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Jones et al.

(54) REVERSIBLE USB CONNECTOR WITH COMPLIANT MEMBER TO SPREAD STRESS AND INCREASE CONTACT NORMAL FORCE

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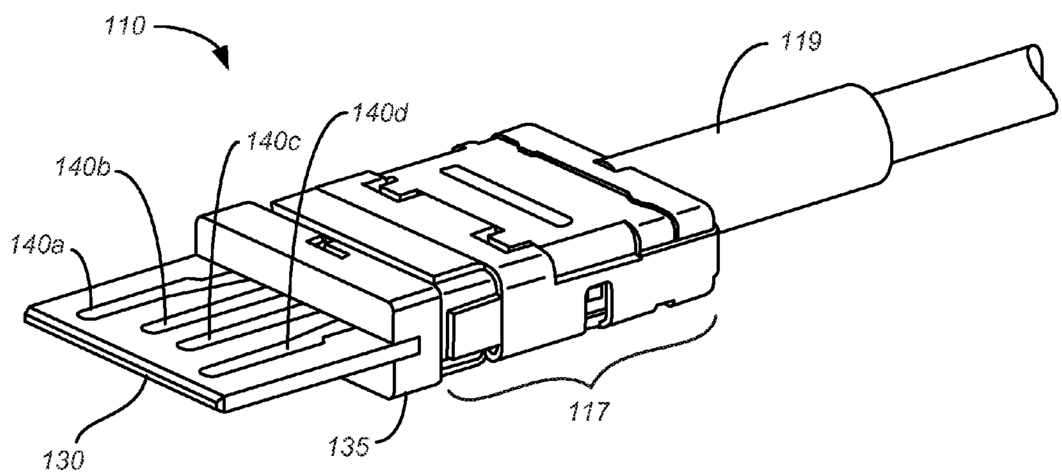
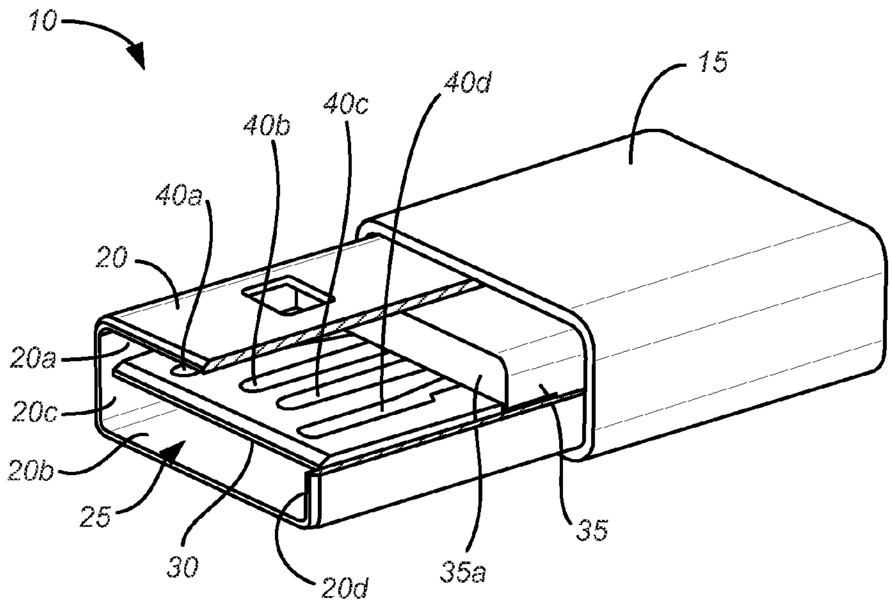
H01R 24/76 (2006.01)

(52) **U.S. Cl.**
CPC ***H01R 24/76*** (2013.01)
USPC **439/449**

(57) **ABSTRACT**

Embodiments can provide reversible or dual orientation USB plug connectors for mating with standard USB receptacle connectors, e.g., a standard Type A USB receptacle connector. Accordingly, the present invention may be compatible with any current or future electronic device that includes a standard USB receptacle connector. USB plug connectors according to the present invention can have a 180 degree symmetrical, double orientation design, which enables the plug connector to be inserted into a corresponding receptacle connector in either of two intuitive orientations. Thus, embodiments of the present invention may reduce the potential for USB connector damage and user frustration during the incorrect insertion of a USB plug connector into a corresponding USB receptacle connector of an electronic device. Reversible USB plug connectors according to the present invention may include a compliant member or structural support for distributing stress and increasing contact normal force at the tongue of the reversible USB plug connector.

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40b
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20a
20c
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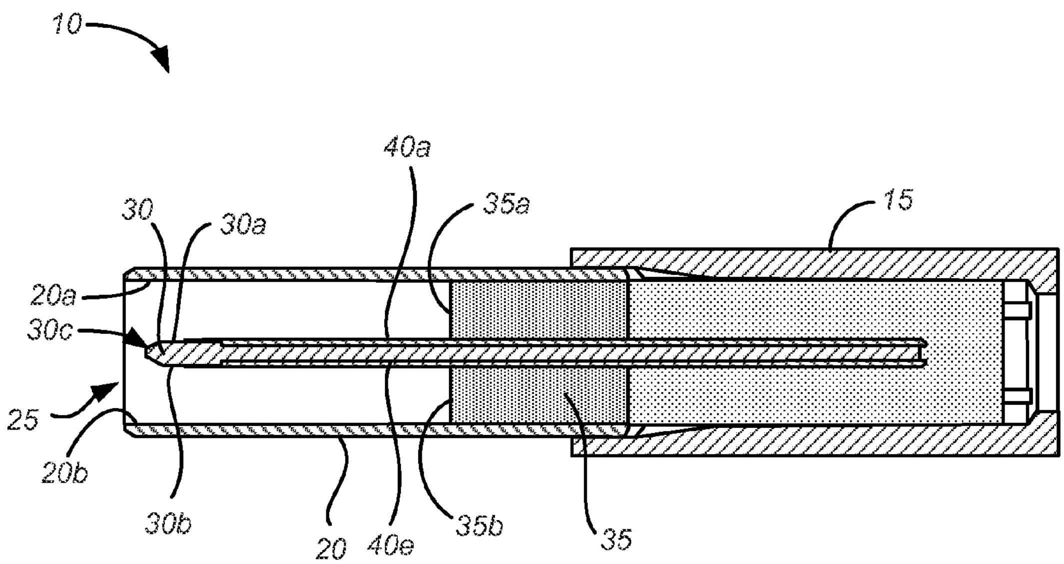
30
20d
35a
35

FIG. 1A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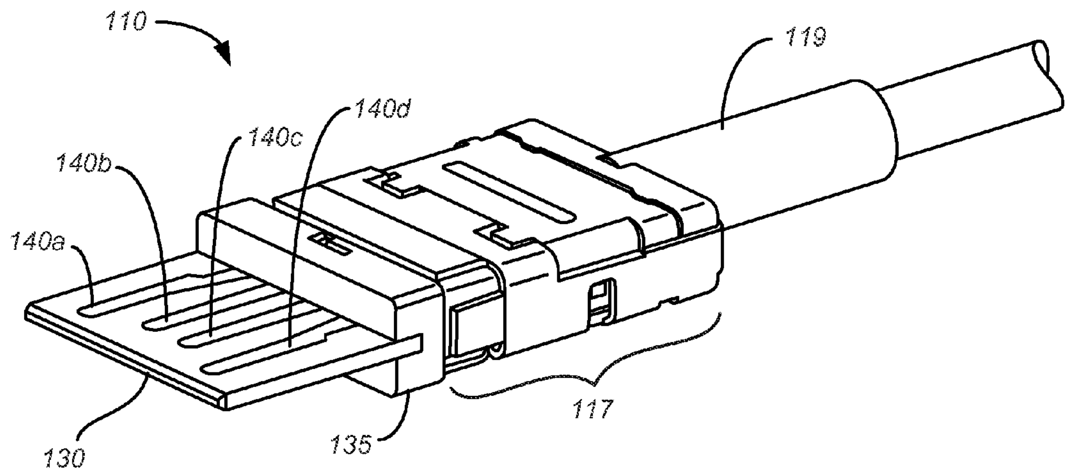
35b
35

FIG. 1B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140d
140c
140b
140a
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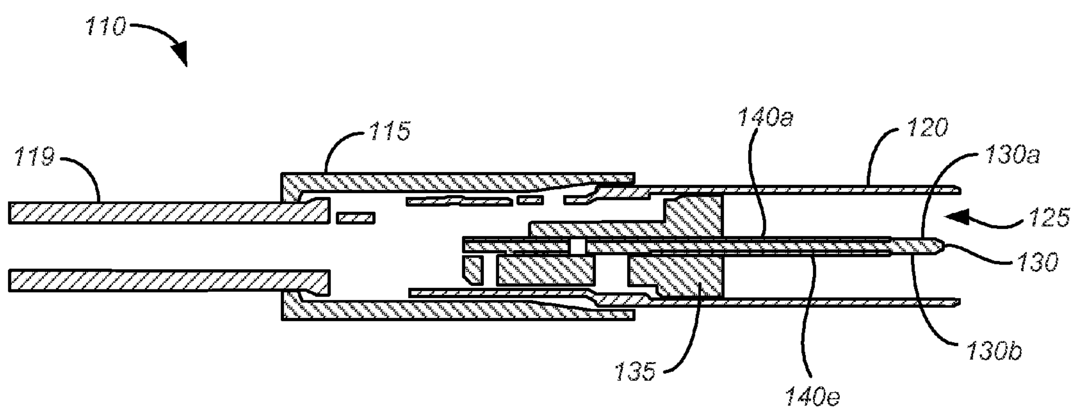
135
117

FIG. 2A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130b
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140e

FIG. 2B

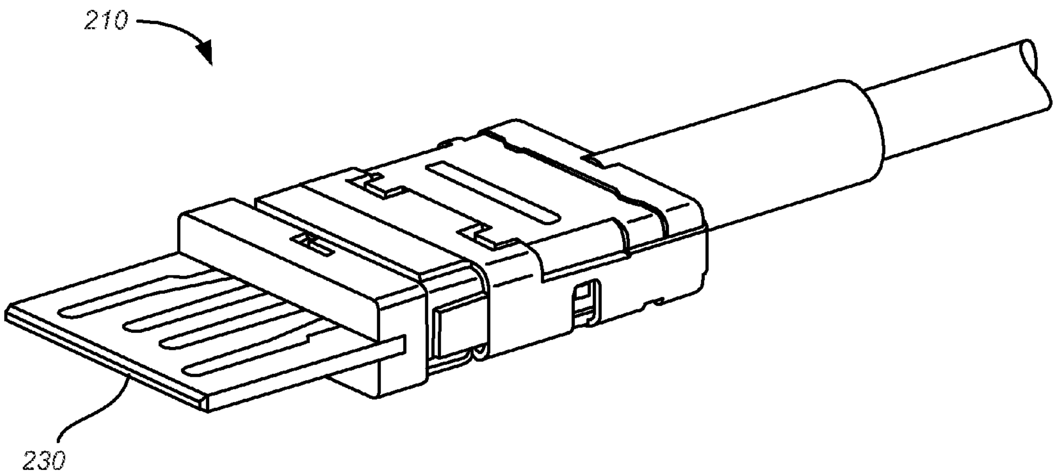


FIG. 3A

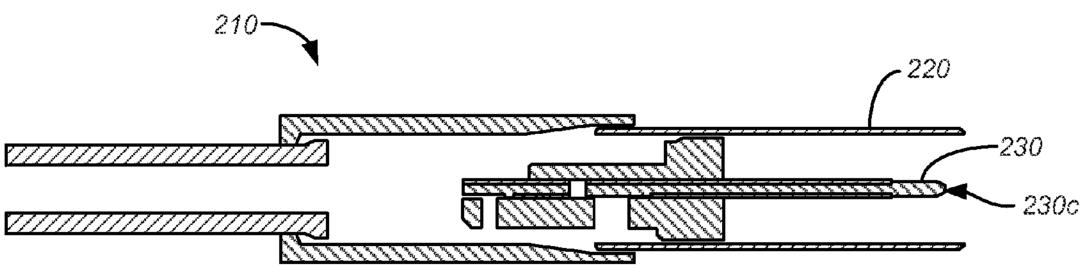
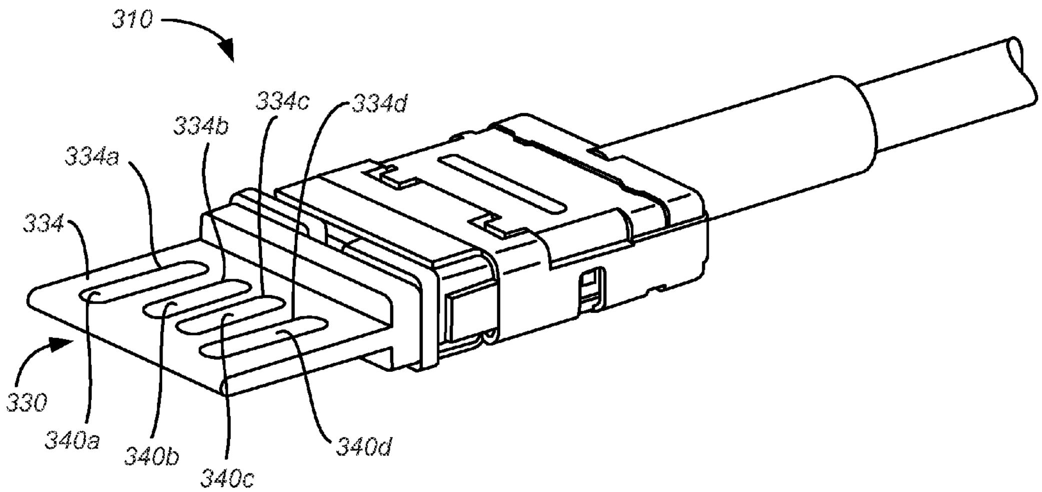


FIG. 3B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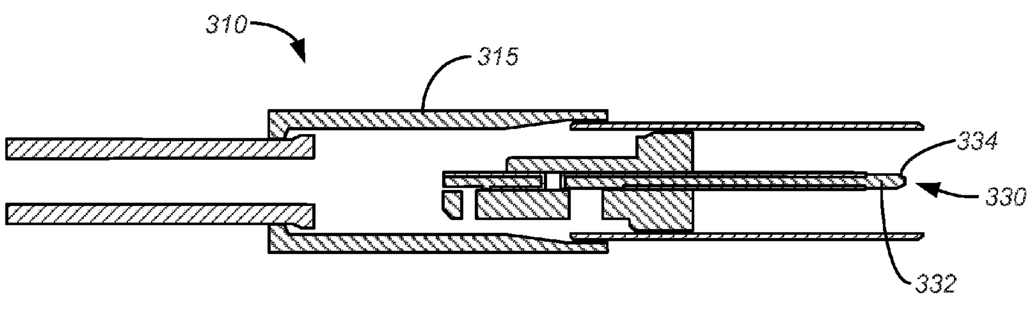
340b
340c
340d

FIG. 4A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315
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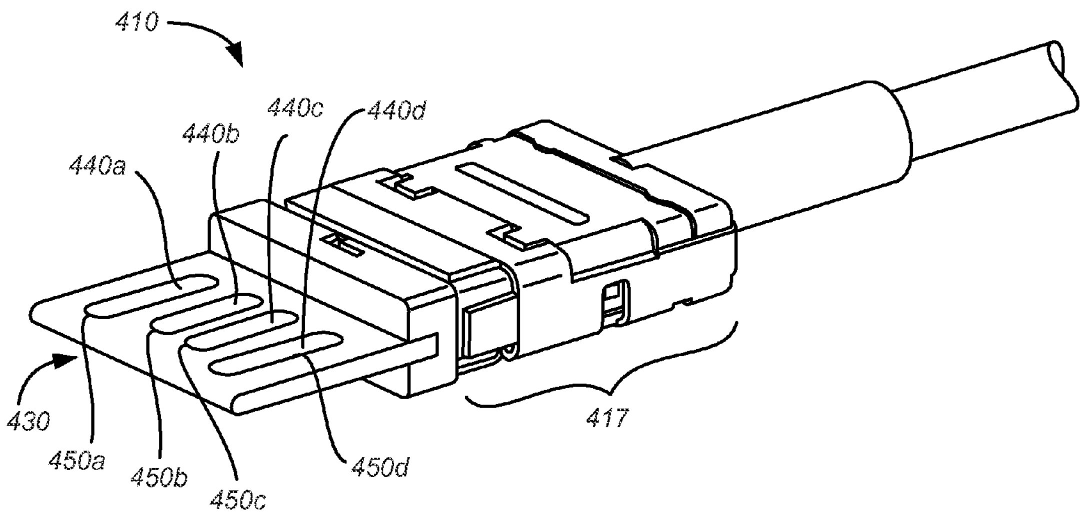
330
332

FIG. 4B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440a
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440d
430
450a
450b
450c
450d
417

FIG. 5A

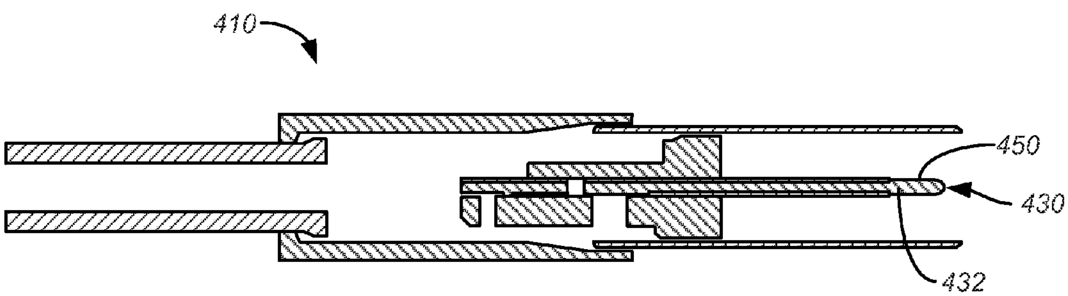
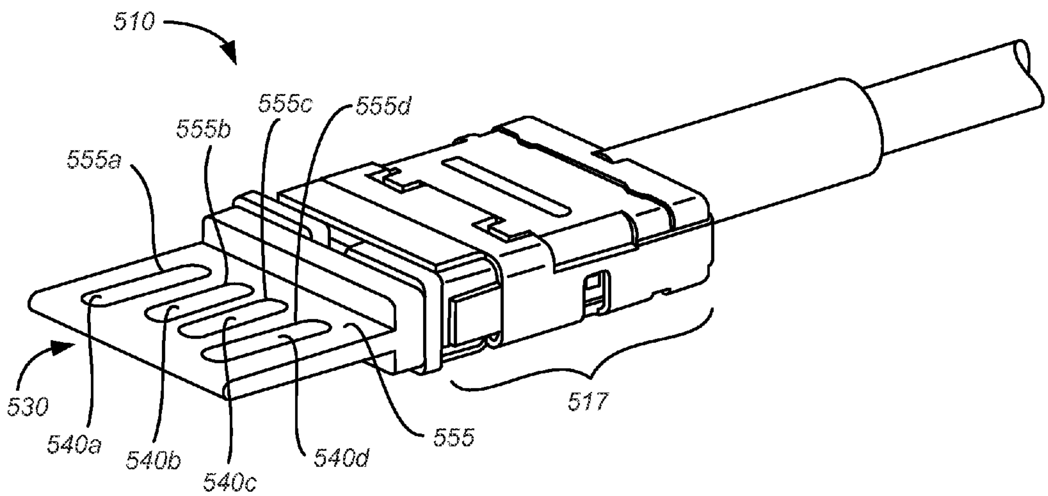

410
450
430
432

FIG. 5B


510
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540a
540b
540c
540d
555
517

FIG. 6A

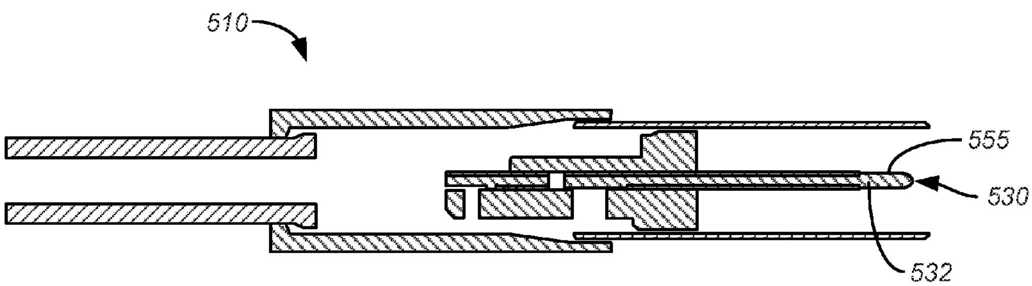
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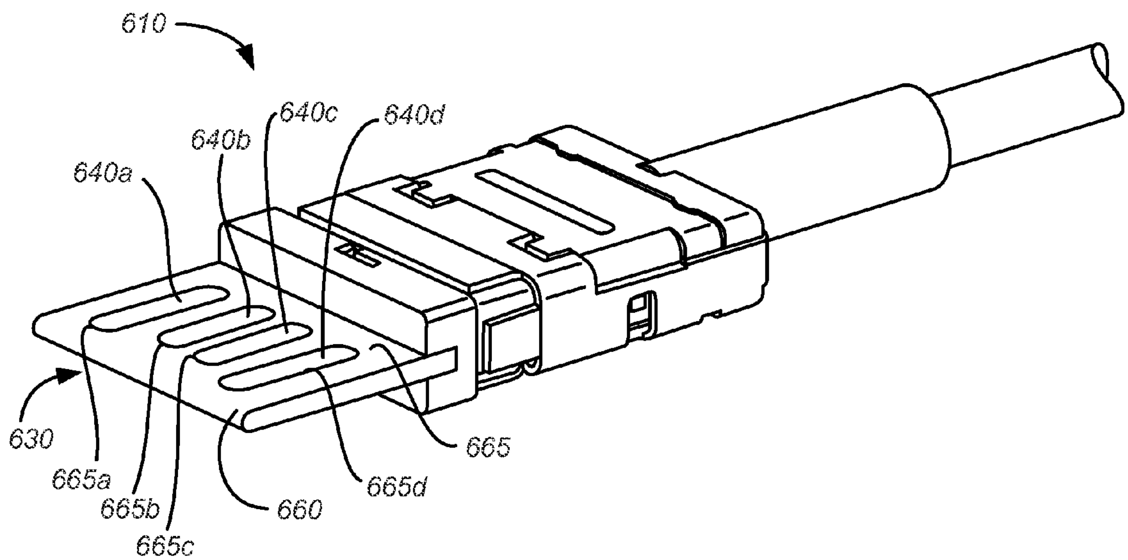
FIG. 6B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630
665a
665b
665c
660
665d
665

FIG. 7A

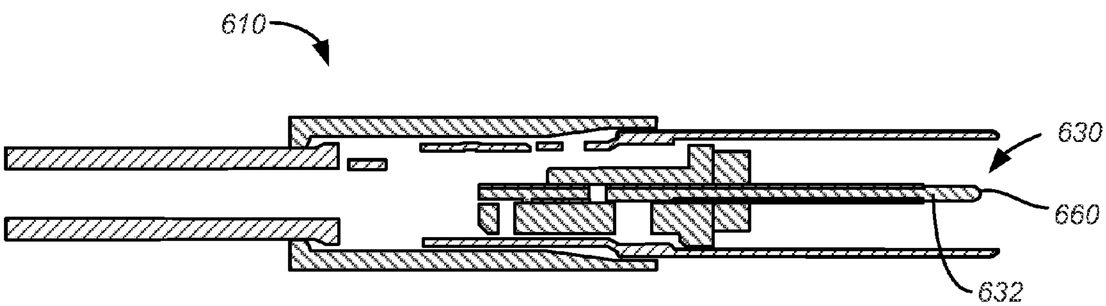
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FIG. 7B

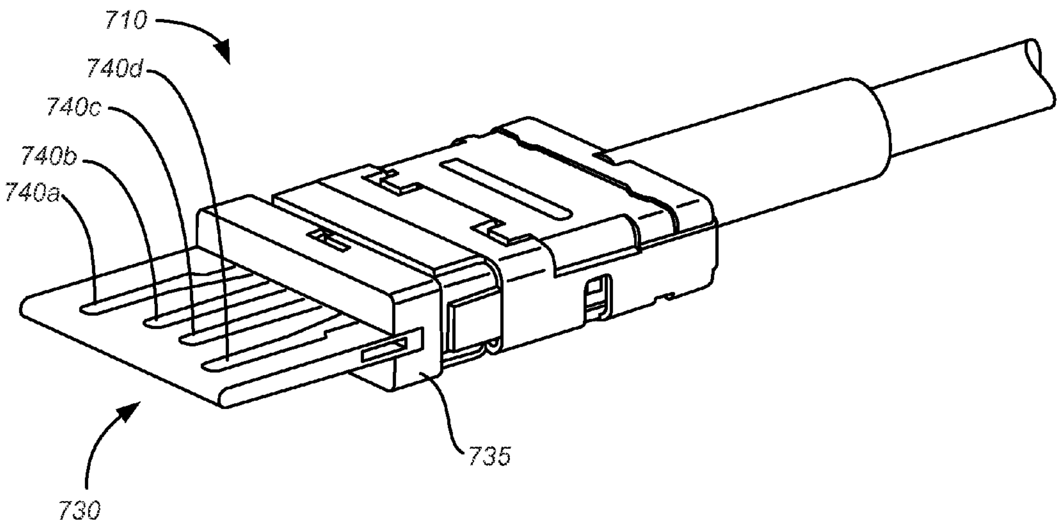


FIG. 8A

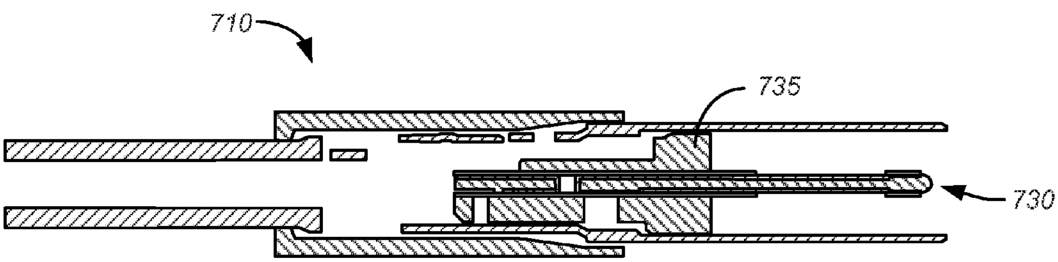


FIG. 8B

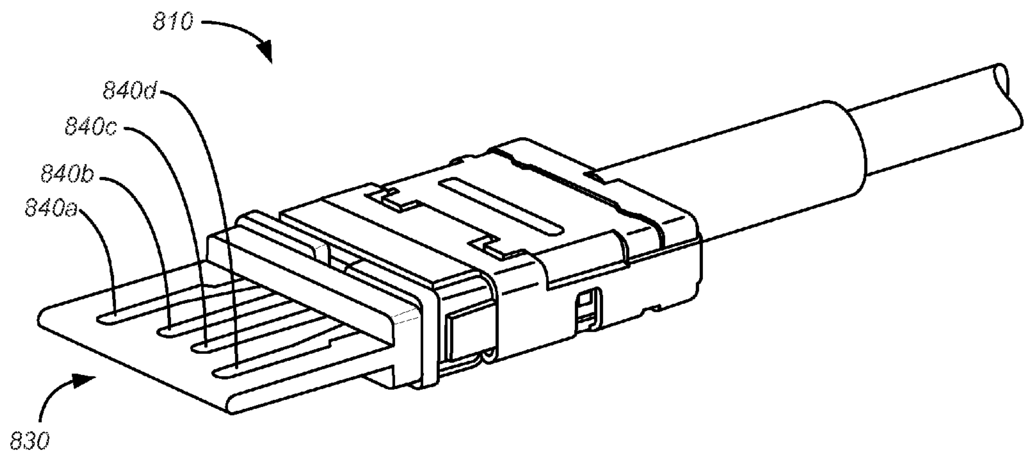
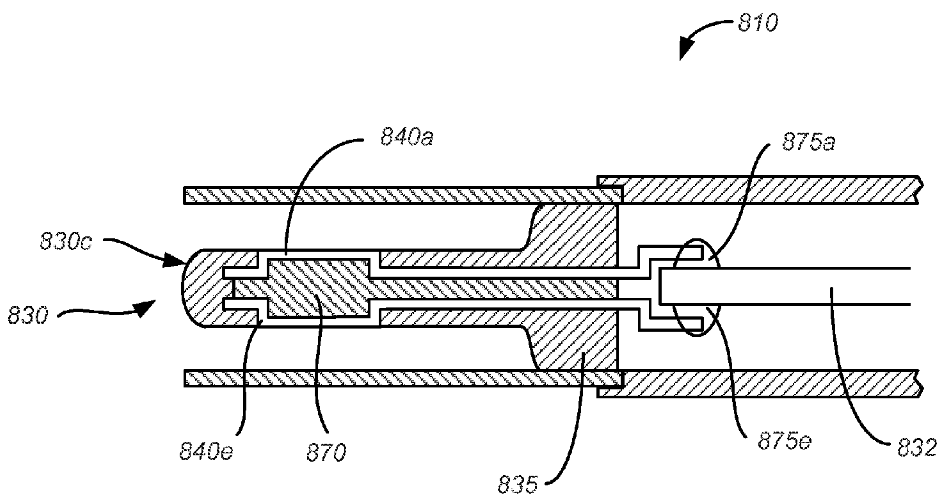

810
840d
840c
840b
840a
830

FIG. 9A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830c
830
840e
870
835
875e
832

FIG. 9B

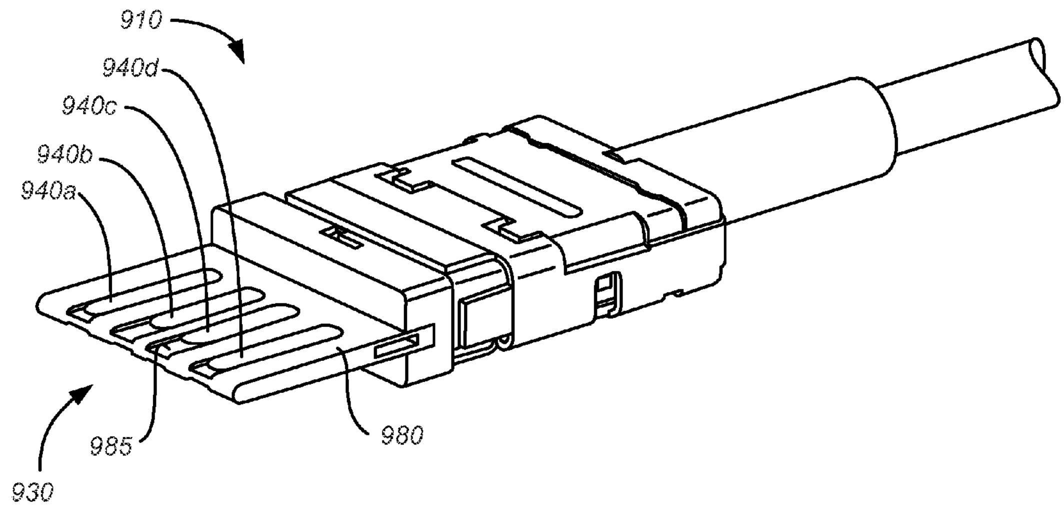


FIG. 10A

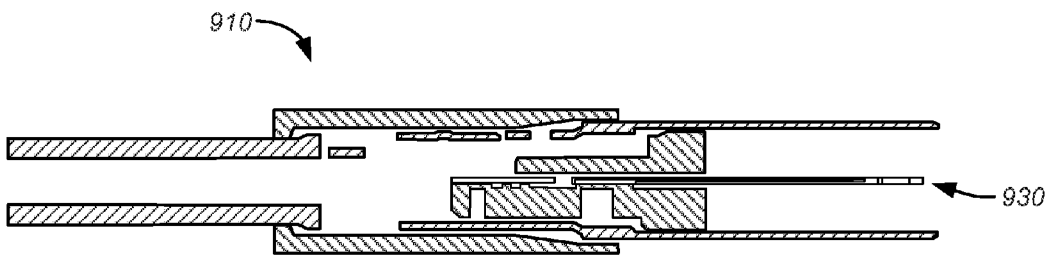


FIG. 10B

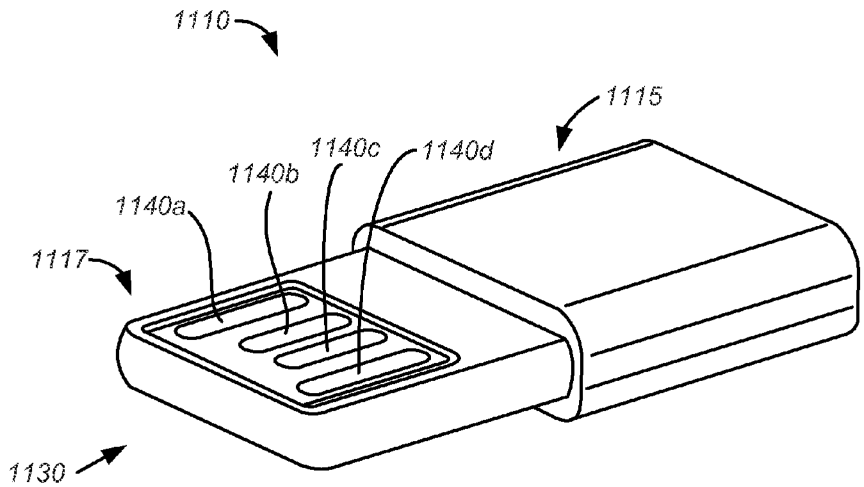


FIG. 11A

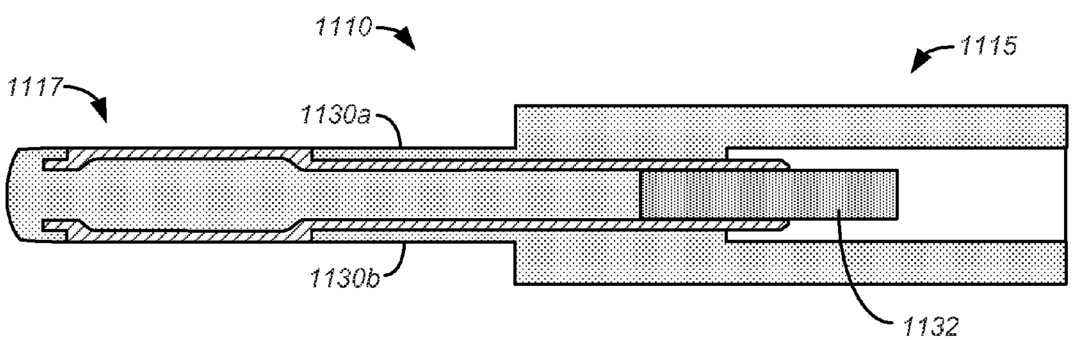


FIG. 11B

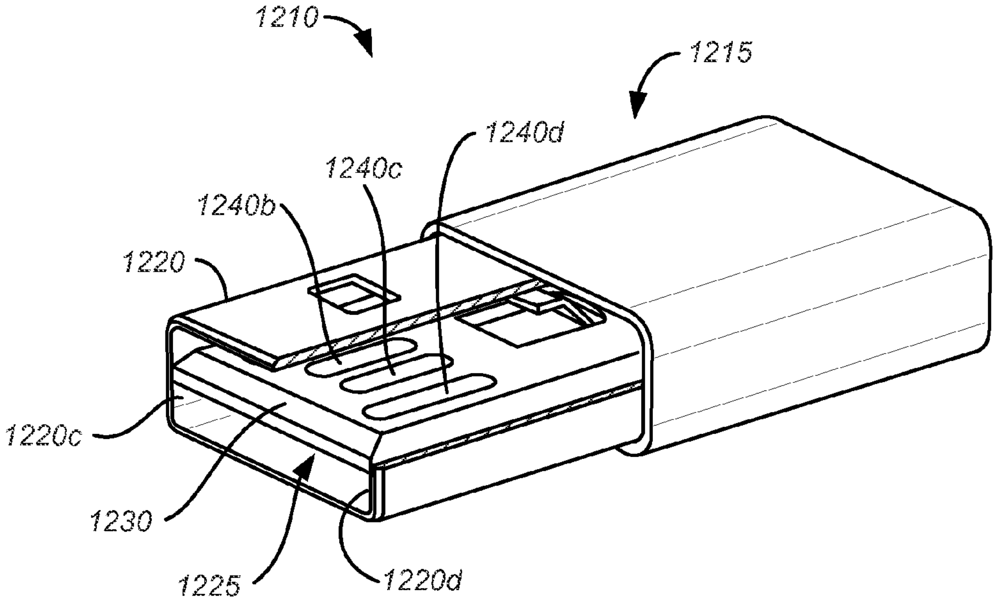


FIG. 12A

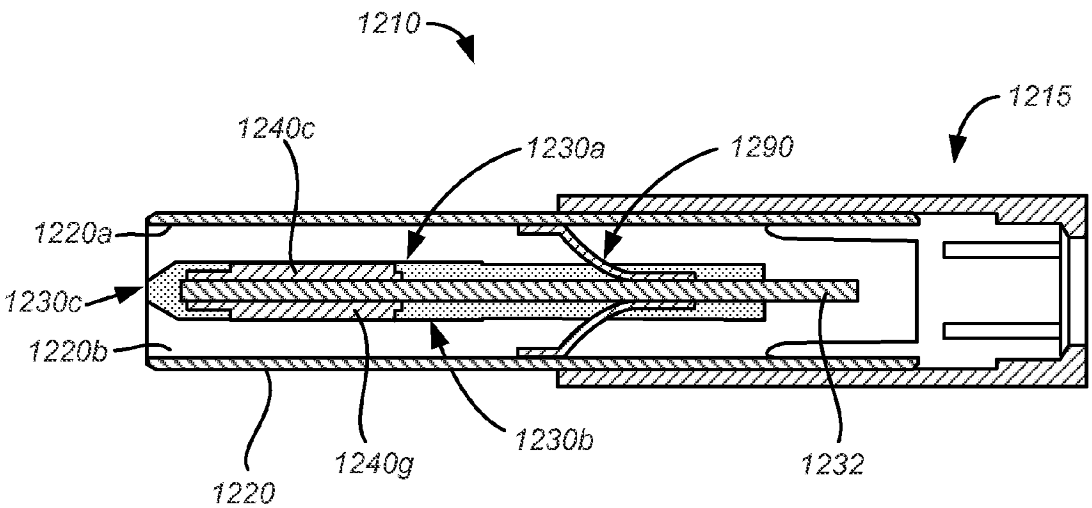


FIG. 12B

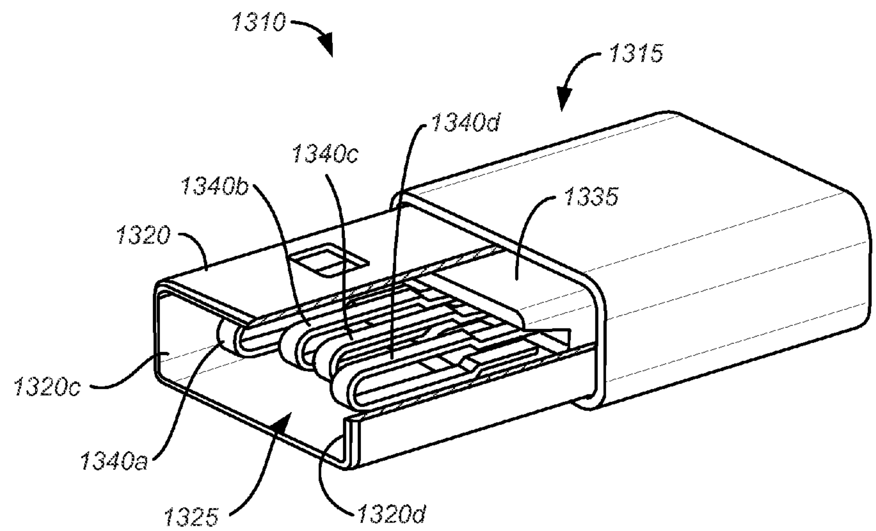


FIG. 13A

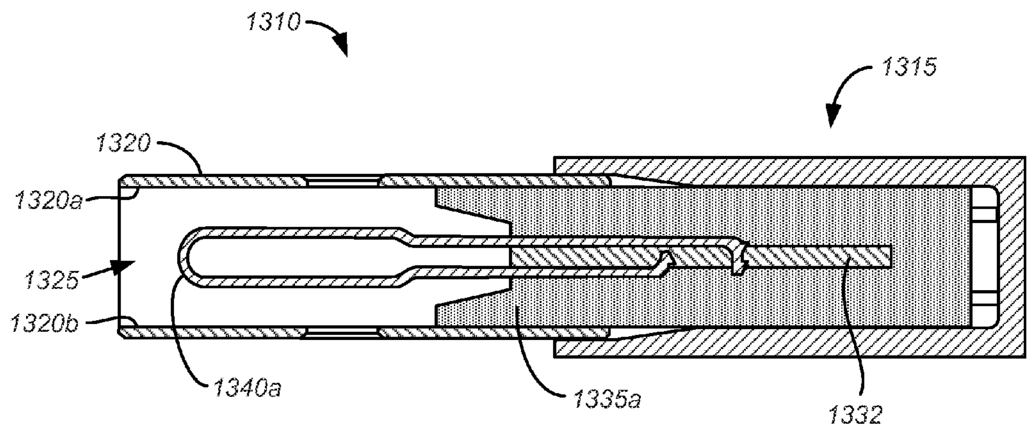


FIG. 13B

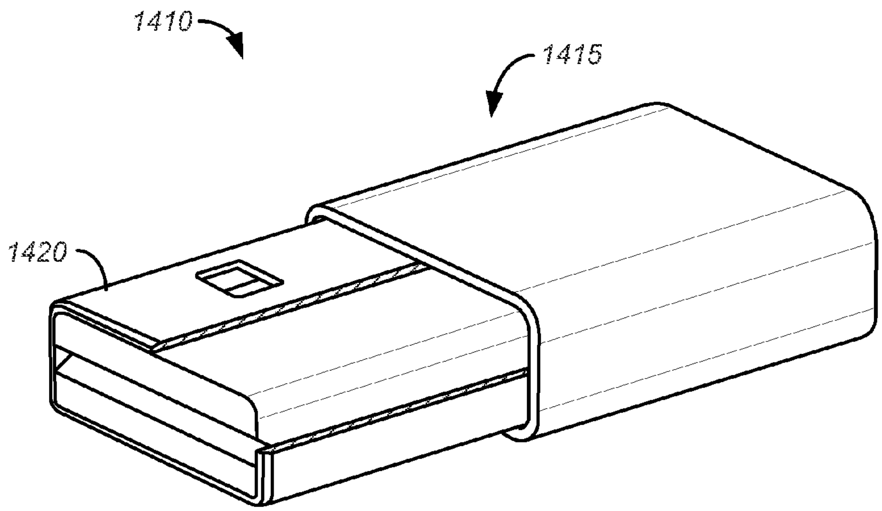


FIG. 14A

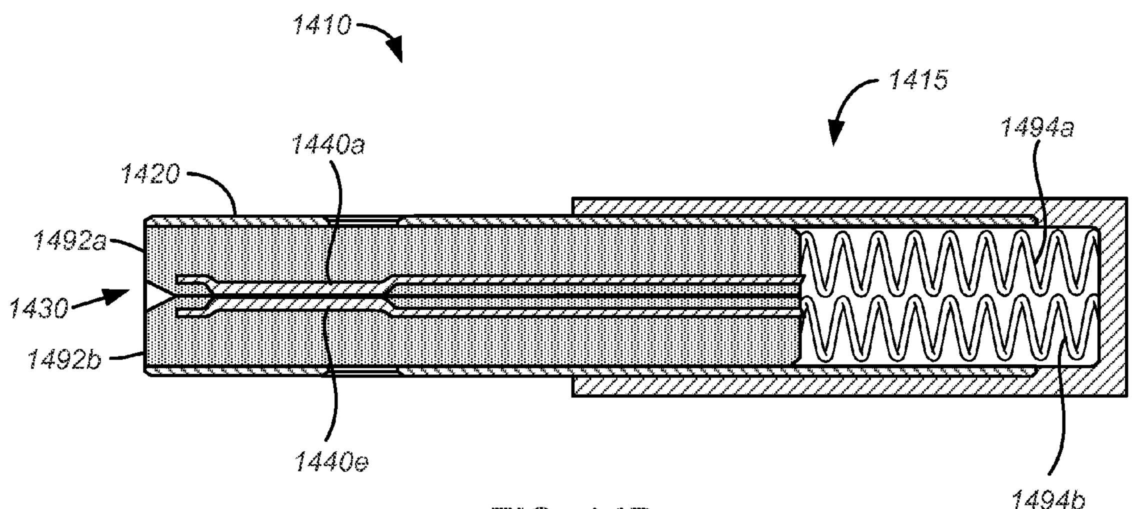


FIG. 14B

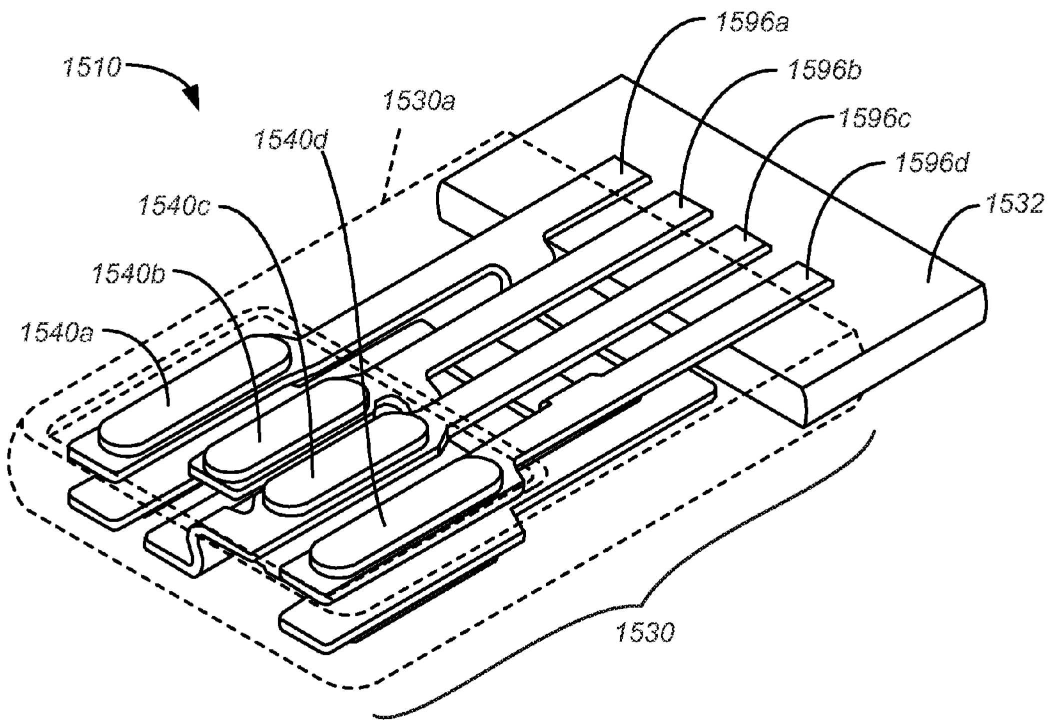


FIG. 15A

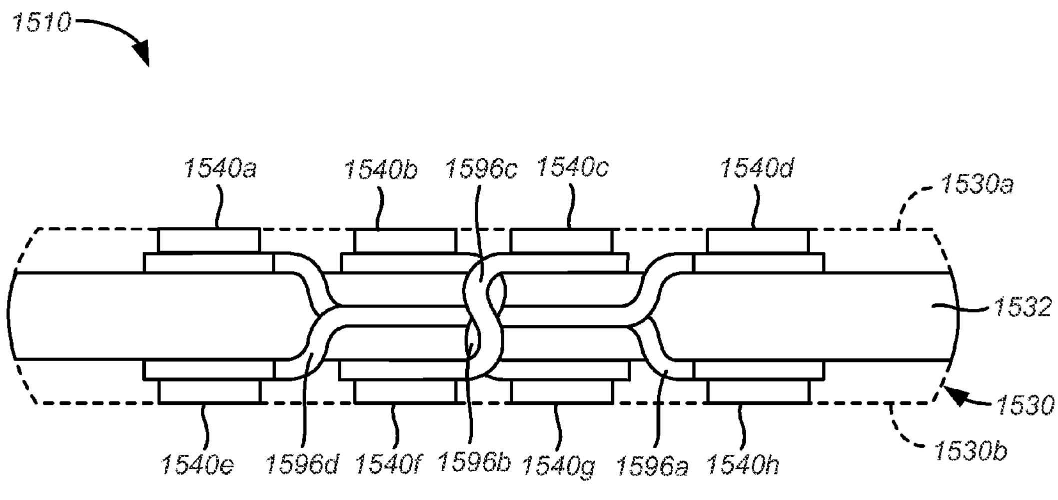


FIG. 15B

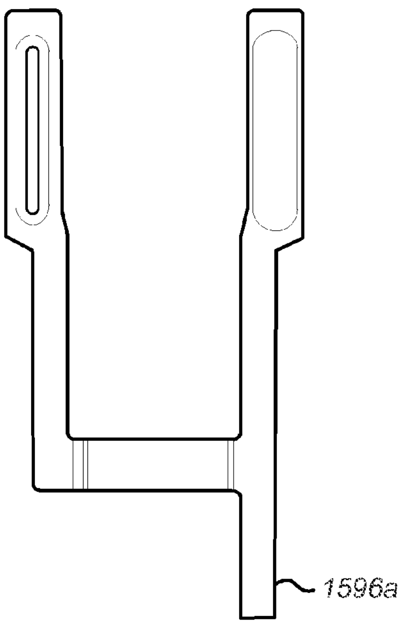


FIG. 15C

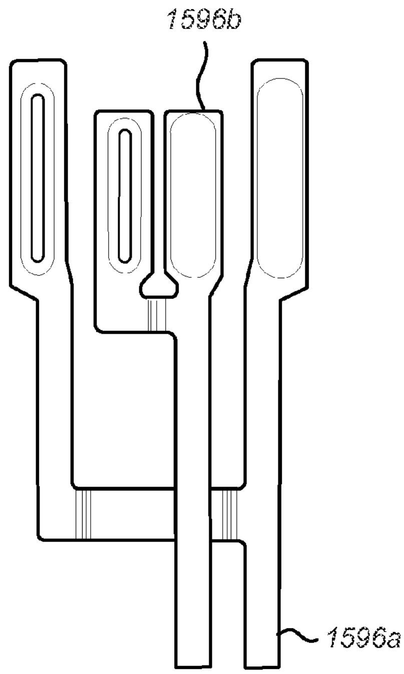


FIG. 15D

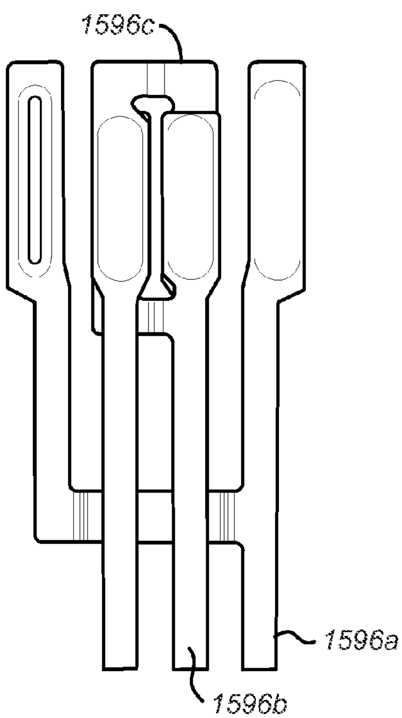


FIG. 15E

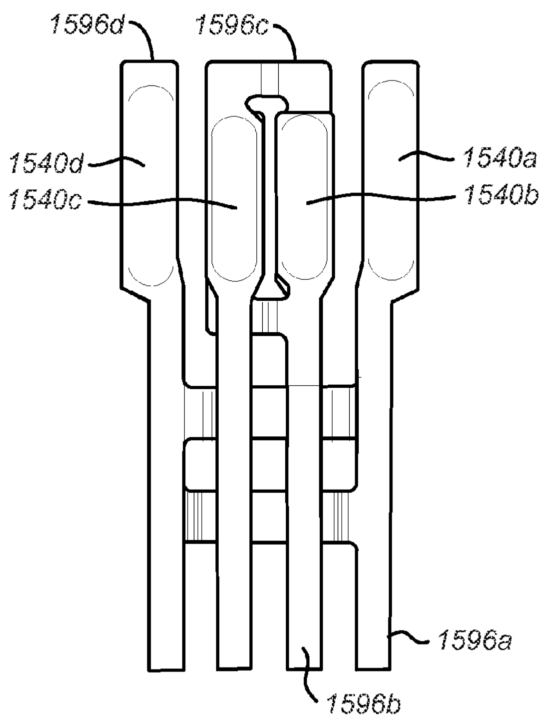


FIG. 15F

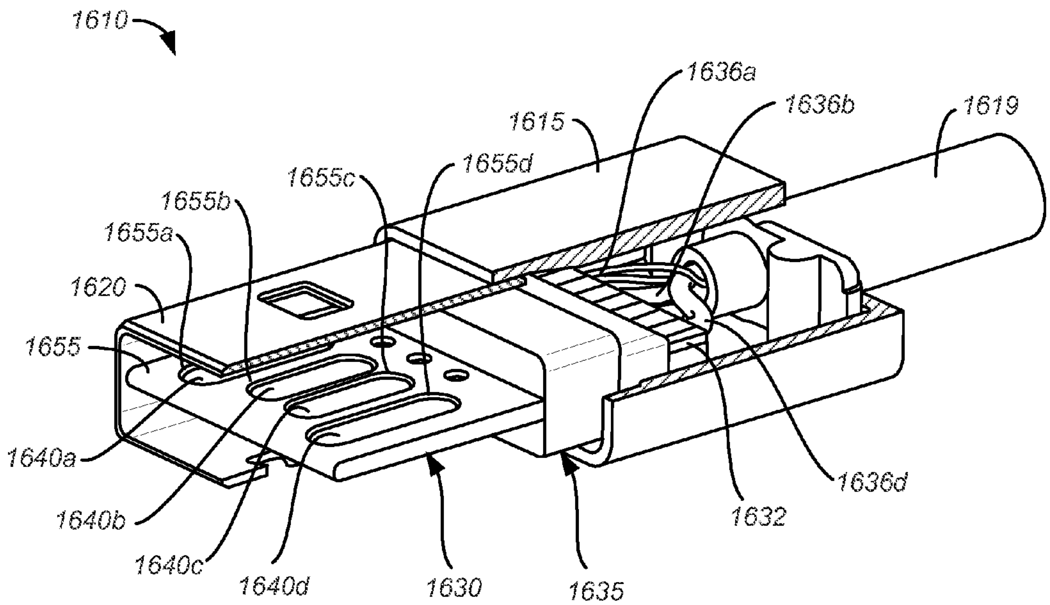


FIG. 16A

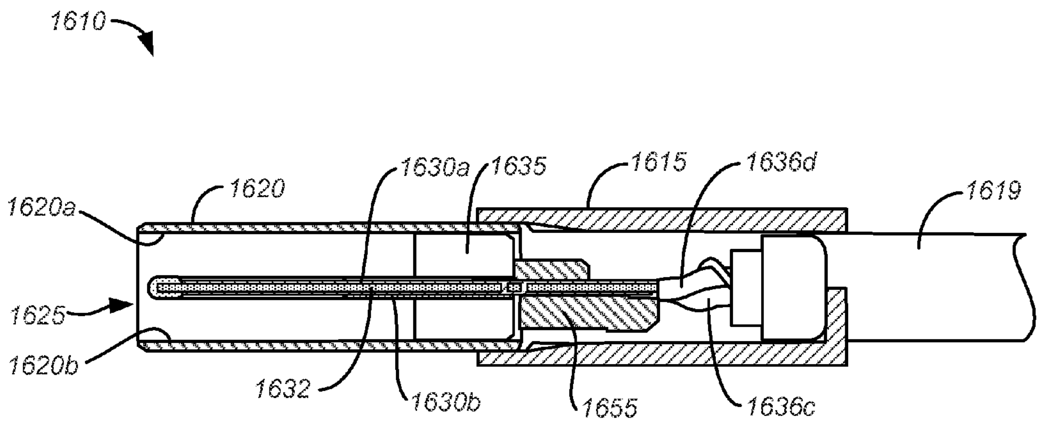
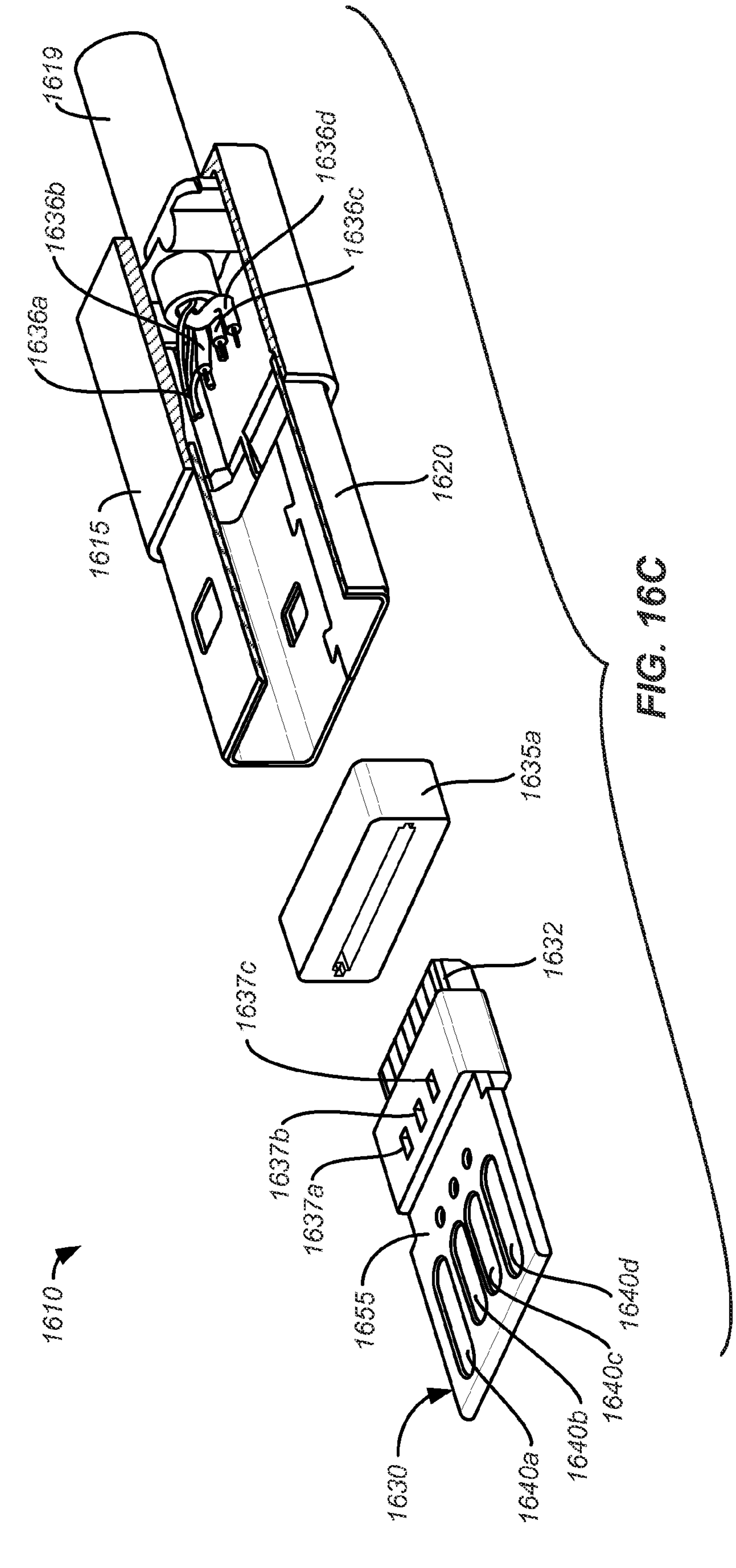


FIG. 16B


1610
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1636d
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1636c
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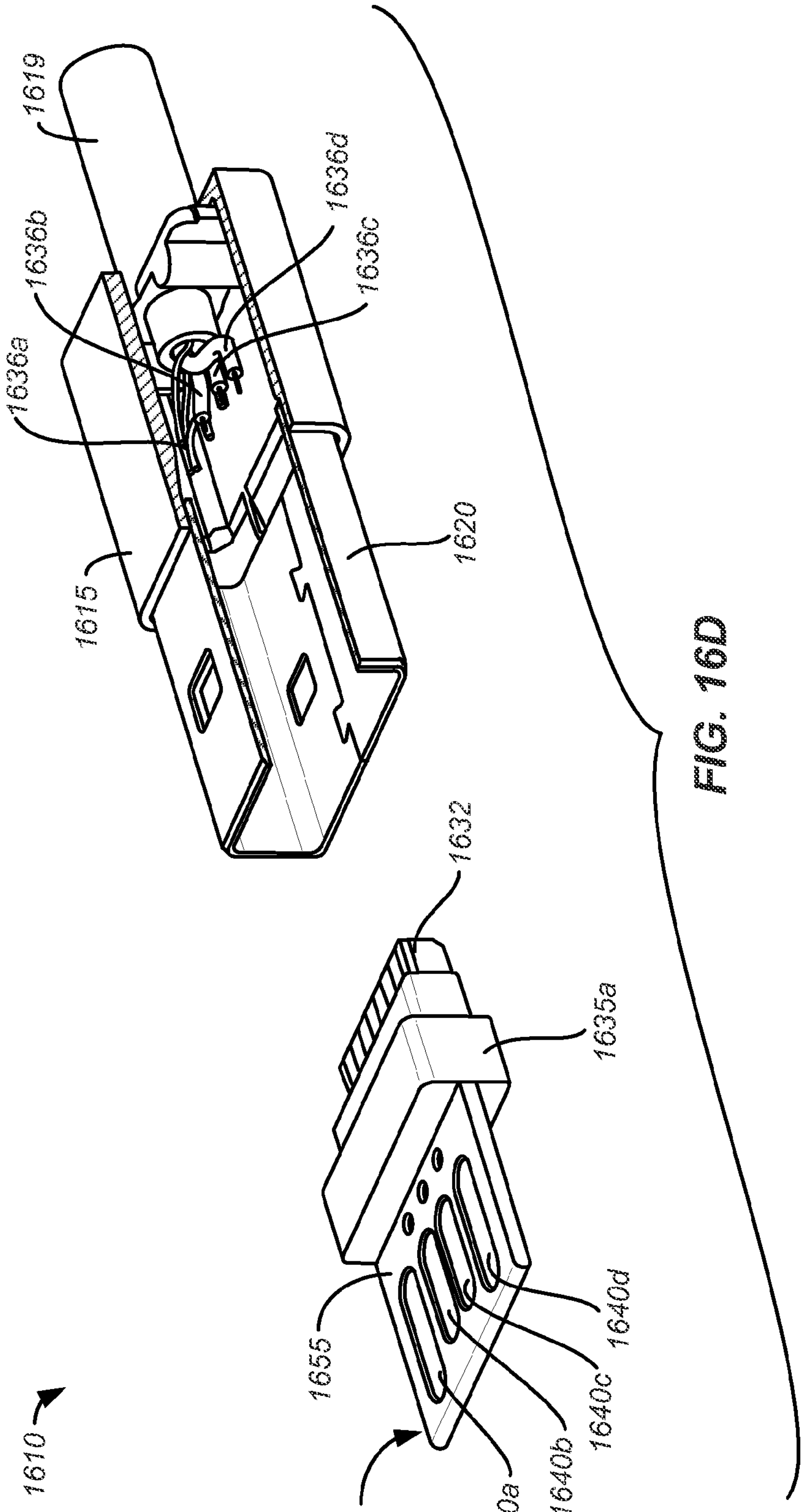
1640a
1640b
1640c
1640d

FIG. 16C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1640d
1640c
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1640a
1630

FIG. 16D

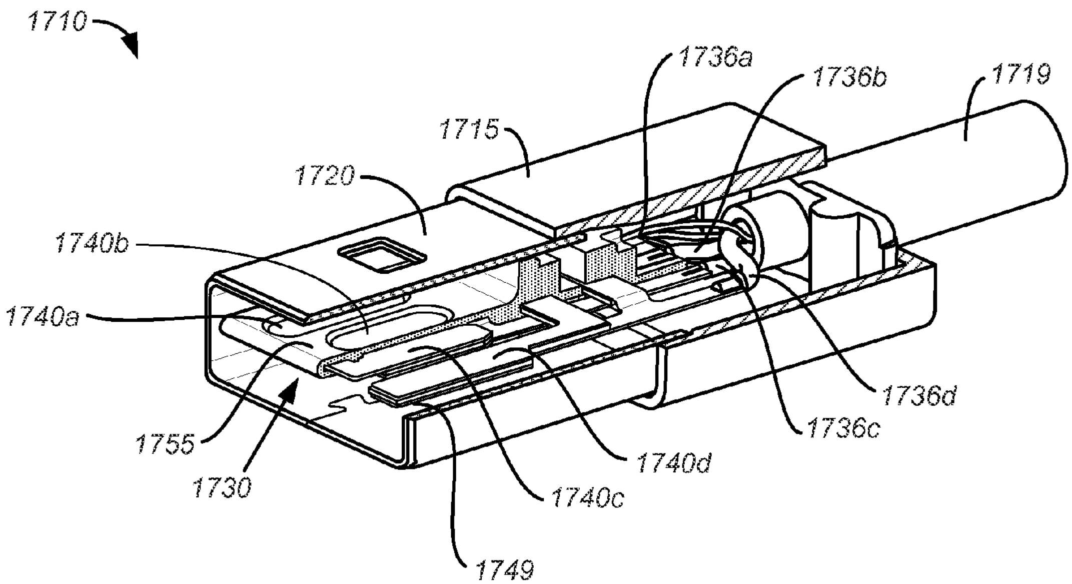


FIG. 17A

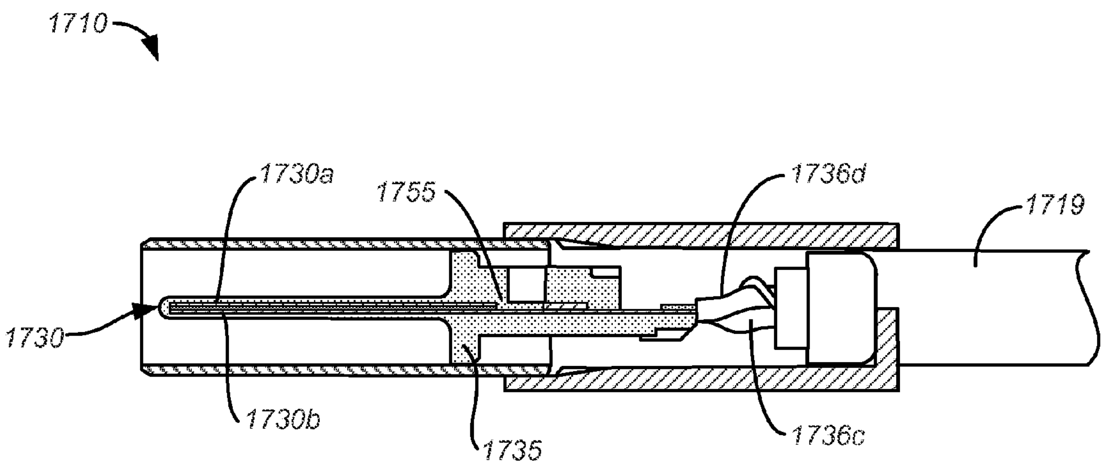
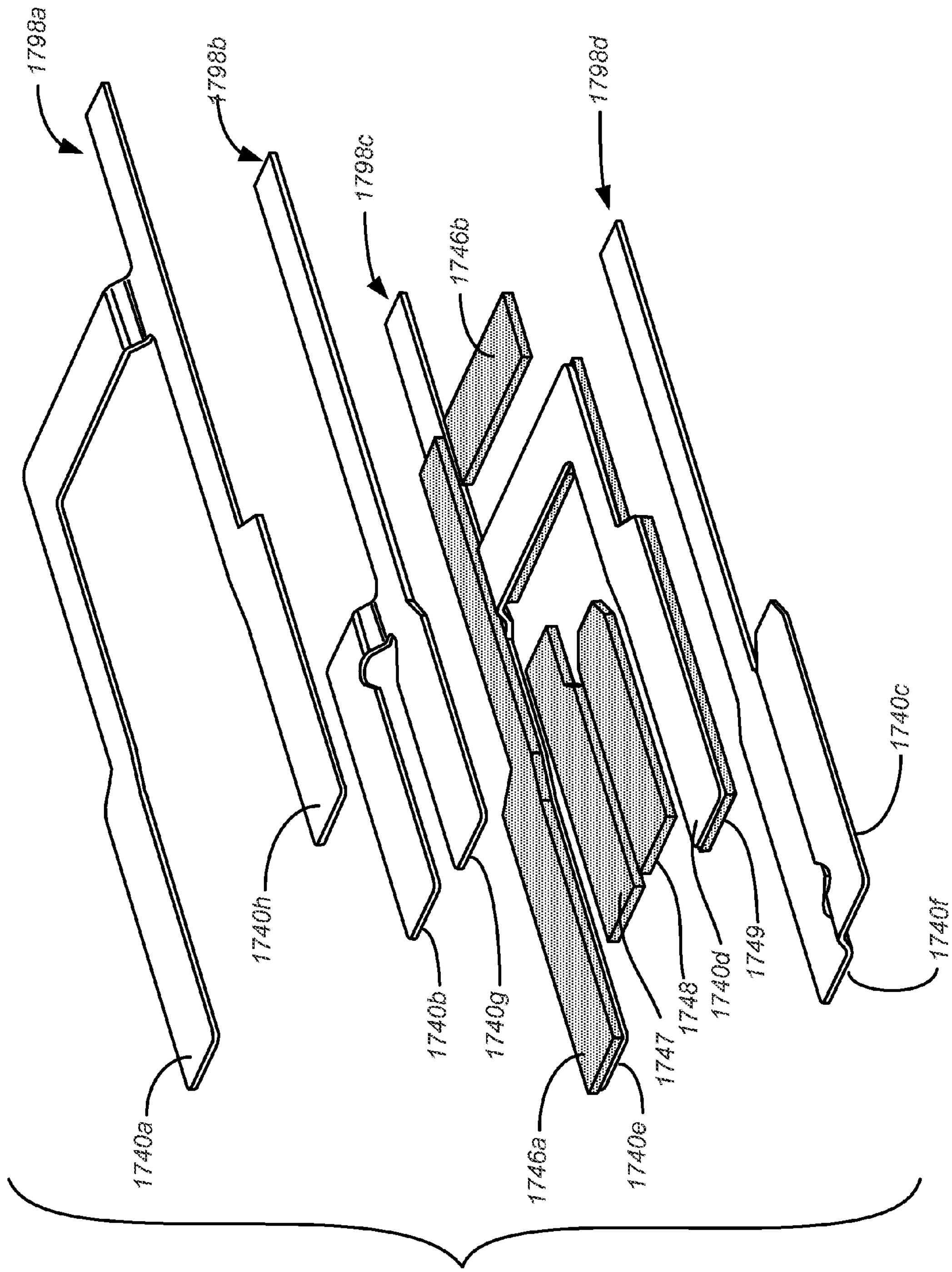


FIG. 17B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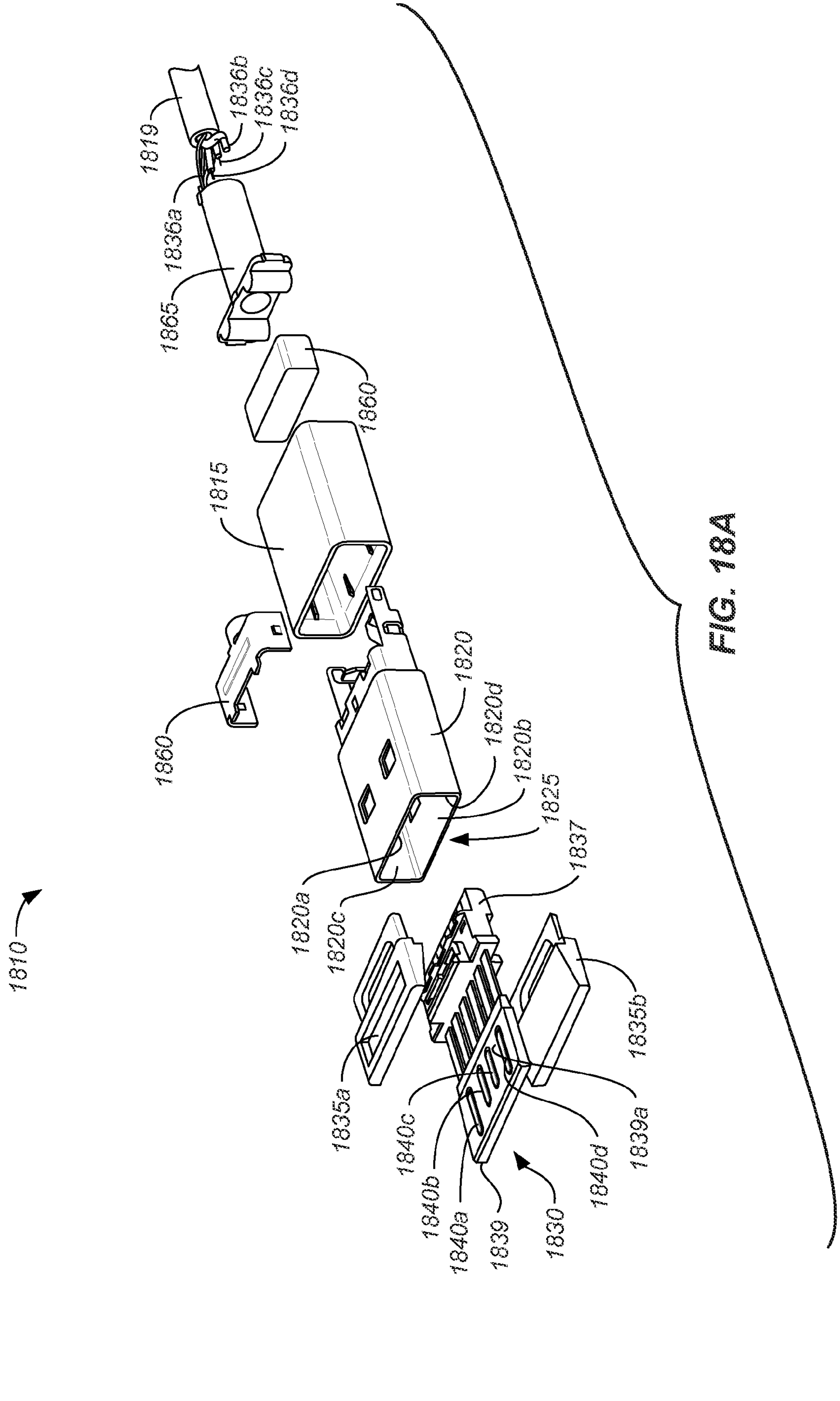
1746a
1740e

FIG. 17C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1840d
1839a

FIG. 18A

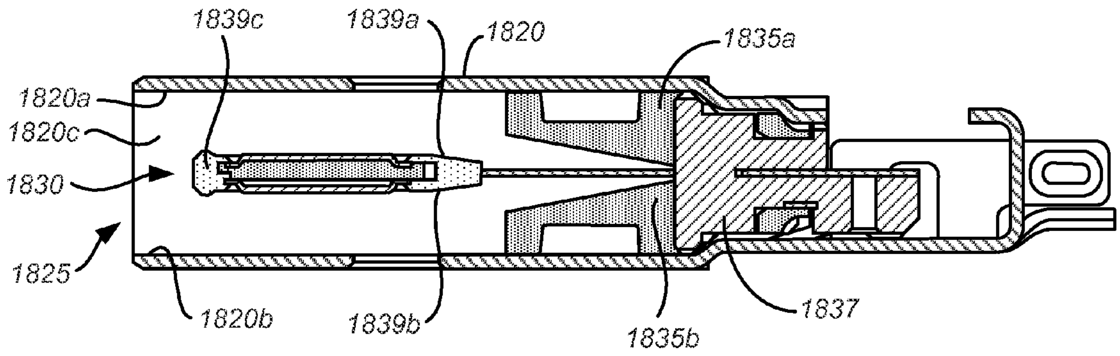

FIG. 18B

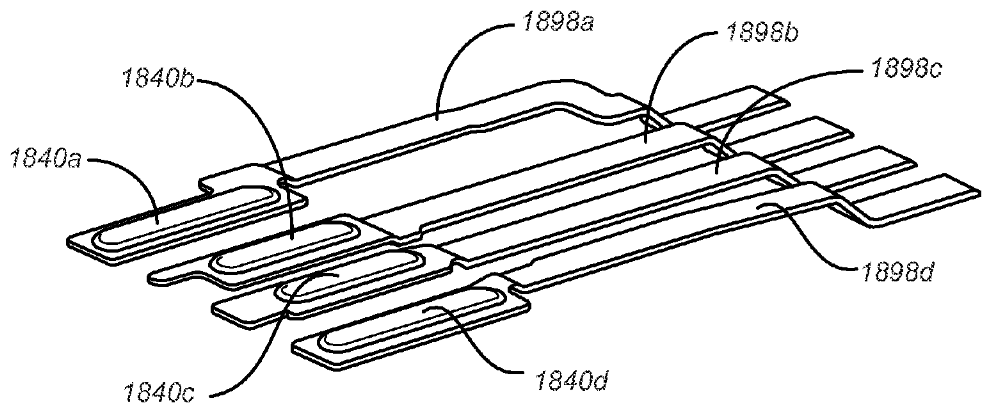

FIG. 18C

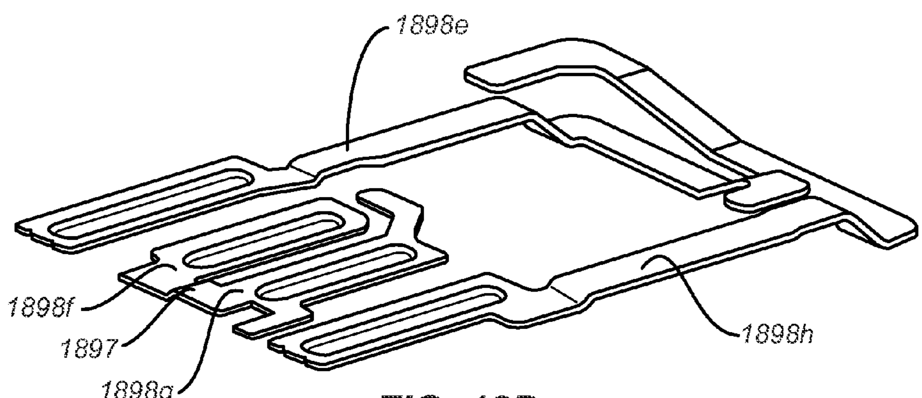

FIG. 18D

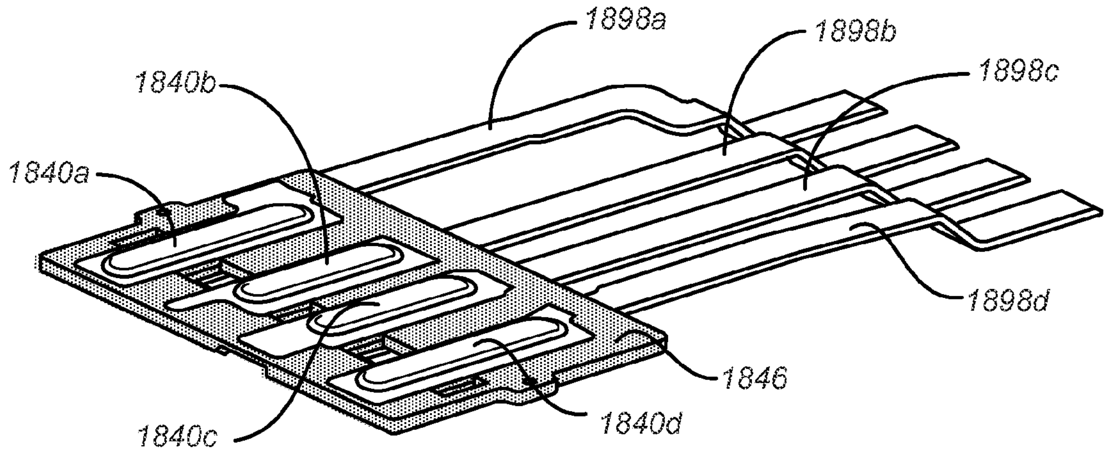

FIG. 18E

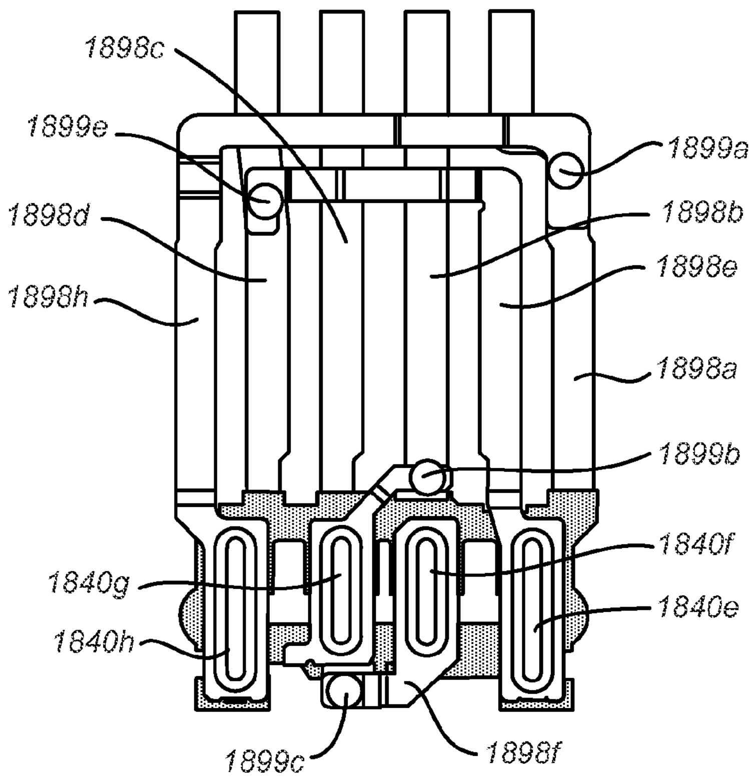

FIG. 18F

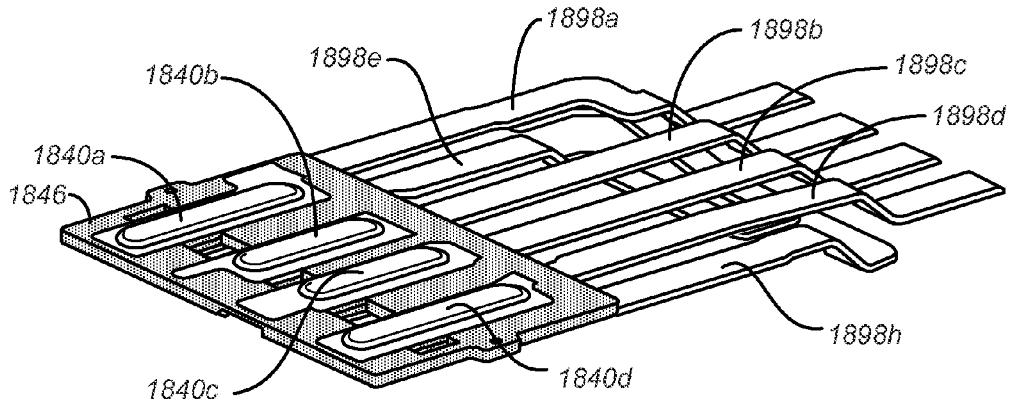

FIG. 18G

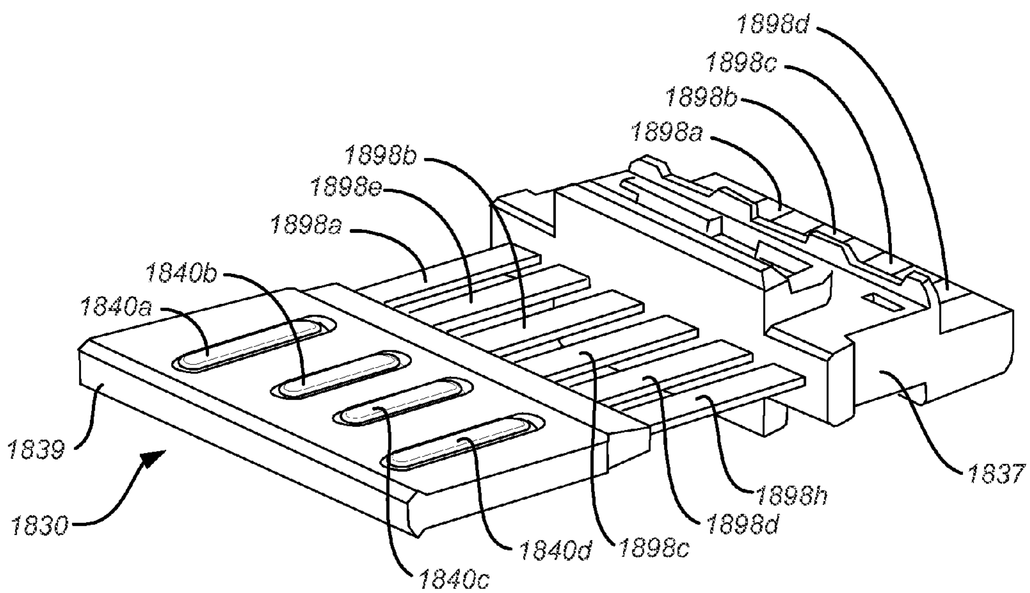

FIG. 18H

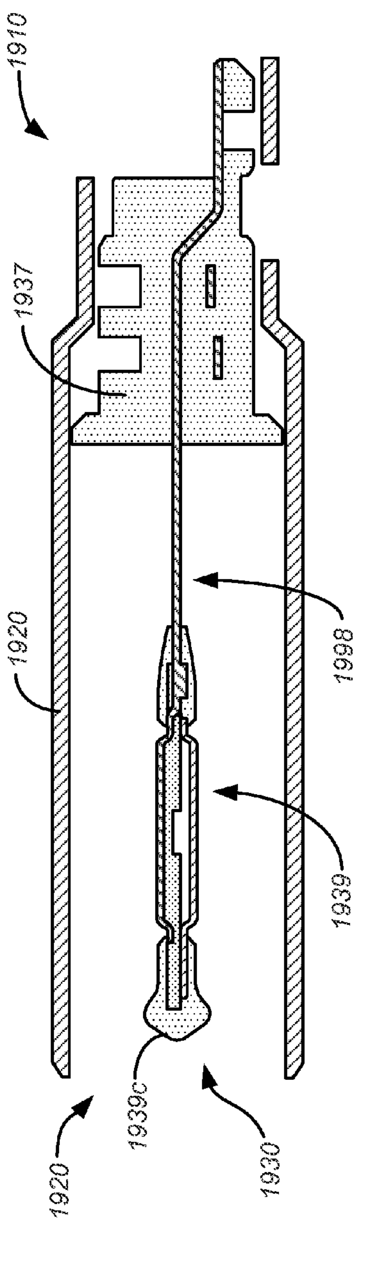

FIG. 19A

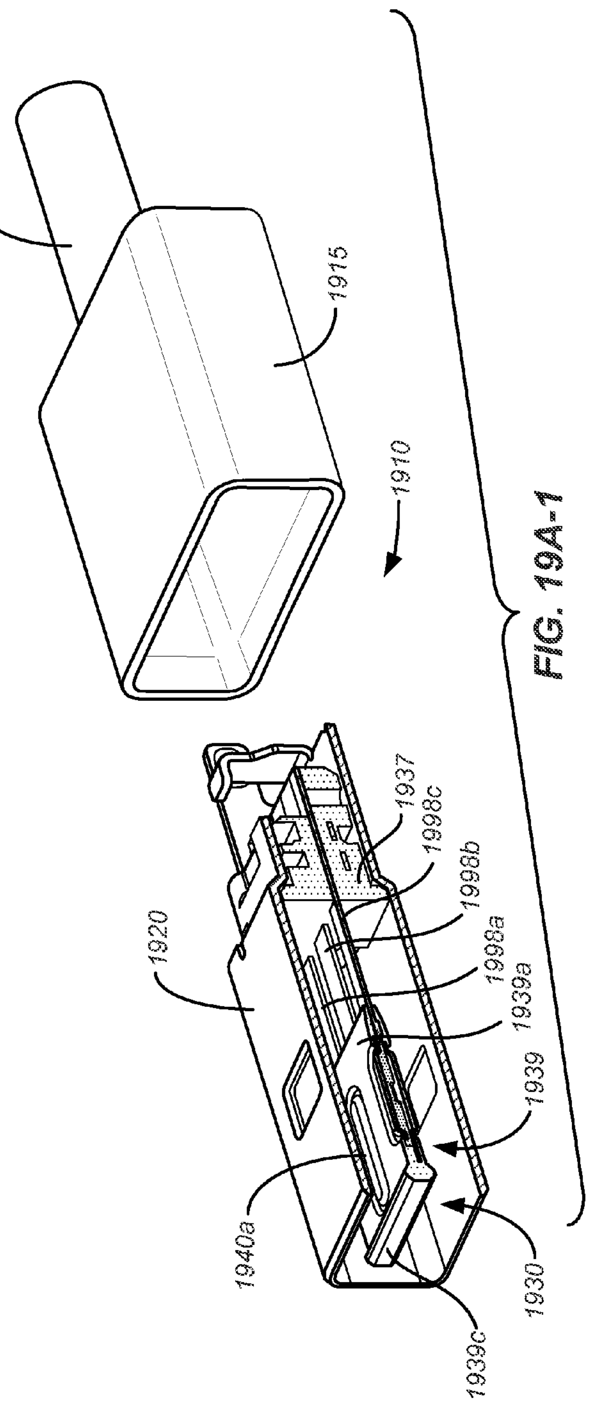

FIG. 19A-1

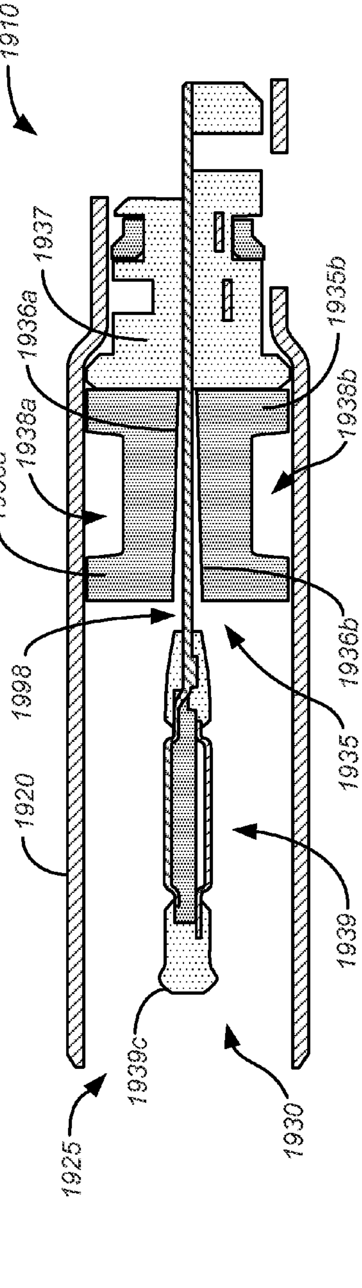

FIG. 19B

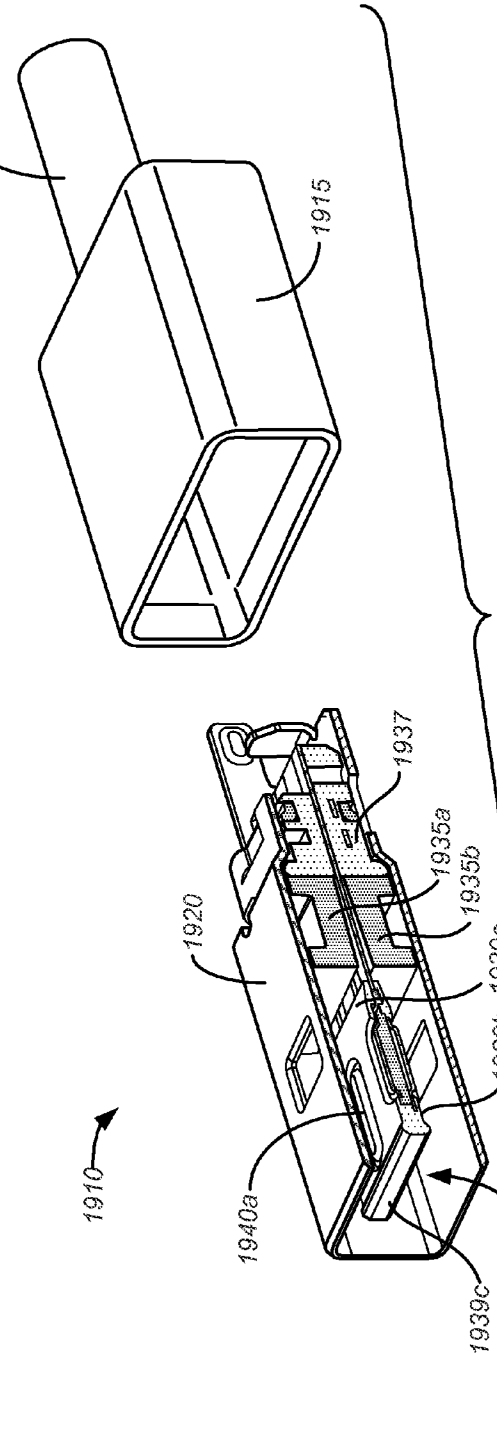

FIG. 19B-1

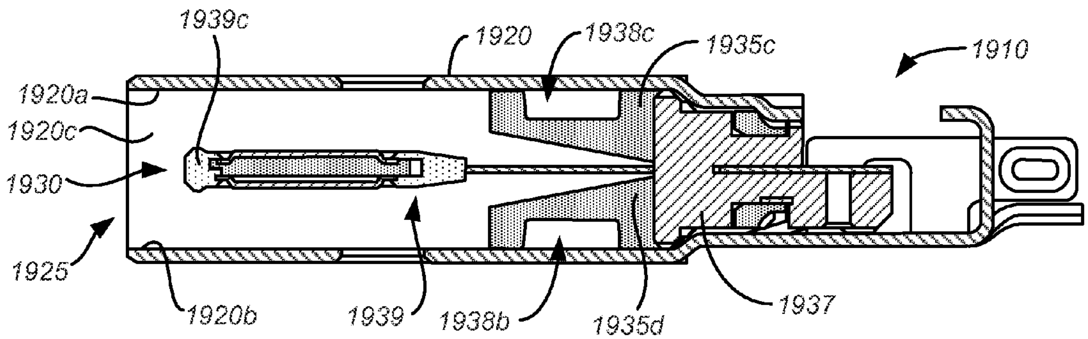

FIG. 19C

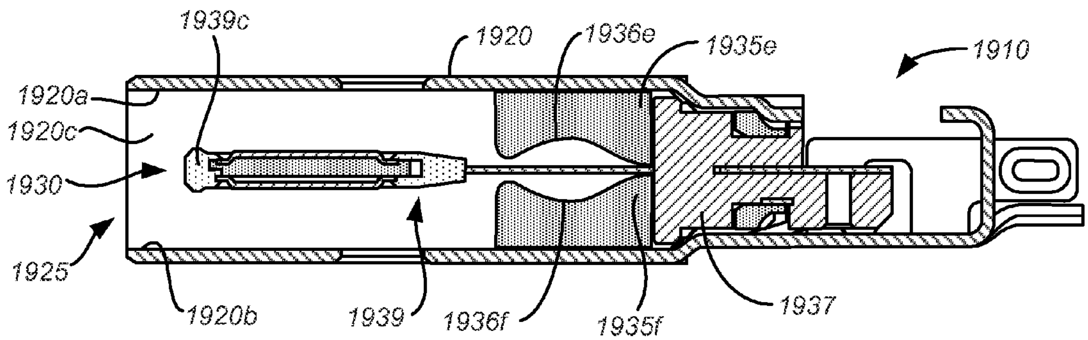

FIG. 19D

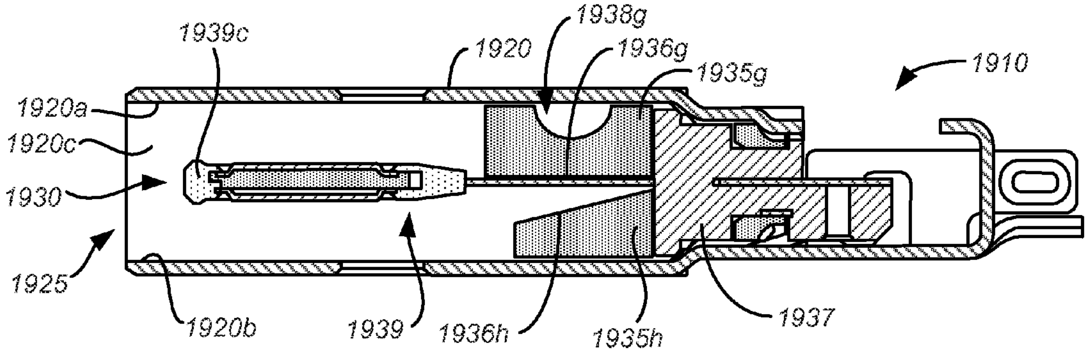

FIG. 19E

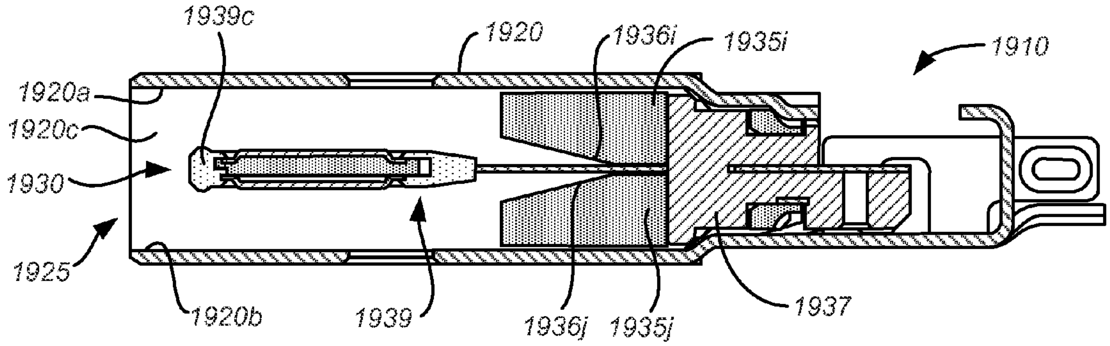

FIG. 19F

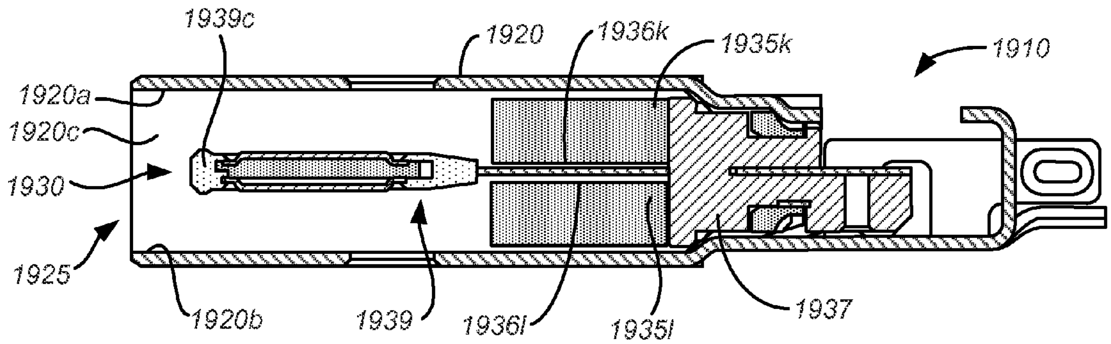

FIG. 19G

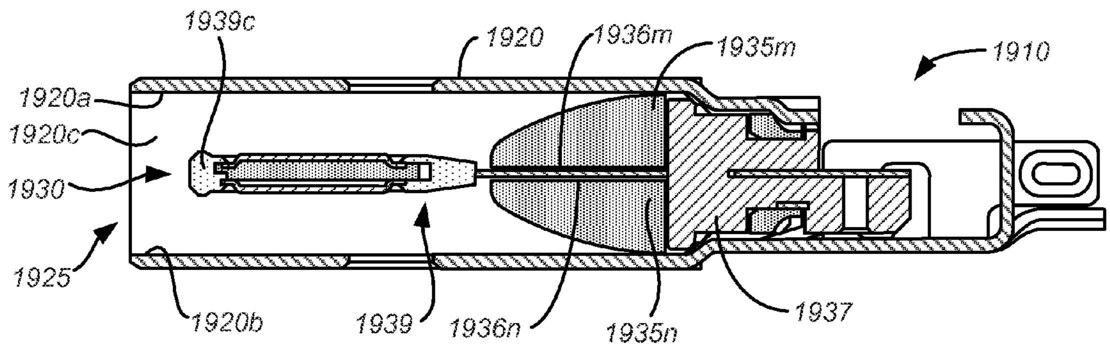

FIG. 19H

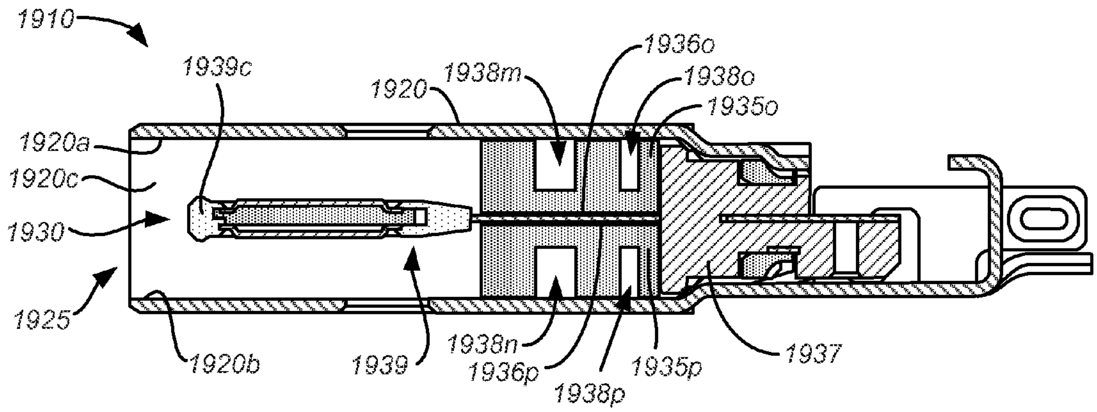

FIG. 19I

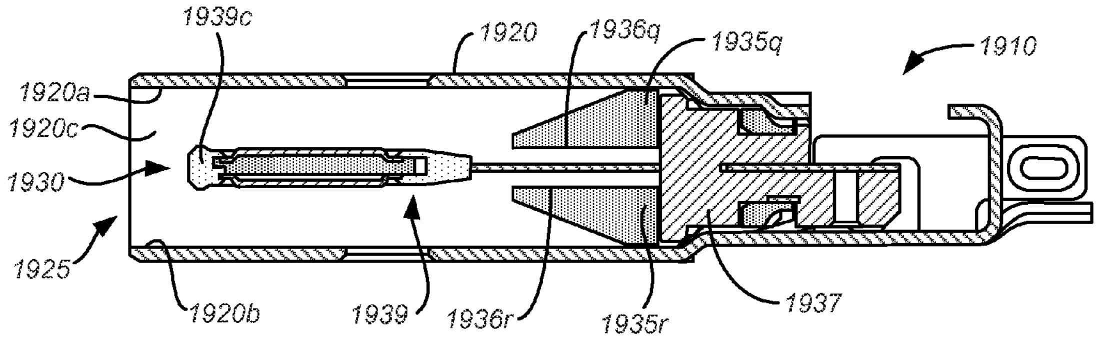

FIG. 19J

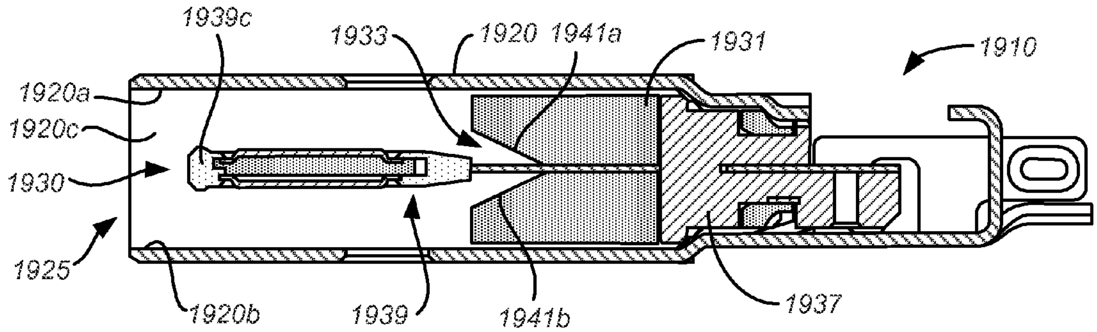

FIG. 19K

REVERSIBLE USB CONNECTOR WITH COMPLIANT MEMBER TO SPREAD STRESS AND INCREASE CONTACT NORMAL FORCE

CROSS-REFERENCE TO RELATED APPLICATION

[0001] This application claims the benefit of commonly owned U.S. Provisional Patent Application No. 61/765,602 filed Feb. 15, 2013. Additionally, commonly owned U.S. Provisional Patent Application No. 61/765,602 filed Feb. 15, 2013 and U.S. Provisional Patent Application No. 61/756,413, filed Jan. 24, 2013 are hereby incorporated by reference herein in their entirety for all purposes.

FIELD

[0002] The described embodiments relate generally to input/output electrical connectors. More particularly, the present embodiments relate to data connectors

BACKGROUND OF THE INVENTION

[0003] Many electronic devices include data connectors, such as Universal Serial Bus (USB) connectors, that receive and provide power and data. These electrical connectors are typically female receptacle connectors and are designed to receive a male plug connector. The plug connector may be on the end of a cable and plug into an electronic device, thereby forming one or more conductive paths for signals and power.

[0004] USB connectors, like many other standard data connectors, require that male plug connectors be mated with corresponding female receptacle connectors in a single, specific orientation in order for the USB connection to function properly. Such connectors can be referred to as polarized connectors. Accordingly, USB receptacle connectors include an insertion opening with features that prevents USB plug connectors from being inserted into the USB receptacle connector in the wrong way. That is, it can only be inserted one way because it is a polarized connector. Many other commonly used data connectors, including mini USB connectors, FireWire connectors, as well as many other proprietary connectors are also polarized connectors.

[0005] It is sometimes difficult for users to determine when a polarized plug connector, such as a USB plug connector, is oriented in the correct orientation for insertion into a corresponding receptacle connector. Some USB plug and/or receptacle connectors may include markings to indicate their orientation such that users know how to properly insert a plug connector into corresponding receptacle connectors. However, these marking are not always utilized by users and/or can be confusing to some users. In some cases, these markings are not helpful because the markings cannot be easily viewed due to the location of the receptacle connector, lighting conditions, or other reasons. Even when visible, these markings may still be unhelpful because not all manufacturers apply these markings in a consistent fashion. Consequently, users may incorrectly insert a plug connector into a corresponding receptacle connector, which may potentially result in damage to the connectors and/or user frustration.

[0006] Accordingly, it is desirable to provide connectors, e.g., USB connectors, that do not suffer from all or some of these deficiencies.

BRIEF DESCRIPTION OF THE DRAWINGS

[0007] To better understand the nature and advantages of the present invention, reference should be made to the following description and the accompanying figures. It is to be understood, however, that each of the figures is provided for the purpose of illustration only and is not intended as a definition of the limits of the scope of the present invention. Also, as a general rule, and unless it is evident to the contrary from the description, where elements in different figures use identical reference numbers, the elements are generally either identical or at least similar in function or purpose.

[0008] FIGS. **1**A and **1**B are partial cross sectional perspective and cross sectional views, respectively, of a USB plug connector according to one embodiment of the present invention;

[0009] FIGS. **2**A and **2**B are simplified perspective and cross sectional views, respectively, of a USB plug connector in various stages of manufacture according to one embodiment of the present invention;

[0010] FIGS. **3**A and **3**B are simplified perspective and cross sectional views, respectively, of a USB plug connector in various stages of manufacture according to another embodiment of the present invention;

[0011] FIGS. **4**A and **4**B are simplified perspective and cross sectional views, respectively, of a USB plug connector in various stages of manufacture according to yet another embodiment of the present invention;

[0012] FIGS. **5**A and **5**B are simplified perspective and cross sectional views, respectively, of a USB plug connector in various stages of manufacture according to still another embodiment of the present invention;

[0013] FIGS. **6**A and **6**B are simplified perspective and cross sectional views, respectively, of a USB plug connector in various stages of manufacture according to still another embodiment of the present invention;

[0014] FIGS. **7**A and **7**B are simplified perspective and cross sectional views, respectively, of a USB plug connector in various stages of manufacture according to still another embodiment of the present invention;

[0015] FIGS. **8**A and **8**B are simplified perspective and cross sectional views, respectively, of a USB plug connector in various stages of manufacture according to still another embodiment of the present invention;

[0016] FIGS. **9**A and **9**B are simplified perspective and cross sectional views, respectively, of a USB plug connector in various stages of manufacture according to still another embodiment of the present invention;

[0017] FIGS. **10**A and **10**B are simplified perspective and cross sectional views, respectively, of a USB plug connector in various stages of manufacture according to still another embodiment of the present invention;

[0018] FIGS. **11**A and **11**B are simplified perspective and cross sectional views, respectively, of a USB plug connector according to one embodiment of the present invention;

[0019] FIGS. **12**A and **12**B are partial cross sectional perspective and cross sectional views, respectively, of a USB plug connector according to one embodiment of the present invention;

[0020] FIGS. **13**A and **13**B are partial cross sectional perspective and cross sectional views, respectively, of a USB plug connector according to one embodiment of the present invention;

[0021] FIGS. **14**A and **14**B are partial cross sectional perspective and cross sectional views, respectively, of a USB plug connector according to one embodiment of the present invention;

[0022] FIGS. **15**A and **15**B are partially transparent simplified perspective and partially transparent front views, respectively, of a USB plug connector according to one particular embodiment of the connector of FIGS. **11**A-**11**B;

[0023] FIGS. **15**C-**15**F are top views of contact frames, in their positions with respect to each other when embedded in a tab;

[0024] FIGS. **16**A and **16**B are partial cross sectional perspective and cross sectional side views, respectively, of a USB plug connector according to one embodiment of the present invention;

[0025] FIGS. **16**C and **16**D are partial cross sectional, exploded perspective views of embodiments of structural support for assembling with and overmolding on tongue of plug connector, respectively, according to manufacturing methods of the present invention;

[0026] FIGS. **17**A and **17**B are partial cross sectional perspective and cross sectional side views, respectively, of a USB plug connector according to one embodiment of the present invention;

[0027] FIG. **17**C is an exploded view of contact frames of the plug connector of FIGS. **17**A and **17**B;

[0028] FIGS. **18**A and **18**B are exploded and cross sectional side views, respectively, of a USB plug connector according to an embodiment of the present invention; and

[0029] FIGS. **18**C-**18**H illustrate contact frames of the connector of FIGS. **18**A and **18**B in various stages of assembly according to an embodiment of the present invention;

[0030] FIGS. **19**A and **19**A-**1** are cross sectional side and partially exploded, partially cross sectional perspective views, respectively, of a USB plug connector with its support structure removed according to one embodiment of the present invention;

[0031] FIGS. **19**B and **19**B-**1** are cross sectional side and partially exploded, partial cross sectional perspective views, respectively, of the USB plug connector of FIGS. **19**A and **19**A-**1** with a support structure according to one embodiment of the present invention;

[0032] FIGS. **19**C-**19**F are cross sectional side views of the USB plug connector of FIGS. **19**A and **19**A-**1** with a support structure according to embodiments of the present invention;

[0033] FIGS. **19**G-**19**J are cross sectional side views of the USB plug connector of FIGS. **19**A and **19**A-**1** with a support structure according to embodiments of the present invention;

[0034] FIG. **19**K is a cross sectional side vies of the USB plug connector of FIGS. **19**A and **19**A-**1** with a one-piece support structure according to an embodiment of the present invention.

DETAILED DESCRIPTION OF THE INVENTION

[0035] The present invention will now be described in detail with reference to certain embodiments thereof as illustrated in the accompanying drawings. In the following description, numerous specific details are set forth in order to provide a thorough understanding of the present invention. It will be apparent, however, to one skilled in the art, that the present invention may be practiced without some or all of these specific details. In other instances, well known details have not been described in detail in order not to unnecessarily obscure the present invention.

[0036] Embodiments can provide reversible or dual orientation USB plug connectors for mating with standard USB receptacle connectors, e.g., a standard Type A USB receptacle connector. Accordingly, the present invention may be compatible with any current or future electronic device that includes a standard USB receptacle connector. USB plug connectors according to the present invention can have a 180 degree symmetrical, dual or double orientation design which enables the plug connector to be inserted into a corresponding receptacle connector in either of two intuitive orientations. To allow for the orientation agnostic feature of such a plug connector, the portion of the plug connector having contacts may not be polarized. Instead, in some embodiments, the portion of the plug connector having contacts may be movable such that its contacts can mate with corresponding contacts of the receptacle connector in either of two intuitive orientations. Thus, embodiments of the present invention may reduce the potential for USB connector damage and user frustration during the insertion of the USB plug connector into a corresponding USB receptacle connector of an electronic device.

[0037] Methods for manufacturing plug connectors according to the present invention are also described below in relation to a specific plug connector embodiment. However, these methods of manufacture may apply to other plug connector embodiments described herein.

[0038] In order to better appreciate and understand the present invention, reference is first made to FIGS. **1**A and **1**B, which are partial cross sectional perspective and cross sectional views, respectively, of a USB plug connector **10** according to one embodiment of the present invention. Connector **10** includes a body **15** and a shell **20** extending longitudinally away from body **15** in a direction parallel to the length of connector **10**. Shell **20** includes an opening **25** that communicates with a cavity defined by first, second, left and right inner surfaces **20***a*-**20***d* of shell **20**, a tongue **30**, and first and second surfaces **35***a*, **35***b* of support structure **35**. As shown in FIGS. **1**A and **1**B, tongue **30** may be centrally located between first and second inner surfaces **20***a*, **20***b* and extend parallel to the length of connector **10**. Contacts **40***a*-**40***d* are disposed on a first major surface **30***a* and four additional contacts (only contact **40***e* is shown in FIG. **1**B) are disposed on second major surface **30***b*. As also shown in FIGS. **1**A and **1**B, tongue **30** may include a bullnose tip **30***c* for reasons that will be explained below.

[0039] As shown in FIGS. **1**A and **1**B, connector **10** can have a 180 degree symmetrical, double orientation design which enables the connector to be inserted into a corresponding receptacle connector in both a first orientation where surface **30***a* is facing up or a second orientation where surface **30***a* is rotated 180 degrees and facing down. To allow for the orientation agnostic feature of connector **10**, tongue **30** is not polarized. That is, tongue **30** does not include a physical key that is configured to mate with a matching key in a corresponding receptacle connector designed to ensure that mating between the two connectors occurs only in a single orientation. Instead, if tongue **30** is divided into top and bottom halves along a horizontal plane that bisects the center of tongue **30** along its width, the physical shape of the upper half of tongue **30** is substantially the same as the physical shape of the lower half. Similarly, if tongue **30** is divided into left and right halves along a vertical plane that bisects the center of tab along its length, the physical shape of the left half of tongue **30** is substantially the same as the shape of the right half. Additionally, contacts **40***a*-**40***d* and four additional contacts

disposed on second major surface **30***b* can be positioned so that the contacts on first and second major surfaces **30***a*, **30***b* are arranged in a symmetric manner. Accordingly, the contacts disposed on first surface **30***a* (contacts **40***a*-**40***d*) mate with contacts of the corresponding receptacle connector in one orientation and contacts disposed on second surface **30***b* mate with contacts of the corresponding receptacle connector in the other orientation.

[0040] Tongue **30** may be a printed circuit board (PCB) or may be made from one or more of a variety of dielectric materials including flexible, wear resistant materials such as liquid crystal polymers (LCP), polyoxymethylene (POM), Nylon and others. Structural support **35** may also be made from a variety of dielectric materials, including flexible polymers. The materials used to form tongue **30** and/or structural support **35** may be chosen such that tongue **30** deflects either toward first or second inner surfaces **20***a*, **20***b* of shell **20** when connector **10** is inserted into a corresponding receptacle connector. This deflection may occur as bullnose tip **30***c* comes into contact with internal features of a corresponding receptacle connector and leads tongue **30** to the appropriate region within a corresponding receptacle connector, allowing contacts disposed on either surface **30***a* or **30***b* of the plug connector **10** to mate with contacts on the corresponding receptacle connector.

[0041] As mentioned earlier, tongue **30** may be centrally located within opening **25** of shell **20**. For example, tongue **30** may be positioned within opening **25** such that its distance from first and second inner surfaces **20***a*, **20***b* causes connector **10** to always deflect, with the assistance of bullnose tip **30***c*, toward the appropriate region within a corresponding receptacle connector regardless of whether plug connector **10** is in the first or second orientation, as described above. Portions of tongue **30** may deform and deflect in different manners in order to put its contact in position to mate with the contacts of the corresponding receptacle connector. The thickness of tongue **30** may be varied depending on the material of tongue **30** such that tongue **30** may elastically deform as necessary for mating events.

[0042] Body **15** is generally the portion of connector **10** that a user will hold onto when inserting or removing connector **10** from a corresponding receptacle connector. Body **15** can be made out of a variety of materials and in some embodiments is made from a dielectric material, such as a thermoplastic polymer formed in an injection molding process. While not shown in FIG. **1**A or **1**B, a cable and a portion of shell **20** may extend within and be enclosed by body **15**. Also, electrical contact to the contacts of surfaces **30***a*, **30***b* can be made with individual wires in a cable within body **15**. In one embodiment, a cable includes a plurality of individual insulated wires for connecting to contacts of surfaces **30***a*, **30***b* that are soldered to bonding pads on a PCB housed within body **15** or on tongue **30** when tongue **30** is a PCB. The bonding pads on the PCB may be electrically coupled to corresponding individual contacts of surfaces **30***a* and **30***b*. In some embodiments, contacts of one of surfaces **30***a* and **30***b* may be shorted through tongue **30** or a PCB to corresponding contacts on the other of surfaces **30***a* and **30***b* and then appropriately routed to the individual wires of a cable within body **15**.

[0043] The contacts of tongue **30** can be made from copper, nickel, brass, a metal alloy or any other appropriate conductive material. In some embodiments, contacts can be printed on surfaces **30***a* and **30***b* using techniques similar to those used to print contacts on printed circuit boards. As with standard USB plug connectors, plug connector **10** may include contacts for power, ground and a pair of differential data signals (e.g., data transmit). For example, contact **40***a* may be a ground pin, contact **40***b* may be a Data+pin, contact **40***c* may be a Data−pin and contact **40***d* may be a power pin (VBUS). As mentioned earlier, the four additional contacts disposed on second major surface **30***b* can be positioned so that the contacts on first and second major surfaces **30***a*, **30***b* are arranged in a symmetric manner. Accordingly, pins may be designated for the contacts on the first and second major surfaces **30***a*, **30***b* such that the pinout may be the same for both surfaces **30***a*, **30***b*. For example, a contact **40***e* on surface **30***b* corresponding to (aligned with in the length and width directions of connector **10**) contact **40***a*, may also be a power pin (VBUS), a contact on surface **30***b* corresponding to contact **40***b* may be a Data−pin, a contact on surface **30***b* corresponding to contact **40***c* may be a Data+pin and a contact on surface **30***b* corresponding to contact **40***d* may be a ground pin. In this manner, regardless of the orientation of plug connector **10**, the same pinout may be mated with a corresponding receptacle connector during a mating event.

[0044] In some embodiments, a sensing circuit in the connector **10** can detect which of surfaces **30***a* and **30***b* of tongue **30** will mate with the contacts of the corresponding receptacle connector and switch internal connections to the contacts in connector **10** as appropriate. For example, a software switch can be used to switch the contacts of connector **10** for the pair of differential data signals depending on the insertion orientation while a hardware switch can be used to switch the ground and power contacts. In other embodiments, both switches can be implemented in software or both switches can be implemented in hardware. In another example, the orientation of the connector can instead be detected by circuitry of connector **10** based on signals received over the contacts. As one example, upon inserting connector **10** within a receptacle connector of a host device, connector **10** may send an Acknowledgment signal to the serial control chip over one of the contacts of connector **10** designated for the specific contact and waits for a Response signal from the host device. If a Response signal is received, the contacts are aligned properly and data and power can be transferred between the connectors. If no response is received, connector **10** flips the signals to correspond to the second possible orientation (i.e., flips the signals 180 degrees) and repeats the Acknowledgement/Response signal routine. As another example, the host device may send the Acknowledgement signal and connector **10** may send the Response signal.

[0045] It may be desirable to provide an effective manufacturing process for plug connectors discussed above as well variations thereof. Accordingly, embodiments of the present invention provide for methods of manufacture of reversible or dual orientation USB plug connectors. For example, inserting molding, assembling, and other methods may be used to manufacture plug connectors according to the present invention. Examples of these methods are illustrated in the following figures.

[0046] FIGS. **2**A and **2**B are simplified perspective and cross sectional views, respectively, of a USB plug connector **110** in various stages of manufacture according to one embodiment of the present invention. Plug connector **110** includes a base **115** (only shown in FIG. **2**B) that may be attached over metallic shield **117** and cable **119**. A shell **120** (only shown in FIG. **2**B) may be assembled with base **115** and extend longitudinally away from body **15** in a direction par-

allel to the length of connector **110**. Shell **120** includes an opening **125** that communicates with a cavity defined in part by tongue **130** and support structure **135** from which tongue **130** extends. As shown in FIGS. **2**A and **2**B, tongue **130** may be assembled with support structure **135** within shell **120** such that tongue **130** extends parallel to the length of connector **110**. Contacts **140***a*-**140***d* may be soldered on a first major surface **130***a* and four additional contacts (only contact **140***e* is shown in FIG. **2**B) may be soldered on a second major surface **130***b*. Support structure **135** may also be overmolded in position to support and possibly provide increased deflection flexibility to tongue **130**. In this embodiment, tongue **130** may be a PCB that deflects when connector **110** is mated with a corresponding plug connector.

[0047] In some embodiments, tongue **130** may be overmolded with a resilient polymer, e.g., LCP or POM, before or after it is assembled with support structure **135**. In this embodiment, the contacts of plug connector **110** may be copper contacts that are thick enough to remain flush with the exterior surface of tongue **130** after tongue **130** has been overmolded with a resilient polymer.

[0048] The methods and structure described above in relation to FIGS. **2**A and **2**B may be varied in other embodiments. Examples of these variations are included in the following figures.

[0049] FIGS. **3**A and **3**B are simplified perspective and cross sectional views, respectively, of a USB plug connector **210** in various stages of manufacture according to another embodiment of the present invention. USB connector **210** is similar to USB connector **110** described above, except that an additional step of routing has been performed on tip **230***c* of tongue **230** such that tip **230** is bullnose shaped for reasons already discussed above.

[0050] FIGS. **4**A and **4**B are simplified perspective and cross sectional views, respectively, of a USB plug connector **310** in various stages of manufacture according to yet another embodiment of the present invention. Connector **310** is similar to embodiments discussed above, e.g., plug connectors **110** and **210**. However, although tongue **330** includes a PCB **332** like the other embodiments described above, tongue **330** also includes a sleeve **334** that may be assembled over PCB **332**. As show in FIG. **4**A, sleeve **334** may include openings **334***a*-**334***d* and additional openings not shown such that all contacts of connector **310** (e.g., contacts **340***a*-**340***d*) remain exposed and accessible by contacts of a corresponding USB receptacle connector.

[0051] FIGS. **5**A and **5**B are simplified perspective and cross sectional views, respectively, of a USB plug connector **410** in various stages of manufacture according to still another embodiment of the present invention. Connector **410** is also similar to embodiments discussed above, e.g., plug connectors **110** and **210**. However, although tongue **430** includes a PCB **432** like the other embodiments described above, tongue **430** also includes a sticker or label **450** that is adhered to PCB **432**. As shown in FIG. **5**A, label **450** may include openings **450***a*-**450***d* and additional openings not shown such that all contacts of connector **410** (e.g., contacts **440***a*-**440***d*) remain exposed and accessible by contacts of a corresponding USB receptacle connector. Label **450** may provide cosmetic benefits in addition to insulating the contacts of plug connector **410**.

[0052] FIGS. **6**A and **6**B are simplified perspective and cross sectional views, respectively, of a USB plug connector **510** in various stages of manufacture according to still another embodiment of the present invention. Connector **510** is also similar to embodiments discussed above, e.g., plug connectors **110** and **210**. However, although tongue **530** may include a PCB **532** like the other embodiments described above, PCB **532** may be inserted molded to form an overmold **555** surrounding PCB **532**. As shown in FIG. **6**A, overmold **555** may include openings **555***a*-**555***d* and additional openings (not shown) corresponding to all the contacts of connector **510** (e.g., contacts **540***a*-**540***d* as well as the contacts not shown in FIG. **6**A). Accordingly, the contacts of connector **510** may remain exposed and accessible by contacts of a corresponding USB receptacle connector. Overmold **555** may provide a cosmetic benefit to tongue **530**.

[0053] An example of an embodiment that may be similar to plug connector **510** is shown in the following figures.

[0054] FIGS. **16**A and **16**B are partial cross sectional perspective and cross sectional side views, respectively, of a USB plug connector **1610** according to one embodiment of the present invention. Again, connector **1610** may be similar to embodiments discussed above, e.g., plug connector **510**. However, further details are shown and discussed in relation to plug connector **1610**. FIGS. **16**A and **16**B show that connector **1610** may include a body **1615** and a shell **1620** extending longitudinally away from body **1615** in a direction parallel to the length of connector **1610**. Shell **1620** includes an opening **1625** that communicates with a cavity defined by inner surfaces, e.g., first and second inner surfaces **1620***a*, **1620***b* of shell **1620**, a tongue **1630**, and surfaces of support structure **1635**.

[0055] As shown in FIGS. **16**A and **16**B, tongue **1630** may be centrally located between first and second inner surfaces **1620***a*, **1620***b* and extend in a direction parallel to length of connector **1610**. Contacts **1640***a*-**1640***d* are disposed on a first major surface **1630***a* and four additional contacts (not shown) are disposed on second major surface **1630***b*. Tongue **1630** may include a PCB **1632** that is inserted molded to form an overmold **1655** surrounding PCB **1632**. As shown in FIG. **16**A, overmold **1655** may include openings **1655***a*-**1655***d* as well as additional openings (not shown) such that overmold **1655** includes openings corresponding to all the contacts of connector **1610** (e.g., contacts **1640***a*-**1640***d* as well as the four additional contacts not shown). Accordingly, the contacts of connector **1610** may remain exposed and accessible by contacts of a corresponding USB receptacle connector.

[0056] In addition to the cosmetic benefits of overmolds discussed herein concerning other embodiments of the present invention, overmolds, e.g., overmolds **1655**, may also provide rigidity and wear resistance to a PCB, e.g., PCB **1632**. For example, overmold **1655** encloses PCB **1632** and may protect it from wear that occurs during insertion/extraction events, misuse and/or other events where tongue **1630** comes into contact with objects. Thus, overmold **1655** may help to extend the lifetime of connector **1610** as the dielectric materials typically used to make a PCB are not chosen based on their strong wear resistance characteristics. A PCB does not typically have strong rigidity characteristics either. Overmold **1655** may also increase the rigidity of PCB **1632** and tongue **1630** by providing an extra layer of material around tongue **1630**.

[0057] As mentioned previously, some plug connectors of the present invention may include structural support elements made from materials chosen to allow plug connector tongues to deflect. Connector **1610** may also include a structural support element, e.g., a structural support **1635**. Structural sup-

port **1635** may provide flexure to PCB **1632** to reduce stress and fatigue on PCB **1632** and allow tongue **1630**, along with PCB **1632**, to deflect toward and away from first or second inner surfaces **1620***a*, **1620***b* during insertion/extraction events. In order to provide this flexure, structural support **1635** may be made from an elastomer that deforms in response to stress, e.g., a mating event, but holds tongue **1630** centrally located between first and second inner surfaces **1620***a*, **1620***b* otherwise.

[0058] FIGS. **16**A and **16**B also illustrate individual wires, wires **1636***a*-**1636***d*, that extend from the interior of cable **1619**. Wires **1636***a*-**1636***d* may directly terminate on PCB **1632**, e.g., wires **1636***a*-**1636***d* may be soldered to PCB **1632**. Cable **1619** may include insulated wires corresponding to each unique contact of plug connector **1610** and may be connected to the contacts of plug connector **1610** via PCB **1632**. For example, wire **1636***d* may be a grounding wire, wire **1636***c* may be a Data+wire, wire **1636***b* may be a Data− wire, and wires **1636***a* may be power wires.

[0059] Embodiments of the present invention also provide for effective methods of manufacturing plug connector **1610**. Examples of these methods are illustrated in the following figures.

[0060] FIGS. **16**C and **16**D are partial cross sectional, exploded perspective views of embodiments of structural support **1635** for assembling with and overmolding on tongue **1630** of plug connector **1610**, respectively, according to manufacturing methods of the present invention. As shown in FIG. **16**C, tongue **1630** may include one or more interlock recesses, e.g., interlock recesses **1637***a*-**1637***c*. And although not shown in FIG. **16**C, support structure **1635***a* may include protruding interlock features corresponding to interlock recesses **1637***a*-**1637***c*. These interlock features—protrusions and corresponding recesses **1637***a*-**1637***c*—may be configured to align and/or interlock tongue **1630** and support structure **1635***a* when assembled together. A clearance fit, an interference fit or a snap-fit may hold tongue **1630** and support structure **1635***a* in their assembled positions. Other embodiments may use different interlock features, e.g., pins and holes, latch features or adhesives.

[0061] In another embodiment, a support structure may be overmolded over a portion of tongue **1630**. For example, tongue **1630** may be overmolded with a resilient polymer, e.g., LCP or POM, to form a support structure **1635***b*, as shown in FIG. **16**D. In order to increase the bonding strength between tongue **1630** and support structure **1635***b*, the same materials, compatible materials (i.e., materials of similar chemistry) or blends of compatible materials may be used to form both tongue **1630** and support structure **1635***b* such that a chemical bond may be created between the elements. Interlock features may also be used to strengthen the bond between tongue **1630** and support structure **1635***b*. For example, during the overmolding of support structure **1635***b*, molten plastic may flow into recesses **1637***a*-**1637***c* and serve as an interlock between support structure **1635***b* and tongue **1630**.

[0062] In other embodiments, a support structure may also be integrally formed with tongue **1630**, similar to embodiments of plug connectors shown in other FIGS. of the present application.

[0063] The structures and methods shown in FIGS. **16**A-**16**D and discussed in relation thereto may also be implemented in various ways in other embodiments of the present invention.

[0064] As mentioned above, the methods and structures described above in relation to FIGS. **2**A and **2**B may be varied in other embodiments. Additional examples of these variations are included in the following figures.

[0065] FIGS. **7**A and **7**B are simplified perspective and cross sectional views, respectively, of a USB plug connector **610** in various stages of manufacture according to still another embodiment of the present invention. Connector **610** is also similar to embodiments discussed above, e.g., plug connectors **110** and **210**. However, although tongue **630** may include a PCB **632** like the other embodiments described above, tongue **630** also includes a frame **660** that may be assembled over PCB **632**. In addition, a sticker or label **665** may be adhered to frame **660**. As shown in FIG. **5**A, label **665** may include openings **665***a*-**665***d* and additional openings corresponding to all the contacts of connector **610** (e.g., contacts **640***a*-**640***d* as well as the contacts not shown in FIG. **6**A). Accordingly, the contacts of connector **610** may remain exposed and accessible by contacts of a corresponding USB receptacle connector. Label **665** may provide cosmetic benefits in addition to insulating the contacts of plug connector **510**. Frame **660** may also include openings (not shown) corresponding to the openings of label **665**.

[0066] FIGS. **8**A and **8**B are simplified perspective and cross sectional views, respectively, of a USB plug connector **710** in various stages of manufacture according to still another embodiment of the present invention. Connector **710** is also similar to embodiments discussed above, e.g., plug connectors **110** and **210**. However, in contrast with the connector discussed above, connector **710** does not include a PCB. Instead, tongue **730** can be produced via a single shot molding process. For example, contacts of connector **710** (e.g., **740***a*-**740***d*) may be inserted molded to form a tongue **730** having exposed contacts as shown in FIG. **8**A. Tongue **730** may then be assembled with structural support **735**, or structural support **735** may be overmolded around a portion of tongue **730**.

[0067] FIGS. **9**A and **9**B are simplified perspective and cross sectional views, respectively, of a USB plug connector **810** in various stages of manufacture according to still another embodiment of the present invention. Connector **810** is similar to embodiments discussed above, particularly connector **710**. Connector **810** does not include a PCB but rather a tongue **830** can be formed via a two shot molding process, as opposed to the one shot molding process of connector **710**. The first insert mold shot may be used to form a first portion **870** using a suitable dielectric material, e.g., LCP. As shown in FIG. **9**B, first portion **870** may be located between the opposing sets of contacts of connector **810**. The second insert mold shot may be used to form a second portion **875** using another dielectric material, e.g., LCP, POM or Nylon. Second portion **875** also forms a tip **830***c* of tongue **830**. Subsequently, an overmolding process may use nylon or another suitable dielectric to form the remaining portion of tongue **830** as well as structural support **835**. In this embodiment, the contacts of plug connector **810**, e.g., contacts **840***a* and **840***e*, are soldered to PCB **832**. Contacts of plug connector **810** may be shorted through PCB **832** or otherwise routed to insulated wires of cable connected to connector **810**.

[0068] FIGS. **10**A and **10**B are simplified perspective and cross sectional views, respectively, of a USB plug connector **910** in various stages of manufacture according to still another embodiment of the present invention. Connector **910** is similar to embodiments discussed above, particularly con-

nector **810**. Connector **910** includes a frame **980** that includes a clamshell style opening. A flex circuit **985** may be assembled in the clamshell opening of frame **980** in order to form a tongue **930** that includes contacts (e.g., contacts **940***a*-**940***d*).

[0069] The methods of manufacturing discussed above may also be suitable in whole or in part for additional embodiments of plug connectors of the present invention. Examples of these additional embodiments of plug connectors of the present invention are illustrated in the following figures.

[0070] FIGS. **11**A and **11**B are simplified perspective and cross sectional views, respectively, of a USB plug connector **1100** according to one embodiment of the present invention. Plug connector **1110** includes a body **1115** and a tab **1117** extending longitudinally away from body **1115** in a direction parallel to the length of connector **1110**. In contrast with connector **10** and similar variations, connector **1110** does not include a shell. Contacts **1140***a*-**1140***d* are disposed on a first major surface **1130***a* and four additional contacts (only contact **1140***e* is shown in FIG. **11**B) are disposed on a second major surface **1130***b*. As also shown in FIGS. **11**A and **11**B, tab **1117** may include a bullnose tip **1130***c* for at least the same reasons discussed above.

[0071] Connector **1100** can have a 180 degree symmetrical, double orientation design which enables the connector to be inserted into a corresponding receptacle connector in both a first orientation where surface **1130***a* is facing up and a second orientation where surface **1130***a* is rotated 180 degrees and facing down. Specifics of general double or dual orientation designs are discussed in greater detail above. Simply stated, the dual orientation design of connector **1100** allows contacts disposed on first surface **1130***a* (contacts **1140***a*-**1140***d*) to mate with contacts of the corresponding receptacle connector in one orientation and contacts disposed on second surface **1130***b* to mate with contacts of the corresponding receptacle connector in the other orientation. Despite connector **1110** being a dual orientation connector, this embodiment of the present invention may only be received by receptacle connectors specially designed for receiving connector **1100**.

[0072] Tab **1130** may be made from one or more of a variety of dielectric materials including wear resistant materials such as LCP, POM, Nylon and others. In contrast with connector **10**, connector **1110** may not be designed to deflect upon insertion into a corresponding receptacle connector. Instead, connector **1100** may remain rigid during insertion and extraction events. Materials used for making tab **1130** may be chosen accordingly.

[0073] Body **1115** is generally the portion of connector **1110** that a user will hold onto when inserting or removing connector **1110** from a corresponding receptacle connector. Body **1115** can be made out of a variety of materials and in some embodiments is made from a dielectric material, such as a thermoplastic polymer formed in an injection molding process. Also, electrical contact to the contacts of surfaces **1130***a*, **1130***b* can be made with individual wires in a cable within body **1115**. In one embodiment, a cable includes a plurality of individual insulated wires for connecting to contacts of surfaces **1130***a*, **1130***b* that are soldered to bonding pads on a PCB housed within body **1115**. The bonding pads on the PCB may be electrically coupled to corresponding individual contacts of surfaces **1130***a* and **1130***b*. In some embodiments, contacts of one of surfaces **1130***a* and **1130***b* to be shorted through tab **1130** or a PCB to corresponding contacts on the other of surfaces **1130***a* and **1130***b* and then appropriately routed to the individual wires of a cable within body **1115**.

[0074] The contacts of tab **1130** can be made from copper, nickel, brass, a metal alloy or any other appropriate conductive material. Plug connector **1110** may include standard USB contacts for power, ground and a pair of differential data signals (e.g., data transmit). For example, contact **1140***a* may be a ground pin, contact **1140***b* may be a Data+pin, contact **1140***c* may be a Data−pin, and contact **1140***d* may be a power pin (VBUS). As mentioned earlier, the four additional contacts disposed on second major surface **1130***b* can be positioned so that the contacts on first and second major surfaces **1130***a*, **1130***b* are arranged in a symmetric manner and have the same pinout. In this manner, either of two intuitive orientations may be used to mate the contacts of plug connector **1110** with contacts of a corresponding receptacle connector during a mating event.

[0075] A sensing circuit as described above may be included with connector **1110** and/or a corresponding receptacle connector.

[0076] An example of a particular embodiment of plug connector **1110** is shown in the following figures.

[0077] FIGS. **15**A and **15**B are partially transparent simplified perspective and partially transparent front views, respectively, of a USB plug connector **1510** according to one particular embodiment of connector **1110**. Connector **1510** may provide the same pinout on both first and second major surfaces **1530***a*, **1530***b* of a tab **1530** using crossover contact frames **1596***a*-**1596***d* that each include a contact for each of the major surfaces of tab **1530**. For example, as shown in FIGS. **15**A and **15**B, tab **1530** extends in a longitudinal direction and includes contacts **1540***a*-**1540***d* disposed on first major surface **1530***a* and contacts **1540***e*-**1540***g* disposed on second major surface **1530***b*. Contacts **1540***a*-**1540***g* may be exposed portions of contact frames **1596***a*-**1596***d*. Crossover contact frames **1596***a*-**1596***d* may serve to connect contacts **1540***a*-**1540***d* to contacts **1540***h*-**1540***e*, respectively, and contacts **1540***a*-**1540***h* to PCB **1532**, which may be assembled with tab **1530**. The configuration of crossover contact frames **1596***a*-**1596***d* is further illustrated in the following figures.

[0078] FIGS. **15**C-**15**F are top views of contact frames **1596***a*; **1596***a* and **1596***b*; **1596***a*, **1596***b* and **1596***c*; and **1596***a*, **1596***b*, **1596***c* and **1596***d*; respectively, in their positions with respect to each other when embedded in tab **1530**. As shown in FIG. **15**C-F as well as FIGS. **15**A and **15**B, a crossover region exists between contacts **1540***a*-**1540***d* and contacts **1540***e*-**1540***h* where portions of contact frames **1596***a*-**1596***d* overlap and cross. The overlapping and crossing of portions of contact frames **1596***a*-**1596***d* in the crossover region may provide shielding to minimize electromagnetic interference (EMI) from degrading signals transferred through contacts **1540***a*-**1540***h*.

[0079] As with connector **1100**, connector **1510** can have a 180 degree symmetrical, double or dual orientation design. Similarly, connector **1510** may include a body having a cable attached thereto like body **1115** or any of the other body embodiments described herein. In one embodiment, a body (not shown in FIGS. **15**A-**15**F) may be assembled with tab **1530**, house PCB **1532** and have a cable (not shown in FIGS. **15**A-**15**F) attached thereto. The cable may include a plurality of individual insulated wires for connecting to contacts

1540*e*-**1540***h* via PCB **1532** that includes solder connections between crossover contact frames **1596***a*-**1596***d* and its bonding pads.

[0080] The contacts of connector **1510** may include contacts for power, ground and a pair of differential data signals (e.g., data transmit). For example, crossover contact frames **1596***a*-**1596***d* may provide lines for ground, Data+, Data− and power (VBUS), respectively. Accordingly, contacts **1540***a* and **1540***h* may be a ground pins, contacts **1540***b* and **1540***g* may be a Data+pins, contacts **1540***c* and **1540***f* may be a Data−pins, and contacts **1540***d* and **1540***e* may power pins (VBUS). In this manner, regardless of the orientation of plug connector **1510**, the same pinout may be mated with a corresponding receptacle connector during a mating event.

[0081] An added benefit of this embodiment may be that sensing circuitry as discussed in relation to other embodiments contained herein may not be necessary for connector **1510** or a corresponding receptacle connector. This is possible because crossover contact frames **1596***a*-**1596***d* may provide the same pinout on each of the first and second orientations and handle the routing of power and data received at contacts **1540***a*-**1540***h* to PCB **1532**. In some embodiments, contact frames **1596***a*-**1596***d* may even directly route power and data to individual wires of a cable connected to connector **1510**. Accordingly, features of connector **1510** may be useful for other embodiments described herein.

[0082] Contact frames **1596***a*-**1596***d* can be made from copper, nickel, brass, a metal alloy or any other appropriate conductive material using a metal stamping operation or other machining operations. Alternatively, contact frames **1596***a*-**1596***d* may be molded.

[0083] The contact arrangements shown in FIGS. **15**A-**15**F and discussed in relation thereto may be implemented in various ways in other embodiments, e.g., those embodiments that do not include a PCB disposed between the contacts of the plug connector. Additional embodiments of contact arrangements that may be implemented with plug connector embodiments that may not include PCB anywhere within the plug connector are shown in the following figures.

[0084] FIGS. **17**A and **17**B are partial cross sectional perspective and cross sectional side views, respectively, of a USB plug connector **1710** according to one embodiment of the present invention. Plug connector **1710** may be similar to embodiments discussed above, e.g., plug connector **1610**. However, plug connector **1710** may not include a PCB. FIGS. **17**A and **17**B show that connector **1710** may include a body **1715** and a shell **1720** extending longitudinally away from body **1715** in a direction parallel to the length of connector **1710**. Shell **1720** includes an opening **1725** that communicates with a cavity. Tongue **1730** may be centrally located within shell **1720** and extend in a direction parallel to the length of plug connector **1710**. Contacts **1740***a*-**1740***d* are exposed on a first major surface **1730***a* and contacts **1740***e*-**1740***h* are exposed on a second major surface **1730***b*. Contacts **1740***a*-**1740***h* may be exposed portions of contact frames **1798***a*-**1798***d*.

[0085] Crossover contact frames **1798***a*-**1798***d* may serve to connect contacts **1740***a*-**1740***d* to contacts **1740***h*-**1740***e*, respectively, and contacts **1740***a*-**1740***h* to wires of cable **1719**. FIGS. **17**A and **17**B illustrate insulated wires, wires **1736***a*-**1736***d*, that extend from the interior of cable **1719**. Wires **1736***a*-**1736***d* may directly terminate on contact frames **1798***a*-**1798***d*, e.g., wires **1736***a*-**1736***d* may be soldered to contact frames **1798***a*-**1798***d*. The Cable **1719** may include wires corresponding to each unique contact of plug connector **1710**. For example, wire **1736***d* may be a grounding wire that connects to contact frame **1798***a* (contacts **1740***a* and **1740***h*), wire **1736***c* may be a Data+wire that connects to contact frame **1798***b* (contacts **1740***b* and **1740***g*), wire **1736***b* may be a Data−wire that connects to contact frame **1798***d* (contacts **1740***c* and **1740***f*), and wires **1736***a* may be power wires that connect to contact frame **1798***c* (contacts **1740***d* and **1740***e*). In this manner, regardless of the orientation of plug connector **1710**, the same pinout may be mated with a corresponding receptacle connector during a mating event.

[0086] The configuration of crossover contact frames **1798***a*-**1798***d* is further illustrated in the following figure.

[0087] FIG. **17**C is an exploded view of contact frames **1798***a*-**1798***d* of plug connector **1710**. As can be understood from FIG. **17**C, a crossover region exists between contacts **1740***a*-**1740***d* and contacts **1740***e*-**1740***h* where portions of contact frames **1798***a*-**1798***d* overlap and cross. Insulative spacers may be placed in this crossover region. For example, strips of electrical insulation materials, e.g., elastomers or other polymers with good electrical insulation properties, may be placed and/or adhered to the surfaces of contact frames **1798***a*-**1798***d* adjacent to other surfaces of contact frames **1798***a*-**1798***d* in plug connector **1710**, as shown in FIG. **17**C. For example, spacers **1746***a* and **1746***b* may shield portions of contact frame **1798***c* from portions of contact frame **1798***a*. Spacers **1747** and **1748** may shield portions of contact frame **1798***b* from portions of contact frame **1798***d*. Spacer **1749** may shield portions of contact frame **1798***c* from portions of contact frame **1798***a*.

[0088] Depending the amount of EMI that is occurring between the contacts of plug connector **1710**, more or less and/or thicker or thinner insulative spacers may be implemented. For example, if additional shielding is required more and/or thicker insulative spacers may be placed in the crossover region between contact frames **1798***a*-**1798***d*. The overlapping and crossing of portions of contact frames **1798***a*-**1798***d* in the crossover region in addition to the insulative spacers may provide shielding from EMI caused by signals passing through **1740***a*-**1740***h*, which EMI may degrade the signals transferred through contacts **1740***a*-**1740***h*.

[0089] Overmold **1755** may be formed around spacers **1746**-**1749** and contact frames **1798***a*-**1798***d* to form tongue **1730**. As discussion herein, tongue overmolds may provide cosmetic, rigidity and wear resistance benefits. Materials used for other tongue overmold embodiments discussed herein may also be used for overmold **1755**.

[0090] The design of plug connector **1710**, as with plug connector **1510**, may be a 180 degree symmetrical, double or dual orientation design. An added benefit of contact frames **1798***a*-**1798***d* may be that sensing circuitry as discussed in relation to other embodiments contained herein may not be necessary for connector **1710** or a corresponding receptacle connector for reasons similar to those mentioned concerning plug connector **1510**.

[0091] As shown in FIG. **17**B, plug connector **1710** may also include a structural support **1735** integrally formed with overmold **1755**. Structural support **1735** may provide flexure to tongue **1730** to reduce stress and fatigue on tongue **1730** and allow tongue **1730** to deflect during insertion/extraction events. In other embodiments, structural support **1735** may be separately overmolded over overmold **1755** or separately

formed and then assembled with tongue **1730** using a clearance fit, an interference fit or a snap-fit or the like.

[0092] Contact frames **1798***a*-**1798***d* can be made from copper, nickel, brass, a metal alloy or any other appropriate conductive material using a metal stamping operation or other machining operations. Alternatively, contact frames **1798***a*-**1798***d* may be molded.

[0093] An example of another plug connector embodiment that may not include PCB is shown in the following figures.

[0094] FIGS. **18**A and **18**B are exploded and cross sectional side views, respectively, of a USB plug connector **1810** according to an embodiment of the present invention. Plug connector **1810** may be similar to embodiments discussed above which does not include a PCB, e.g., plug connector **1710**. As shown in FIGS. **18**A and **18**B, connector **1810** includes a body **1815** and a shell **1820** extending longitudinally away from body **1815** in a direction parallel to the length of connector **1810**. Shell **1820** includes an opening **1825** that communicates with a cavity defined by first, second, left and right inner surfaces **1820***a*-**1820***d* of shell **1820**, a tongue **1830**, and first and second support elements **1835***a*, **1835***b* assembled with a base **1837**. Tongue **1830** may be centrally located between first and second inner surfaces **1820***a*, **1820***b* and extend parallel to the length of connector **1810**. Tongue **1830** includes contacts **1840***a*-**1840***d* exposed at a first major surface **1839***a* of a tip **1839** and four additional contacts (e.g., contacts **1840***e*-**1840***h*, as shown in FIG. **18**F) exposed on a second major surface **1839***b*. Contacts **1840***a*-**1840***h* can be made from copper, nickel, brass, a metal alloy such as a copper-titanium alloy or any other appropriate conductive material. As shown in FIGS. **18**A and **18**B, tongue **1830** may also include a bullnose tip **1839***c* for reasons that will be explained below.

[0095] Connector **1810** can have a 180-degree symmetrical, double orientation design that enables the connector to be inserted into a corresponding receptacle connector in either a first orientation where surface **1839***a* is facing up or a second orientation where surface **1839***a* is rotated 180 degrees and facing down. To allow for the orientation agnostic feature of connector **1810**, tongue **1830** is not polarized. That is, tongue **1830** does not include a physical key that is configured to mate with a matching key in a corresponding receptacle connector designed to ensure that mating between the two connectors only occurs in a single orientation. Instead, if tongue **1830** is divided into top and bottom halves along a horizontal plane that bisects the center of tongue **1830** along its width, the physical shape of the upper half of tongue **1830** is substantially the same as the physical shape of the lower half. Similarly, if tongue **1830** is divided into left and right halves along a vertical plane that bisects the center of tab along its length, the physical shape of the left half of tongue **1830** is substantially the same as the shape of the right half. Additionally, contacts **1840***a*-**1840***d* and contacts **1840***e*-**1840***g* can be positioned so that they are arranged in a symmetric manner. Accordingly, contacts **1840***a*-**1840***d* can mate with contacts of the corresponding receptacle connector in one orientation and contacts **1840***e*-**1840***h* (shown in FIG. **18**F) can mate with contacts of the corresponding receptacle connector in the other orientation.

[0096] Tongue **1830** may be coupled to base **1837**, which can be made from a variety of dielectric materials, including flexible polymers and polyamides. The materials used to form tongue **1830** and/or base **1837** may be chosen such that tongue **1830** deflects either toward first or second inner surfaces **1820***a*, **1820***b* of shell **1820** when connector **1810** is inserted into a corresponding receptacle connector, e.g., a female USB connector. This deflection may occur as bullnose tip **1839***c* comes into contact with internal features of a corresponding receptacle connector, causing tongue **1830** to deflect toward an appropriate region within a corresponding receptacle connector and allowing contacts **1830***a*-**1830***d* or **1830***e*-**1830***h* of plug connector **1810** to mate with contacts on the corresponding receptacle connector.

[0097] As discussed above, tongue **1830** may be centrally located within opening **1825** of shell **1820**. For example, tongue **1830** may be positioned within opening **1825** such that its distance from first and second inner surfaces **1820***a*, **1820***b* always causes connector **1810** to deflect toward the appropriate region within a corresponding receptacle connector regardless of whether plug connector **1810** is in the first or second orientation, as described above. Portions of tongue **1830** may deform and deflect in different manners in order to put its contacts in position to mate with the contacts of the corresponding receptacle connector. Depending on the materials of the individual components of tongue **1830**, the size of tongue **1830** may be varied such that tongue **1830** elastically deforms as necessary during mating events.

[0098] Body **1815** is generally the portion of connector **1810** that a user will hold onto during mating events. Body **1815** can be made out of a variety of materials and in some embodiments is made from a dielectric material, such as a thermoplastic polymer formed in an injection molding process. A portion of a cable **1819** and shell **1820** may extend within and be enclosed by body **1815**. To prevent cable **1819** from being damaged when flexed during normal use (e.g., mating events), a strain relief element **1865** (e.g., a structure made from elastomers) may be formed over or assembled with the portion of cable **1819** closest to body **1815**, as shown in FIG. **18**A.

[0099] In one embodiment, cable **1819** includes a plurality of individual insulated wires **1836***a*-**1836***d* for connecting to contacts **1840***a*-**1840***h*. The electrical connection between insulated wires **1836***a*-**1836***d* and contacts **1840***a*-**1840***h* can be formed by soldering wires **1836***a*-**1836***d* to ends of contact frames **1898***a*-**1898***d* (as shown in FIGS. **18**C, **18**D and **18**H). As further discussed below, contacts **1840***a*-**1840***h* may be exposed portions of contact frames **1898***a*-**1898***h*. Accordingly, contact frames **1898***a*-**1898***h* can route electrical signals between wires **1836***a*-**1836***d* and contacts **1840***a*-**1840***h*. A polymer innermold **1855** may be formed around the connection between wires **1836***a*-**1836***d* and the ends of contact frames **1898***a*-**1898***d*. A metallic shield cap **1860** may be assembled over innermold **1855** and with shell **1820** to increase electromagnetic interference and electromagnetic compatibility performance ("EMI/EMC performance") of connector **1810**. The configuration of contact frames **1898***a*-**1898***h* is further illustrated in the following figures.

[0100] FIGS. **18**C-**18**H illustrate contact frames **1898***a*-**1898***h* in various stages of assembly according to an embodiment of the present invention. FIG. **18**C show a first set of contact frames **1898***a*-**1898***d* shaped to extend through base **1837** and form a portion of tongue **1830** with raised protuberances that function as contacts **1840***a*-**1840***d*. FIG. **18**D shows a second set of contact frames **1898***e*-**1898***h* having raised protuberances that function as contacts **1840***e*-**1840***h*. Contact frames **1898***e*-**1898***h* may be shaped to be coupled with the first set of contact frames **1898***a*-**1898***d* such that contacts **1840***a*-**1840***d* are electrically connected to contacts

1840*h*-**1840***e*, respectively. Contact frames **1898***a*-**1898***e* and **1898***h* may also extend into base **1837**, while contact frames **1898***f* and **1898***g* do not extend into base **1837**. As shown in FIG. **18**D, contact frames **1898***f* and **1898***g* may be connected via an arm **1897**. The shape of contact frames **1898***f*, **1898***g* and arm **1987** can minimize or reduce electrical stub and thereby minimize insertion loss, allowing for improved signal integrity for contacts **1840***b*, **1840***d*, **1840***g* and **1840***f*, which may be differential data contacts, as discussed below.

[0101] As shown in FIG. **18**E, a insulative spacer **1846** may be insert molded over and between portions of contacts **1898***a*-**1898***d* to electrically shield and isolate contacts **1840***a*-**1840***h*, even when assembled as shown in FIG. **18**F. As such, portions of contact frames **1898***a*-**1898***d* can overlap and cross contact frames **1898***e*-**1898***h* while maintaining acceptable levels of EMI/EMC performance. Spacer **1846** can be made from dielectric materials, e.g., elastomers or other polymers with good electrical insulation properties. A larger or smaller, thicker or thinner and/or otherwise shaped insulative spacer **1846** may be implemented depending on the amount of EMI that is occurring between the contacts and/or contact frames of plug connector **1810**. For example, if additional shielding is required, insulative spacer **1846** may be thickened where any one of contact frames **1898***a*-**1898***d* overlap any one of contact frames **1898***e*-**1898***h*, thereby shielding EMI that could potentially degrade the signals passing to or from contacts **1840***a*-**1840***h* via contact frames **1898***a*-**1898***h*.

[0102] In order to achieve the 180-degree symmetrical, double or dual orientation design of connector **1810**, contact frames **1898***e*-**1898***h* may be electrically connected to contact frames **1836***a*-**1836***d* such that the same pinout or arrangement of contact types (e.g., data, power, ground) is provided at first and second surfaces **1839***a*, **1839***b*. Accordingly, as shown in FIG. **18**F, contacts **1840***a*-**1840***d* are electrically connected with contacts **1840***h*-**1840***e*, respectively, via the coupling (e.g., welding or otherwise electrically connecting) to the first and second set of contact frames. More specifically, a weld **1899***a* (e.g., a laser weld) may electrically couple contact frame **1898***a* to contact frame **1898***h*, thereby coupling contacts **1840***a* and **1840***h*; a weld **1899***b* may electrically couple contact frame **1898***b* to contact frame **1898***g*, thereby electrically coupling contacts **1840***b* and **1840***g*; a weld **1899***c* may electrically couple contact frame **1898***c* to contact frame **1898***f*, thereby electrically coupling contacts **1840***c* and **1840***f*; and a weld **1899***e* may electrically couple contact frame **1898***e* to contact frame **1898***d*, thereby electrically coupling contacts **1840***d* and **1840***e*.

[0103] As with standard USB plug connectors, plug connector **1810** may include contacts for power, ground and a pair of differential data signals (e.g., data transmit). Cable **1819** may include wires corresponding to each of these unique contacts. As discussed above, wires **1836***a*-**1836***d* may directly terminate on contact frames **1836***a*-**1836***d* in order to couple with contacts **1840***a*-**1840***h*. For example, wire **1836***d* may be a grounding wire that connects to contacts **1840***d* and **1840***e* via contact frames **1898***d* and **1898***e*, wire **1836***c* may be a Data+wire that connects to contacts **1840***c* and **1840***f* via contact frames **1898***c* and **1898***f*, wire **1836***b* may be a Data−wire that connects contacts **1840***b* and **1840***g* via contact frames **1898***b* and **1898***g*, and wires **1836***a* may be power wires that connect to contacts **1840***a* and **1840***h* via contact frames **1898***a* and **1898***h*. In this manner, regardless of the orientation of plug connector **1810**, the same pinout may be mated with a corresponding receptacle connector during a mating event.

[0104] The design of plug connector **1810**, as with plug connector **1510**, may be a 180-degree symmetrical, double or dual orientation design. An added benefit of using contact frames, e.g., frames **1898***a*-**1898***h* may be that sensing circuitry as discussed in relation to other embodiments contained herein may not be necessary for connector **1810** or a corresponding receptacle connector for reasons similar to those mentioned concerning plug connector **1510**.

[0105] As mentioned earlier, plug connector **1810** may also include a base **1837** and first and second support elements **1835***a*, **1835***b* assembled with a base **1837**. The combination of support elements **1835***a*, **1835***b* and base **1837** may support tongue **1830** as it flexes during insertion/extraction events in order to reduce stress and fatigue experienced by, e.g., contact frames **1898***a*-**1898***h* of tongue **1830**. Base **1837** may be overmolded over contact frames **1898***a*-**1898***e* and **1898***h* or separately formed and then assembled with the rest of tongue **1830** using a clearance fit, an interference fit, a snap-fit or the like. In another embodiment, support elements **1835***a*, **1835***b* may be overmolded separately or integrally with base **1837**. Support elements **1835***a*, **1835***b* may be made from a resilient polymer, e.g., LCP or POM. Overmolding may also be used to form tip **1839** over spacer **1846** and around the contacts of contact frames **1898***a*-**1898***h*, as shown in FIG. **18**H. Tip **1839** may provide cosmetic, rigidity and wear resistance benefits. Materials used for other tongue overmold embodiments discussed herein may also be used for tip **1839**. Alternatively, tip **1839** may be assembled on contact frames **1898***a*-**1898***h*.

[0106] Contact frames **1898***a*-**1898***h* can be made from copper, nickel, brass, a metal alloy such as a copper-titanium alloy or any other appropriate conductive material using a metal stamping operation or other machining operations. Alternatively, contact frames **1898***a*-**1898***h* may be molded. Contacts **1840***a*-**1840***h* may be made from the same material as contact frames **1898***a*-**1898***h*. In addition, contacts **1840***a*-**1840***h* may be plated with nickel and/or gold.

[0107] The structures and methods shown in FIGS. **18**A-**18**H and discussed in relation thereto may also be implemented in various ways in other embodiments of the present invention.

[0108] It will be appreciated that connector **1810** is illustrative and that variations and modifications are possible. The shapes and number of contact frames of connector **1810** can be varied in ways not specifically described here. Further, while contact frames are described above as being coupled, i.e., via welding, at particular locations, it is to be understood that these weld points can vary for contact frames having different shapes and configurations. Further, the contact frames of connector **1810** may be replaced with a tongue-shaped element made from a metallic material or a polymer and not configured to carry signals. In this embodiment, a flex circuit having contacts may simply be wrapped around the tongue-shaped element to provide a dual orientation connector such as a USB connector. Embodiments of the present invention can be realized in a variety of apparatus including cable assemblies, docking stations and flash drives. Support elements or members **1835***a*, **1835***b*, which collectively may be referred to as a support structure, of connector **1810** can be varied in ways not specifically described above. The follow-

ing figures illustrate examples of variations of this support structure, which may be implemented in various embodiments described herein.

[0109] In order to discuss the utility of a support structure, such as support members **1835***a*, **1835***b*, reference is first made to a reversible connector with its support structure removed: FIGS. **19**A and **19**A-**1** are cross sectional side and partially exploded, partially cross sectional perspective views, respectively, of a USB plug connector **1910** with its support structure removed according to one embodiment of the present invention. Plug connector **1910** may be similar to embodiments discussed above, e.g., plug connector **1810**. Again, for the purpose of discussion, the support structure (as shown in FIGS. **19**B and **19**B-**1**) of plug connector **1910** is not shown in FIGS. **19**A and **19**A-**1**. As with connector **1810**, plug connector **1910** includes a body **1915** and a shell **1920** extending longitudinally away from body **1915** in a direction parallel to the length of connector **1910**. Shell **1920** includes an opening **1925** that communicates with a cavity defined by inner surfaces (e.g., surfaces **1820***a*-**1820***d* as shown in FIG. **18**A) of shell **1920** and a base **1937**.

[0110] Tongue **1930** may be centrally located between inner surfaces of shell **1920** and extend parallel to the length of connector **1910**. Tongue **1930** can include contacts (only contact **1940***a* is shown in FIG. **19**A-**1**, but see, e.g., contacts **1840***a*-**1840***d* in FIG. **18**A) exposed at a first major surface **1939***a* of a contact region **1939** and additional contacts (e.g., contacts **1840***e*-**1840***h*, as shown in FIG. **18**F) exposed on a second major surface of contact region **1939**. The contacts of connector **1910** may be exposed portions of contact frames **1998** (only contact frames **1998***a*-**1998***c* are shown in FIG. **19**A-**1**, but see, e.g., contact frames **1898***a*-**1898***h* in FIG. **18**F), at least some of which are spaced apart along a width of the tongue, as shown in FIG. **19**A-**1**. Tongue **1930** may also include a bullnose tip **1939***c* (e.g., tip **1839***c*, as shown in FIG. **18**B). A cable **1919** can be coupled to base **1915** and include a plurality of individual insulated wires (e.g., wires **1836***a*-**1836***d*, as shown in FIG. **18**A) for coupling with contacts of connector **1910**.

[0111] Like connector **1810** above, connector **1910** can also have a 180-degree symmetrical, double orientation design that enables the connector to be inserted into a corresponding receptacle connector in either a first orientation where surface **1939***a* is facing up or a second orientation where surface **1939***a* is rotated 180 degrees and facing down. For example, tongue **1930** may be positioned within opening **1925** such that tongue **1930** deflects toward the an inner surface of shell **1920** and is positioned in an appropriate region within a corresponding receptacle connector, regardless of whether plug connector **1910** is in the first or second orientation. Bending portions of tongue **1930** (e.g., portions of contact frames **1998**) may bend or deform and deflect in different manners in order to put the contacts of connector **1910** in position to mate with the contacts of the corresponding receptacle connector.

[0112] The discussion of elements and variations thereof concerning connector **1810** may apply to corresponding elements of connector **1910**. Additional elements and variations thereof discussed with reference to connector **1810** above may also be implemented in connector **1910**.

[0113] The absence of a support structure in connector **1910** may result in a number of issues. As mentioned concerning other embodiments, a support structure (support members **1835***a*, **1835***b*), as well as a base (e.g., base **1837**), can support a tongue as it flexes during insertion/extraction events in order to reduce stress experienced at any given point of the tongue. FIG. **19**A can be used to identify where stress might be concentrated in the absence of a support structure. For example, the point at which tongue **1930** protrudes through base **1937** and into the cavity of shell **1920** may be the pivot point for tongue **1930**. As such, the majority of the stress experienced by tongue **1930** during a mating event may be concentrated at and/or around that pivot point, which would be the bending portion of tongue **1930**. Even if the stress experienced at this bending portion of tongue **1930** is less than the yield stress of the material at this bending portion of tongue **1930**, permanent deformation may occur over time if connector **1910** is left in the mated position for a period (e.g., if connector **1910** is left in receptacle for months, weeks or possibly even days).

[0114] To resolve these potential issues, the length of the bending portion of tongue **1930** could be increased such that the angle of deflection of tongue **1930** is decreased, resulting in less stress occurring at the bending portion. However, this could also decrease the contact normal force or contact mating force provided by tongue **1930** to press its contacts against the contacts of a corresponding receptacle connector during a mating event such that data and/or power can be transferred therebetween. That is, the stress occurring at the bending portion of tongue **1930** may correlate to the contact normal force provided by tongue **1930**. Alternatively, if the size of the bending portion of tongue **1930** could be increased such that the stress could be distributed over a larger portion of tongue **1930**, damage to and/or permanent deformation of tongue **1930** could potentially be avoided. For example, a structural support could be used to spread or distribute stress (e.g., uniformly spread stress) over a larger bending portion of a tongue, while maintaining or even increasing contact normal force by spreading stress instead of decreasing the overall stress.

[0115] FIGS. **19**B and **19**B-**1** are cross sectional side and partially exploded, partial cross sectional perspective views, respectively, of the USB plug connector of FIGS. **19**A and **19**A-**1** with a support structure according to one embodiment of the present invention. Structural support **1935** can include first and second support members **1935***a*, **1935***b* that are overmolded adjacent to, integrally formed with base **1937** (e.g., using a single or a multiple shot process) or separately formed and then assembled with base **1937** or other elements of connector **1910** (e.g., shell **1920**) using a clearance fit, an interference fit, a snap-fit or the like. First and second support members **1935***a*, **1935***b* of structural support **1935** may be made from a compliant material such as a thermoplastic elastomer (e.g., silicone santoprene) or other materials suitable for distributing stress while maintaining or providing sufficient contact normal force.

[0116] As shown in FIGS. **19**B and **19**B-**1**, first and second support members **1935***a*, **1935***b* can be positioned on opposite sides of tongue **1930** with first support member **1935***a* including a surface **1936***a* that faces a surface of tongue **1930** and second support member **1935***b* including a surface **1936***b* that faces another surface of tongue **1930**. FIGS. **19**B and **19**B-**1** also show that the distance between surfaces **1936***a*, **1936***b* varies along the portion of the length of tongue **1930** that is positioned between these surfaces **1936***a*, **1936***b*. For example, the distance between surfaces **1936***a*, **1936***b* may increase in the direction that tongue **1930** extends from base **1937**. Thus, the opening formed by the first and second sup-

port members **1935***a*, **1935***b* may be tapered. As such, when tongue **1930** deflects during a mating event, the stress experienced by tongue **1930** may be distributed across the bending portion of tongue **1930** (e.g., the portion of tongue **1930** that is deflected towards and makes contact with surface **1936***a* or surface **1936***b*). In some embodiments, this may cause tongue **1930** to experience a low, constant stress across the bending portion of tongue **1930** during mating events, as opposed to experiencing a high stress at the pivot point, as discussed with reference to FIGS. **19**A and **19**A-**1**.

[0117] First and second support members **1935***a*, **1935***b* may also include a recess (e.g., recesses **1938***a*, **1938***b*) at surfaces opposite surfaces **1936***a*, **1936***b*, respectively, such that the height of first and second support members **1935***a*, **1935***b* also varies along the portion of the length of tongue **1930** that is positioned between surfaces **1936***a*, **1936***b*. These recesses may be shaped and sized based on the height of first and second support members **1935***a*, **1935***b* in order to distribute stress and provide contact normal force for tongue **1930**.

[0118] Alternatively or additionally, the durometer of structural support **1935** may vary along a portion of the length of tongue **1930**. For example, the durometer of portions of first and second support elements **1935***a*, **1935***b* nearest to base **1937** may be higher than other portions of first and second support elements **1935***a*, **1935***b* that are closer to opening **1925**. In some embodiments, the durometer of first and second support elements **1935***a*, **1935***b* may not vary in the same manner along the length of tongue **1930**. The durometer of first and second support elements **1935***a*, **1935***b* may be adjusted based on the shape of first and second support elements **1935***a*, **1935***b*, the material properties of the bending portions of tongue **1930**, the dimensions of tongue **1930** such that tongue **1930** is prevented from breaking due to stress while allowing the contacts of tongue **1930** to properly couple with the contacts of a corresponding receptacle connector during mating events.

[0119] FIGS. **19**C-**19**F are cross sectional side views of the USB plug connector of FIGS. **19**A and **19**A-**1** with a support structure according to embodiments of the present invention. The support structures shown in FIGS. **19**C-**19**F may be similar to support structure **1935** in that they include support members having a surface that faces a surface of tongue **1930** and the distance between those surfaces may vary along a portion of the length of tongue **1930** (e.g., the bending portion). However, there may be differences between support structure **1935** and the support structures of FIGS. **19**C-**19**F.

[0120] For example, FIG. **19**C illustrates a support structure, including support members **1935***c* and **1935***d*, which include opposing surfaces that face tongue **1930**. As compared with FIGS. **19**B and **19**B**1**, the distance between these opposing surfaces vary to a greater extent along a portion of the length of tongue **1930**, resulting in a larger tapered opening. As shown in FIG. **19**C, support members **1935***c* and **1935***d* can also include recesses **1938***c*, **1938***d* shaped and sized as shown in FIG. **19**C. These recesses **1935***a*, **1935***b* may be otherwise sized and shaped in order to reduce stress concentrations at tongue **1930** while providing sufficient contact normal force.

[0121] FIG. **19**D illustrates a support structure, including support members **1935***e* and **1935***f* having opposing surfaces **1936***e* and **1936***f* that face tongue **1930** and have a curvature. Surfaces **1936***e*, **1936***f* can be described as having hills and a valley. In some embodiments, surfaces **1936***e*, **1936***f* can include a series of hills and valleys of various shapes and sizes. As with other embodiments described above, opposing surfaces **1936***e*, **1936***f* may be sized and shaped in order reduce stress concentrations at tongue **1930** while providing sufficient contact normal force for the contacts of tongue **1930**.

[0122] FIG. **19**E illustrates another support structure for use in an embodiment of connector **1910**. In contrast with the support structures above, support members **1935***g*, **1935***h* are not symmetric about a length direction of the tongue. For example, support member **1935***g* extends farther from base **1937** than support member **1935***h*. In addition, support member **1935***g* includes a surface **1936***g* facing tongue **1930** and orientated in a plane parallel to the plane in which an opposing surface of tongue **1930** is oriented, whereas support member **1935***h* includes a surface **1936***h* facing tongue **1930** that is oriented in a plane that intersects the plane of the opposing surface of tongue **1930**. In addition, as shown in FIG. **19**E, support member **1935***h* does not include a recess while support member **1935***g* does include a recess **1938***g*. As with other embodiments described above, opposing surfaces **1936***g*, **1936***h* may be sized and shaped in order to reduce stress concentrations at tongue **1930** while providing sufficient contact normal force for the contacts of tongue **1930**.

[0123] FIG. **19**F illustrates a support structure that includes a mix of the features of the support structures shown in FIGS. **19**C-**19**E. For example, the support structure shown in FIG. **19**F includes support members **1935***i*, **1935***j* that are symmetric about a length direction of tongue **1930**. Support members **1935***i* and **1935***j* include opposing surfaces **1936***i* and **1936***j*, respectively, which face tongue **1930**. A distance between these opposing surfaces varies along a portion of the length of tongue **1930** and is constant along another portion of the length of tongue **1930**. As with the other embodiments, support members **1935***i* and **1935***j* may be shaped and sized to distribute stress along the bending portion of tongue **1930** while providing sufficient contact normal force for the contacts of tongue **1930**.

[0124] FIGS. **19**G-**19**J are cross sectional side views of the USB plug connector of FIGS. **19**A and **19**A-**1** with a support structure according to embodiments of the present invention. The support structures shown in FIGS. **19**G-**19**J may be similar to support structure **1935**, as shown in FIGS. **19**B and **19**B-**1**, in that they include support members having surfaces that face a surface of tongue **1930** and the distance between the surfaces of the support members may be constant along a portion of the length of tongue **1930** (e.g., the bending portion). However, there are differences between support structure **1935** and the support structures of FIGS. **19**G-**19**J.

[0125] FIG. **19**G illustrates a support structure for use in an embodiment of connector **1910**. The support structure shown in FIG. **19**G includes support members **1935***k*, **1935***l* that are symmetric about a length direction of tongue **1930**. Support member **1935***k* includes a surface **1936***k* facing tongue **1930** and is orientated in a plane parallel to the plane in which the opposing surface of tongue **1930** is oriented. Similarly, support member **1935***l* also includes a surface **1936***l* facing another opposing surface of tongue **1930** and is orientated in a plane parallel to the plane in which the other opposing surface of tongue **1930** is oriented. Varying the durometer of support members **1935***k*, **1935***l* or portions thereof and/or choosing an appropriate material for support members **1935***k*, **1935***l* (as shown in FIG. **19**G) may distribute stress along the

bending portion of tongue **1930** while providing sufficient contact normal force for the contacts of tongue **1930**.

[0126] FIG. **19**H illustrates another support structure for use in an embodiment of connector **1910**. The support structure shown in FIG. **19**H includes support members **1935***m*, **1935***n* that are similar to support members **1935***k*, **1935***l* (as shown in FIG. **19**G) except that the height of support members **1935***m*, **1935***n* varies along a portion of the length of tongue **1930**. More specifically, the surfaces opposite surfaces **1936***m*, **1936***n* are curved surfaces. As with other embodiments described herein, varying the durometer of support members **1935***m*, **1935***n* or portions thereof, choosing an appropriate material for support members **1935***m*, **1935***n* and/or shaping or sizing support members **1935***m*, **1935***n* may be used to allow stress to be distributed along the bending portion of tongue **1930** while providing sufficient contact normal force for the contacts of tongue **1930**.

[0127] FIG. **191** illustrates yet another support structure for use in an embodiment of connector **1910**. The support structure shown in FIG. **19**I includes support members **1935***o*, **1935***p* that are similar to support members **1935***k*, **1935***l*, except that support members **1935***o*, **1935***p* include recesses at the surfaces opposite surfaces **1936***o*, **1936***p*. Support members **1935***o*, **1935***p* each include rectangular prism shaped recesses of varying sizes. These recesses, recesses **1938***m*-**1938***p* may be sized and/or shaped such that support members **1935***o*, **1935***p* can distribute stress along the bending portion of tongue **1930** while providing sufficient contact normal force for the contacts of tongue **1930**.

[0128] FIG. **19**J illustrates yet another support structure for use in an embodiment of connector **1910**. The support structure shown in FIG. **19**J includes support members **1935***q*, **1935***r* that are similar to support members **1935***k*, **1935***l* (as shown in FIG. **19**G) except that the height of support members **1935***q*, **1935***r* varies about a portion of the length of tongue **1930**. More specifically, as shown in FIG. **19**J, the surfaces opposite surfaces **1936***q*, **1936***r* include flat and angled portions. As with other embodiments described herein, varying the durometer of support members **1935***q*, **1935***r* or portions thereof, choosing an appropriate material for support members **1935***q*, **1935***r* and/or shaping or sizing support members **1935***q*, **1935***r* may be used to allow stress to be distributed along the bending portion of tongue **1930** while providing sufficient contact normal force for the contacts of tongue **1930**.

[0129] FIG. **19**K is a cross sectional side view of the USB plug connector of FIGS. **19**A and **19A-1** with a one-piece support structure according to an embodiment of the present invention. The support structures shown in FIG. **19**K may be similar to support structure **1935**, as shown in FIGS. **19**C-**19**J, except that support structure **1931** may be integrally formed as one piece. In some embodiments, support structure **1931** may be similarly sized and similarly shaped as of the aforementioned support structure. As shown in FIG. **19**K, support structure **1931** may include a slot. Tongue **1930** extends through base **1937** and support structure **1931** and between a surface **1941** of slot **1933** and towards opening **1925**. During a mating event, tongue **1930** may either deflect towards and make contact with a first portion **1941***a* of slot **1933** or defect towards and make contact with a second portion **1941***b* of slot **1933**. As such, slot **1933** may distribute stress across the bending portions of tongue **1930** (e.g., a portion of contact frames).

[0130] A person of skill in the art will recognize instances where the features of one of the above embodiments can be combined with the features of another of the above embodiments and where one of the above embodiments may be modified according to any of the other above embodiments. The structures and methods shown in FIGS. **19**A-**19**K and discussed in relation thereto may also be implemented in various ways in other embodiments of the present invention.

[0131] It will be appreciated that connector **1910** is illustrative and that variations and modifications are possible. The shapes and number of contact frames of connector **1910** can be varied in ways not specifically described here. Further, while connector **1910** above was described with reference to a reversible USB plug connector, the invention may apply to other connectors male or female and reversible and otherwise. Further, the contact frames of connector **1810** may be replaced with a PCB, as discussed above with reference to other figures.

[0132] An example of another embodiment of the present invention is shown in the following figures.

[0133] FIGS. **12**A and **12**B are partial cross sectional perspective and cross sectional views, respectively, of a USB plug connector **1210** according to one embodiment of the present invention. Connector **1210** includes a body **1215** and a shell **1220** extending longitudinally away from body **1215** in a direction parallel to the length of connector **1210**. Shell **1220** includes an opening **1225** that communicates with a cavity defined in part by first, second, left and right inner surfaces **1220***a*-**1220***d* of shell **1220** and a tongue **1230**. As shown in FIGS. **12**A and **12**B, tongue **1230** may be centrally located within shell **1220** and extend parallel to the length of connector **1210**. Contacts **1240***a*-**1240***d* are disposed on a first major surface **1230***a* and four additional contacts (only contact **1240***g* is shown in FIG. **1**B) are disposed on a second major surface **1230***b*. As also shown in FIGS. **12**A and **12**B, tongue **1230** may include a bullnose tip **1230***c* for reasons that will be explained again below.

[0134] As shown in FIGS. **12**A and **12**B, connector **1210** can have a 180 degree symmetrical, double orientation design which enables the connector to be inserted into a corresponding receptacle connector in both a first orientation where surface **1230***a* is facing up or a second orientation where surface **1230***a* is rotated 180 degrees and facing down. Specifics of general double or dual orientation design are discussed in greater detail above. Simply stated, contacts disposed on first surface **1230***a* (contacts **1240***a*-**1240***d*) mate with contacts of the corresponding receptacle connector in one orientation and contacts disposed on second surface **1230***b* mate with contacts of the corresponding receptacle connector in the other orientation.

[0135] Tongue **1230** may be a PCB having contacts, which PCB may be overmolded with one or more of a variety of dielectric materials including flexible, wear resistant materials such as LCP, POM, Nylon and others. Tongue **1230** may vertically translate either toward first or second inner surfaces **1220***a*, **1220***b* of shell **1220** when connector **1210** is inserted into a corresponding receptacle connector. This vertical translation may be facilitated by an elevator mechanism **1290**, e.g., a spring or other vertical translation guide, that may not allow tongue **1230** to move horizontally or pivot. Elevator mechanism **1290** may be engaged as bullnose tip **1230***c* comes into contact with internal features of a corresponding receptacle connector during an insertion event and may vertically translate tongue **1230** to the appropriate region within a corre-

sponding receptacle connector, allowing contacts disposed on either surface **1230***a* or **1230***b* of the plug connector **1210** to mate with contacts on the corresponding receptacle connector.

[0136] As mentioned earlier, tongue **1230** may be centrally located within opening **1225** of shell **1220**. For example, tongue **1230** may be positioned within opening **1225** such that its distance from first and second inner surfaces **1220***a*, **1220***b* causes connector **1210** to always vertically translate, with the assistance of bullnose tip **1230***c* and elevator mechanism **1290**, toward the appropriate region within a corresponding receptacle connector regardless of whether plug connector **1210** is in the first or second orientation, as described above.

[0137] Body **1215** is generally the portion of connector **1210** that a user will hold onto when inserting or removing connector **1210** from a corresponding receptacle connector. Body **1215** can be made out of a variety of materials and in some embodiments is made from a dielectric material, such as a thermoplastic polymer formed in an injection molding process. While not shown in FIG. **12**A or **12**B, a cable and a portion of shell **1220** may extend within and be enclosed by body **1215**. In addition, electrical contact to the contacts of surfaces **1230***a*, **1230***b* can be made with individual wires in a cable within body **1215**. In one embodiment, a cable includes a plurality of individual insulated wires for connecting to contacts of surfaces **1230***a*, **1230***b* that are soldered to bonding pads on a PCB housed within body **1215** or on tongue **1230** when tongue **1230** is a PCB. The bonding pads on the PCB may be electrically coupled to corresponding individual contacts of surfaces **1230***a* and **1230***b*. In some embodiments, contacts of one of surfaces **1230***a* and **1230***b* to be shorted through tongue **1230** to corresponding contacts on the other of surfaces **1230***a* and **1230***b* and then appropriately routed to the individual wires of a cable within body **1215**.

[0138] The contacts of tongue **1230** can be made from copper, nickel, brass, a metal alloy or any other appropriate conductive material. In some embodiments, contacts can be printed on surfaces PCB **1232**. As with standard USB plug connectors, plug connector **1210** may include contacts for power, ground and a pair of differential data signals (e.g., data transmit). For example, contact **1240***a* (not shown in FIG. **12**A) may be a ground pin, contact **1240***b* may be a Data+pin, contact **1240***c* may be a Data−pin, and contact **1240***d* may be a power pin (VBUS). As mentioned earlier, the four additional contacts disposed on second major surface **1230***b* can be positioned so that the contacts on first and second major surfaces **1230***a*, **1230***b* are arranged in a symmetric manner and have the same pinout. In this manner, either of two intuitive insertion orientations may result in the same plug connector **1210** pinout being mated with corresponding contacts of a receptacle connector during a mating event.

[0139] A sensing circuit as described above may be included with connector **1210** and/or a corresponding receptacle connector.

[0140] An example of another embodiment of the present invention is shown in the following figures.

[0141] FIGS. **13**A and **13**B are partial cross sectional perspective and cross sectional views, respectively, of a USB plug connector **1310** according to one embodiment of the present invention. Connector **1310** includes a body **1315** and a shell **1320** extending longitudinally away from body **1315** in a direction parallel to the length of connector **1310**. Shell **1320** includes an opening **1325** that communicates with a cavity defined by first, second, left and right inner surfaces **1320***a*-**1320***d* of shell **1320**, spring contacts **1340***a*-**1340***d*, and a support structure **1335**. As shown in FIGS. **13**A and **13**B, spring contacts **1340***a*-**1340***d* may be centrally located between first and second inner surfaces **1320***a*, **1320***b* and extend parallel to the length of connector **1310**. As also shown in FIGS. **13**A and **13**B, a bullnose tip may be formed at the distal ends of spring contacts **1340***a*-**1340***d*.

[0142] As shown in FIGS. **13**A and **13**B, connector **1310** can have a 180 degree symmetrical, double orientation design which enables the connector to be inserted into a corresponding receptacle connector in both a first orientation where surface **1330***a* is facing up or a second orientation where surface **1330***a* is rotated 180 degrees and facing down. To allow for the orientation agnostic feature of connector **1310**, spring contacts **1340***a*-**1340***d* are not polarized. Specifics of general double or dual orientation designs are discussed in detail above. Simply stated, one side of spring contacts **1340***a*-**1340***d* mate with contacts of a corresponding receptacle connector in one orientation and the other side of spring contacts **1340***a*-**1340***d* may mate with contacts of a corresponding receptacle connector in the other orientation.

[0143] Structural support **1335** may be made from a variety of dielectric materials, including flexible polymers. The materials used to form structural support **1335** may be chosen such that spring contacts **1340***a*-**1340***d* deflects either toward first or second inner surfaces **1320***a*, **1320***b* of shell **1320** when connector **1310** is inserted into a corresponding receptacle connector. This deflection may occur as the distal tip of spring contacts **1340***a*-**1340***d*, which may be a bullnose tip, comes into contact with internal features of a corresponding receptacle connector and leads spring contacts **1340***a*-**1340***d* to the appropriate region within a corresponding receptacle connector, allowing spring contacts **1340***a*-**1340***d* to mate with contacts on the corresponding receptacle connector.

[0144] As mentioned earlier, spring contacts **1340***a*-**1340***d* may be centrally located within opening **1325** of shell **1320**. For example, spring contacts **1340***a*-**1340***d* may be positioned within opening **1325** such that its distance from first and second inner surfaces **1320***a*, **1320***b* causes spring contacts **1340***a*-**1340***d* to always deflect, possibly with the assistance of bullnose tips, toward the appropriate region within a corresponding receptacle connector regardless of whether plug connector **1310** is in the first or second orientation, as described above.

[0145] Body **1315** is generally the portion of connector **10** that a user will hold onto when inserting or removing connector **1310** from a corresponding receptacle connector. Body **1315** can be made out of a variety of materials and in some embodiments is made from a dielectric material, such as a thermoplastic polymer formed in an injection molding process. While not shown in FIG. **13**A or **13**B, a cable and a portion of shell **1320** may extend within and be enclosed by body **1315**. Also, electrical contact to spring contacts **1340***a*-**1340***d* can be made with individual wires in a cable within body **1315**. In one embodiment, a cable includes a plurality of individual insulated wires for connecting to spring contacts **1340***a*-**1340***d* that are soldered to bonding pads on a PCB housed within body **1315**. Thus, the bonding pads on the PCB may be electrically coupled to corresponding individual spring contacts **1340***a*-**1340***d*.

[0146] Spring contacts **1340***a*-**1340***d* can be made from copper, nickel, brass, a metal alloy or any other appropriate conductive material. As with standard USB plug connectors,

plug connector **1310** may include contacts for power, ground and a pair of differential data signals (e.g., data transmit). For example, contact **1340***a* may be a ground pin, contact **1340***b* may be a Data+pin, contact **1340***c* may be a Data−pin, and contact **1340***d* may be a power pin (VBUS).

[0147] A sensing circuit as described above may be included with connector **1310** and/or a corresponding receptacle connector.

[0148] An example of another embodiment of the present invention is shown in the following figures.

[0149] FIGS. **14**A and **14**B are partial cross sectional perspective and cross sectional views, respectively, of a USB plug connector **1410** according to one embodiment of the present invention. Connector **1410** includes a body **1415** and a shell **1420** extending longitudinally away from body **1415** in a direction parallel to the length of connector **1410**. Shell **1420** contains a first and second pistoning contact blocks **1492***a*, **1492***b*. Springs **1494***a* and **1494***b* may bias pistoning blocks **1492***a* and **1492***b*, respectively, in the position shown in FIG. **4**B. When a pistoning contact blocks **1492***a* and/or **1492***b* are pressed into shell **1420** (e.g., during a mating event with a receptacle connector corresponding to plug connector **1410**), springs **1494***a* and/or **1494***b* may compress in order to allow this movement. And when a pressing force is removed from pistoning contact blocks **1492***a* and/or **1492***b*, springs **1494***a* and/or **1494***b* may cause pistoning contact blocks **1492***a* and/or **1492***b* to return to their positions as shown in FIG. **14**B. Additionally, when one of pistoning blocks **1492***a*, **1492***b* is pressed into shell **1420**, a tongue **1430** may be revealed. Tongue **1430** may be centrally located within shell **1420** and extend parallel to the length of connector **1410**. Four contacts (e.g., contacts **1440***a* and **1440***e* as shown in FIG. **14**B) may be disposed on both of first and second major surfaces of tongue **1430**.

[0150] As shown in FIGS. **14**A and **14**B, connector **1410** can have a 180 degree symmetrical, double orientation design which enables the connector to be inserted into a corresponding receptacle connector in both a first orientation as shown in FIG. **14**A and a second orientation where connector **1410** is rotated 180 degrees about its length axis. Specifics of general double or dual orientation designs are discussed in greater detail above. Simply stated, the dual orientation design of connector **1410** allows one set of four contacts of **1410** to mate with contacts of the corresponding receptacle connector in the first and in the second orientation.

[0151] Tongue **1430** may be any of the tongue embodiments previously described herein. However, a rigid embodiment of tongues according to the present invention may be useful for connector **1410**. The contacts of tongue **1430** may also be any of the contacts embodiments previously described herein.

[0152] Body **1415** is generally the portion of connector **1410** that a user will hold onto when inserting or removing connector **1410** from a corresponding receptacle connector. Body **1415** can be made out of a variety of materials and in some embodiments is made from a dielectric material, such as a thermoplastic polymer formed in an injection molding process. While not shown in FIG. **14**A or **14**B, a cable and a portion of shell **1420** may extend within and be enclosed by body **1415**, as described in relation to other embodiments of the present invention.

[0153] A sensing circuit as described above may be included with connector **1410** and/or a corresponding receptacle connector.

[0154] Also, while a number of specific embodiments were disclosed with specific features, a person of skill in the art will recognize instances where the features of one embodiment can be combined with the features of another embodiment. For example, some specific embodiments of the invention set forth above were illustrated with specific tongue or tab designs. A person of skill in the art will readily appreciate that any of the tongues or tab described herein, as well as others not specifically mentioned, may be used instead of or in addition to the tongue or tab discussed with respect to specific embodiments of the present invention. As another example, some specific embodiments of the invention set forth above were illustrated with cable assemblies having a cable connected to a USB connector. A person of skill in the art will readily appreciate that any of the cable assemblies herein, as well as others not specifically mentioned, may be modified to be a USB flash drive or another device that includes a USB connector but does not include a cable. Also, those skilled in the art will recognize, or be able to ascertain using no more than routine experimentation, many equivalents to the specific embodiments of the inventions described herein.

What is claimed is:

1. A reversible plug connector comprising:

a body;

a dielectric base;

a shell extending from the body and having an opening at a first end that communicates with a cavity defined by inner surfaces of the shell and the dielectric base;

a deflectable tongue disposed within the cavity and extending from the dielectric base towards the opening, the tongue having a tip proximal the opening and first and second opposing surfaces that extend from the tip towards the base, the tongue including a first plurality of contacts exposed at the first surface of the tongue proximal the tip and a second plurality of contacts exposed at the second surface of the tongue proximal the tip; and

a support structure that includes first and second support members disposed adjacent to the base and located on opposite sides of the tongue, the first support member having a first major surface that faces the first surface of the tongue, the second support member having a second major surface that faces the second surface of the tongue, the first and second major surfaces oriented in first and second planes, respectively, the first plane extending parallel to the second plane, wherein the first support member is configured to distribute stress across a bending portion of the tongue when the tongue deflects towards and makes contact with the first major surface and the second support member is configured to distribute stress across the bending portion of the tongue when the tongue deflects towards and makes contact with the second major surface.

2. The plug connector set forth in claim **1** wherein a height of the first support member varies about a portion of a length of the tongue.

3. The plug connector set forth in claim **1** wherein the first support member has a varying durometer.

4. The plug connector set forth in claim **1** wherein the first and second support members are symmetric about a length direction of the tongue.

5. The plug connector set forth in claim **1** wherein the first and second support members are injection molded.

6. The plug connector set forth in claim **1** wherein the first and second support members are made from a thermoplastic.

7. The plug connector set forth in claim **1** wherein the tongue includes a plurality of contact frames.

8. A reversible plug connector comprising:

a body;

a dielectric base;

a shell extending from the body and having an opening at a first end that communicates with a cavity defined by inner surfaces of the shell and the dielectric base;

a deflectable tongue disposed within the cavity and extending from the dielectric base towards the opening, the tongue having a tip proximal the opening and first and second opposing surfaces that extend from the tip towards the base, the tongue including a first plurality of contacts exposed at the first surface of the tongue proximal the tip and a second plurality of contacts exposed at the second surface of the tongue proximal the tip; and

a support structure that includes first and second support members disposed adjacent to the base and located on opposite sides of the tongue, the first support member having a first major surface that faces the first surface of the tongue, the second support member located having a second major surface that faces the second surface of the tongue, wherein a distance between the first and second major surfaces varies along a portion of a length of the tongue, wherein the first support member is configured to distribute stress across a bending portion of the tongue when the tongue deflects towards and makes contact with the first major surface and the second support member is configured to distribute stress across the bending portion of the tongue when the tongue deflects towards and makes contact with the second major surface.

9. The plug connector set forth in claim **8** wherein the first and second support members form a tapered opening through which the tongue extends.

10. The plug connector set forth in claim **8** wherein at least one of the first and second major surfaces includes a series of hills and valleys.

11. The plug connector set forth in claim **8** wherein at least one of the first and second major surfaces is at least partially curved.

12. The plug connector set forth in claim **8** wherein the first support member extends farther from the base than that of the second support member.

13. The plug connector set forth in claim **8** wherein the tongue includes a printed circuit board.

14. The plug connector set forth in claim **8** wherein the first and second support members are assembled with the base.

15. A reversible Universal Serial Bus plug connector comprising:

a body;

a dielectric base;

a support structure having a slot and being disposed adjacent to the base;

a shell extending from the body and having an opening at a first end that communicates with a cavity defined by four inner surfaces of the shell and the support structure; and

a deflectable tongue disposed within the cavity and extending from a surface of the slot towards the opening, the tongue having a tip proximal the opening and first and second opposing surfaces that extend from the tip towards the surface of the slot, the tongue including a contact region that includes a first plurality of contacts exposed at the first surface of the tongue proximal the tip and a second plurality of contacts exposed at the second surface of the tongue proximal the tip, the tongue including a plurality of contact frames spaced apart from each other along a width of the tongue and extending between the surface of the slot and the contact region,

wherein each of the contact frames is coupled to at least one contact of the first or second plurality of contacts;

wherein a first portion of the slot surface faces the first surface of the tongue and a second portion of the slot surface faces the second surface of the tongue, wherein the first portion of the slot surface is configured to distribute stress across bending portions of the plurality of contact frames when the tongue deflects towards and makes contact with the first portion of the slot surface and the second portion of the slot surface is configured to distribute stress across the bending portions of the plurality of contacts when the tongue deflects towards and makes contact with the second portion of the slot surface.

16. The plug connector set forth in claim **15** wherein a distance between the first and second portions varies along a portion of a length of the tongue.

17. The plug connector set forth in claim **15** wherein the first and second portions are oriented in first and second planes, respectively, the first plane extending parallel to the second plane.

18. The plug connector set forth in claim **15** wherein the support structure has a varying durometer.

19. The plug connector set forth in claim **15** wherein a cable is coupled to the body and includes a plurality of insulated wires that are electrically coupled to the tongue.

20. The plug connector set forth in claim **15** wherein the plurality of contact frames are made from a metal alloy.

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