be formed from independently manufactured pixels and bull nose extension fingers 128, or may be injection molded as a sheet of multiple pixels.

5 **[0048]** When under a load, the load may contact with and press down on the top mat layer 106. Alternatively, the support structure 100 may also include a covering layer secured above the top mat layer 106. The covering layer may include a cushion, fabric, leather, or other covering materials. The covering layer may provide enhanced comfort and/or aesthetics to the support structure 100.

10 **[0049]** Figure 2 shows a broader view of the support structure 100 shown in Figure 1. The top mat layer 106 is supported on the local layer 104, which is supported on the global layer 102. The global layer 102 is secured to the frame 132. While Figure 2 shows a rectangular multi-layered support structure 100, the support structure 100 may include alternative shapes, including a circular shape.

15 **[0050]** The top mat layer 106 includes a pixel region 200 connected to a bull nose extension finger region 202. The pixel region 200 includes multiple interconnected pixels 204. The bull nose extension finger region 202 includes multiple interconnected bull nose extension fingers 128.

20 **[0051]** The top mat layer 106 also includes multiple pixel connectors to facilitate the connections between adjacent pixels 204 and bull nose extension fingers 128. The pixel connectors are described in more detail below and a close-up of one pixel connector is shown in Figure 8.

25 **[0052]** The pixels 204 provide enhanced flexibility to the top mat layer 106. The pixels 204 may include stems for connecting to a local layer 104. The bull nose extension fingers 128 may facilitate connection of the top mat layer 106 to a seating structure. For example, the bull nose extension fingers 128 may be glidably inserted into a seating structure. For example, the seating structure may include tracks into which each bull nose extension finger glides.

30 **[0053]** Figure 2 shows the spring attachment members 124 of the multiple spring elements 120. The spring attachment members 124 include a stem 206 extending downward towards the global layer 102. Each stem 206 may be inserted into and secured within an opening defined in a corresponding node 114

of the global layer 102. The stems 206 of the spring elements 120 are discussed in more detail below and are shown close-up in Figure 6. The respective heights of the stems 206 may vary within the local layer 104 to provide counter to the support structure 100.

5 **[0054]** Figure 3 shows a top view of a global layer 300. As noted above in connection with Figure 1, the global layer 300 includes multiple support rails 302 and one or more frame attachments 304. The ends of the support rails 302 connect between two substantially parallel frame attachments 304. In Figure 3, the frame attachments 304 each comprise a unitary segment extending along the
10 length of the frame attachment 304. As shown in Figure 1, the frame attachments may include discrete segments.

[0055] The global layer 300 may be formed using an injection molding technique. In particular, the global layer 300 may be formed using a center gating injection molding technique in which the cavity mold is gated at or near
15 positions of the cavity mold that correspond to the center of the support rails. An injection molding process may result in molding pressure loss within the molded apparatus, where the pressure loss may be greater in regions farther from the gate than regions closer to the gate. The center gating technique may facilitate symmetrical pressure loss along the support rails 302. As pressure loss can
20 affect alignment, a symmetrical pressure loss within the support rails may facilitate symmetrical alignment within the support rails 302.

[0056] Each support rail 302 comprises two straps 306 and multiple nodes 308 connected between adjacent straps. Each strap 306 includes aligned regions 310 and unaligned regions 312 defined along the length of the strap 306.
25 The aligned regions 310 may be defined by a cross-sectional area that is less than the cross-sectional area of the unaligned regions 312. The cross-sectional area of each aligned region 310 defined along a strap 306 may be tuned to the relative location of the aligned region 310 on the strap 306. The cross-sectional area of aligned regions 310 along a strap 306 may gradually increase the farther
30 the aligned region 310 is from the center of the strap 306. The cross-sectional area of the aligned regions 310 may also be tuned to the relative position of each aligned region 310 from the position of the gate. The cross-sectional area of

each aligned region 310 may increase by between about .1% to about 1%, such as by about .5%, the more distant the aligned region is from the position of the gate. For example, the cross-sectional area of an aligned region may be between about .1% and about 1% greater than the cross-sectional area of an aligned region on the strap that is immediately closer to the position of the gate.

[0057] The nodes 308 are connected between adjacent unaligned regions 312. The nodes 308 may comprise a spring connection for connecting the global layer 300 to the local layer. The spring connection may be an opening defined in the node 308 for receiving a stem or other protrusion from a spring element. The nodes 308 may connect to the spring elements with a snap-fit connection, a press fit, or be integrally molded together.

[0058] The frame attachments 304 facilitate connection of the global layer 300 to a frame. The frame attachments 304 may comprise an inside edge 314 and an outside edge 316. Each strap 306 that is part of a support rail 302 may include two ends that connect to the inside edges 314 of the frame attachments 304. The connection between the ends of adjacent straps 306 and the inside edge 314 of a frame attachment 304 may define an opening 318 between adjacent straps 306 along the inside edge 314 of the frame attachment 304.

[0059] Figure 4 shows a portion of the support rail 302 including the node 308 connected between two straps 306. In particular, the node 308 is connected between the adjacent unaligned regions 312 of the two straps 306. Each strap 306 includes aligned regions 310 connected on either side of the corresponding unaligned region 312. The cross-sectional area of the unaligned region 312 may be greater than the cross-sectional area of the aligned regions 310.

[0060] The node 308 may include a spring connection 400 for connecting the global layer 300 to a local layer. In Figure 4, the spring connection 400 is an opening defined in the node 308 for receiving a stem or other protrusion of the local layer. The spring connection may alternatively be a stem or protrusion extending vertically above the node 308 for mating with an opening defined in the local layer.

[0061] Figure 5 shows a top view of a local layer 500. The local layer 500 includes multiple interconnected spring elements 502. The local layer 500 may

be formed from a unitary piece of material. Each of the spring elements 502 includes a top 504, at least one deflectable member 506, and a spring attachment member 508. The top 504 may define an opening for receiving a stem or other protrusion extending from the lower surface of a corresponding pixel of a top mat layer.

[0062] The deflectable member 506 includes two spiral arms connected to and spiraling away from the top 504. The cross-sectional area of the spiraled arms may be tapered or otherwise vary along the length of each arm. For example, the cross-sectional area of a spiral arm may gradually increase or decrease, beginning where the arm connects to the top 504, along the length of the spiral arm and be smallest where the spiral arm connects to the spring attachment member 508. The cross-sectional area of each spiral arm may be tailored to the relative location of the spring element 502 within the local layer 500, a desired spring rate of the spring element 500, or other factors.

[0063] The spiral arms may include or be connected to the spring attachment member 508. In Figure 5, a spiral arm of two adjacent spring elements 502 connects the same spring attachment member 508.

[0064] The spring elements 502 are arranged in diagonal rows extending from one side of the local layer 500 to the other. The spring elements 502 may be interconnected with adjacent spring elements in the same diagonal row, but may not directly connect to spring elements in adjacent diagonal rows. In this configuration, spring elements 502 within a diagonal row may deflect or respond to a load substantially independently to the response of spring elements 502 in an adjacent diagonal row.

[0065] Figure 6 shows a portion of the spring attachment member 508. In particular, Figure 6 shows a portion of the stem that may fit into an opening defined in the global layer. The stem includes a first cylindrical portion 600 that tapers down into a second cylindrical portion 602, where the first cylindrical portion 600 has a greater cross-sectional area than does the second cylindrical portion 602. The second cylindrical portion 602 may include a tapered end 604. A portion of the second cylindrical portion 602 may be recessed to define a ridge 606 in the face of the second cylindrical portion 602. The ridge 606 may facilitate

a snap-fit connection between the stem and an opening defined in the global layer.

[0066] Figure 7 shows a top view of an exemplary local layer 700. The local layer 700 includes multiple spring elements 702 that each includes a top 704, a deflectable member 706, and a spring attachment member 708. The deflectable member 706 may include at least one spiraled arm 710. For example, Figure 7 shows that some of the spring elements 712 near the edges of the local layer 700 include deflectable members having a single spiraled arm 710.

[0067] Figure 8 shows a top view of a top mat layer 800 including a pixel region 802 and a bull nose region 804. The pixel region 802 includes multiple hexagonal pixels 806 interconnected at their corners with pixel connectors 808. Each of the multiple pixels includes an upper surface and a lower surface. The multiple pixels 806 are shown as hexagonal, but may take other shapes, such as rectangles, octagons, triangles, or other shapes. The lower surface includes a stem extending from the lower surface for connecting to the local layer.

[0068] Each of the multiple pixel connectors 808 interconnects three adjacent pixels 806. The multiple pixel connectors 808 may alternatively interconnect the multiple pixels 806 at their respective sides. The multiple pixels 806 may be planar, non-linear, and/or contoured.

[0069] The multiple pixels 806 may define openings within each pixel. The openings may add flexibility to the top mat layer 800 in adapting to a load. The top mat layer 800 may define any number of openings within each pixel 806, including zero or more openings. Additionally, each pixel 806 within the top mat layer 800 may define a different number of openings or different sized openings, depending, for example, on the pixel's respective position within the pixel region 802.

[0070] Figure 9 shows the underside of a pixel 900 within the top mat layer 800 in which the lower surface 902 of the pixel 900 is shown facing upwards. In particular, Figure 9 shows the lower surface 902 of the pixel and a stem 904 extending from the lower surface 902. The stem 904 may connect the pixel 900 to a spring element of a local layer. The connection between the stem 904 and a

spring element may be an integral molding, a snap-fit connection, or another connection technique.

[0071] The stem may include two ends 906 and 908, a first end 906 connected to the lower surface of the pixel 902, and a second end 908 for connecting to the spring element. The stem 904 may include one or more shoulders 910 extending laterally from the stem 904, where the shoulder 910 has a height that is less than the height of the stem 904. The second end 908 of the stem 904 may be tapered. The second or tapered end 908 may include a lip 912 extending beyond the stem 904. To facilitate connection between the top mat layer and a local layer, the stem may be inserted into an opening defined in a top of the spring element. After the stem 904 passes a certain distance into the opening of the top of the spring element, the lip 912 may provide a catch to hold the stem 904 within the opening and resist removal of the stem 904. The lip 912 may catch on the lower surface of the top, on a ridge defined in an inside edge of the top opening, or on another surface.

[0072] The shoulders 910 may mate or otherwise be in contact with the upper surface of the top when the stem 904 passes through the top opening sufficiently for the lip to catch on the top and secure the pixel 900 to the top of the corresponding spring element. As an alternative, the stem 904 may omit the shoulders 910 and the lower surface 902 may contact with the upper surface of the top when the stem 904 mates with the top opening.

[0073] Figure 9 shows a pixel connector 914 connecting adjacent pixels. In Figures 8 and 9, the pixel connectors 914 connect between the corners of three adjacent hexagonal pixels. The pixel connector 914 includes arched arms 916 connected to a corner of one of the pixels to provide slack for each pixel's independent movement when a load is applied. The arched arms 916 may extend from the corner and meet at a junction 918 between the pixels. The junction 918 may be below the plane defined by the interconnected pixels. Other shapes, such as an S-shape, or other undulating shape may be implemented as part of the pixel connector 914. The pixel connectors 914 may help reduce or prevent contact between adjacent pixels under deflection. The top mat layer 600 may alternatively omit the pixel connectors to increase the independence of the

multiple pixels. While Figures 8 and 9 show pixel connectors 914 connected at the corners of the multiple pixels, the multiple pixels may alternatively be connected at their respective sides. The pixel connectors 914 may, for example, include a U-shaped bend connected between the sides of adjacent pixels.

5 **[0074]** Figure 10 is a process 1000 for manufacturing a layered support structure. The process 1000 may be automated or executed manually. An assembly apparatus may be utilized to carry out the process 1000. The process 1000 obtains the global layer, local layer, and the top mat layer (1002). Each of the obtained global, local, and top mat layers may correspond to the layers
10 described above, respectively.

15 **[0075]** One or more of the global layer, local layer, and top mat layer may be formed using an injection molding technique. The global layer may be formed using a center gated injection molding technique. The gates used in the cavity mold for the injection molding process may be located on the portion of the cavity
20 mold corresponding to approximately the middle of each support rail. The cavity mold may include a gate corresponding to each support rail, or each strap of the support rails, or according to other configurations.

25 **[0076]** As discussed above, the global layer within a layered support structure includes straps with aligned and unaligned regions defined along the straps. Before alignment, the global layer may include pre-alignment regions defined
30 along the straps. The pre-alignment regions may become the aligned regions after alignment or orientation of those regions. The global layer obtained for the process may have been previously aligned.

35 **[0077]** As an alternative, the process 1000 may align or orient the global layer (1004). The process 1000 may stretch the global layer to orient the pre-alignment regions. Other alignment techniques may also be used, including compression. The assembly apparatus may grip or otherwise hold opposite
40 sides of the global layer and stretch the global layer along the direction of the support rails. The global layer may be stretched between approximately 10-12 inches. The stretching may also cause each pre-alignment region to stretch
45 between approximately four to approximately eight times its original length.

[0078] Figure 11 shows a global layer 1100 stretched by an assembly apparatus 1102. The aligned regions 1104 of the stretched global layer 1100 correspond to the thinner portions of each strap 1106. The unstretched or unaligned regions 1108 of the global layer correspond to the positions at which a node 1110 is connected between adjacent straps 1106. The global layer 1100 includes openings 1112 defined between adjacent nodes and adjacent straps of the global layer 1100. The cross-sectional area of each opening 1112 increases as the global layer 1100 is stretched.

[0079] While the global layer is stretched according to block 1004 of the process 1000, node locators may be inserted into the openings 1112 (1006). The node locators may be part of or separate from the assembly apparatus. The node locators may be blocks that fit in the openings 1112.

[0080] The process 1000 may connect the local layer to the global layer (1008). As discussed above, the local layer may include spring elements having spring attachment members that facilitate connection of the local layer to the global layer, such as the spring attachment member 508 shown in Figures 5 and 6. The process 1000 may guide the spring attachment members into corresponding openings defined in the nodes of the global layer until a snap-fit or other connection type is achieved.

[0081] The process 1000 connects the top mat layer to the local layer (1010). As discussed above, the top mat layer may include pixels having one or more stems extending downward from the pixels. The stems may facilitate connection of the top mat layer to the local layer. The process 1000 may guide the stems into corresponding openings at the top of each spring element until a snap-fit or other connection type is achieved.

[0082] The process 1000 may assemble the layered support structure in an upside-down orientation relative to the assembly apparatus, or relative to the orientation of the layered support structure's intended use (e.g., in a chair). For example, Figure 10 shows the assembly apparatus from a top view perspective holding the global layer with its underside facing up, i.e., the side of the global layer viewable in Figure 10 is the side that would typically face down in a chair application.

[0083] In this example, the node locators (according to 1006) may be inserted from above the upside-down oriented global layer down into the openings 1112. According further to this example, the process 1000 may connect the local layer to the global layer (according to 1008) by bringing the local layer, oriented upside-down relative to the assembly apparatus, and guiding the spring attachment members up into the corresponding openings defined by the nodes of the global layer until snap-fit or other connection type is achieved, such that the top of each spring element is oriented downward relative to the assembly apparatus. Likewise, the process 1000 may connect the top mat layer to the local layer (according to 1010) be bring the top mat layer, oriented upside-down relative to the assembly apparatus, and guiding the stems of the pixels up into corresponding openings at the top of each spring element until a snap-fit or other connection type is achieved, such that the top of the top mat layer is oriented downward relative to the assembly apparatus.

[0084] The process 1000 retracts the node locators (1012) from the assembled layered support structure. The process 1000 may secure the assembled layered support structure to a frame, such as the frame of a chair, or may provide the assembled layered support structure to another process for frame attachment.

[0085] Figure 12 shows a pre-aligned global layer 1200. The pre-aligned global layer 1200 may be provided using an injection molding process. The gate locations 1202 for the molding process may be located at the center, or near the center of each pre-aligned support rail 1204. The gate locations 1202 may be located at a node 1206 or other portion of each pre-aligned support rail 1204. In Figure 12, the gate location is at a node 1206 located near the center of each pre-aligned support rail 1204.

[0086] Figure 13 shows a close-up view of a portion of the pre-aligned global layer 1200 shows in Figure 12. In particular, Figure 13 shows the gate location 1202 on the node 1206. The hot drop depression 1300 in the unaligned region 1302 connected to the node 1206 may be product of the molding process. For example, the hot drop depression 1300 may correspond to a depression in the cavity mold for providing clearance to a hot drop tip.

[0087] Figure 14 shows a top view of a global layer cavity mold 1400 and hot drop channels 1402 for forming a pre-aligned global layer, such as the pre-aligned global layer 1200 shows in Figure 12, though an injection molding process. The positions of the hot drops 1402 relative to the cavity mold correspond approximately to the gate locations of the mold.

[0088] While various embodiments of the invention have been described, it will be apparent to those of ordinary skill in the art that many more embodiments and implementations are possible within the scope of the invention. Accordingly, the invention is not to be restricted except in light of the attached claims and their equivalents.

CLAIMS

“We” claim:

1. A layered support structure comprising:
5 a first layer comprising:
a support rail comprising:
a first strap comprising multiple aligned regions and
unaligned regions defined along the first strap;
a second strap substantially parallel to the first strap and
10 comprising multiple aligned regions and unaligned regions defined along the
second strap; and
multiple nodes connected between the first and second
straps.
- 15 2. The layered support structure of claim 1, the first layer further comprising:
a first frame attachment connected to a first end of the support rail and that
is oriented substantially perpendicular to the support rail; and
a second frame attachment connected to a second end of the support rail
and that is oriented substantially perpendicular to the support rail.
- 20 3. The layered support structure of claim 1, where a cross-sectional area of
each aligned region of the first strap is tuned based on a respective location of
each aligned region within the first strap.
- 25 4. The layered support structure of claim 1, the first strap further comprising a
gate position, where each of the multiple aligned regions of the first strap
comprises a cross-sectional area that is greater than a cross-sectional area of
any aligned region of the first strap positioned closer to the gate position.
- 30 5. The layered support structure of claim 4, where the cross-sectional area of
each aligned region is between approximately .1% to approximately 1% greater
than the cross-sectional area of an adjacent aligned region immediately closer to

the gate position along the first strap.

6. The layered support structure of claim 1, further comprising:

a second layer positioned above the first layer and comprising multiple
5 spring elements supported by the multiple nodes; and

a third layer positioned above the second layer and comprising multiple
interconnected pixels supported by the second layer.

7. The layered support structure of claim 6, where each spring element
10 comprises:

a top;

a deflectable member connected to the top; and

a spring attachment member connected to the deflectable member for
connecting the spring to at least one node of the first layer.

8. The layered support structure of claim 7, where the deflectable member
comprises two spiraled arms extending away from the top.

9. The layered support structure of claim 7, where the spring attachment
20 member comprises a stem for connecting the spring attachment member to at
least one of the nodes of the first layer.

10. The layered support structure of claim 9, where each node defines an
opening for receiving the stem of a spring attachment member, and where the
25 stem comprises a ridge that facilitates a snap-fit connection when the stem is
inserted into the opening.

11. The layered support structure of claim 6, where the third layer further
comprises multiple bull nose extension fingers located at a side of the third layer,
30 where each bull nose extension finger comprises a substantially parallel
orientation relative to the other bull nose extension fingers.

12. The layered support structure of claim 6, where each pixel comprises an upper surface and a lower surface, where the lower surface is oriented to face the second layer, and where each pixel comprises a stem extending from the lower surface.

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13. The layered support structure of claim 12, where each spring element comprises a top that defines an opening for receiving one of the stems extending from the pixels to facilitate a connection between the second and third layers.

10

14. The layered support structure of claim 13, where stem comprises:
a first end connected to the lower surface of the pixel;
a second end comprising a tapered segment;
a cylindrical strap extending between the first and second ends; and
a lip connected to the tapered segment that extends beyond the cylindrical
strap to facilitate a snap-fit connection when the stem is inserted into the opening.

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15. The layered support structure of claim 6, where the second layer comprises a unitary piece of elastomeric material.

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16. The layered support structure of claim 6, where the third layer comprises a unitary piece of elastomeric material.

17. The layered support structure of claim 1, where the first layer comprises a unitary piece of elastomeric material.

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18. A layered support structure comprising:
a first layer comprising:
a first frame attachment;
a second frame attachment; and
multiple support rails extending between the first and second frame
attachments, each support rails comprising:
a first strap comprising a first length that extends between

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the first and second frame attachments, the first strap comprising:

multiple aligned regions defined along the first strap;

and

multiple unaligned regions defined along the first strap

5 between adjacent aligned regions;

a second strap comprising a second length that extends between the first and second frame attachments substantially parallel to the first strap, the second strap comprising:

multiple aligned regions defined along the second

10 strap; and

multiple unaligned regions defined along the second strap between adjacent aligned regions, where a position along the second strap of each unaligned region corresponds to a position of an unaligned region in the first strap; and

15 multiple nodes connected between the first and second straps.

19. The layered support structure of claim 18, where each of the multiple aligned regions of the first strap comprise a cross-sectional area tailored to a
20 location of the aligned region along the first strap.

20. The layered support structure of claim 19, where the first strap comprises:

a first end connected to the first frame attachment;

a second end connected to the second frame attachment; and

25 a gate position located approximately half-way between the first end and the second end; and

where the cross-sectional area of each of the multiple aligned regions is tailored to the location of the aligned region relative to a gate position along the first strap.

30 21. The layered support structure of claim 20, where the cross-sectional area of each of the multiple aligned regions is less than or equal to the cross-sectional

area of each of the aligned regions that are located closer to the gate position.

22. The layered support structure of claim 20, where the cross-sectional area of each of the multiple aligned regions is between approximately .1% to approximately 1% greater than the cross-sectional area of an adjacent aligned region immediately closer to the gate position along the first strap.

23. The layered support structure of claim 19, further comprising:

a second layer positioned above the first layer, the second layer comprising multiple spring elements supported by the multiple nodes; and

a top mat layer supported by the second layer, the top mat layer comprising multiple interconnected pixels supported by the multiple spring elements.

24. The layered support structure of claim 23, where each of the multiple spring elements comprise:

a top;

a deflectable member connected to the top and supported by one or more of the multiple nodes.

25. The layered support structure of claim 24, where the deflectable member comprises:

a first spiral arm comprising:

a first end connected to the top; and

a second end connected to a spring attachment member; and

a second spiral arm comprising:

a third end connected to the top; and

a fourth end connected to the spring attachment member.

26. The layered support structure of claim 25, where the spring attachment member comprises a protrusion extending towards the first layer, and where the first node defines an opening for receiving the protrusion with a snap-fit

connection.

27. A layered support structure comprising:

a first unitary piece of elastomeric material forming a first layer, the first layer comprising:

multiple dual-strap support rails, each dual-strap support rail comprising:

a first strap;

a second strap oriented substantially parallel to the first

strap; and

multiple nodes connected between the first and second strap.

28. The layered support structure of claim 27, where the first strap comprises:

multiple aligned regions defined along the strap; and

multiple unaligned regions defined along the strap, where each aligned region is positioned between adjacent unaligned regions.

29. The layered support structure of claim 28, where each of the multiple unaligned regions comprises a greater cross-sectional area than each of the aligned regions.

30. The layered support structure of claim 28, where the first strap comprises a gate position and where each aligned region comprises a cross-sectional area that is greater than or equal to a cross-sectional area of any other aligned region that is positioned farther from the gate position of the first strap.

31. The layered support structure of claim 27, further comprising:

a second unitary piece of elastomeric material forming a second layer positioned above the first layer, the second layer comprising multiple spring elements supported on the multiple nodes;

a third unitary piece of elastomeric material forming a third layer positioned

above the second layer, the third layer comprising a pixel region that comprises multiple interconnected pixels, where each pixel is supported on at least one of the multiple spring elements.

5 32. A method for manufacturing a layered support structure, comprising:
 providing a first layer comprising:

 a support rail comprising:

 a first strap comprising multiple pre-alignment regions and
unaligned regions defined along the first strap;

10 a second strap substantially parallel to the first strap and
comprising multiple pre-aligned regions and unaligned regions defined along the
second strap;

 multiple nodes connected between the first and second
straps; and

15 multiple openings defined along the support rail between an
inside edge of adjacent nodes, an inside edge of the first strap, and an inside
edge of the second strap, where the inside edges of adjacent nodes substantially
face each other and the inside edges of the first and second straps substantially
face each other.

20 33. The method of claim 32, where the first layer is provided using an injection
molding technique.

25 34. The method of claim 32, where the first layer is provided using a center
gated injection molding technique.

30 35. The method of claim 32, further comprising aligning each of the multiple
pre-alignment regions of the first and second straps to form multiple aligned
regions defined along the first strap and the second strap.

36. The method of claim 35, where aligning each of the pre-alignment regions
comprises:

stretching the first layer in a direction substantially parallel to the direction of the first and second straps; and

inserting a node locator into each of the multiple openings.

5 37. The method of claim 36, where the first layer is stretched approximately 10-12 inches.

38. The method of claim 36, where the stretching causes each of the multiple pre-alignment regions to be stretched approximately four to eight times a pre-
10 alignment length.

39. The method of claim 32, further comprising:
providing a second layer comprising multiple spring elements supported by the multiple nodes; and
15 providing a third layer comprising multiple interconnected pixels supported by the second layer.

40. The method of claim 39, where the second and third layers are provided using an injection molding technique.
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41. The method of claim 39, further comprising:
connecting the second layer to the first layer, where the second layer is positioned below the first layer after the connecting; and
connecting the third layer to the second layer, where the third layer is
25 positioned below the second layer after the connecting.