

METHOD AND APPARATUS FOR OPHTHALMIC DEVICES INCLUDING GRADIENT-INDEXED AND SHAPED LIQUID CRYSTAL LAYERS

CROSS REFERENCE TO RELATED APPLICATIONS

This application claims priority to Provisional Application No. 61/878,723 filed

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BACKGROUND OF THE INVENTION

1. Field of the Invention

10 The present invention describes an ophthalmic lens device with a variable optic capability and, more specifically, in some embodiments, the fabrication of an ophthalmic lens with a variable optic insert utilizing liquid crystal elements.

2. Discussion of the Related Art

15 Traditionally an ophthalmic lens, such as a contact lens or an intraocular lens provided a predetermined optical quality. A contact lens, for example, may provide one or more of the following: vision correcting functionality; cosmetic enhancement; and therapeutic effects, but only a set of vision correction functions. Each function is provided by a physical characteristic of the lens. Basically, a design incorporating a refractive
20 quality into a lens provides vision corrective functionality. A pigment incorporated into the lens may provide a cosmetic enhancement. An active agent incorporated into a lens may provide a therapeutic functionality.

To date, optical quality in an ophthalmic lens has been designed into the physical characteristic of the lens. Generally, an optical design has been determined and then
25 imparted into the lens during fabrication of the lens, for example, through cast molding, or lathing. The optical qualities of the lens have remained static once the lens has been formed. However, wearers may at times find it beneficial to have more than one focal power available to them in order to provide sight accommodation. Unlike spectacle

wearers, who may change spectacles to change an optical correction, contact wearers or those with intraocular lenses have not been able to change the optical characteristics of their vision correction without significant effort or the complementing of spectacles with contact lenses or intraocular lenses.

5 SUMMARY OF THE INVENTION

Accordingly, the present invention includes innovations relating to a variable optic insert with liquid crystal elements that may be energized and incorporated into an ophthalmic device, which is capable of changing the optical quality of the device.

10 Examples of such ophthalmic devices may include a contact lens or an intraocular lens. In addition, methods and apparatus for forming an ophthalmic lens with a variable optic insert with liquid crystal elements are presented. Some embodiments may also include a cast-molded silicone hydrogel contact lens with a rigid or formable energized insert, which additionally includes a variable optic portion, wherein the insert is included within
15 the ophthalmic lens in a biocompatible fashion.

The present invention therefore includes disclosure of an ophthalmic lens with a variable optic insert, apparatus for forming an ophthalmic lens with a variable optic insert, and methods for manufacturing the same. An energy source may be deposited or assembled onto a variable optic insert and the insert may be placed in proximity to one, or
20 both of, a first mold part and a second mold part. A composition comprising a reactive monomer mixture (hereafter referred to as a reactive monomer mixture) is placed between the first mold part and the second mold part. The first mold part is positioned proximate to the second mold part thereby forming a lens cavity with the energized media insert and at least some of the reactive monomer mixture in the lens cavity; the reactive monomer
25 mixture is exposed to actinic radiation to form an ophthalmic lens. Lenses are formed via the control of actinic radiation to which the reactive monomer mixture is exposed. In some embodiments, an ophthalmic lens skirt or an insert-encapsulating layer comprises standard hydrogel ophthalmic lens formulations. Exemplary materials with characteristics that may provide an acceptable match to numerous insert materials may include, for example, the

Narafilcon family(including Narafilcon A and Narafilcon B), the Etafilcon family(including Etafilcon A), Galyfilcon A and Senofilcon A.

5 The methods of forming the variable optic insert with liquid crystal elements and the resulting inserts are important aspects of various exemplary embodiments of the present invention. In some exemplary embodiments, the liquid crystal may be located between two alignment layers, which may set the resting orientation for the liquid crystal. In some exemplary embodiments the alignment layers may be patterned in various manners. The patterning of the alignment layers may be performed such that the alignment of the molecules in the alignment layer interacts with liquid crystal molecules to form a smoothly varying pattern from a first orientation in the center of the lens to a second orientation at or near the edge of the lens. The smoothly varying pattern may be classified as a gradient pattern, and since the orientation of liquid crystal molecules may affect the effective index of refraction of the layer, the smoothly varying pattern may also be classified as forming a gradient-indexed pattern. Those two alignment layers may be in electrical communication with an energy source through electrodes deposited on substrate layers that contain the variable optic portion. The electrodes may be energized through an intermediate interconnect to an energy source or directly through components embedded in the insert.

20 The energization of the electrode layers may cause a shift in the liquid crystal from a resting orientation which may be patterned in a gradient-indexed pattern to an energized orientation. In exemplary embodiments that operate with two levels of energization, on or off, the liquid crystal may only have one energized orientation. In other alternative exemplary embodiments, where energization occurs along a scale of energy levels, the liquid crystal may have multiple energized orientations. Still further exemplary embodiments may derive where the energization process may cause a switch between different states through an energization pulse.

25 The resulting alignment and orientation of the molecules may affect light that passes through the liquid crystal layer thereby causing the variation in the variable optic insert. For example, the alignment and orientation may act with refractive characteristics upon the incident light. Additionally, the effect may include an alteration of the

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polarization of the light. Some exemplary embodiments may include a variable optic insert wherein energization alters a focal characteristic of the lens.

In some exemplary embodiments, the liquid crystal layer may be formed in a manner wherein a polymerizable mixture comprising liquid crystal molecules is caused to polymerize. The monomer(s) used to form the polymer matrix may itself contain attached liquid crystal portions. By controlling the polymerization and including liquid crystal molecules unattached to the monomer compounds a matrix of cross-linked polymer regions may be formed that encompass regions where the individual liquid crystal molecules are located. In some terminology such a combination of cross-linked polymerized molecules with interstitial included liquid crystal molecules may be call a network arrangement. Alignment layers may guide alignment of the liquid crystal molecules which are attached to monomer such that the network of polymerized material is aligned to the guiding alignment layers. In some exemplary embodiments, there may be a smoothly varying pattern formed by various manners into the alignment layers which may then cause the liquid crystal molecules or networks of liquid crystal material to form gradient-indexed patterns. The attached liquid crystal molecules are locked into an orientation during the polymerization, however the interstitially located liquid crystal molecules may be free to orient in space. When no external influence is present, the free liquid crystal molecules will have their alignment influenced by the matrix of aligned liquid crystal molecules.

Accordingly, in some exemplary embodiments an ophthalmic device may be formed by the incorporation of a variable optic insert comprising liquid crystal molecules within an ophthalmic device. The variable insert may comprise at least a portion which may be located in the optic zone of the ophthalmic device. The variable insert may comprise a front insert piece and a back insert piece. In some exemplary embodiments, the liquid crystal molecules may be aligned into a pattern wherein the index of refraction across a least a first portion of the optic insert may vary with a radial dependence. The radial dependence may have a primarily parabolic dependence on the radial distance and in some exemplary embodiments the radial dependence may have parabolic and higher order parametric dependence on the radial distance from a center of the optic device.

The front and back insert pieces may have either or both of their surfaces curved in various manners, and in some exemplary embodiments the radius of curvature of a back surface on the front insert piece may be different from the radius of curvature of the front surface of the back insert piece. In an alternative manner of description, in some exemplary
5 embodiments, the front insert piece may have a surface with a first curvature, and the back insert piece may have a second surface with a second curvature. In some exemplary embodiments the first curvature may be different from the second curvature. An energy source may be included into the lens and into the insert, and in some embodiments the energy source may be located wherein at least a portion of the energy source is in the non-
10 optic zone of the device.

In some exemplary embodiments the gradient-indexed layer comprising liquid crystal material may be capable of causing an optical effect supplementary to the effect of the different radii of insert surfaces.

In some exemplary embodiments the ophthalmic device may be a contact lens.
15 In some exemplary embodiments the insert of the ophthalmic device may comprise electrodes made of various materials, including transparent materials such as indium tin oxide (ITO) as a non-limiting example. A first electrode may be located proximate to a back surface of a front curve piece, and a second electrode may be located proximate to a front surface of a back curve piece. When an electric potential is applied across the first and
20 second electrodes, an electric field may be established across a liquid crystal layer located between the electrodes. The application of an electric field across the liquid crystal layer may cause free liquid crystal molecules within the layer to physically align with the electric field. In some exemplary embodiments, the free liquid crystal molecules may be located in interstitial regions within a network of polymer and in some exemplary embodiments the
25 polymer backbone may contain chemically bound liquid crystal molecules which may be aligned during polymerization by alignment layers. When the liquid crystal molecules align with the electric field, the alignment may cause a change in the optical characteristics that a light ray may perceive as it traverses the layer containing liquid crystal molecules. A non-limiting example may be that the index of refraction may be altered by the change in
30 alignment. In some exemplary embodiments, the change in optical characteristics may

result in a change in focal characteristics of the lens which contains the layer containing liquid crystal molecules.

In some exemplary embodiments, the ophthalmic devices as described may include a processor.

5 In some exemplary embodiments, the ophthalmic devices as described may include an electrical circuit. The electrical circuit may control or direct electric current to flow within the ophthalmic device. The electrical circuit may control electrical current to flow from an energy source to the first and second electrode elements.

10 The insert device may comprise more than a front insert piece and a back insert piece in some exemplary embodiments. An intermediate piece or pieces may be located between the front insert piece and the back insert piece. In one example, a liquid crystal containing layer may be located between the front insert piece and the intermediate piece. The intermediate piece may also be referred to as an intermediate curve piece. The variable insert may comprise at least a portion which may be located in the optic zone of the
15 ophthalmic device. The front, intermediate and back insert piece may have either or both of their surfaces curved in various manners, and in some exemplary embodiments the radius of curvature of a back surface on the front insert piece may be different from the radius of curvature of the front surface of the intermediate insert piece. An energy source may be included into the lens and into the insert, and in some exemplary embodiments the energy
20 source may be located wherein at least a portion of the energy source is in the non-optic zone of the device.

The insert with a front insert piece, a back insert piece and at least a first intermediate insert piece may comprise at least a first liquid crystal molecule, and the liquid crystal molecule or molecules may also be found in polymer networked regions of
25 interstitially located liquid crystal molecules. In some exemplary embodiments, there may be a smoothly varying pattern formed by various manners into alignment layers which may then cause the liquid crystal molecules or networks of liquid crystal material to form gradient-indexed patterns. In some exemplary embodiments of gradient-indexed patterns, the liquid crystal molecules may be aligned into a pattern wherein the index of refraction
30 across at least a first portion of the optic insert may vary with a radial dependence. The

radial dependence may have a primarily parabolic dependence on the radial distance, and in some exemplary embodiments, the radial dependence may have parabolic and higher order parametric dependence on the radial distance from a center of the optic device.

5 In some exemplary embodiments with a front insert piece, a back insert piece and at least a first intermediate insert piece the ophthalmic device may be a contact lens.

10 In some exemplary embodiments the insert of the ophthalmic device with a front insert piece, a back insert piece and at least a first intermediate insert piece may comprise electrodes made of various materials, including transparent materials such as ITO as a non-limiting example. A first electrode may be located proximate to a back surface of a front curve piece, which may also be referred to as an insert front curve piece, and a second electrode may be located proximate to a front surface of an intermediate piece. When an electric potential is applied across the first and second electrodes, an electric field may be established across a liquid crystal layer located between the electrodes. The application of an electric field across the liquid crystal layer may cause liquid crystal molecules within the layer to physically align with the electric field. In some exemplary embodiments, the liquid crystal molecules may be located in polymer networked regions of interstitially located liquid crystal material. When the liquid crystal molecules align with the electric field, the alignment may cause a change in the optical characteristics that a light ray may perceive as it traverses the layer containing liquid crystal molecules. A non-limiting example may be that the index of refraction may be altered by the change in alignment. In some embodiments, the change in optical characteristics may result in a change in focal characteristics of the lens which contains the layer containing liquid crystal molecules.

15 In some exemplary embodiments the intermediate piece may comprise multiple pieces that are joined together.

25 In some exemplary embodiments where the insert device may be comprised of a front insert piece, a back insert piece and an intermediate piece or pieces, a liquid crystal containing layer may be located between the front insert piece and the intermediate piece or between the intermediate piece and the back insert piece. In addition, a polarizing element may be located within the variable insert device as well. The variable insert may comprise at least a portion which may be located in the optic zone of the ophthalmic device. The

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front, intermediate and back insert pieces may have either or both of their surfaces curved in various manners, and in some exemplary embodiments the radius of curvature of a back surface on the front insert piece may be different from the radius of curvature of the front surface of the intermediate insert piece. An energy source may be included into the lens
5 and into the insert and in some exemplary embodiments the energy source may be located wherein at least a portion of the energy source is in the non-optic zone of the device.

In some exemplary embodiments it may be possible to reference surfaces within the variable optic insert rather than pieces. In some exemplary embodiments, an ophthalmic lens device may be formed where a variable optic insert may be positioned within the
10 ophthalmic lens device where at least a portion of the variable optic insert may be positioned in the optical zone of the lens device. These exemplary embodiments may include a curved front surface and a curved back surface. In some exemplary embodiments the front surface and the back surface may be configured to form at least a first chamber. The ophthalmic lens device may also include an energy source embedded in the insert in at
15 least a region comprising a non-optical zone. The ophthalmic lens device may also include a layer containing liquid crystal material positioned within the chamber, wherein the layer includes regions of liquid crystal material aligned in a pattern wherein an index of refraction across at least a first portion of the variable optic insert varies with a radial dependence.

20 In some exemplary embodiments a contact lens device may be formed where a variable optic insert may be positioned within the ophthalmic lens device where at least a portion of the variable optic insert may be positioned in the optical zone of the lens device. These exemplary embodiments may include a curved front surface and a curved back surface. In some exemplary embodiments the front surface and the back surface may be
25 configured to form at least a first chamber or at least one chamber. The contact lens device may also include a layer containing liquid crystal material positioned within the chamber, wherein the layer includes regions of liquid crystal material aligned in a pattern wherein an index of refraction across at least a first portion of the variable optic insert or across at least a portion of one chamber varies with a radial dependence.

In some exemplary embodiments a contact lens device may be formed where a variable optic insert may be positioned within the ophthalmic lens device where at least a portion of the variable optic insert may be positioned in the optical zone of the lens device. The contact lens device may also include a layer containing liquid crystal material

5 positioned within the chamber, wherein the layer includes regions of liquid crystal material aligned in a pattern wherein an index of refraction across at least a first portion of the variable optic insert varies with a radial dependence, and wherein at least a first surface of the layer may be curved.

In some exemplary embodiments an ophthalmic lens device may be formed where

10 a variable optic insert may be positioned within the ophthalmic lens device where at least a portion of the variable optic insert may be positioned in the optical zone of the lens device. These embodiments may include a curved front surface and a curved back surface. In some exemplary embodiments a first curved front surface and a first curved back surface may be configured to form at least a first chamber. A second curved front surface and a second

15 curved back surface may be configured to form at least a second chamber. The ophthalmic lens device may also include a layer containing liquid crystal material positioned within the first chamber, wherein the layer includes regions of liquid crystal material aligned in a pattern wherein an index of refraction across at least a first portion of the variable optic insert varies with a radial dependence. The ophthalmic lens device may also include an

20 energy source embedded in the insert in at least a region comprising a non-optical zone. In some exemplary embodiments the ophthalmic lens may be a contact lens.

In some exemplary embodiments a contact lens device may be formed where a variable optic insert may be positioned within the ophthalmic lens device where at least a portion of the variable optic insert may be positioned in the optical zone of the lens device.

25 The contact lens may include a curved first front surface and a curved first back surface wherein the first front surface and the first back surface are configured to form at least a first chamber. The contact lens may also include a first layer of electrode material proximate to the back surface of the curved first front surface. The contact lens may also comprise a second layer of electrode material proximate to the front surface of the first

30 back curve piece, which may also be considered an insert back curve piece. The contact

lens may also include a first layer containing liquid crystal material positioned within the first chamber, wherein the layer includes regions of liquid crystal material aligned in a pattern wherein an index of refraction across at least a first portion of the variable optic insert varies with a radial, wherein the first layer containing liquid crystal material varies its index of refraction affecting a ray of light traversing the first layer of liquid crystal material when an electric potential is applied across the first layer of electrode material and the second layer of electrode material. The contact lens device may additionally include a curved second front surface and a curved second back surface wherein the second front surface and the second back surface are configured to form at least a second chamber. The contact lens device may also comprise a third layer of electrode material proximate to the back surface of the curved second front surface, and a fourth layer of electrode material proximate to the front surface of the second back curve piece. A second layer containing liquid crystal material positioned within the second chamber may also be included wherein the layer includes regions of liquid crystal material aligned in a pattern wherein an index of refraction across at least a first portion of the variable optic insert varies with a radial dependence, and wherein the second layer containing liquid crystal material varies its index of refraction affecting a ray of light traversing the first layer containing liquid crystal material when an electric potential is applied across the third layer of electrode material and the forth layer of electrode material. The contact lens may also include an energy source embedded in the insert in at least a region comprising a non-optical zone. The contact lens may also include an electrical circuit comprising a processor, wherein the electrical circuit controls the flow of electrical energy from the energy source to one or more of the first, second, third or fourth electrode layers. And, the contact lens' variable optic insert may also alter a focal characteristic of the ophthalmic lens.

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BRIEF DESCRIPTION OF THE DRAWINGS

The foregoing and other features and advantages of the invention will be apparent from the following, more particular description of preferred embodiments of the invention, as illustrated in the accompanying drawings.

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Figure 1 illustrates exemplary mold assembly apparatus components that may be useful in implementing some embodiments of the present invention.

Figures 2A and 2B illustrate an exemplary energized ophthalmic lens with a variable optic insert embodiment.

- 5 Figure 3A illustrates a cross sectional view of a variable optic insert where the front and back curve pieces of the variable optic insert may have different curvature and wherein the variable optic portion may be comprised of liquid crystal.

- Figure 3B illustrates a cross sectional view of an ophthalmic lens device embodiment with a variable optic insert wherein the variable optic portion may be comprised of polymer
10 networked regions of interstitially located liquid crystal.

Figures 4A and 4B illustrate an exemplary gradient-indexed pattern in a flattened embodiment that may relate and explain the relevance to various embodiments with three-dimensional shape.

- Figures 4C, 4D and 4E illustrate exemplary depictions of the influence of alignment layers
15 upon liquid crystal molecules and the formation of patterns in exemplary manners.

Figure 4F illustrates exemplary models for the effect of gradient-index patterning of liquid crystal layers and the resulting focal characteristics that may be modeled.

- Figure 5A illustrates an exemplary embodiment of a variable optic insert wherein the variable optic portion may be comprised of gradient-indexed regions of liquid crystal
20 molecules between shaped insert pieces.

Figure 5B illustrates an exemplary embodiment of a variable optic insert wherein the variable optic portion may be comprised of gradient-indexed regions of networked polymer liquid crystal molecules with interstitial liquid crystal molecules. The liquid crystal containing layer is illustrated between shaped insert pieces.

Figure 5C illustrates a close-up of an exemplary embodiment of a variable optic insert wherein the variable optic portion may be comprised of gradient-indexed regions of liquid crystal molecules between shaped insert pieces and wherein there is no imposed electric field across the layer and thus may be in a resting orientation

- 5 Figure 5D illustrates a close-up of an exemplary embodiment of a variable optic insert wherein the variable optic portion may be comprised of gradient-indexed regions of liquid crystal molecules between shaped insert pieces and wherein there is an imposed electric field across the layer and thus may be in an energized orientation

- 10 Figure 6 illustrates an alternative embodiment of a variable optic lens comprising an insert wherein the variable optic portions may be comprised of gradient-indexed regions of liquid crystal molecules between shaped insert pieces.

Figure 7 illustrates the method steps for forming an ophthalmic lens with a variable optic insert which may be comprised of gradient-indexed regions of liquid crystal molecules between shaped insert pieces.

- 15 Figure 8 illustrates an example of apparatus components for placing a variable optic insert comprised of gradient-indexed regions of liquid crystal molecules between shaped insert pieces into an ophthalmic lens mold part.

Figure 9 illustrates a processor that may be used to implement some embodiments of the present invention.

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DETAILED DESCRIPTION OF THE INVENTION

- The present invention includes methods and apparatus for manufacturing an ophthalmic lens with a variable optic insert wherein the variable optic portion is comprised of a liquid crystal or a composite material which itself includes liquid crystal constituents. In addition, the present invention includes an ophthalmic lens with a variable optic insert comprised of liquid crystal incorporated into the ophthalmic lens.
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According to the present invention, an ophthalmic lens is formed with an embedded insert and an energy source, such as an electrochemical cell or battery as the storage means for the energy. In some exemplary embodiments, the materials comprising the energy source may be encapsulated and isolated from an environment into which an ophthalmic lens is placed. In some exemplary embodiments the energy source may include an electrochemical cell chemistry which may be used in a primary or rechargeable configuration.

A wearer-controlled adjustment device may be used to vary the optic portion. The adjustment device may include, for example, an electronic device or passive device for increasing or decreasing a voltage output or engaging and disengaging the energy source. Some exemplary embodiments may also include an automated adjustment device to change the variable optic portion via an automated apparatus according to a measured parameter or a wearer input. Wearer input may include, for example, a switch controlled by wireless apparatus. Wireless may include, for example, radio frequency control, magnetic switching, patterned emanations of light, and inductance switching. In other exemplary embodiments activation may occur in response to a biological function or in response to a measurement of a sensing element within the ophthalmic lens. Other exemplary embodiments may result from the activation being triggered by a change in ambient lighting conditions as a non-limiting example.

Variation in optic power may occur when electric fields, created by the energization of electrodes, causes realignment within the liquid crystal layer thereby shifting the molecules from the resting orientation to an energized orientation. In other alternative exemplary embodiments, different effects caused by the alteration of liquid crystal layers by energization of electrodes may be exploited, for example, by changing of the light polarization state, particularly, polarization rotation.

In some exemplary embodiments with liquid crystal layers, there may be elements in the non-optical zone portion of the ophthalmic lens that may be energized, whereas other exemplary embodiments may not require energization. In the exemplary embodiments without energization, the liquid crystal may be passively variable based on some exterior factor, for example, ambient temperature, or ambient light.

A liquid crystal lens may provide an electrically variable index of refraction to polarized light incident upon its body. A combination of two lenses where the optical axis orientation is rotated in the second lens relative to the first lens allows for a lens element that may be able to vary the index of refraction to ambient non-polarized light.

5 By combining electrically active liquid crystal layers with electrodes, a physical entity may be derived that may be controlled by applying an electrical field across the electrodes. If there is a dielectric layer that is present on the periphery of the liquid crystal layer, then the field across the dielectric layer and the field across the liquid crystal layer may combine into the field across the electrodes. In a three-dimensional shape the nature
10 of the combination of the fields across the layers may be estimated based on electrodynamic principals and the geometry of the dielectric layer and the liquid crystal layer. If the effective electrical thickness of the dielectric layer is made in a non-uniform manner then the effect of a field across the electrodes may be “shaped” by the effective shape of the dielectric and create dimensionally shaped changes in refractive index in the
15 liquid crystal layers. In some exemplary embodiments, such shaping may result in lenses that have the ability to adopt variable focal characteristics.

 An alternative exemplary embodiment may be derived when the physical lens elements that contain the liquid crystal layers are shaped themselves to have different focal characteristics. The electrically variable index of refraction of a liquid crystal layer
20 may then be used to introduce changes in the focal characteristics of the lens based on the application of an electric field across the liquid crystal layer through the use of electrodes. The index of refraction of a liquid crystal layer may be referred to as an effective index of refraction, and it may be possible to consider each treatment relating to an index of refraction as equivalently referring to an effective index of refraction. The effective index
25 of refraction may come, for example, from the superposition of multiple regions with different indices of refraction. In some exemplary embodiments, the effective aspect may be an average of the various regional contributions, while in other exemplary embodiments the effective aspect may be a superposition of the regional or molecular effects upon incident light. The shape that the front containment surface makes with the

liquid crystal layer and the shape that the back containment surface makes with the liquid crystal layer may determine, to first order, the focal characteristics of the system.

In the following sections detailed descriptions of embodiments of the invention will be given. The description of both preferred and alternative embodiments are
5 exemplary embodiments only, and it is understood that to those skilled in the art that variations, modifications and alterations may be apparent. It is therefore to be understood that said exemplary embodiments do not limit the scope of the underlying invention.

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GLOSSARY

In this description and claims directed to the present invention, various terms may be used for which the following definitions will apply:

Alignment Layer: as used herein refers to a layer adjacent to a liquid crystal layer
15 that influences and aligns the orientation of molecules within the liquid crystal layer. The resulting alignment and orientation of the molecules may affect light that passes through the liquid crystal layer. For example, the alignment and orientation may act with refractive characteristics upon the incident light. Additionally, the effect may include alteration of the polarization of the light.

20 Electrical Communication: as used herein refers to being influenced by an electrical field. In the case of conductive materials, the influence may result from or in the flow of electrical current. In other materials, it may be an electrical potential field that causes an influence, such as the tendency to orient permanent and induced molecular dipoles along field lines as an example.

25 Energized: as used herein refers to the state of being able to supply electrical current to or to have electrical energy stored within.

Energized Orientation: as used herein refers to the orientation of the molecules of a liquid crystal when influenced by an effect of a potential field powered by an energy source. For example, a device containing liquid crystals may have one energized

orientation if the energy source operates as either on or off. In other exemplary embodiments, the energized orientation may change along a scale affected by the amount of energy applied.

5 Energy: as used herein refers to the capacity of a physical system to do work. Many uses within the present invention may relate to the capacity being able to perform electrical actions in doing work.

 Energy source: as used herein refers to device capable of supplying energy or placing a biomedical device in an energized state.

10 Energy Harvesters: as used herein refers to device capable of extracting energy from the environment and convert it to electrical energy.

 Interstices and Interstitial as used herein refer to regions within the boundaries of a polymer networked layer that are unoccupied by portions of the polymer and may be locations for other atoms or molecules to reside. Typically, herein, a liquid crystal molecule itself may co-reside in a region within the polymer network and the space that the liquid
15 crystal therefore occupies may be classified as an interstice.

 Intraocular Lens: as used herein refers to an ophthalmic lens that is embedded within the eye.

 Lens-Forming Mixture or Reactive Mixture or reactive monomer mixture (RMM): as used herein refers to a monomer or prepolymer material that may be cured and
20 crosslinked or crosslinked to form an ophthalmic lens. Various embodiments may include lens-forming mixtures with one or more additives such as: UV blockers, tints, photoinitiators or catalysts, and other additives one might desire in an ophthalmic lens such as, for example, contact or intraocular lenses.

 Lens-Forming Surface: as used herein refers to a surface that is used to mold a
25 lens. In some exemplary embodiments, any such surface may have an optical quality surface finish, which indicates that it is sufficiently smooth and formed so that a lens surface fashioned by the polymerization of a lens-forming mixture in contact with the molding surface is optically acceptable. Further, in some exemplary embodiments, the lens-forming surface may have a geometry that is necessary to impart to the lens surface

the desired optical characteristics, including, for example, spherical, aspherical and cylinder power, wave front aberration correction, and corneal topography correction.

Liquid Crystal: as used herein refers to a state of matter having properties between a conventional liquid and a solid crystal. A liquid crystal may not be characterized as a solid, but its molecules exhibit some degree of alignment. As used herein, a liquid crystal is not limited to a particular phase or structure, but a liquid crystal may have a specific resting orientation. The orientation and phases of a liquid crystal may be manipulated by external forces, for example, temperature, magnetism, or electricity, depending on the class of liquid crystal.

Lithium Ion Cell: as used herein refers to an electrochemical cell where Lithium ions move through the cell to generate electrical energy. This electrochemical cell, typically called a battery, may be reenergized or recharged in its typical forms.

Media Insert or Insert: as used herein refers to a formable or rigid substrate capable of supporting an energy source within an ophthalmic lens. In some exemplary embodiments, the media insert also includes one or more variable optic portions.

Mold: as used herein refers to a rigid or semi-rigid object that may be used to form lenses from uncured formulations. Some preferred molds include two mold parts forming a front curve mold part and a back curve mold part.

Ophthalmic Lens or Lens: as used herein refers to any ophthalmic device that resides in or on the eye. These devices may provide optical correction or modification, or may be cosmetic. For example, the term “lens” may refer to a contact lens, intraocular lens, overlay lens, ocular insert, optical insert, or other similar device through which vision is corrected or modified, or through which eye physiology is cosmetically enhanced (e.g. iris color) without impeding vision. In some exemplary embodiments, the preferred lenses of the invention are soft contact lenses which are made from silicone elastomers or hydrogels, which include, for example, silicone hydrogels and fluorohydrogels.

Optical or Optic Zone: as used herein refers to an area of an ophthalmic lens through which a wearer of the ophthalmic lens sees.

Power: as used herein refers to work done or energy transferred per unit of time.

Rechargeable or Reenergizable: as used herein refers to a capability of being

restored to a state with higher capacity to do work. Many uses within the present invention may relate to the capability of being restored with the ability to flow electrical current at a certain rate for certain, reestablished time period.

5 Reenergize or Recharge: as used herein refers to the restoration of an energy source to a state with higher capacity to do work. Many uses within the present invention may relate to restoring a device to the capability to flow electrical current at a certain rate for a certain, reestablished time period.

10 Released from a mold: as used herein refers to a lens is either completely separated from the mold, or is only loosely attached so that it may be removed with mild agitation or pushed off with a swab.

Resting Orientation: as used herein refers to the orientation of the molecules of a liquid crystal device in its resting, non-energized state.

15 Variable Optic: as used herein refers to the capacity to change an optical quality, for example, the optical power of a lens or the polarizing angle.

OPHTHALMIC LENSES

Referring to Figure 1, an apparatus 100 to form ophthalmic devices comprising sealed and encapsulated inserts is depicted. The apparatus includes an exemplary front curve mold 102 and a matching back curve mold 101. A variable optic insert 104 and a
20 body 103 of the ophthalmic device may be located inside the front curve mold 102 and the back curve mold 101. In some exemplary embodiments, the material of the body 103 may be a hydrogel material, and the variable optic insert 104 may be surrounded on all surfaces by this material.

25 The variable optic insert 104 may comprise multiple liquid crystal layers (also called layers containing liquid crystal) 109 and 110. Other exemplary embodiments may include a single liquid crystal layer, some of which are discussed in later sections. The use of the apparatus 100 may create a novel ophthalmic device comprising a combination of components with numerous sealed regions.

In some exemplary embodiments, a lens with a variable optic insert 104 may include a rigid center soft skirt design wherein a central rigid optical element including the liquid crystal layers 109 and 110 is in direct contact with the atmosphere and the corneal surface on respective anterior and posterior surfaces. The soft skirt of lens material
5 (typically a hydrogel material) is attached to a periphery of the rigid optical element, and the rigid optical element may also add energy and functionality to the resulting ophthalmic lens.

Referring to Figure 2A, at 200 a top down and Figure 2B at 250 a cross sectional depiction of an exemplary embodiment of a variable optic insert is shown. In this
10 depiction, an energy source 210 is shown in a periphery portion 211 of the variable optic insert. The energy source 210 may include, for example, a thin film, rechargeable lithium ion battery or an alkaline cell based battery. The energy source 210 may be connected to interconnect features 214 to allow for interconnection. Additional interconnects at 225 and 230 for example may connect the energy source 210 to a circuit such as item 205. In other
15 exemplary embodiments, an insert may have interconnect features deposited on its surface.

In some exemplary embodiments, the variable optic insert 200 may include a flexible substrate. This flexible substrate may be formed into a shape approximating a typical lens form in a similar manner previously discussed or by other means. However to
20 add additional flexibility, the variable optic insert 200 may include additional shape features such as radial cuts along its length. There may be multiple electronic components, indicated by 205, such as integrated circuits, discrete components, passive components and such devices that may also be included.

A variable optic portion 220 is also illustrated. The variable optic portion 220 may
25 be varied on command through the application of a current through the variable optic insert which in turn may typically vary an electric field established across a liquid crystal layer. In some exemplary embodiments, the variable optic portion 220 comprises a thin layer comprising liquid crystal between two layers of transparent substrate. There may be numerous manners of electrically activating and controlling the variable optic component,
30 typically through action of the electronic circuit 205. The electronic circuit, 205 may

receive signals in various manners and may also connect to sensing elements which may also be in the insert such as item 215. In some exemplary embodiments, the variable optic insert may be encapsulated into a lens skirt 255, which may be comprised of hydrogel material or other suitable material to form an ophthalmic lens. In these exemplary
5 embodiments the ophthalmic lens may be comprised of the ophthalmic skirt 255 and an encapsulated ophthalmic lens insert 200 which may itself comprise layers or regions of liquid crystal material or comprising liquid crystal material and in some exemplary embodiments the layers may comprise polymer networked regions of interstitially located liquid crystal material.

10

A VARIABLE OPTIC INSERT INCLUDING LIQUID CRYSTAL ELEMENTS

Referring to Fig. 3A, item 300, an illustration of the lens effect of two differently shaped lens pieces may be found. As mentioned previously, a variable optic insert of the inventive art herein may be formed by enclosing an electrode and liquid crystal layer
15 system within two differently shaped lens pieces. The electrode and liquid crystal layer system may occupy a space between the lens pieces as illustrated at 350. At 320 a front curve piece may be found and at 310, a rear curve piece may be found.

In a non-limiting example, the front curve piece 320 may have a concave shaped surface that interacts with the space 350. The shape may be further characterized as having
20 a radius of curvature depicted as 330 and a focal point 335 in some exemplary embodiments. Other more complicated shapes with various parametric characteristics may be formed within the scope of the inventive art; however, for illustration a simple spherical shape may be depicted.

In a similar and also non-limiting fashion, the back curve piece 310 may have a
25 convex shaped surface that interacts with the space 350. The shape may be further characterized as having a radius of curvature depicted as 340 and a focal point 345 in some exemplary embodiments. The curved pieces may be referred to as having different curvature of their surfaces or of their insert surfaces. Equivalently they may be referred to as having a different radii of their insert surfaces. Other more complicated shapes with

various parametric characteristics may be formed within the scope of the inventive art; however, for illustration a simple spherical shape may be depicted.

To illustrate how the lens of the type as 300 may operate, the material that comprises items 310 and 320 may have a natural index of refraction of a value. Within the space 350 the liquid crystal layer may be chosen in a non-limiting example to match that value for the index of refraction. Thus when light rays traverse the lens pieces 310 and 320 and the space 350, they will not react to the various interfaces in a manner that would adjust the focal characteristics. In its function, portions of the lens not shown may activate an energization of various components that may result in the liquid crystal layer in space 350 assuming a different index of refraction to the incident light ray. In a non-limiting example the resulting index of refraction may be lowered. Now, at each material interface the path of the light may be modeled to be altered based on the focal characteristics of the surface and the change of the index of refraction.

The model may be based on Snell's law: $\sin(\theta_1) / \sin(\theta_2) = n_2/n_1$. For example, the interface may be formed by piece 320 and space 350, wherein θ_1 may be the angle that the incident ray makes with a surface normal at the interface; θ_2 may be the modeled angle that the ray makes with a surface normal as it leaves the interface, n_2 may represent the index of refraction of the space 350 and n_1 may represent the index of refraction of the piece 320. When n_1 is not equal to n_2 then the angles θ_1 and θ_2 will be different as well. Thus, when the electrically variable index of refraction of the liquid crystal layer in space 350 is changed, the path that a light ray would take at the interface will change as well.

Referring to Fig. 3B, an ophthalmic lens 360 is shown with an embedded variable optic insert 371. The ophthalmic lens 360 may have a front curve surface 370 and a back curve surface 372. The insert 371 may have a variable optic portion 373 with a liquid crystal layer 374. In some exemplary embodiments, the insert 371 may have multiple liquid crystal layers 374 and 375. Portions of the insert 371 may overlap with the optical zone of the ophthalmic lens 360.

Referring to Figure 4A, a depiction of a gradient-indexing effect is depicted. In exemplary embodiments with gradient-indexing, alignment layers may be used to control

the orientation of liquid crystal molecules. The control of the orientation may itself control regional effective index of refraction. Thus, the control of the orientation of the liquid crystal molecules can form a regionally variable effective index of refraction that may be characterized as a gradient-indexed pattern. In Figure 4A, an exemplary depiction of the effect may be shown where the various elements are depicted as flat elements. Although effective optic devices may be formed from flat elements, such as may be useful in intraocular lens devices or spectacles, which may form parts of the inventive art herein; there may also be numerous embodiments that utilize the gradient-indexed effect depicted but are formed into three-dimensional shapes as well. At 410 a front optic piece may be found which may support electrodes 420 and alignment layers 425. The alignment layer 425, may be programmed by various means, some examples may be found later in this description. The alignment layer may have a programmed alignment that varies from a feature parallel to the surface of the front optic piece as depicted at 440 to a perpendicular orientation as depicted at 430 to orientations between these. The effect of the alignment layers programmed orientation may be to cause the liquid crystal layer to form a gradient-indexed pattern. The liquid crystal molecules may align as well with some molecules being oriented parallel to the front optic surface such as depicted at 445 and some molecules oriented perpendicular to the front optic surface such as depicted at 435 as well as orientations or effective orientations in between the two extremes. For liquid crystal molecules this variation may cause the effective index of refraction to vary or be gradated across the optic zone of the optic device formed with these layers. There may be a back optic piece in some exemplary embodiments as shown at 405. The back optic piece may have electrode layers 415 and alignment layers 426 as well. In some exemplary embodiments these alignment layers may be programmed to assume orientations similar to those defined on the front optic surface.

Referring to Figure 4B, the depiction of Figure 4A is demonstrated where the presence of an electric field 401 may cause the liquid crystal molecules at both 475 and 485 to align with the electric field. In the absence of an electric field, these regions 475 and 485 may be caused to align in different manners due to the effects of the alignment layers at 470 and 480. These effects may be dominated by the establishment of the

electric field 401 which may be caused by establishing an electro-potential between electrodes 460 and 465.

Referring to Figure 4C, a close-up depiction of an exemplary embodiment of alignment layer molecules in an orienting layer 442 interacting with liquid crystal molecules 441 may be found. In a non-limiting example, the alignment layer molecule may be an Azobenzene moiety. The orientation of phenyl groups in the azobenzene moiety may occur in a relatively linear fashion as depicted at 442. In some exemplary embodiments, one stable configuration of the azobenzene moiety may place the aromatic ring portions of the moiety in a trans-configuration where the rings are located on opposite sides of an intervening double bonded chemical bond. This may be the configuration depicted at 442 and may result in a long liner shape to the molecule. As depicted the interaction of the exemplary azobenzene moiety with liquid crystal molecules may cause them to align along the axes of the azobenzene moieties.

Referring to Figure 4D, a close up depiction of an exemplary embodiment of an alternative orientation of molecules in the orienting layer is depicted at 443. For exemplary azobenzene moieties the depiction at 443 may represent a second configuration of the azobenzene moiety backbone where the aromatic ring portions of the ring are oriented in a cis-configuration. As depicted this may place the end portions of the molecule into a configuration that is more parallel to the optic piece surface. The liquid crystal molecules, at 440 may in an exemplary manner now align with the parallel orientation of the alignment molecules. In some exemplary embodiments the orientation at 442 and at 443 may impart the maxima and minima of the effective index of refraction into the liquid crystal layers.

Referring now to Figure 4E, a close up depiction of a combination of different alignment layer configurations is depicted in an exemplary fashion. In regions where the orientation is dominated by parallel configurations relative to the insert piece surface the liquid crystal molecules may be primarily oriented parallel to the surface. Alternatively in the regions dominated by perpendicular molecules the liquid crystal molecules may thereabout be aligned primarily in an orientation perpendicular to the surface. In between these extreme orientations the molecules may be aligned based on the average

configuration of alignment molecules. As shown in the figure this may result in an effective intermediate orientation. In this manner a distribution of orientations of the liquid crystal molecules may be controlled in such a manner to allow for the creation of gradient-indexed patterns of liquid crystal molecules where the effective index of refraction is smoothly varied from one extremum to another across the dimensions of the lens elements.

Referring to Figure 4F a depiction of the modelling of a gradient-indexed or GRIN lens according to principles herein may be found at 490. As a simple model the lens surfaces are depicted in a flattened form, but the principles related to curved surfaces may follow for generalized curved surfaces. Therefore, the exemplary embodiment at 490 is depicted for the case where the gradient-indexed layer is flat as shown, and the results are applicable and similar to those for a transformation of the layer under a three-dimensional shaping as has been discussed herein. The gradient-indexed lens 490 may have a thickness modelled as “d” on the figure and in the radial dimension it may have a gradient of index of refraction which may be depicted as the different shading of black color. A high index of refraction may be located at the center 491 of the radial dimension and a decrease may occur along the radial direction as shown at 492. The gradient-indexed effect may be able to focus light as depicted at 493.

The patterning of the gradient-indexed lens which may be imparted through patterning of the alignment layers may have a smooth variation that depends on the radial location. If the center of the lens surface is assigned a position of (0,0°) in polar coordinates then the index of refraction may assume an exemplary functional relationship as shown at 496. A more generalized approach to represent a gradient-indexed lens where the index varies in a radial fashion may be the following representation:

$$\text{Eq(1)} \quad n(r) = n_0[a_0 + a_1r^2 + a_2r^4 + a_3r^6 + \dots].$$

As shown at 496 this generalized form may be simplified to a parabolic relationship where the index of refraction depends on the radius with the following relationship:

$$\text{Eq(2)} \quad n(r) = n_0 \left[1 - \frac{A}{2} r^2 \right] ,$$

for a liquid crystal based radially varying parabolic gradient-indexed lens Equation 2 may be estimated where the parameter A may be represented as depicted at Eq(3):

$$\text{Eq(3)} \quad A = 2 \frac{n_{\text{parallel}} - n_{\text{perpendicular}}}{n_{\text{parallel}} * r_{\text{max}}^2} \quad .$$

The power for a parabolic radial varying GRIN lens of thickness d may be represented by:

$$5 \quad \text{Eq(4)} \quad \text{Power} = -n_0 \sqrt{A} \sin(\sqrt{A} d) \quad .$$

This may be converted to represent the focal length as :

$$\text{Eq(5)} \quad \text{Focal Length} = \frac{1}{n_0 \sqrt{A} \sin(\sqrt{A} d)} \quad .$$

For cases where the thickness of the lens is very much less than the radius of the lens

Eq(5) may be simplified since the sine of a small number is approximately the small

10 number. This results in the estimated focal length 495 for a GRIN type LC lens of :

$$\text{Eq(6)} \quad \text{Focal Length} \approx \frac{1}{n_0 A d} \quad .$$

Thus, in the programming of the alignment layer, a gradient-indexed lens may be formed

15 where the orientation of the liquid crystal is controlled such that it follows the relationship depicted in Eq. 2. The thickness of the liquid crystal layer may then be controlled such that the focal length complies with Eq(6).

Referring to Figure 5A, a variable optic portion 500 that may be inserted into an ophthalmic lens is illustrated with an exemplary radially varying index of refraction

20 programmed through control of the orientation of the liquid crystal layer 530. The variable optic portion 500 may have a similar diversity of materials and structural relevance as has been discussed in other sections of this specification. In some exemplary embodiments, transparent electrodes at 520 and 545 may be placed on a first transparent substrate 510 and a second transparent substrate 550 respectively. The first 525 and second 540 lens

25 surfaces may be comprised of a dielectric film, and the patterned alignment layers which may be placed upon the transparent electrodes or dielectric films respectively. The

gradient-indexed orientation of the liquid crystal layers may introduce additional focusing power of the lens element above geometric effects.

Proceeding to Figure 5B exemplary embodiments for gradient-indexed liquid crystal lenses 560 may be depicted where liquid crystal polymer liquid crystal compositions may be employed. In a first example, a mixture of a monomer and a liquid crystal molecule may be formed with the combination being heated to form an homogenous mixture. Next, the mixture may be applied to a front curve insert piece 561 and then encapsulated in the lens insert by the addition of a back curve or intermediate insert piece 567. The insert containing the liquid crystal mixture may then be caused to polymerize under predetermined conditions forming cross linked networked regions of polymerized material as well as intercalated regions of liquid within the interstices of the polymer network. In some examples, actinic radiation may be shown on the mixture to initiate polymerization. The presence of patterned alignment layers at 563 and 565 may orientate the monomers and liquid crystal molecules 564 prior to and during the polymerization process to form the radially varying pattern as depicted. In some exemplary embodiments there may be transparent electrodes as may be depicted at 562 and 566.

There may be numerous manners to incorporate liquid crystal molecules into the polymerized or gelled regions. Therefore, any method of creating polymer networked liquid crystal layers may comprise art within the scope of the present invention and may be used to create an ophthalmic device where a gradient-indexed radial profile is formed. The previous examples mentioned the use of monomers with attached liquid crystal portions to create networked layers that create interstitial locations for unbound liquid crystal molecules. The state of the polymerized monomers may be a crystalline form, a semicrystalline form or an amorphous form of polymerized material or in other embodiments may also exist as a gelled or semi-gelled form of polymerized monomer.

The variable optic portion in Figs. 5A and 5B may have other aspects that may be defined by a similar diversity of materials and structural relevance as has been discussed in other sections of this specification. In some exemplary embodiments, a first transparent electrode 520 may be placed on the first transparent substrate 510. The first lens surface

may be comprised of a dielectric film, and in some exemplary embodiments, alignment layers which may be placed upon the first transparent electrodes.

Referring to Fig. 5C, item 570 may represent a portion of a gradient-indexed lens comprising liquid crystal aligned in a manner consistent with a gradient-indexed lens.

5 Some variation in the orientation of the liquid crystal molecules is depicted in an exemplary fashion for the variation of the index of refraction with a radial distance. There may be a first insert piece 571, and a second insert piece 576 with alignment layers 572 and 575 thereupon. The alignment layers may guide the free standing orientation of liquid crystal molecules 574 within the liquid crystal layer 573.

10 The same portion of the gradient-index lens comprising liquid crystal shown in reference to Fig. 5C may be found in reference to Fig. 5D. In the case depicted in Fig. 5D, an electric field may be imposed across the layer comprising aligned liquid crystal molecules and thus may be in an energized orientation. The electric field is depicted by the field vector at 580 and is created by the energization of the electrode layers. The liquid
15 crystal molecules, for example at 581, are shown to align with the imposed electric field. In this energized configuration the gradient-indexing is essentially erased as the layer lines up to present a relatively uniform index of refraction to incident radiation. There may be other optical effects of the lens surfaces and shapes, but by lining up the liquid crystal orientations a different focal characteristic will result.

20 Referring to Fig. 6, an alternative of a variable optic insert 600 that may be inserted into an ophthalmic lens is illustrated with two liquid crystal layers 620 and 640. Each of the aspects of the various layers around the liquid crystal region may have similar diversity as described in relation to the variable optic insert 500 in Fig. 5A or 560 in Fig. 5B. For exemplary purposes, both the layer at 620 and 640 are depicted to have similar
25 gradient-indexed programming; however, it may be possible to combine a gradient-index type lens with another liquid crystal element in some other exemplary embodiments. In some exemplary embodiments, the combination of multiple gradient-indexed layers may allow for multiple focal characteristics to be defined in a compound manner. By combining a first liquid crystal based element formed by a first substrate 610, whose
30 intervening layers in the space around 620 and a second substrate 630 may have a first

focal characteristic , with a second liquid crystal based element formed by a second surface on the second substrate 630, the intervening layers in the space around 640 and a third substrate 650 with a second focal characteristic, a combination may be formed which may allow for an electrically variable focal characteristic of a lens as an example.

5 At the exemplary element 600, a combination of two electrically active liquid crystal layers of the various types and diversity associated with the examples at 500 and 560 may be formed utilizing three substrate layers. In other examples, the device may be formed by the combination of four different substrates. In such examples, the intermediate substrate 630 may be split into two layers. If the substrates are combined at a later time, a
10 device that functions similarly to item 600 may result. The combination of four layers may present an example for the manufacturing of the element where similar devices may be constructed around both 620 and 640 liquid crystal layers where the processing difference may relate to the portion of steps that define alignment features for the liquid crystal element.

15

MATERIALS

Microinjection molding embodiments may include, for example, a poly(4-methylpent-1-ene) copolymer resin which may be used to form lenses with a diameter of between about 6mm to 10mm and a front surface radius of between about 6 mm and 10
20 mm and a rear surface radius of between about 6 mm and 10 mm and a center thickness of between about 0.050 mm and 1.0 mm. Some exemplary embodiments include an insert with diameter of about 8.9 mm and a front surface radius of about 7.9 mm and a rear surface radius of about 7.8 mm and a center thickness of about 0.200 mm and an edge thickness of about 0.050 mm.

25 The variable optic insert 104 illustrated in Figure 1 may be placed in a mold part 101 and 102 utilized to form an ophthalmic lens. Mold part 101 and 102 material may include, for example, a polyolefin of one or more of: polypropylene, polystyrene, polyethylene, polymethyl methacrylate, and modified polyolefins. Other molds may include a ceramic or metallic material.

A preferred alicyclic co-polymer contains two different alicyclic polymers. Various grades of alicyclic co-polymers may have glass transition temperatures ranging from 105°C to 160°C.

5 In some exemplary embodiments, the molds of the present invention may contain polymers such as polypropylene, polyethylene, polystyrene, polymethyl methacrylate, modified polyolefins containing an alicyclic moiety in the main chain and cyclic polyolefins. This blend may be used on either or both mold halves, where it is preferred that this blend is used on the back curve and the front curve consists of the alicyclic co-polymers.

10 In some preferred methods of making molds according to the present invention, injection molding is utilized according to known techniques; however, exemplary embodiments may also include molds fashioned by other techniques including, for example: lathing, diamond turning, or laser cutting.

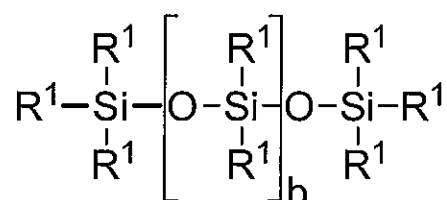
15 Typically, lenses are formed on at least one surface of both mold parts 101 and 102. However, in some exemplary embodiments, one surface of a lens may be formed from a mold part 101 or 102 and another surface of a lens may be formed using a lathing method, or other methods.

In some exemplary embodiments, a preferred lens material includes a silicone containing component. A “silicone-containing component” is one that contains at least one
20 [-Si-O-] unit in a monomer, macromer or prepolymer. Preferably, the total Si and attached O are present in the silicone-containing component in an amount greater than about 20 weight percent, and more preferably greater than 30 weight percent of the total molecular weight of the silicone-containing component. Useful silicone-containing components preferably comprise polymerizable functional groups such as acrylate, methacrylate,
25 acrylamide, methacrylamide, vinyl, N-vinyl lactam, N-vinylamide, and styryl functional groups.

In some exemplary embodiments, the ophthalmic lens skirt, also called an insert-encapsulating layer, that surrounds the insert may be comprised of standard hydrogel ophthalmic lens formulations. Exemplary materials with characteristics that may provide
30 an acceptable match to numerous insert materials may include, the Narafilcon family

(including Narafilcon A and Narafilcon B), and the Etafilcon family (including Etafilcon A). A more technically inclusive discussion follows on the nature of materials consistent with the art herein. One ordinarily skilled in the art may recognize that other material other than those discussed may also form an acceptable enclosure or partial enclosure of the sealed and encapsulated inserts and should be considered consistent and included within the scope of the claims.

Suitable silicone containing components include compounds of Formula I



where

R^1 is independently selected from monovalent reactive groups, monovalent alkyl groups, or monovalent aryl groups, any of the foregoing which may further comprise functionality selected from hydroxy, amino, oxa, carboxy, alkyl carboxy, alkoxy, amido, carbamate, carbonate, halogen or combinations thereof; and monovalent siloxane chains comprising 1-100 Si-O repeat units which may further comprise functionality selected from alkyl, hydroxy, amino, oxa, carboxy, alkyl carboxy, alkoxy, amido, carbamate, halogen or combinations thereof;

where $b = 0$ to 500, where it is understood that when b is other than 0, b is a distribution having a mode equal to a stated value;

wherein at least one R^1 comprises a monovalent reactive group, and in some embodiments between one and 3 R^1 comprise monovalent reactive groups.

As used herein “monovalent reactive groups” are groups that may undergo free radical and/or cationic polymerization. Non-limiting examples of free radical reactive groups include (meth)acrylates, styryls, vinyls, vinyl ethers, C_{1-6} alkyl(meth)acrylates, (meth)acrylamides, C_{1-6} alkyl(meth)acrylamides, N-vinyl lactams, N-vinyl amides, C_{2-12} alkenyls, C_{2-12} alkenylphenyls, C_{2-12} alkenyl naphthyls, C_{2-6} alkenylphenyl C_{1-6} alkyls, O-vinyl carbamates and O-vinyl carbonates. Non-limiting examples of cationic reactive

groups include vinyl ethers or epoxide groups and mixtures thereof. In one exemplary embodiment the free radical reactive groups comprises (meth)acrylate, acryloxy, (meth)acrylamide, and mixtures thereof.

Suitable monovalent alkyl and aryl groups include unsubstituted monovalent C₁ to C₁₆ alkyl groups, C₆-C₁₄ aryl groups, such as substituted and unsubstituted methyl, ethyl, propyl, butyl, 2-hydroxypropyl, propoxypropyl, polyethylenoxypropyl, combinations thereof and the like.

In one exemplary embodiment, b is zero, one R¹ is a monovalent reactive group, and at least 3 R¹ are selected from monovalent alkyl groups having one to 16 carbon atoms, and in another exemplary embodiment from monovalent alkyl groups having one to 6 carbon atoms. Non-limiting examples of silicone components of this exemplary embodiment include 2-methyl-2-hydroxy-3-[3-[1,3,3,3-tetramethyl-1-[(trimethylsilyl)oxy]disiloxanyl]propoxy]propyl ester ("SiGMA"), 2-hydroxy-3-methacryloxypropyloxypropyl-tris(trimethylsiloxy)silane, 3-methacryloxypropyltris(trimethylsiloxy)silane ("TRIS"), 3-methacryloxypropylbis(trimethylsiloxy)methylsilane and 3-methacryloxypropylpentamethyl disiloxane.

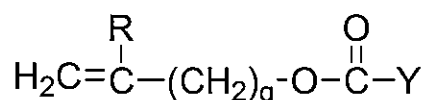
In another exemplary embodiment, b is 2 to 20, 3 to 15 or in some exemplary embodiments 3 to 10; at least one terminal R¹ comprises a monovalent reactive group and the remaining R¹ are selected from monovalent alkyl groups having 1 to 16 carbon atoms, and in another exemplary embodiment from monovalent alkyl groups having 1 to 6 carbon atoms. In yet another exemplary embodiment, b is 3 to 15, one terminal R¹ comprises a monovalent reactive group, the other terminal R¹ comprises a monovalent alkyl group having 1 to 6 carbon atoms and the remaining R¹ comprise monovalent alkyl group having 1 to 3 carbon atoms. Non-limiting examples of silicone components of this embodiment include (mono-(2-hydroxy-3-methacryloxypropyl)-propyl ether terminated polydimethylsiloxane (400-1000 MW)) ("OH-mPDMS"), monomethacryloxypropyl terminated mono-n-butyl terminated polydimethylsiloxanes (800-1000 MW), ("mPDMS").

In another exemplary embodiment, b is 5 to 400 or from 10 to 300, both terminal R¹ comprise monovalent reactive groups and the remaining R¹ are independently selected from monovalent alkyl groups having 1 to 18 carbon atoms, which may have ether linkages between carbon atoms and may further comprise halogen.

5 In one exemplary embodiment, where a silicone hydrogel lens is desired, the lens of the present invention will be made from a reactive mixture comprising at least about 20 and preferably between about 20 and 70%wt silicone containing components based on total weight of reactive monomer components from which the polymer is made.

10 In another exemplary embodiment, one to four R¹ comprises a vinyl carbonate or carbamate of the formula:

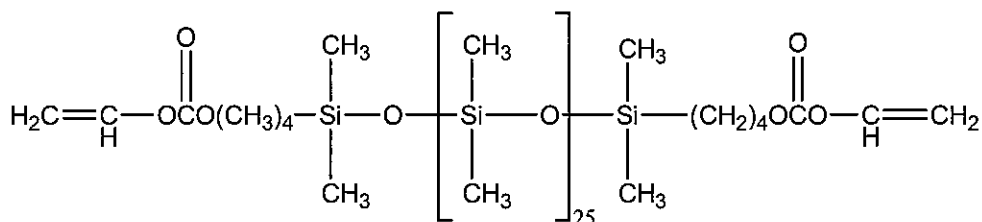
Formula II



15 wherein: Y denotes O-, S- or NH-;

R denotes, hydrogen or methyl; d is 1, 2, 3 or 4; and q is 0 or 1.

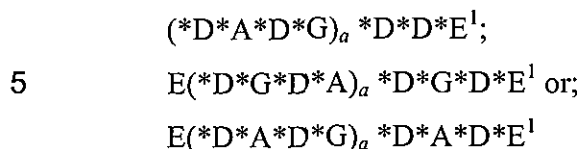
The silicone-containing vinyl carbonate or vinyl carbamate monomers specifically include: 1,3-bis[4-(vinylloxycarbonyloxy)but-1-yl]tetramethyl-disiloxane; 3-(vinylloxycarbonylthio) propyl-[tris (trimethylsiloxy)silane]; 3-[tris(trimethylsiloxy)silyl]
20 propyl allyl carbamate; 3-[tris(trimethylsiloxy)silyl] propyl vinyl carbamate; trimethylsilylethyl vinyl carbonate; trimethylsilylmethyl vinyl carbonate, and



Where biomedical devices with modulus below about 200 are desired, only one R¹ shall comprise a monovalent reactive group and no more than two of the remaining R¹
25 groups will comprise monovalent siloxane groups.

Another class of silicone-containing components includes polyurethane macromers of the following formulae:

Formulae IV-VI



wherein:

D denotes an alkyl diradical, an alkyl cycloalkyl diradical, a cycloalkyl diradical, an aryl diradical or an alkylaryl diradical having 6 to 30 carbon atoms,

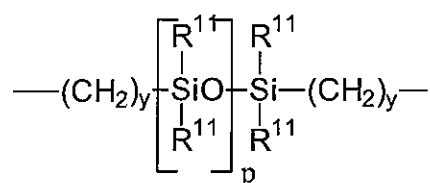
10 G denotes an alkyl diradical, a cycloalkyl diradical, an alkyl cycloalkyl diradical, an aryl diradical or an alkylaryl diradical having 1 to 40 carbon atoms and which may contain ether, thio or amine linkages in the main chain;

* denotes a urethane or ureido linkage;

a is at least 1;

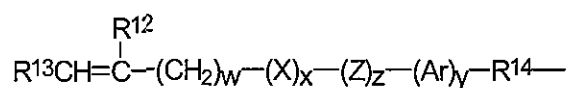
15 A denotes a divalent polymeric radical of formula:

Formula VII



R^{11} independently denotes an alkyl or fluoro-substituted alkyl group having 1 to 10 carbon atoms, which may contain ether linkages between carbon atoms; y is at least 1; and p provides a moiety weight of 400 to 10,000; each of E and E^1 independently denotes a polymerizable unsaturated organic radical represented by formula:

Formula VIII



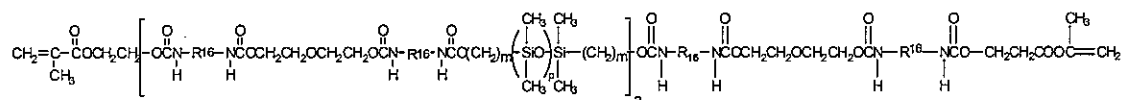
wherein: R^{12} is hydrogen or methyl; R^{13} is hydrogen, an alkyl radical having 1 to 6 carbon atoms, or a $\text{---CO---Y---R}^{15}$ radical wherein Y is ---O--- , Y---S--- or ---NH--- ; R^{14} is a

divalent radical having 1 to 12 carbon atoms; X denotes —CO— or —OCO—; Z denotes —O— or —NH—; Ar denotes an aromatic radical having 6 to 30 carbon atoms; w is 0 to 6; x is 0 or 1; y is 0 or 1; and z is 0 or 1.

A preferred silicone-containing component is a polyurethane macromer

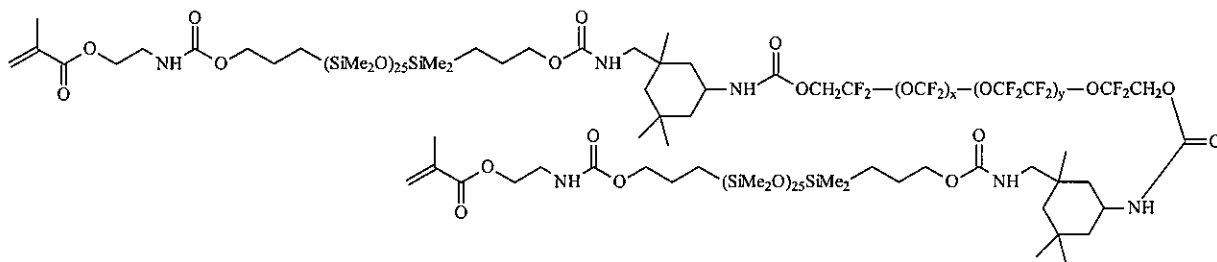
5 represented by the following formula:

Formula IX



wherein R¹⁶ is a diradical of a diisocyanate after removal of the isocyanate group, such as the diradical of isophorone diisocyanate. Another suitable silicone containing macromer is
 10 compound of formula X (in which x + y is a number in the range of 10 to 30) formed by the reaction of fluoroether, hydroxy-terminated polydimethylsiloxane, isophorone diisocyanate and isocyanatoethylmethacrylate.

Formula X



15 Other silicone containing components suitable for use in the present invention include macromers containing polysiloxane, polyalkylene ether, diisocyanate, polyfluorinated hydrocarbon, polyfluorinated ether and polysaccharide groups; polysiloxanes with a polar fluorinated graft or side group having a hydrogen atom attached to a terminal difluoro-substituted carbon atom; hydrophilic siloxanyl methacrylates
 20 containing ether and siloxanyl linkages and crosslinkable monomers containing polyether and polysiloxanyl groups. Any of the foregoing polysiloxanes may also be used as the silicone containing component in the present invention.

LIQUID CRYSTAL MATERIALS

There may be numerous materials that may have characteristics consistent with the liquid crystal layer types that have been discussed herein. It may be expected that liquid crystal materials with favorable toxicity may be preferred and naturally derived cholesteryl based liquid crystal materials may be useful. In other examples, the encapsulation technology and materials of ophthalmic inserts may allow a broad choice of materials that may include the LCD display related materials which may typically be of the broad categories related to nematic or cholesteric N or smectic liquid crystals or liquid crystal mixtures. Commercially available mixtures such as Merck Specialty chemicals Licristal mixtures for TN, VA, PSVA, IPS and FFS applications and other commercially available mixtures may form a material choice to form a liquid crystal layer.

In a non-limiting sense, mixtures or formulations may comprise the following liquid crystal materials: 1-(trans-4-Hexylcyclohexyl)-4-isothiocyanatobenzene liquid crystal, benzoic acid compounds including (4-Octylbenzoic acid and 4-Hexylbenzoic acid), carbonitrile compounds including (4'-Pentyl-4-biphenylcarbonitrile, 4'-Octyl-4-biphenylcarbonitrile, 4'-(Octyloxy)-4-biphenylcarbonitrile, 4'-(Hexyloxy)-4-biphenylcarbonitrile, 4-(trans-4-Pentylcyclohexyl)benzonitrile, 4'-(Pentyloxy)-4-biphenylcarbonitrile, 4'-Hexyl-4-biphenylcarbonitrile), and 4,4'-Azoxyanisole.

In a non-limiting sense, formulations showing particularly high birefringence of $n_{\text{par}} - n_{\text{perp}} > 0.3$ at room temperature may be used as a liquid crystal layer forming material. For example, such formulation referred to as W1825 may be as available from AWAT and BEAM Engineering for Advanced Measurements Co. (BEAMCO).

There may be other classes of liquid crystal materials that may be useful for the inventive concepts here. For example, ferroelectric liquid crystals may provide function for electric field oriented liquid crystal embodiments, but may also introduce other effects such as magnetic field interactions. Interactions of electromagnetic radiation with the materials may also differ.

ALIGNMENT LAYER MATERIALS

In many of the exemplary embodiments that have been described, the liquid crystal layers within ophthalmic lenses may need to be aligned in various manners at insert boundaries. The alignment, for example, may be parallel or perpendicular to the boundaries of the inserts, and this alignment may be obtained by proper processing of the various surfaces. The processing may involve coating the substrates of the inserts that contain the liquid crystal (LC) by alignment layers. Those alignment layers are described herein.

A technique commonly practiced in liquid crystal based devices of various types may be the rubbing technique. This technique may be adapted to account for the curved surfaces such as the ones of the insert pieces used for enclosing the liquid crystal. In an example, the surfaces may be coated by a Polyvinyl Alcohol (PVA) layer. For example, a PVA layer may be spin coated using a 1 wt.% aqueous solution. The solution may be applied with spin coating at 1000 rpm for time such as approximately 60 s, and then dried. Subsequently, the dried layer may then be rubbed by a soft cloth. In a non-limiting example, the soft cloth may be velvet.

Photo-alignment may be another technique for producing alignment layers upon liquid crystal enclosures. In some exemplary embodiments, photo-alignment may be desirable due to its non-contact nature and the capability of large scale fabrication. In a non-limiting example, the photo-alignment layer used in the liquid crystal variable optic portion may be comprised of a dichroic azobenzene dye (azo dye) capable of aligning predominantly in the direction perpendicular to the polarization of linear polarized light of typically UV wavelengths. Such alignment may be a result of repetitive trans-cis-trans photoisomerization processes.

As an example, PAAD series azobenzene dyes may be spin coated from a 1 wt.% solution in DMF at 3000 rpm for 30 s. Subsequently, the obtained layer may be exposed to a linear polarized light beam of a UV wavelength (such as for example, 325 nm, 351 nm, 365 nm) or even a visible wavelength (400-500 nm). The source of the light may take various forms. In some embodiments, light may originate from laser sources for example. Other light sources such as LEDs, halogen and incandescent sources may be other non-

limiting examples. Either before or after the various forms of light are polarized in the various patterns as appropriate, the light may be collimated in various manners such as through the use of optical lensing devices. Light from a laser source may inherently have a degree of collimation, for example.

5 A large variety of photoanisotropic materials are known currently, based on azobenzene polymers, polyesters, photo-crosslinkable polymer liquid crystals with mesogenic 4-(4-methoxycinnamoyloxy)biphenyl side groups and the like. Examples of such materials include sulfonic bisazodye SD1 and other azobenzene dyes, particularly, PAAD-series materials available from BEAM Engineering for Advanced Measurements
10 Co. (BEAMCO), Poly(vinyl cinnamates), and others.

 In some exemplary embodiments, it may be desirable to use water or alcohol solutions of PAAD series azo dyes. Some azobenzene dyes, for example, Methyl Red, may be used for photoalignment by directly doping a liquid crystal layer. Exposure of the azobenzene dye to a polarized light may cause diffusion and adhesion of the azo dyes to
15 and within the bulk of the liquid crystal layer to the boundary layers creating desired alignment conditions.

 Azobenzene dyes such as Methyl Red may also be used in combination with a polymer, for example, PVA. Other photoanisotropic materials capable of enforcing alignment of adjacent layers of liquid crystals may be acceptable are known currently.
20 These examples may include materials based on coumarines, polyesters, photo-crosslinkable polymer liquid crystals with mesogenic 4-(4-methoxycinnamoyloxy) - biphenyl side groups, poly(vinyl cinnamates), and others. The photo-alignment technology may be advantageous for embodiments comprising patterned orientation of liquid crystal.

 In another exemplary embodiment of producing alignment layers, the alignment
25 layer may be obtained by vacuum deposition of silicon oxide (SiO_x where $1 \leq x \leq 2$) on the insert piece substrates. For example, SiO_2 may be deposited at low pressure such as $\sim 10^{-6}$ mbar. It may be possible to provide alignment features at a nanoscaled size that are injection molded into with the creation of the front and back insert pieces. These molded features may be coated in various manners with the materials that have been mentioned or

other materials that may directly interact with physical alignment features and transmit the alignment patterning into alignment orientation of liquid crystal molecules.

Ion-beam alignment may be another technique for producing alignment layers upon liquid crystal enclosures. In some exemplary embodiments, a collimated argon ion or
5 focused gallium ion beam may be bombarded upon the alignment layer at a defined angle/orientation. This type of alignment may also be used to align silicon oxide, diamond-like-carbon (DLC), polyimide and other alignment materials.

Still further exemplary embodiments may relate to the creation of physical alignment features to the insert pieces after they are formed. Rubbing techniques as are
10 common in other liquid crystal based art may be performed upon the molded surfaces to create physical grooves. The surfaces may also be subjected to a post-molding embossing process to create small grooved features upon them. Still further exemplary embodiments may derive from the use of etching techniques which may involve optical patterning processes of various kinds.

15

DIELECTRIC MATERIALS

Dielectric films and dielectrics are described herein. By way of non-limiting
20 examples, the dielectric film or dielectrics used in the liquid crystal variable optic portion possess characteristics appropriate to the invention described herein. A dielectric may comprise one or more material layers functioning alone or together as a dielectric. Multiple layers may be used to achieve dielectric performance superior to that of a single dielectric.

25 The dielectric may permit a defect-free insulating layer at a thickness desired for the discretely variable optic portion, for example, between 1 and 10 μm . A defect may be referred to as a pinhole, as is known by those skilled in the art to be a hole in the dielectric permitting electrical and/or chemical contact through the dielectric. The dielectric, at a given thickness, may meet requirements for breakdown voltage, for example, that the
30 dielectric should withstand 100 volts or more.

The dielectric may allow for fabrication onto curved, conical, spherical, and complex three-dimensional surfaces (e.g., curved surfaces or non-planar surfaces). Typical methods of dip- and spin-coating may be used, or other methods may be employed.

5 The dielectric may resist damage from chemicals in the variable optic portion, for example the liquid crystal or liquid crystal mixture, solvents, acids, and bases or other materials that may be present in the formation of the liquid crystal region. The dielectric may resist damage from infrared, ultraviolet, and visible light. Undesirable damage may include degradation to parameters described herein, for example, breakdown voltage and optical transmission. The dielectric may resist permeation of ions. The dielectric may
10 prevent electromigration, dendrite growth, and other degradations of the underlying electrodes. The dielectric may adhere to an underlying electrode and/or substrate, for example, with the use of an adhesion promotion layer. The dielectric may be fabricated using a process which allows for low contamination, low surface defects, conformal coating, and low surface roughness.

15 The dielectric may possess relative permittivity or a dielectric constant which is compatible with electrical operation of the system, for example, a low relative permittivity to reduce capacitance for a given electrode area. The dielectric may possess high resistivity, thereby permitting a very small current to flow even with high applied voltage. The dielectric may possess qualities desired for an optic device, for example, high
20 transmission, low dispersion, and refractive index within a certain range. Exemplary, non-limiting, dielectric materials, include one or more of Parylene-C, Parylene-HT, Silicon Dioxide, Silicon Nitride, and Teflon AF.

25 ELECTRODE MATERIALS

Electrodes are described herein for applying an electric potential for achieving an electric field across the liquid crystal region. An electrode generally comprises one or more material layers functioning alone or together as an electrode.

The electrode may adhere to an underlying substrate, dielectric coating, or other objects in the system, perhaps with the use of an adhesion promoter (e.g., methacryloxypropyltrimethoxysilane). The electrode may form a beneficial native oxide or be processed to create a beneficial oxide layer. The electrode may be transparent,
5 substantially transparent or opaque, with high optical transmission and little reflection. The electrode may be patterned or etched with known processing methods. For example, the electrodes may be evaporated, sputtered, or electroplated, using photolithographic patterning and/or lift-off processes.

10 The electrode may be designed to have suitable resistivity for use in the electrical system described herein, for example, meeting the requirements for resistance in a given geometric construct.

The electrodes may be manufactured from one or more of indium tin oxide (ITO), aluminum-doped zinc oxide (AZO), gold, stainless steel, chrome, graphene, graphene-doped layers and aluminum. It will be appreciated that this is not an exhaustive list.

15 The electrodes may be used to establish an electric field in a region between the electrodes. In some embodiments, there may be numerous surfaces upon which electrodes may be formed. It may be possible to place electrodes on any or all of the surfaces that are defined, and an electric field may be established in the region between any of the surfaces upon which electrodes have been formed by application of electric potential to at least
20 those two surfaces.

PROCESSES

The following method steps are provided as examples of processes that may be implemented according to some aspects of the present invention. It should be understood
25 that the order in which the method steps are presented is not meant to be limiting and other orders may be used to implement the invention. In addition, not all of the steps are required to implement the present invention and additional steps may be included in various exemplary embodiments of the present invention. It may be obvious to one skilled

in the art that additional embodiments may be practical, and such methods are well within the scope of the claims.

Referring to Figure 7, a flowchart illustrates exemplary steps that may be used to implement the present invention. At 701, a step of forming a first substrate layer, which
5 may comprise a back curve surface and have a top surface with a shape of a first type that may differ from the shape of surface of other substrate layers is performed. In some exemplary embodiments, the difference may include a different radius of curvature of the surface at least in a portion that may reside in the optical zone. At 702, a step of forming a
10 second substrate layer which may comprise a front curve surface or an intermediate surface or a portion of an intermediate surface for more complicated devices is performed. At 703, an electrode layer may be deposited upon the first substrate layer. The deposition may occur, for example, by vapor deposition or electroplating. In some exemplary
15 embodiments, the first substrate layer may be part of an insert that has regions both in the optical zone and regions in the non-optic zone. The electrode deposition process may simultaneously define interconnect features in some embodiments. In some exemplary
embodiments a dielectric layer may be formed upon the interconnects or electrodes. The dielectric layer may comprise numerous insulating and dielectric layers such as for
example silicon dioxide.

At 704, the first substrate layer may be further processed to add an alignment layer
20 upon the previously deposited dielectric or electrode layer. The alignment layers may be deposited upon the top layer on the substrate and then processed in standard manners, for example, rubbing techniques, to create the grooving features that are characteristic of standard alignment layers or by treatment with exposure to energetic particles or light. Thin layers of photoanisotropic materials may be processed with light exposure to form
25 alignment layers with various characteristics. As mentioned previously, in methods to form layers of liquid crystal wherein polymer networked regions of interstitially located liquid crystal are formed, the methods may not include steps related to the formation of alignment layers.

At 705, the second substrate layer may be further processed. An electrode layer
30 may be deposited upon the second substrate layer in an analogous fashion to step 703.

Then in some exemplary embodiments, at 706, a dielectric layer may be applied upon the second substrate layer upon the electrode layer. The dielectric layer may be formed to have a variable thickness across its surface. As an example, the dielectric layer may be molded upon the first substrate layer. Alternatively, a previously formed dielectric layer
5 may be adhered upon the electrode surface of the second substrate piece.

At 707, an alignment layer may be formed upon the second substrate layer in similar fashion to the processing step at 704. After 707, two separate substrate layers that may form at least a portion of an ophthalmic lens insert may be ready to be joined. In some exemplary embodiments at 708, the two pieces will be brought in close proximity to
10 each other and then liquid crystal material may be filled in between the pieces. There may be numerous manners to fill the liquid crystal in between the pieces including as non-limiting examples, vacuum based filling where the cavity is evacuated and liquid crystal material is subsequently allowed to flow into the evacuated space. In addition, the capillary forces that are present in the space between the lens insert pieces may aid in the
15 filling of the space with liquid crystal material. At 709, the two pieces may be brought adjacent to each other and then sealed to form a variable optic element with liquid crystal. There may be numerous manners of sealing the pieces together including the use of adhesives, sealants, and physical sealing components such as o-rings and snap lock features as non-limiting examples.

20 In some exemplary embodiments, two pieces of the type formed at 709 may be created by repeating method steps 701 to 709, wherein the alignment layers are offset from each other to allow for a lens that may adjust the focal power of non-polarized light. In such exemplary embodiments, the two variable optic layers may be combined to form a single variable optic insert. At 710, the variable optic portion may be connected to the
25 energy source and intermediate or attached components may be placed thereon.

At 711, the variable optic insert resulting at step 710 may be placed within a mold part. The variable optic insert may or may not also comprise one or more components. In some preferred embodiments, the variable optic insert is placed in the mold part via mechanical placement. Mechanical placement may include, for example, a robot or other
30 automation, such as that known in the industry to place surface-mount components.

Human placement of a variable optic insert is also within the scope of the present invention. Accordingly, any mechanical placement or automation may be utilized which is effective to place a variable optic insert with an energy source within a cast mold part such that the polymerization of a reactive mixture contained by the mold part will include the
5 variable optic in a resultant ophthalmic lens.

In some exemplary embodiments, a variable optic insert may be placed in a mold part attached to a substrate. An energy source and one or more components may also be attached to the substrate and may be in electrical communication with the variable optic insert. Components may include, for example, circuitry to control power applied to the
10 variable optic insert. Accordingly, in some exemplary embodiments a component includes control mechanism for actuating the variable optic insert to change one or more optical characteristics, for example, a change of state between a first optical power and a second optical power.

In some exemplary embodiments, a processor device, microelectromechanical
15 system (MEMS), nanoelectromechanical system (NEMS) or other component may also be placed into the variable optic insert and in electrical contact with the energy source. At 712, a reactive monomer mixture may be deposited into a mold part. At 713, the variable optic insert may be positioned into contact with the reactive mixture. In some exemplary embodiments the order of placement of variable optic and depositing of monomer mixture
20 may be reversed. At 714, the first mold part is placed proximate to a second mold part to form a lens-forming cavity with at least some of the reactive monomer mixture and the variable optic insert in the cavity. As discussed above, preferred embodiments include an energy source and one or more components also within the cavity and in electrical communication with the variable optic insert.

25 At 715, the reactive monomer mixture within the cavity is polymerized. Polymerization may be accomplished, for example, via exposure to one or both of actinic radiation and heat. At 716, the ophthalmic lens is removed from the mold parts with the variable optic insert adhered to or encapsulated within the insert-encapsulating polymerized material making up the ophthalmic lens.

Although the invention herein may be used to provide hard or soft contact lenses made of any known lens material, or material suitable for manufacturing such lenses, preferably, the lenses of the invention are soft contact lenses having water contents of about 0 to about 90 percent. More preferably, the lenses are made of monomers containing
5 hydroxy groups, carboxyl groups, or both or be made from silicone-containing polymers, such as siloxanes, hydrogels, silicone hydrogels, and combinations thereof. Material useful for forming the lenses of the invention may be made by reacting blends of macromers, monomers, and combinations thereof along with additives such as polymerization initiators. Suitable materials include, silicone hydrogels made from
10 silicone macromers and hydrophilic monomers.

APPARATUS

Referring now to Figure 8, automated apparatus 810 is illustrated with one or more
15 transfer interfaces 811. Multiple mold parts, each with an associated variable optic insert 814 are contained on a pallet 813 and presented to transfer interfaces 811. Exemplary embodiments, may include, for example a single interface individually placing variable optic insert 814, or multiple interfaces (not shown) simultaneously placing variable optic inserts 814 into the multiple mold parts, and in some exemplary embodiments, in each
20 mold part. Placement may occur via vertical movement 815 of the transfer interfaces 811.

Another aspect of some exemplary embodiments of the present invention includes apparatus to support the variable optic insert 814 while the body of the ophthalmic lens is molded around these components. In some exemplary embodiments the variable optic insert 814 and an energy source may be affixed to holding points in a lens mold (not
25 illustrated). The holding points may be affixed with polymerized material of the same type that will be formed into the lens body. Other exemplary embodiments include a layer of prepolymer within the mold part onto which the variable optic insert 814 and an energy source may be affixed.

PROCESSORS INCLUDED IN INSERT DEVICES

Referring now to Figure 9, a controller 900 is illustrated that may be used in some exemplary embodiments of the present invention. The controller 900 includes a processor 910, which may include one or more processor components coupled to a communication device 920. In some exemplary embodiments, a controller 900 may be used to transmit energy to the energy source placed in the ophthalmic lens.

The controller may include one or more processors, coupled to a communication device configured to communicate energy via a communication channel. The communication device may be used to electronically control one or more of the placement of a variable optic insert into the ophthalmic lens or the transfer of a command to operate a variable optic device.

The communication device 920 may also be used to communicate, for example, with one or more controller apparatus or manufacturing equipment components.

The processor 910 is also in communication with a storage device 930. The storage device 930 may comprise any appropriate information storage device, including combinations of magnetic storage devices (*e.g.*, magnetic tape and hard disk drives), optical storage devices, and/or semiconductor memory devices such as Random Access Memory (RAM) devices and Read Only Memory (ROM) devices.

The storage device 930 may store a program 940 for controlling the processor 910. The processor 910 performs instructions of the program 940, and thereby operates in accordance with the present invention. For example, the processor 910 may receive information descriptive of variable optic insert placement, processing device placement, and the like. The storage device 930 may also store ophthalmic related data in one or more databases 950, 960. The database 950 and 960 may include specific control logic for controlling energy to and from a variable optic lens.

In this description, reference has been made to elements illustrated in the figures. Many of the elements are depicted for reference to depict the embodiments of the inventive art for understanding. The relative scale of actual features may be significantly different from that as depicted, and variation from the depicted relative scales should be

assumed within the spirit of the art herein. For example, liquid crystal molecules may be of a scale to be impossibly small to depict against the scale of insert pieces. The depiction of features that represent liquid crystal molecules at a similar scale to insert pieces to allow for representation of factors such as the alignment of the molecules is therefore such
5 an example of a depicted scale that in actual embodiments may assume much different relative scale.

Although shown and described in what is believed to be the most practical and preferred embodiments, it is apparent that departures from specific designs and methods described and shown will suggest themselves to those skilled in the art and may be used
10 without departing from the spirit and scope of the invention. The present invention is not restricted to the particular constructions described and illustrated, but should be constructed to cohere with all modifications that may fall within the scope of the appended claims.

CLAIMS

1. An ophthalmic lens device with a variable optic insert positioned within at least a portion of an optical zone of the ophthalmic lens device, wherein the variable optic insert comprises:
 - a curved front surface and a curved back surface, wherein the front surface and the back surface are configured to bound at least a portion of one chamber;
 - an energy source embedded in the variable optic insert in at least a region comprising a non-optical zone; and
 - a layer containing liquid crystal material positioned within the at least one chamber, wherein the layer includes regions of liquid crystal material aligned in a pattern wherein an index of refraction across at least a first portion of the variable optic insert varies with a radial dependence.
2. The ophthalmic lens device of Claim 1 wherein the index of refraction across at least the first portion of the optic insert has a parabolic dependence on a radial dimension.
3. The ophthalmic lens device of Claim 2 wherein an optical effect of the layer containing liquid crystal material is supplemented by an effect of different radii of insert surfaces.
4. The ophthalmic lens device of Claim 2 wherein the lens is a contact lens.
5. The ophthalmic lens device of Claim 4 further comprising :
 - a first layer of electrode material proximate to the curved back surface; and
 - a second layer of electrode material proximate to the curved front surface.
6. The ophthalmic lens device of Claim 5 wherein at least a portion of the layer containing liquid crystal material varies its index of refraction affecting a ray

of light traversing the layer containing liquid crystal material when an electric potential is applied across the first layer of electrode material and the second layer of electrode material.

7. The ophthalmic lens device of Claim 6 wherein the variable optic insert alters a focal characteristic of the lens.
8. The ophthalmic lens device of Claim 7 further comprising an electrical circuit, wherein the electrical circuit controls a flow of electrical energy from the energy source to the first and second electrode layers.
9. The ophthalmic lens device of claim 8 wherein the electrical circuit comprises a processor.
10. An ophthalmic lens device with a variable optic insert positioned within at least a portion of an optical zone of the ophthalmic lens device, wherein the variable optic insert comprises:
 - a curved first front surface and a curved first back surface wherein the first front surface and the first back surface are configured to bound at least a portion of a first chamber;
 - a curved second front surface and a curved second back surface wherein the second front surface and the second back surface are configured to bound at least a portion of a second chamber;
 - at least one layer containing liquid crystal material positioned within the at least one chamber, wherein the at least one layer includes regions of liquid crystal material aligned in a pattern wherein an index of refraction across at least a first portion of the variable optic insert varies with a radial dependence; and
 - an energy source embedded in the insert in at least a region comprising a non-optical zone.

11. The ophthalmic lens device of Claim 10 wherein the index of refraction across at least the first portion of the optic insert has a parabolic dependence on a radial dimension.
12. The ophthalmic lens device of Claim 11 wherein an optical effect of the layer containing liquid crystal material is supplemented by an effect of different curvature of insert surfaces.
13. The ophthalmic lens device of Claim 10 wherein the lens is a contact lens.
14. The ophthalmic lens device of Claim 13 further comprising :
 - a first layer of electrode material proximate to the first curved back surface;
 - and
 - a second layer of electrode material proximate to the curved first front surface.
15. The ophthalmic lens device of Claim 14 wherein the layer containing liquid crystal material varies its index of refraction affecting a ray of light traversing the layer containing liquid crystal material when an electric potential is applied across the first layer of electrode material and the second layer of electrode material.
16. The ophthalmic lens device of Claim 15 wherein the variable optic insert alters a focal characteristic of the lens.
17. The ophthalmic lens device of Claim 16 further comprising an electrical circuit, wherein the electrical circuit controls a flow of electrical energy from the energy source to the first and second electrode layers.

18. The ophthalmic lens device of claim 17 wherein the electrical circuit comprises a processor.
19. A contact lens device with a variable optic insert positioned within at least a portion of an optical zone of the contact lens device, wherein the variable optic insert comprises:
- a curved first front surface and a curved first back surface wherein the first front surface and the first back surface are configured to form at least a first chamber;
 - a first layer of electrode material proximate to the curved first front surface;
 - a second layer of electrode material proximate to the curved first back surface;
 - a first layer containing liquid crystal material positioned within the first chamber, wherein the first layer includes regions of liquid crystal material aligned in a first pattern wherein a first index of refraction across at least a first portion of the variable optic insert varies with a first radial dependence, and wherein the first layer containing liquid crystal material varies its first index of refraction affecting a first ray of light traversing the first layer containing liquid crystal material when a first electric potential is applied across the first layer of electrode material and the second layer of electrode material;
 - a curved second front surface and a curved second back surface wherein the second front surface and the second back surface are configured to form at least a second chamber;
 - a third layer of electrode material proximate to the curved second front surface;
 - a fourth layer of electrode material proximate to the curved second back surface;
 - a second layer containing liquid crystal material positioned within the second chamber, wherein the second layer includes regions of liquid crystal material aligned in a second pattern wherein a second index of refraction

across at least a second portion of the variable optic insert varies with a second radial dependence, and wherein the second layer containing liquid crystal material varies its second index of refraction affecting a second ray of light traversing the second layer containing liquid crystal material when a second electric potential is applied across the third layer of electrode material and the fourth layer of electrode material;

an energy source embedded in the insert in at least a region comprising a non-optical zone;

an electrical circuit comprising a processor, wherein the electrical circuit controls a flow of electrical energy from the energy source to one or more of the first, second, third or fourth electrode layers; and

wherein the variable optic insert alters a focal characteristic of the contact lens device.

20. A contact lens device with a variable optic insert positioned within at least a portion of an optical zone of the contact lens device, wherein the variable optic insert comprises:

a layer containing liquid crystal material positioned within the variable optic insert, wherein the layer includes regions of liquid crystal material aligned in a pattern wherein an index of refraction across at least a first portion of the variable optic insert varies with a radial dependence; and

wherein at least a first surface of the layer containing liquid crystal material is curved.

21. An ophthalmic lens device with a variable optic insert positioned within at least a portion of an optical zone of the ophthalmic lens device, wherein the variable optic insert comprises:

an insert front curve piece and an insert back curve piece, wherein a back surface of the front curve piece has a first curvature and a front surface of the back curve piece has a second curvature;

an energy source embedded in the insert in at least a region comprising a non-optical zone; and

a layer containing liquid crystal material, wherein the layer includes regions of liquid crystal material aligned in a pattern wherein an index of refraction across at least a first portion of the variable optic insert varies with a radial dependence.

22. The ophthalmic lens device of Claim 21 wherein the index of refraction across at least the first portion of the optic insert has a parabolic dependence on a radial dimension.

23. The ophthalmic lens device of Claim 22 wherein an optical effect of the layer containing liquid crystal material is supplemented by an effect of different curvature of insert surfaces.

24. The ophthalmic lens device of Claim 21 wherein the first curvature is different from the second curvature.

25. The ophthalmic lens device of Claim 21 wherein the lens is a contact lens.

26. The ophthalmic lens device of Claim 25 further comprising :

a first layer of electrode material proximate to the back surface of the front curve piece; and

a second layer of electrode material proximate to the front surface of the back curve piece.

27. The ophthalmic lens device of Claim 26 wherein the layer containing liquid crystal material varies its index of refraction affecting a ray of light traversing the layer containing liquid crystal material when an electric potential is applied across the first layer of electrode material and the second layer of electrode material.

28. The ophthalmic lens device of Claim 27 wherein the variable optic insert alters a focal characteristic of the lens.
29. The ophthalmic lens device of Claim 28 further comprising an electrical circuit, wherein the electrical circuit controls a flow of electrical energy from the energy source to the first and second electrode layers.
30. The ophthalmic lens device of claim 29 wherein the electrical circuit comprises a processor.
31. An ophthalmic lens device with a variable optic insert positioned within at least a portion of an optical zone of the ophthalmic lens device, wherein the variable optic insert comprises:
- an insert front curve piece, at least a first intermediate curve piece and an insert back curve piece, wherein a back surface of the front curve piece has a first curvature and a front surface of the first intermediate curve piece has a second curvature;
 - an energy source embedded in the insert in at least a region comprising a non-optical zone; and
 - the variable optic insert comprising a layer containing liquid crystal material, wherein the layer includes regions of liquid crystal material aligned in a pattern wherein an index of refraction across at least a first portion of the variable optic insert varies with a radial dependence.
32. The ophthalmic lens device of Claim 31 wherein the index of refraction across at least the first portion of the optic insert has a parabolic dependence on a radial dimension.
33. The ophthalmic lens device of Claim 32 wherein the first curvature is different from the second curvature.

34. The ophthalmic lens device of Claim 31 wherein the lens is a contact lens.
35. The ophthalmic lens device of Claim 34 further comprising:
a first layer of electrode material proximate to the front curve piece; and
a second layer of electrode material proximate to one or more of the
intermediate curve piece and the back curve piece.
36. The ophthalmic lens device of Claim 34 further comprising:
a first layer of electrode material proximate to the front curve piece; and
a second layer of electrode material proximate to the intermediate curve
piece.
37. The ophthalmic lens device of Claim 36 wherein the layer containing liquid
crystal material varies its index of refraction affecting a ray of light traversing
the layer containing liquid crystal material when an electric potential is applied
across the first layer of electrode material and the second layer of electrode
material.
38. The ophthalmic lens device of Claim 37 wherein:
the variable optic insert alters a focal characteristic of the lens.
39. The ophthalmic lens device of Claim 38 further comprising an electrical
circuit, wherein the electrical circuit controls a flow of electrical energy from
the energy source to the first and second electrode layers.
40. The ophthalmic lens device of claim 39 wherein the electrical circuit comprises
a processor.