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Popovich et al.

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- (54) **MOUNTING ARRANGEMENT FOR LIGHT EMITTING DIODES**
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- (*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

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Related U.S. Application Data

- (63) Continuation of application No. 09/693,548, filed on Oct. 19, 2000, now Pat. No. 6,712,486.
- (60) Provisional application No. 60/160,480, filed on Oct. 19, 1999, provisional application No. 60/200,531, filed on Apr. 27, 2000.

- (51) **Int. Cl.**
F21Y 101/02 (2006.01)
- (52) **U.S. Cl.** **362/294; 362/800; 362/547**
- (58) **Field of Classification Search** 362/294, 362/373, 800, 547
See application file for complete search history.

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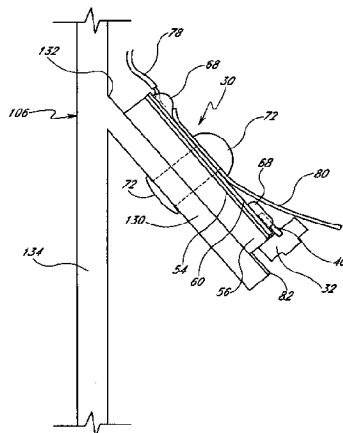
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(57) **ABSTRACT**

A modular light emitting diode (LED) mounting configuration is provided including a light source module having a plurality of pre-packaged LEDs arranged in a serial array. The module includes a heat conductive body portion adapted to conduct heat generated by the LEDs to an adjacent heat sink. As a result, the LEDs are able to be operated with a higher current than normally allowed. Thus, brightness and performance of the LEDs is increased without decreasing the life expectancy of the LEDs. The LED modules can be used in a variety of illumination applications employing one or more modules.

90 Claims, 19 Drawing Sheets



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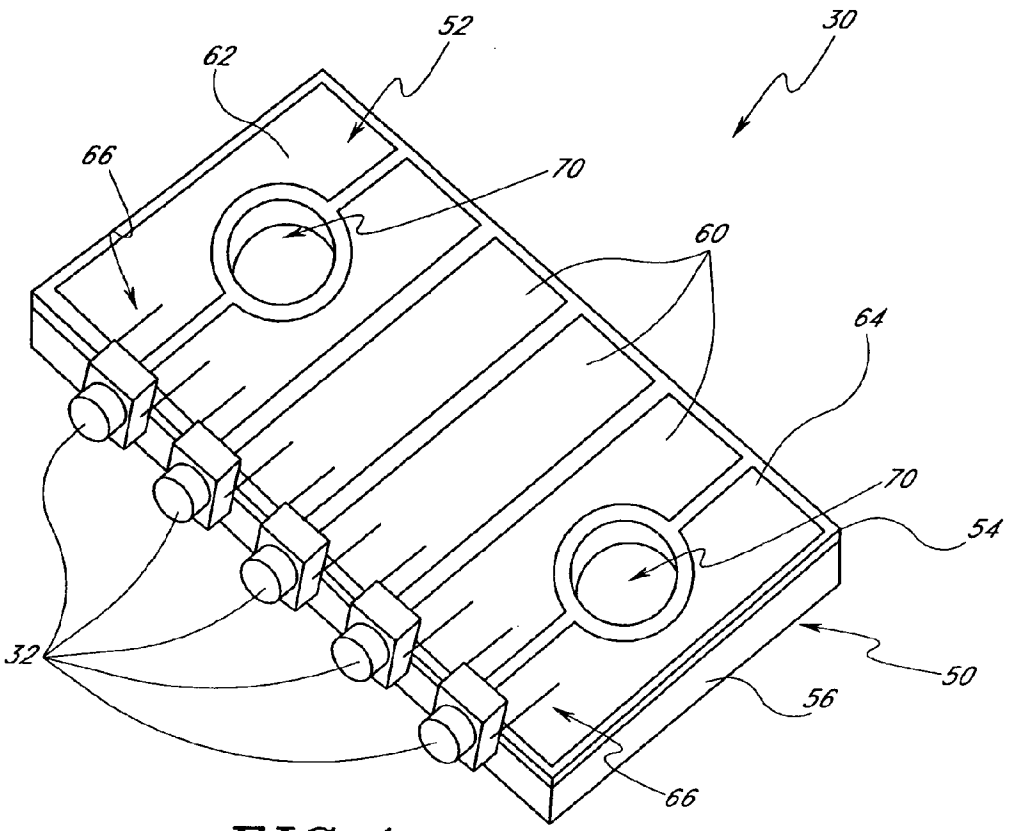


FIG. 1

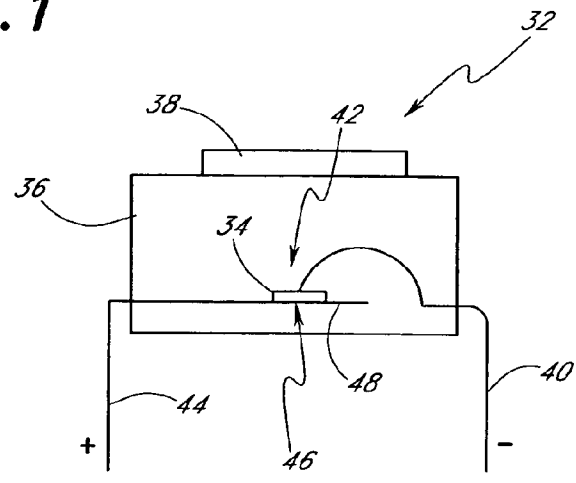
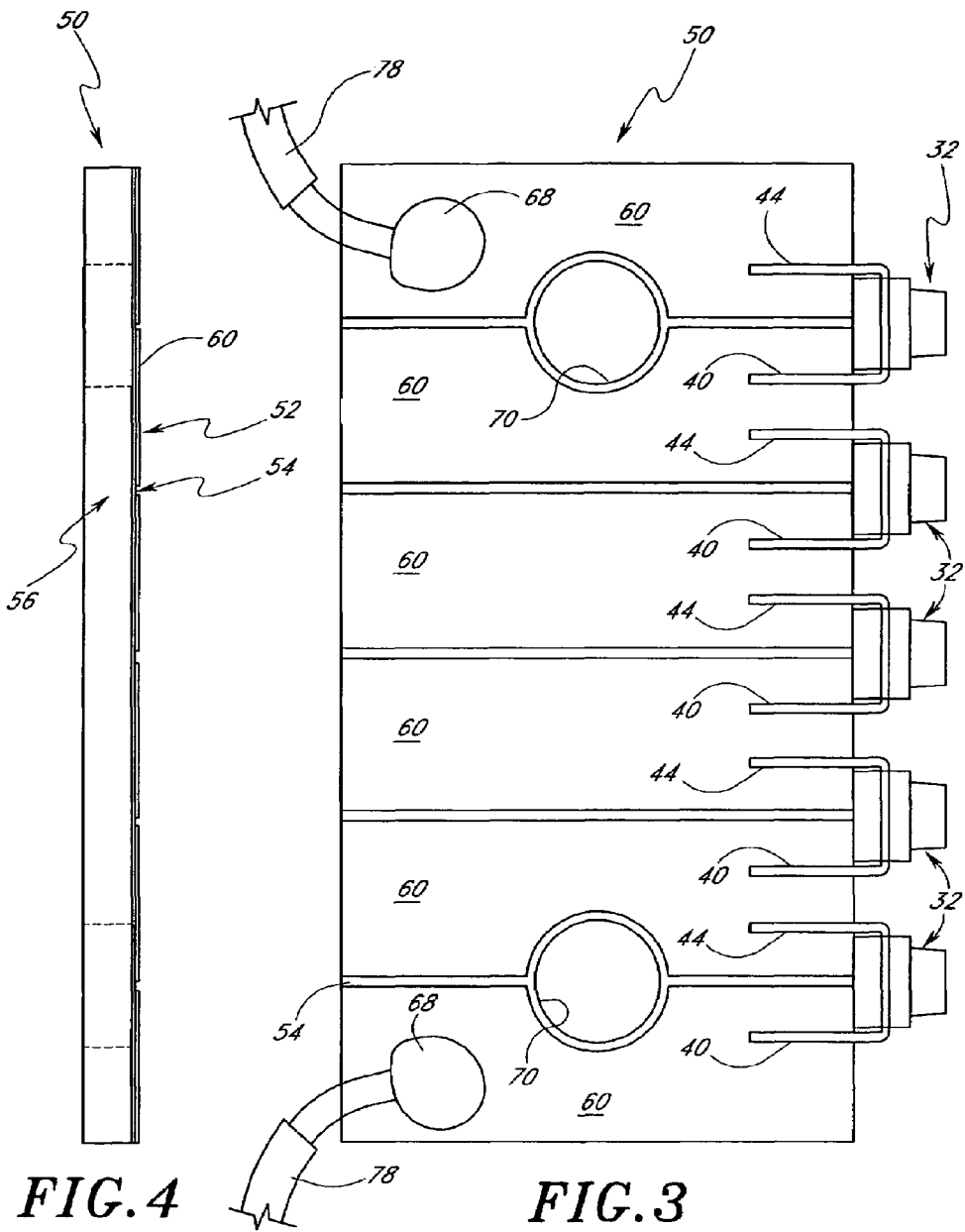


FIG. 2



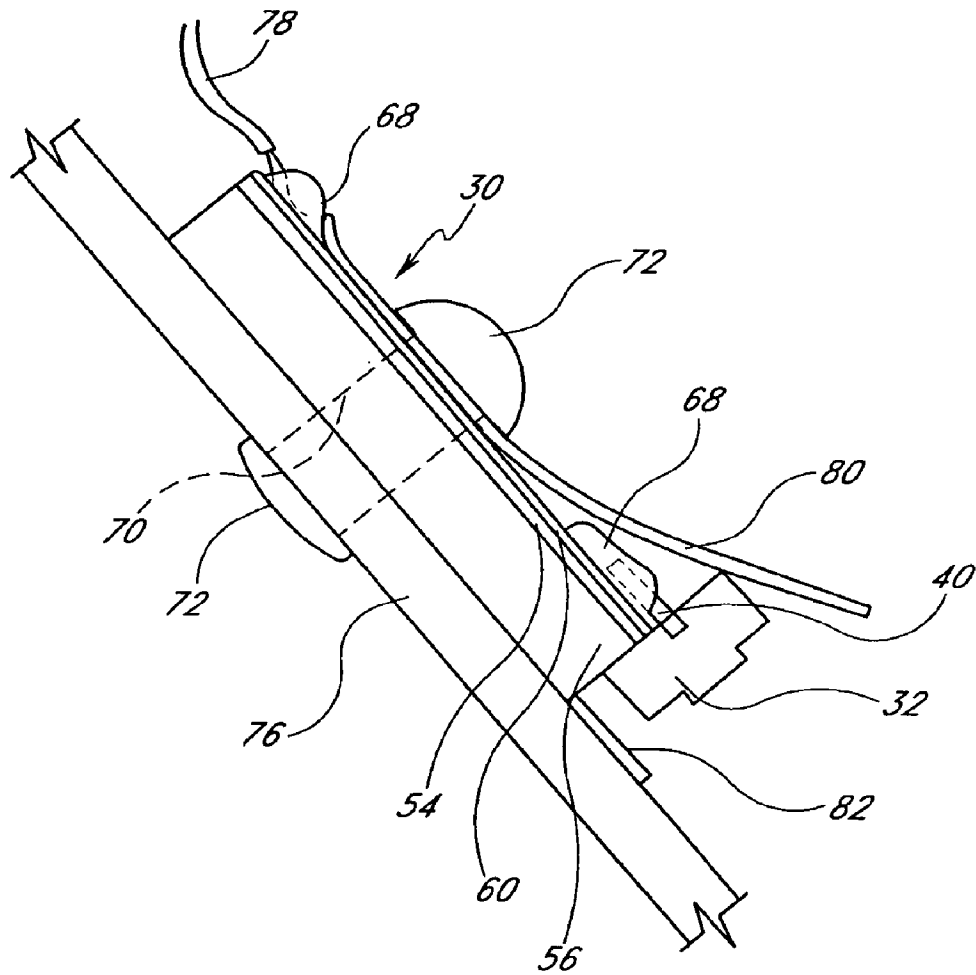
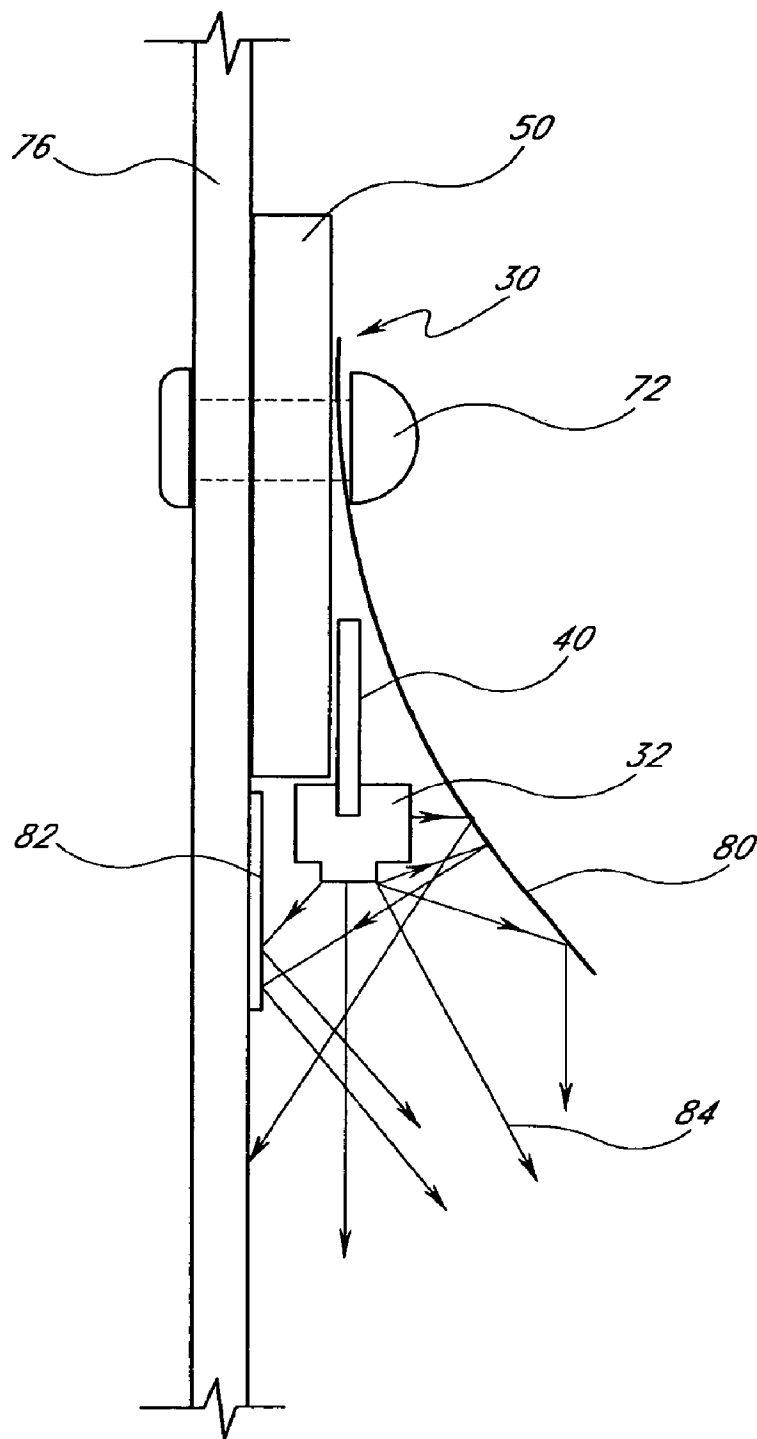


FIG.5

**FIG. 6**

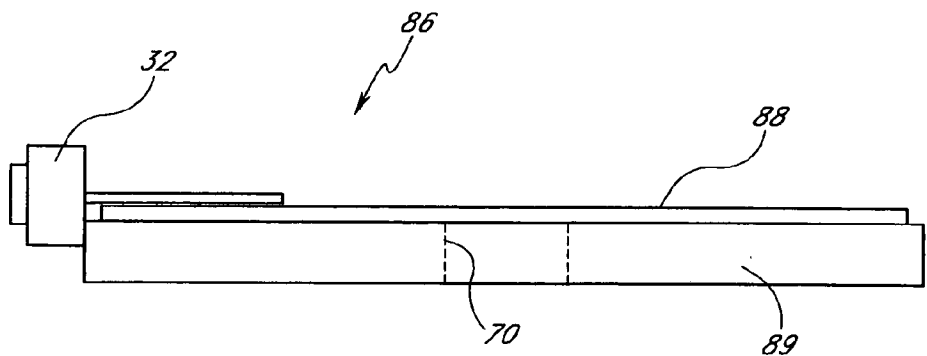


FIG. 7

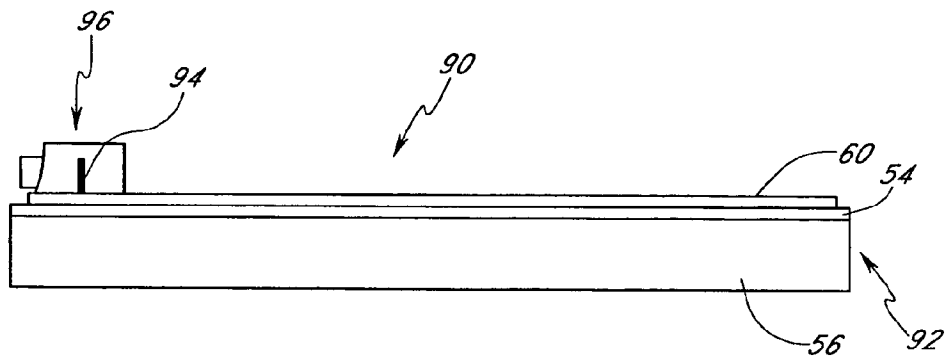


FIG. 8

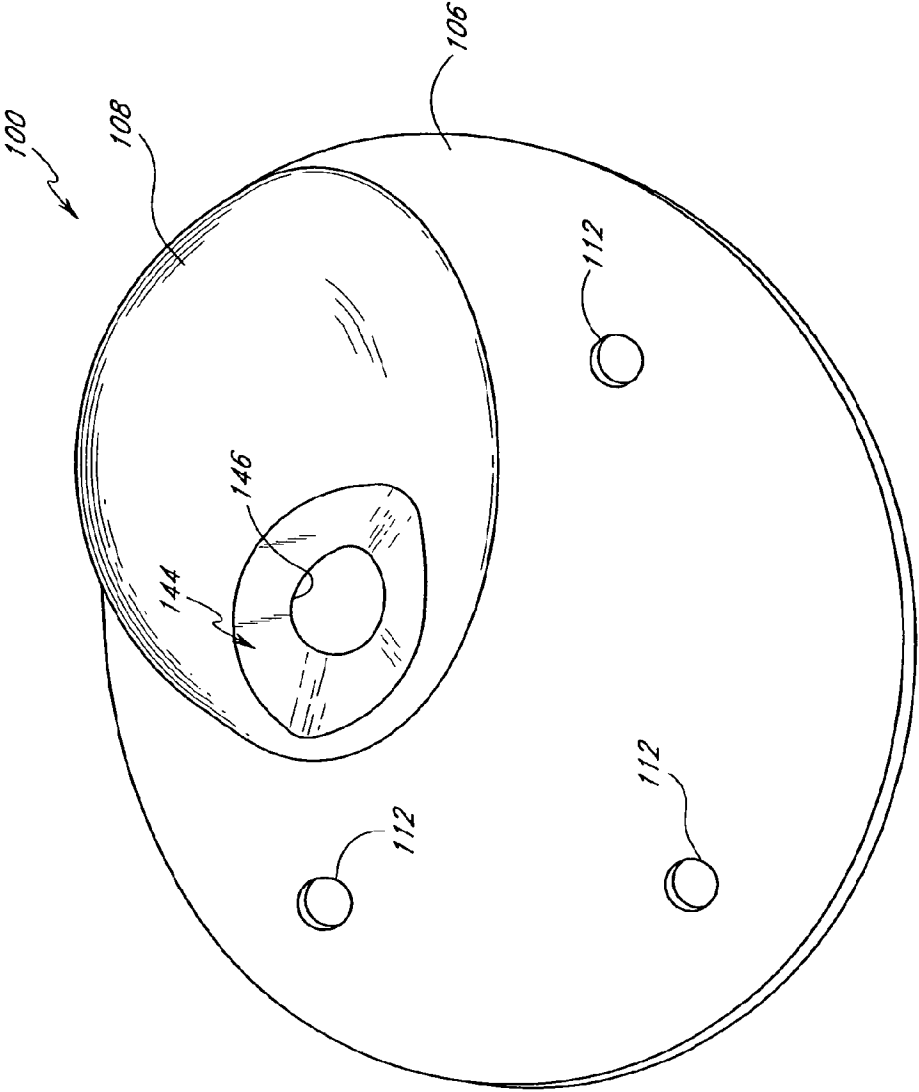


FIG. 9

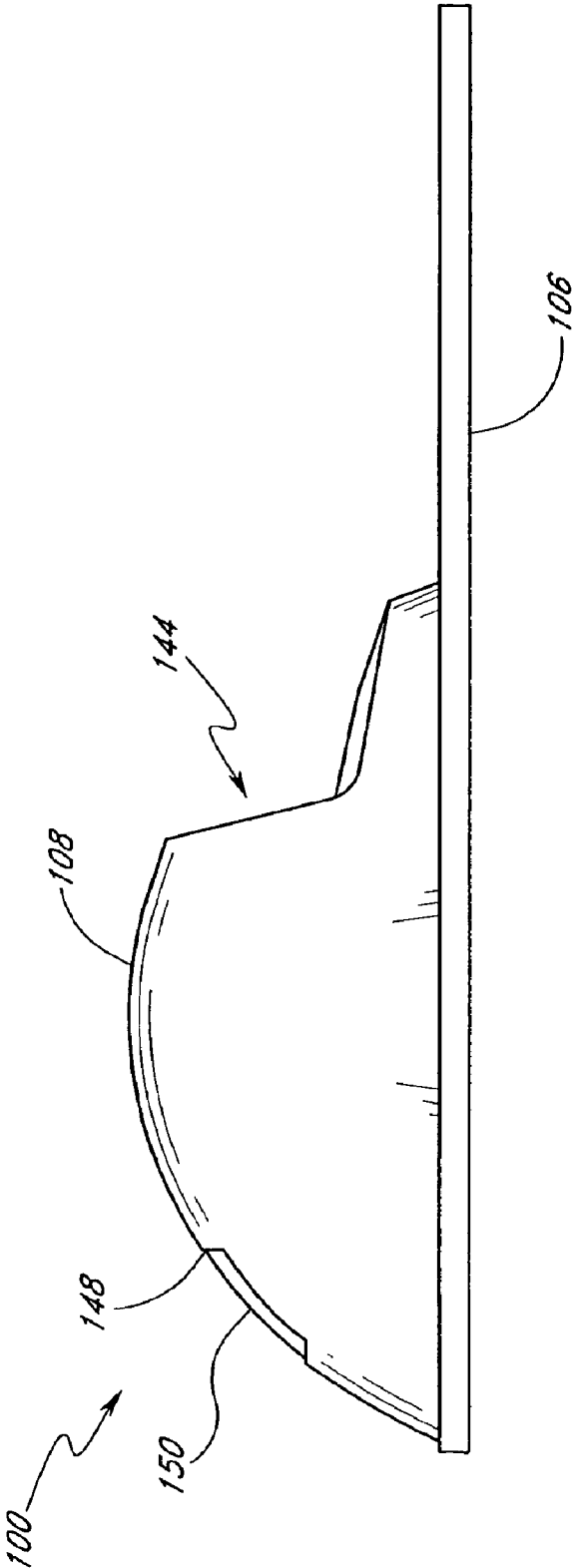


FIG. 10

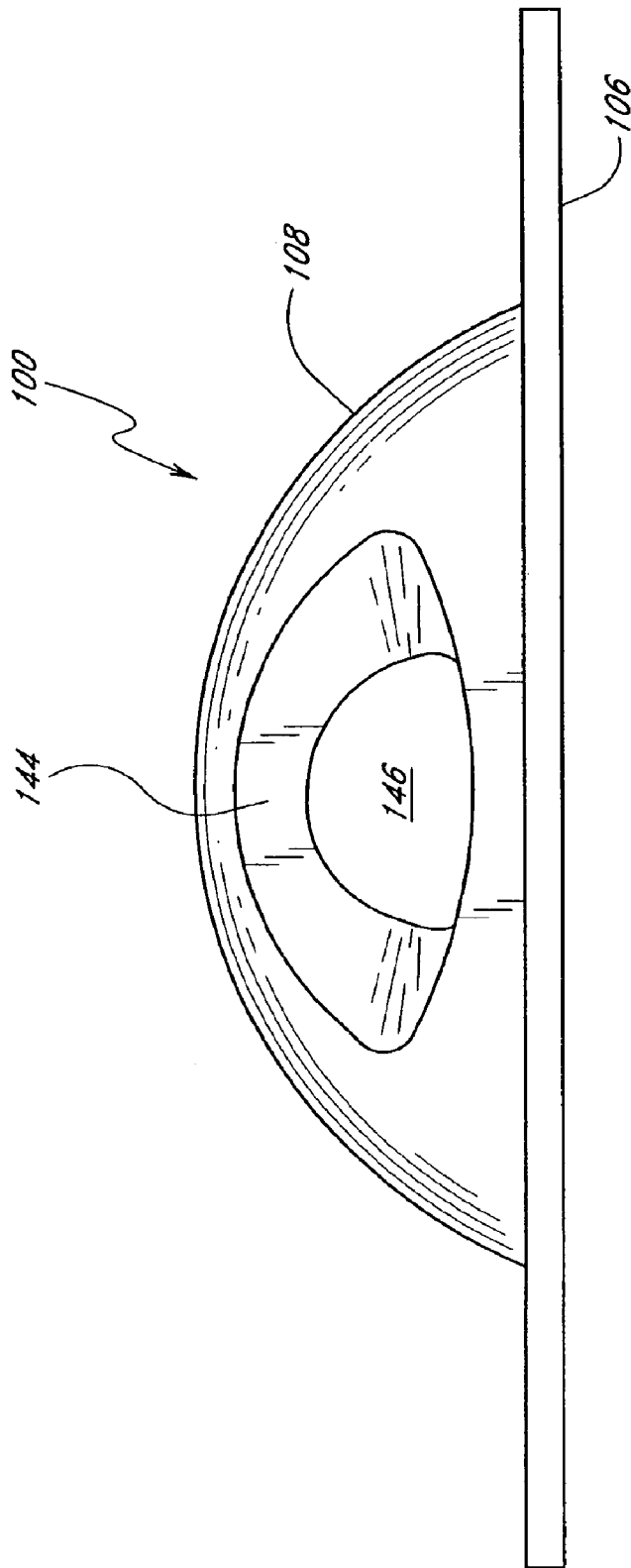
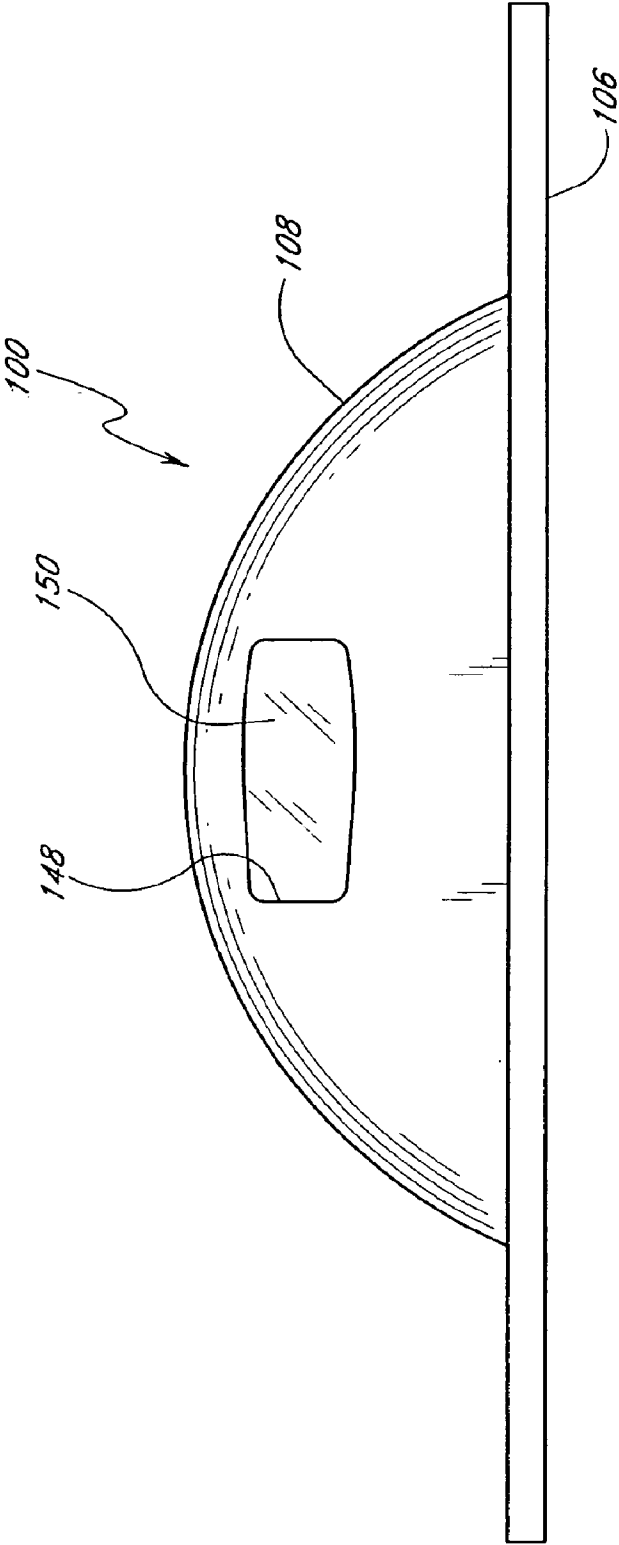


FIG. 11



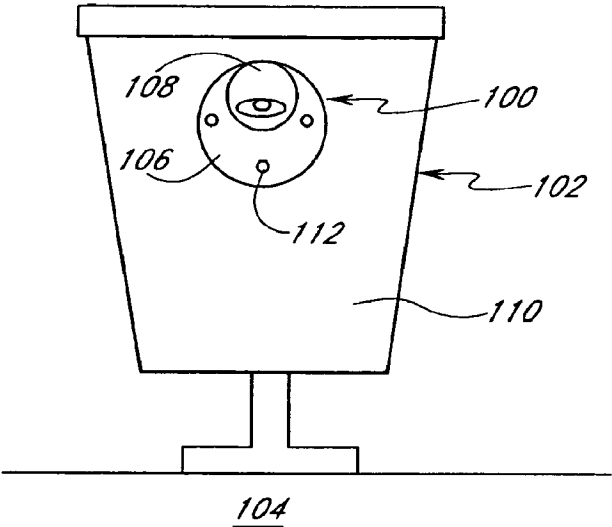


FIG. 13

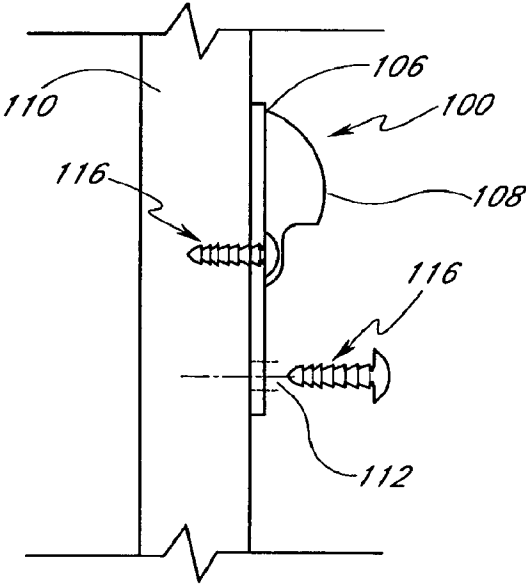


FIG. 14

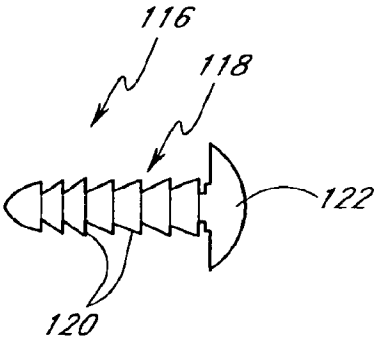


FIG. 15

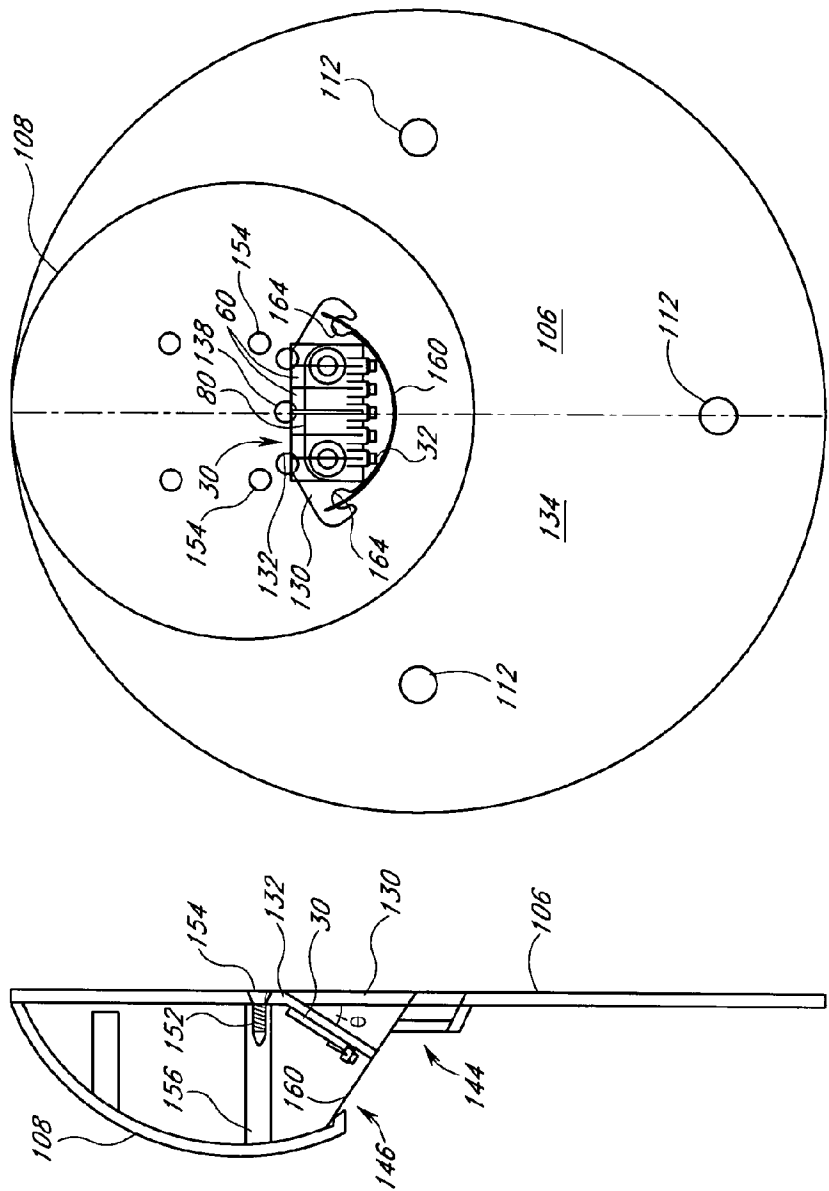


FIG. 16

FIG. 17

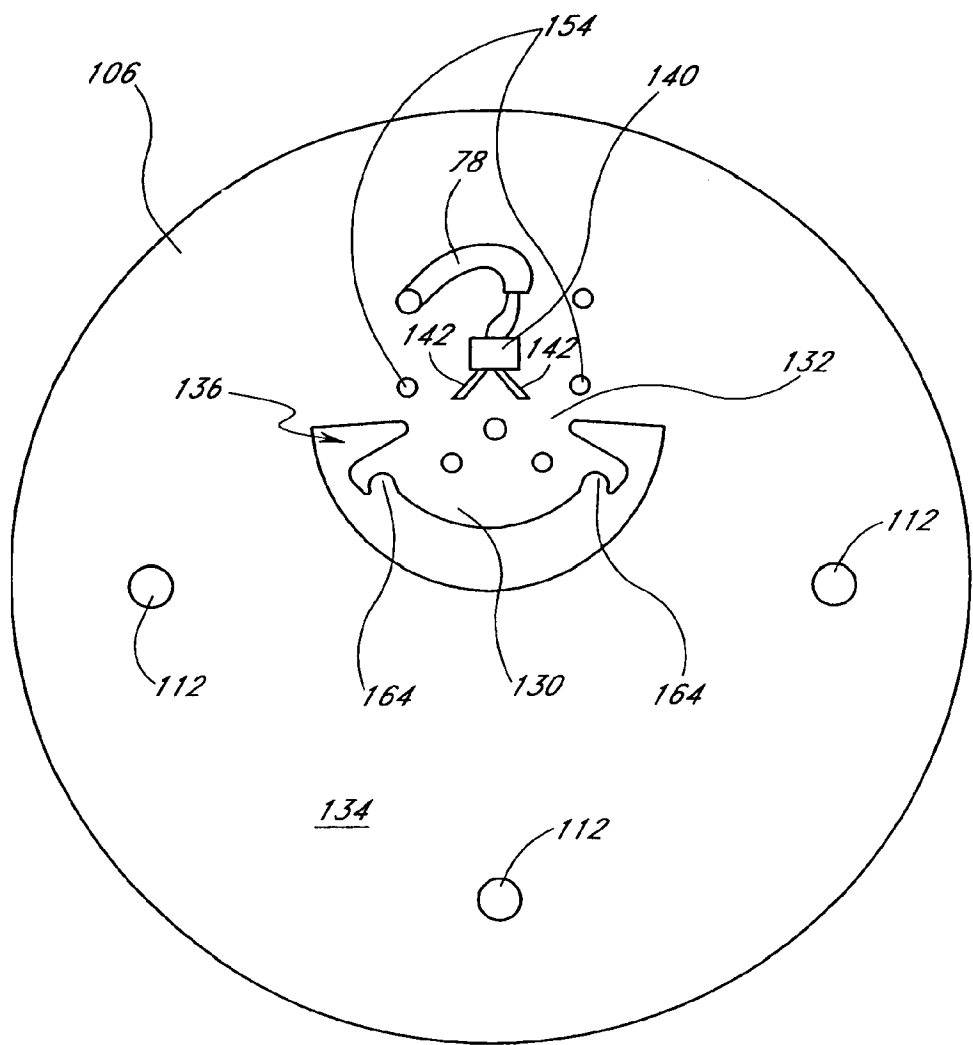


FIG. 18

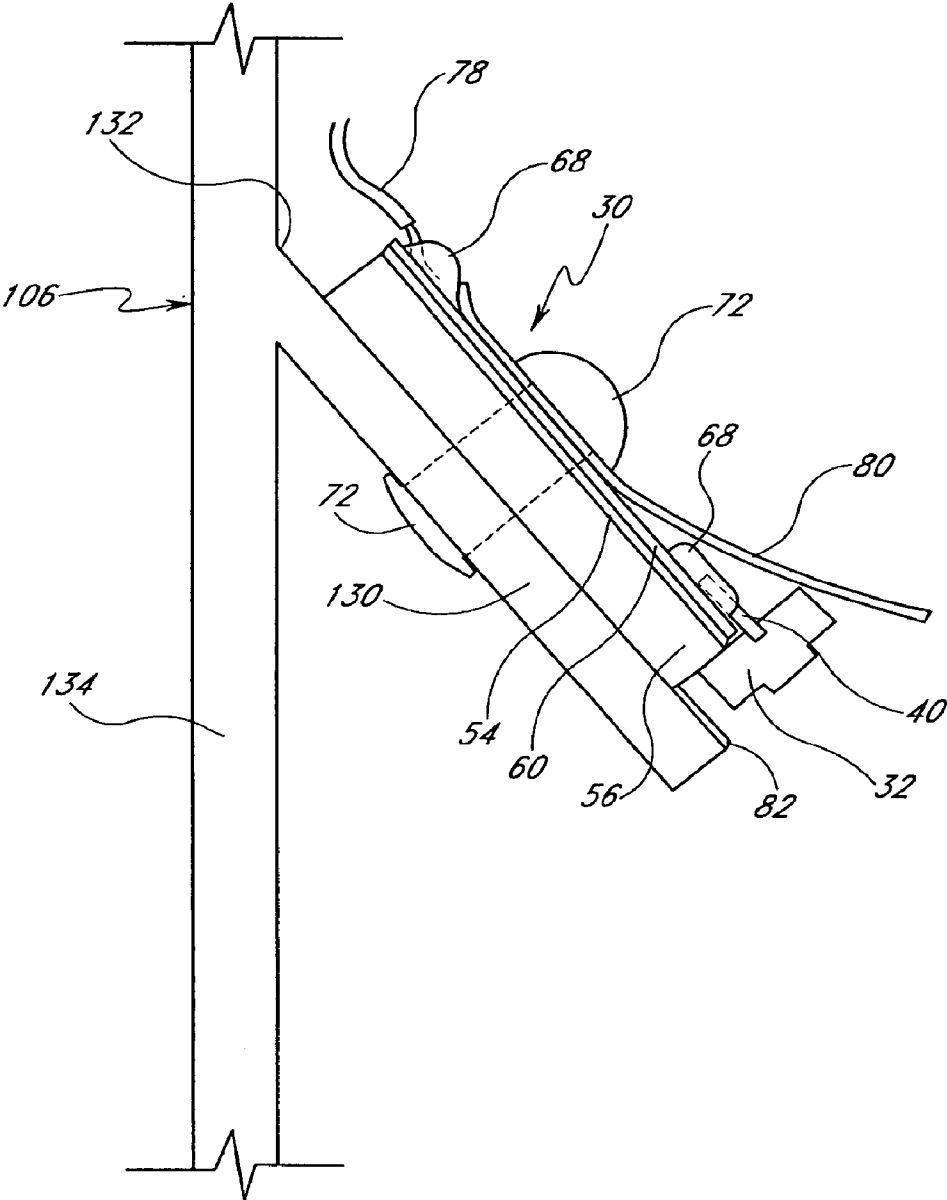


FIG. 19

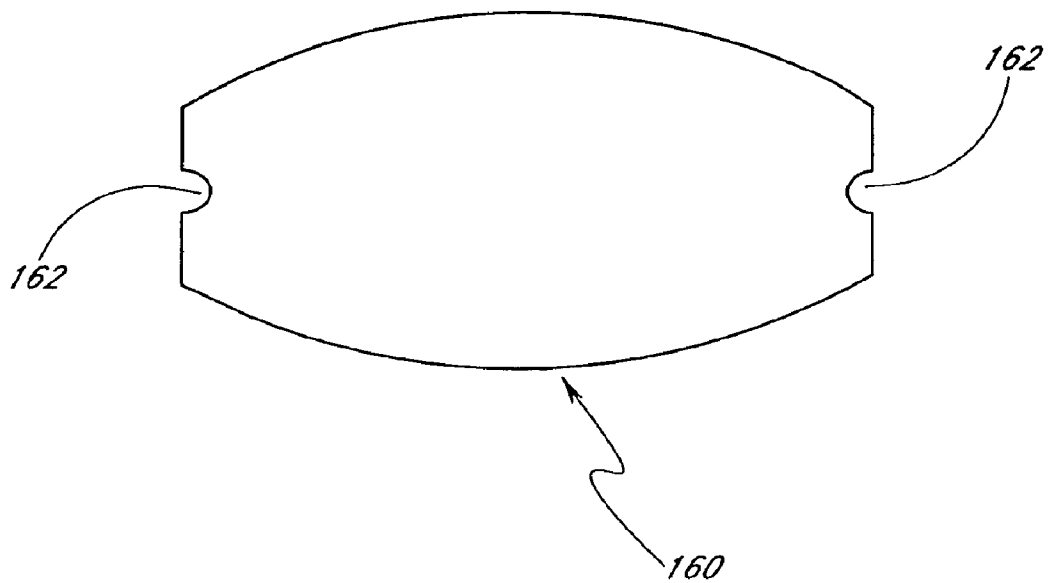
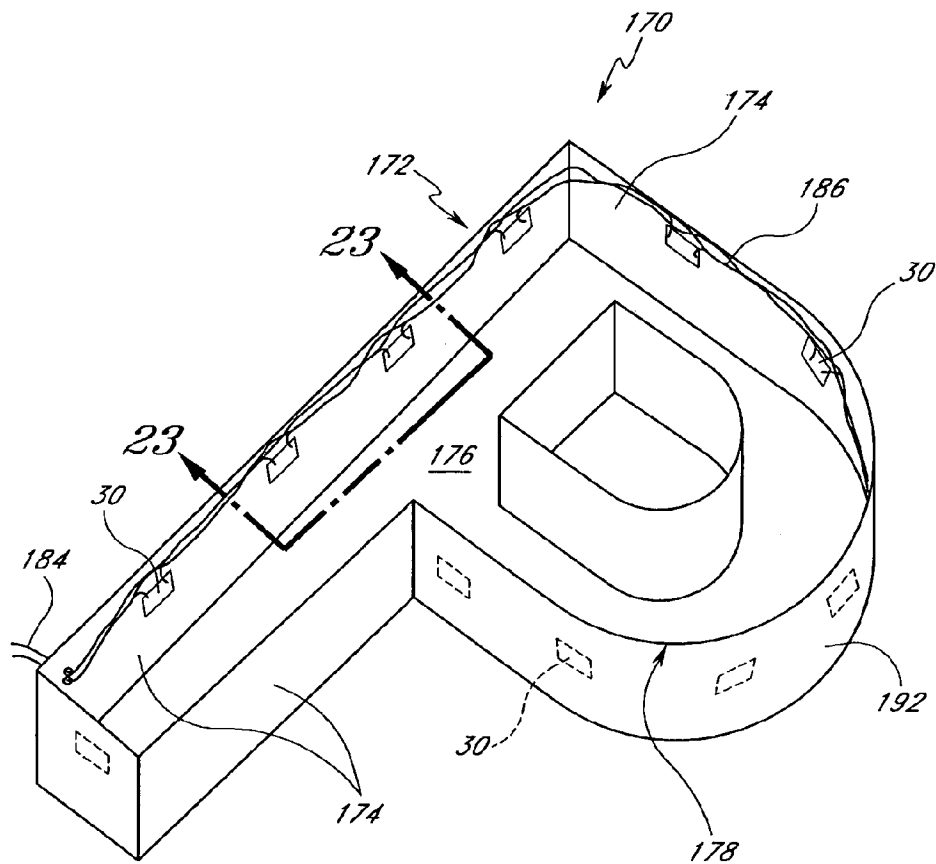
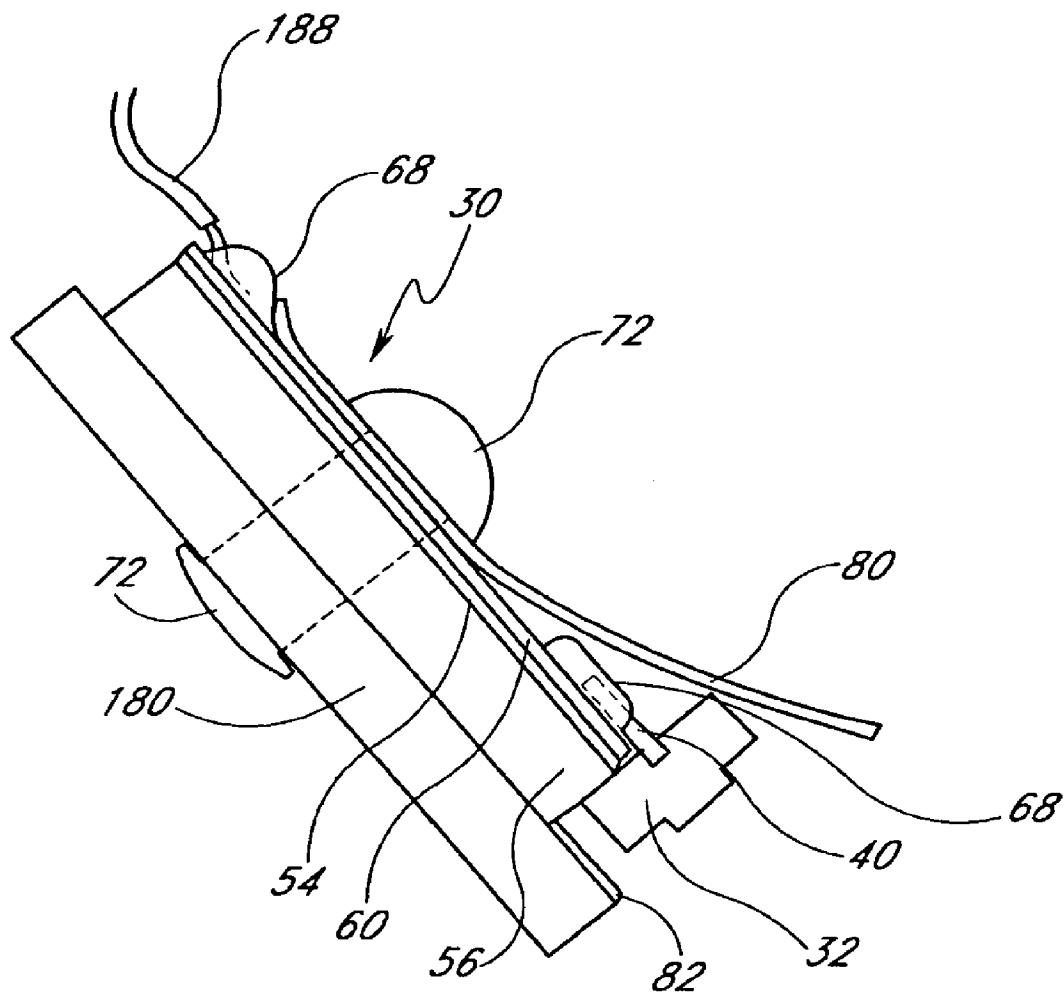


FIG. 20

**FIG. 21**

**FIG. 22**

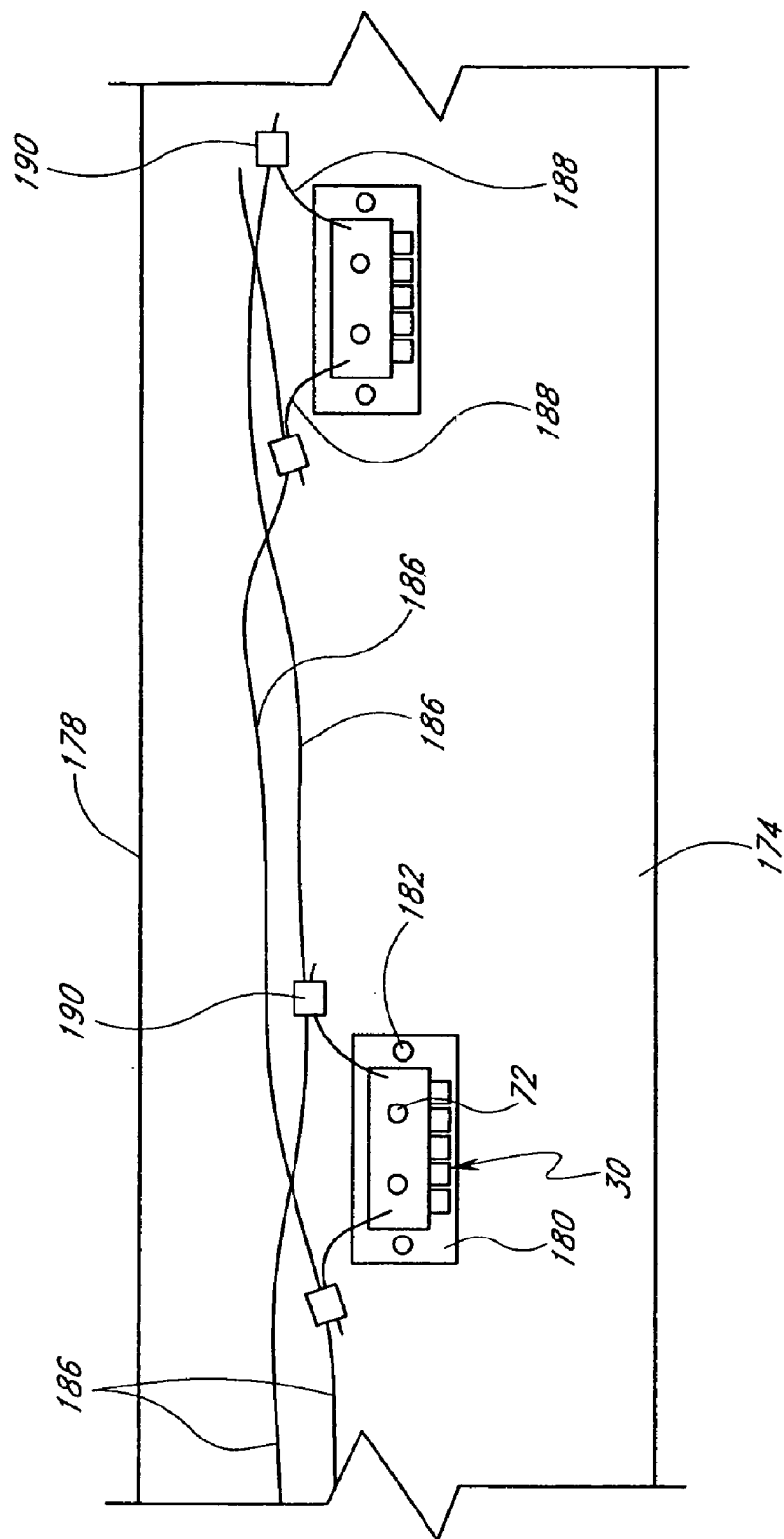


FIG. 23

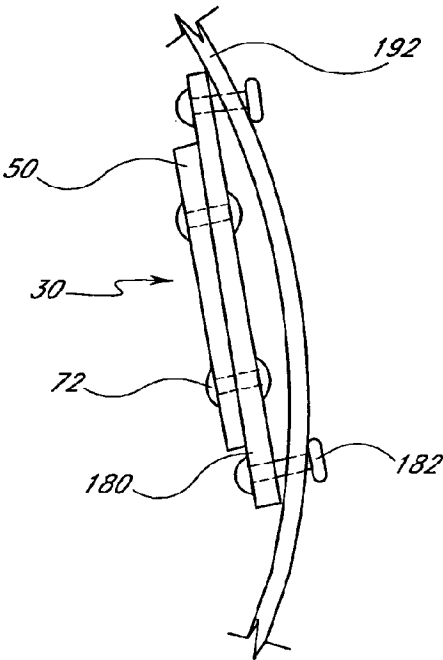


FIG. 24

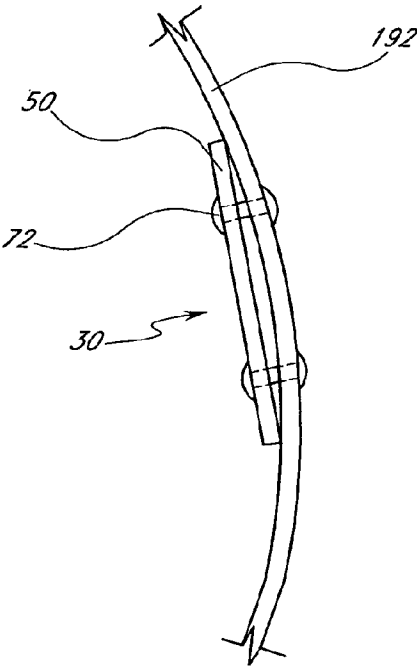


FIG. 25

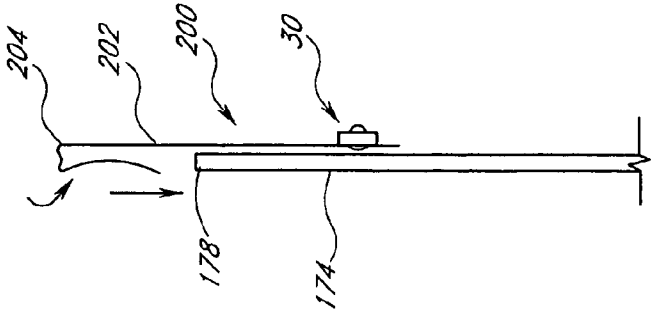


FIG. 26A

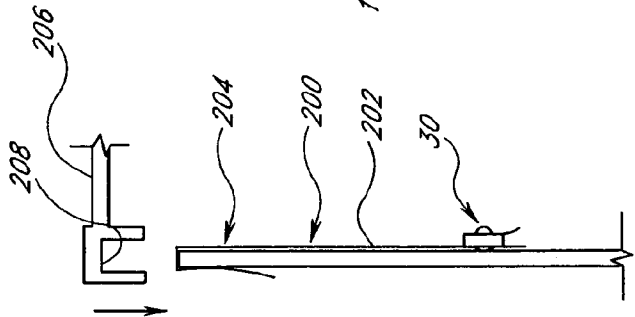


FIG. 26B

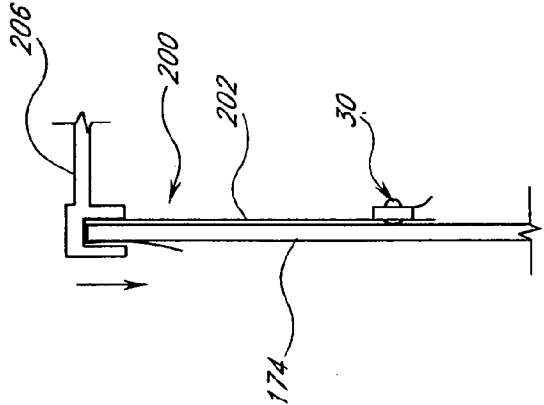


FIG. 26C

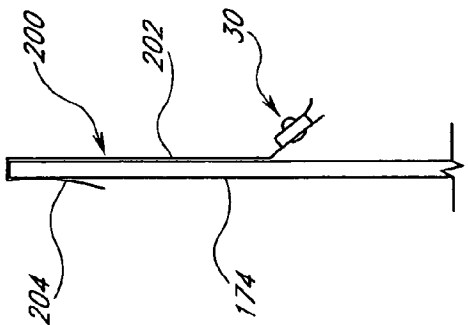


FIG. 26D

MOUNTING ARRANGEMENT FOR LIGHT EMITTING DIODES

RELATED APPLICATIONS

This application is a continuation of copending U.S. application Ser. No. 09/693,548, which was filed on Oct. 19, 2000, and which claims priority to U.S. Provisional Patent Application No. 60/160,480, which was filed on Oct. 19, 1999 and U.S. Provisional Patent Application No. 60/200,531, which was filed on Apr. 27, 2000. The entirety of each of these related applications is hereby incorporated by reference.

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention is in the field of light emitting diode (LED) lighting devices and more particularly in the field of an LED lighting module having heat transfer properties that improve the efficiency and performance of LEDs.

2. Description of the Related Art

Light emitting diodes (LEDs) are currently used for a variety of applications. The compactness, efficiency and long life of LEDs is particularly desirable and makes LEDs well suited for many applications. However, a limitation of LEDs is that they typically cannot maintain a long-term brightness that is acceptable for middle to large-scale illumination applications. Instead, more traditional incandescent or gas-filled light bulbs are often used.

An increase of the electrical current supplied to an LED generally increases the brightness of the light emitted by the LED. However, increased current also increases the junction temperature of the LED. Increased junction temperature may reduce the efficiency and the lifetime of the LED. For example, it has been noted that for every 10° C. increase in temperature, silicone and gallium arsenide lifetime drops by a factor of 2.5–3. LEDs are often constructed of semiconductor materials that share many similar properties with silicone and gallium arsenide.

SUMMARY OF THE INVENTION

Accordingly, there is a need in the art for an LED lighting apparatus having heat removal properties that allow an LED on the apparatus to operate at relatively high current levels without increasing the junction temperature of the LED beyond desired levels.

In accordance with an aspect of the present invention, an LED module is provided for mounting on a heat conducting surface that is substantially larger than the module. The module comprises a plurality of LED packages and a circuit board. Each LED package has an LED and at least one lead. The circuit board comprises a thin dielectric sheet and a plurality of electrically-conductive contacts on a first side of the dielectric sheet. Each of the contacts is configured to mount a lead of an LED package such that the LEDs are connected in series. A heat conductive plate is disposed on a second side of the dielectric sheet. The plate has a first side which is in thermal communication with the contacts through the dielectric sheet. The first side of the plate has a surface area substantially larger than a contact area between the contacts and the dielectric sheet. The plate has a second side adapted to provide thermal contact with the heat conducting surface. In this manner, heat is transferred from the module to the heat conducting surface.

In accordance with another aspect of the present invention, a modular lighting apparatus is provided for conducting heat away from a light source of the apparatus. The apparatus comprises a plurality of LEDs and a circuit board. The circuit board has a main body and a plurality of electrically conductive contacts. Each of the LEDs electrically communicates with at least one of the contacts in a manner so that the LEDs are configured in a series array. Each of the LEDs electrically communicates with corresponding contacts at an attachment area defined on each contact. An overall surface of the contact is substantially larger than the attachment area. The plurality of contacts are arranged adjacent a first side of the main body and are in thermal communication with the first side of the main body. The main body electrically insulates the plurality of contacts relative to one another.

For purposes of summarizing the invention and the advantages achieved over the prior art, certain objects and advantages of the invention have been described herein above. Of course, it is to be understood that not necessarily all such objects or advantages may be achieved in accordance with any particular embodiment of the invention. Thus, for example, those skilled in the art will recognize that the invention may be embodied or carried out in a manner that achieves or optimizes one advantage or group of advantages as taught herein without necessarily achieving other objects or advantages as may be taught or suggested herein.

All of these embodiments are intended to be within the scope of the invention herein disclosed. These and other embodiments of the present invention will become readily apparent to those skilled in the art from the following detailed description of the preferred embodiments having reference to the attached figures, the invention not being limited to any particular preferred embodiment(s) disclosed.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a perspective view of an LED module having features in accordance with the present invention.

FIG. 2 is a schematic side view of a typical pre-packaged LED lamp.

FIG. 3 is a top plan view of the LED module of FIG. 1.

FIG. 4 is a side plan view of the apparatus of FIG. 3.

FIG. 5 is a close-up side view of the apparatus of FIG. 3 mounted on a heat conductive member.

FIG. 6 is another sectional side view of the apparatus of FIG. 3 mounted onto a heat conductive flat surface.

FIG. 7 is a side plan view of an LED module having features in accordance with another embodiment of the present invention.

FIG. 8 is a side plan view of another LED module having features in accordance with yet another embodiment of the present invention.

FIG. 9 is a perspective view of an illumination apparatus having features in accordance with the present invention.

FIG. 10 is a side view of the apparatus of FIG. 9.

FIG. 11 is a bottom view of the apparatus of FIG. 9.

FIG. 12 is a top view of the apparatus of FIG. 9.

FIG. 13 is a schematic view of the apparatus of FIG. 9 mounted on a theater seat row end.

FIG. 14 is a side view of the apparatus of FIG. 13 showing the mounting orientation.

FIG. 15 is a side view of a mounting barb.

FIG. 16 is a front plan view of the illumination apparatus of FIG. 9.

FIG. 17 is a cutaway side plan view of the apparatus of FIG. 20.

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FIG. 18 is a schematic plan view of a heat sink base plate.

FIG. 19 is a close-up side sectional view of an LED module mounted on a mount tab of a base plate.

FIG. 20 is a plan view of a lens for use with the apparatus of FIG. 9.

FIG. 21 is a perspective view of a channel illumination apparatus incorporating LED modules having features in accordance with the present invention.

FIG. 22 is a close-up side view of an LED module mounted on a mount tab.

FIG. 23 is a partial view of a wall of the apparatus of FIG. 21, taken along line 23—23.

FIG. 24 is a top view of an LED module mounted to a wall of the apparatus of FIG. 21.

FIG. 25 is a top view of an alternative embodiment of an LED module mounted to a wall of the apparatus of FIG. 21.

FIG. 26A is a side view of an alternative embodiment of a lighting module being mounted onto a channel illumination apparatus wall member.

FIG. 26B shows the apparatus of the arrangement of FIG. 26A with the lighting module installed.

FIG. 26C shows the arrangement of FIG. 26B with a lens installed on the wall member.

FIG. 26D shows a side view of an alternative embodiment of a lighting module installed on a channel illumination apparatus wall member.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

With reference first to FIG. 1, an embodiment of a light-emitting diode (LED) lighting module 30 is disclosed. In the illustrated embodiment, the LED module 30 includes five pre-packaged LEDs 32 arranged on one side of the module 30. It is to be understood, however, that LED modules having features in accordance with the present invention can be constructed having any number of LEDs 32 mounted in any desired configuration.

With next reference to FIG. 2, a typical pre-packaged LED 32 includes a diode chip 34 encased within a resin body 36. The body 36 typically has a focusing lens portion 38. A negative lead 40 connects to an anode side 42 of the diode chip 34 and a positive lead 44 connects to a cathode side 46 of the diode chip 34. The positive lead 44 preferably includes a reflector portion 48 to help direct light from the diode 34 to the lens portion 38.

With next reference to FIGS. 1–5, the LED module 30 preferably comprises the five pre-packaged LED lamps 32 mounted in a linear array on a circuit board 50 and electrically connected in series. The illustrated embodiment employs pre-packaged aluminum indium gallium phosphide (AlInGaP) LED lamps 32 such as model HLMT-PL00, which is available from Hewlett Packard. In the illustrated embodiment, each of the pre-packaged LEDs is substantially identical so that they emit the same color of light. It is to be understood, however, that nonidentical LEDs may be used to achieve certain desired lighting effects.

The illustrated circuit board 50 preferably is about 0.05 inches thick, 1 inch long and 0.5 inch wide. It includes three layers: a copper contact layer 52, an epoxy dielectric layer 54 and an aluminum main body layer 56. The copper contact layer 52 is made up of a series of six elongate and generally parallel flat copper plates 60 that are adapted to attach to the leads 40, 44 of the LEDs 32. Each of the copper contacts 60 is electrically insulated from the other copper contacts 60 by the dielectric layer 54. Preferably, the copper contacts 60 are substantially coplanar.

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The pre-packaged LEDs 32 are attached to one side of the circuit board 50, with the body portion 36 of each LED generally abutting a side of the circuit board 50. The LED lens portion 38 is thus pointed outwardly so as to direct light in a direction substantially coplanar with the circuit board 50. The LED leads 40, 44 are soldered onto the contacts 60 in order to create a series array of LEDs. Excess material from the leads of the individual pre-packaged LED lamps may be removed, if desired. Each of the contacts 60, except for the first and last contact 62, 64, have both a negative lead 40 and a positive lead 44 attached thereto. One of the first and last contacts 62, 64 has only a negative lead 40 attached thereto; the other has only a positive lead 44 attached thereto.

A bonding area of the contacts accommodates the leads 40, 44, which are preferably bonded to the contact 60 with solder 68; however, each contact 60 preferably has a surface area much larger than is required for adequate bonding in the bonding area 66. The enlarged contact surface area allows each contact 60 to operate as a heat sink, efficiently absorbing heat from the LED leads 40, 44. To maximize this role, the contacts 60 are shaped to be as large as possible while still fitting upon the circuit board 50.

The dielectric layer 54 preferably has strong electrical insulation properties but also relatively high heat conductance properties. In the illustrated embodiment, the layer 54 is preferably as thin as practicable. For example in the illustrated embodiment, the dielectric layer 54 comprises a layer of Thermagon® epoxy about 0.002 inches thick.

It is to be understood that various materials and thicknesses can be used for the dielectric layer 54. Generally, the lower the thermal conductivity of the material used for the dielectric layer, the thinner that dielectric layer should be in order to maximize heat transfer properties of the module. For example, in the illustrated embodiment, the layer of epoxy is very thin. Certain ceramic materials, such as beryllium oxide and aluminum nitride, are electrically non-conductive but highly thermally conductive. When the dielectric layer is constructed of such materials, it is not as crucial for the dielectric layer to be so very thin, because of the high thermal conductivity of the material.

In the illustrated embodiment, the main body 56 makes up the bulk of the thickness of the circuit board 50 and preferably comprises a flat aluminum plate. As with each of the individual contacts 60, the main body 56 functions as a heat conduit, absorbing heat from the contacts 60 through the dielectric layer 54 to conduct heat away from the LEDs 32. However, rather than just absorbing heat from a single LED 32, the main body 56 acts as a common heat conduit, absorbing heat from all of the contacts 60. As such, in the illustrated embodiment, the surface area of the main body 56 is about the same as the combined surface area of all of the individual contacts 60. The main body 56 can be significantly larger than shown in the illustrated embodiment, but its relatively compact shape is preferable in order to increase versatility when mounting the light module 30. Additionally, the main body 56 is relatively rigid and provides structural support for the lighting module 30.

In the illustrated embodiment, aluminum has been chosen for its high thermal conductance properties and ease of manufacture. It is to be understood, however, that any material having advantageous thermal conductance properties, such as having thermal conductivity greater than about 100 watts per meter per Kelvin (W/m-K), would be acceptable.

A pair of holes 70 are preferably formed through the circuit board 50 and are adapted to accommodate a pair of

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aluminum pop rivets 72. The pop rivets 72 hold the circuit board 50 securely onto a heat conductive mount member 76. The mount member 76 functions as or communicates with a heat sink. Thus, heat from the LEDs 32 is conducted with relatively little resistance through the module 30 to the attached heat sink 76 so that the junction temperature of the diode chip 34 within the LED 32 does not exceed a maximum desired level.

With reference again to FIGS. 3 and 5, a power supply wire 78 is attached across the first and last contacts 62, 64 of the circuit board 50 so that electrical current is provided to the series-connected LEDs 32. The power supply is preferably a 12-volt system and may be AC, DC or any other suitable power supply. A 12-volt AC system may be fully rectified.

The small size of the LED module 30 provides versatility so that modules can be mounted at various places and in various configurations. For instance, some applications will include only a single module for a particular lighting application, while other lighting applications will employ a plurality of modules electrically connected in parallel relative to each other.

It is also to be understood that any number of LEDs can be included in one module. For example, some modules may use two LEDs, while other modules may use 10 or more LEDs. One manner of determining the number of LEDs to include in a single module is to first determine the desired operating voltage of a single LED of the module and also the voltage of the power supply. The number of LEDs desired for the module is then roughly equal to the voltage of the power supply divided by the operating voltage of each of the LEDs.

The present invention rapidly conducts heat away from the diode chip 34 of each LED 32 so as to permit the LEDs 32 to be operated in regimes that exceed normal operating parameters of the pre-packaged LEDs 32. In particular, the heat sinks allow the LED circuit to be driven in a continuous, non-pulsed manner at a higher long-term electrical current than is possible for typical LED mounting configurations. This operating current is substantially greater than manufacturer-recommended maximums. The optical emission of the LEDs at the higher current is also markedly greater than at manufacturer-suggested maximum currents.

The heat transfer arrangement of the LED modules 30 is especially advantageous for pre-packaged LEDs 32 having relatively small packaging and for single-diode LED lamps. For instance, the HLMT-PL00 model LED lamps used in the illustrated embodiment employ only a single diode, but since heat can be drawn efficiently from that single diode through the leads and circuit board and into the heat sink, the diode can be run at a higher current than such LEDs are traditionally operated. At such a current, the single-diode LED shines brighter than LED lamps that employ two or more diodes and which are brighter than a single-diode lamp during traditional operation. Of course, pre-packaged LED lamps having multiple diodes can also be employed with the present invention. It is also to be understood that the relatively small packaging of the model HLMT-PL00 lamps aids in heat transfer by allowing the heat sink to be attached to the leads closer to the diode chip.

With next reference to FIG. 5, a first reflective layer 80 is preferably attached immediately on top of the contacts 60 of the circuit board 50 and is held in position by the rivets 72. The first reflector 80 preferably extends outwardly beyond the LEDs 32. The reflective material preferably comprises an electrically non-conductive film such as visible mirror film available from 3M. A second reflective layer 82 is

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preferably attached to the mount member 76 at a point immediately adjacent the LED lamps 32. The second strip 82 is preferably bonded to the mount surface 76 using adhesive in a manner known in the art.

With reference also to FIG. 6, the first reflective strip 80 is preferably bent so as to form a convex reflective trough about the LEDs 32. The convex trough is adapted to direct light rays 84 emitted by the LEDs 32 outward with a minimum of reflections between the reflector strips 80, 82. Additionally, light from the LEDs is limited to being directed in a specified general direction by the reflecting films 80, 82. As also shown in FIG. 6, the circuit board 50 can be mounted directly to any mount surface 76.

In another embodiment, the aluminum main body portion 56 may be of reduced thickness or may be formed of a softer metal so that the module 30 can be partially deformed by a user. In this manner, the module 30 can be adjusted to fit onto various surfaces, whether they are flat or curved. By being able to adjust the fit of the module to the surface, the shared contact surface between the main body and the adjacent heat sink is maximized, improving heat transfer properties. Additional embodiments can use fasteners other than rivets to hold the module into place on the mount surface/heat sink material. These additional fasteners can include any known fastening means such as welding, heat conductive adhesives, and the like.

As discussed above, a number of materials may be used for the circuit board portion of the LED module. With specific reference to FIG. 7, another embodiment of an LED module 86 comprises a series of elongate, flat contacts 88 similar to those described above with reference to FIG. 3. The contacts 88 are mounted directly onto the main body portion 89. The main body 89 comprises a rigid, substantially flat ceramic plate. The ceramic plate makes up the bulk of the circuit board and provides structural support for the contacts 88. Also, the ceramic plate has a surface area about the same as the combined surface area of the contacts. In this manner, the plate is large enough to provide structural support for the contacts 88 and conduct heat away from each of the contacts 88, but is small enough to allow the module 86 to be relatively small and easy to work with. The ceramic plate 89 is preferably electrically non-conductive but has high heat conductivity. Thus, the contacts 88 are electrically insulated relative to each other, but heat from the contacts 88 is readily transferred to the ceramic plate 89 and into an adjoining heat sink.

With next reference to FIG. 8, another embodiment of an LED lighting module 90 is shown. The LED module 90 comprises a circuit board 92 having features substantially similar to the circuit board 50 described above with reference to FIG. 3. The diode portion 94 of the LED 96 is mounted substantially directly onto the contacts 60 of the lighting module 90. In this manner, any thermal resistance from leads of pre-packaged LEDs is eliminated by transferring heat directly from the diode 94 onto each heat sink contact 60, from which the heat is conducted to the main body 56 and then out of the module 90. In this configuration, heat transfer properties are yet further improved.

As discussed above, an LED module having features as described above can be used in many applications such as, for example, indoor and outdoor decorative lighting, commercial lighting, spot lighting, and even room lighting. With next reference to FIGS. 9-12, a self-contained lighting apparatus 100 incorporates an LED module 30 and can be used in many such applications. In the illustrated embodiment, the lighting apparatus 100 is adapted to be installed on

the side of a row of theater seats **102**, as shown in FIG. **13**, and is adapted to illuminate an aisle **104** next to the theater seats **102**.

The self-contained lighting apparatus **100** comprises a base plate **106**, a housing **108**, and an LED module **30** arranged within the housing **108**. As shown in FIGS. **9**, **10** and **13**, the base plate **106** is preferably substantially circular and has a diameter of about 5.75 inches. The base plate **106** is preferably formed of about $\frac{1}{16}$ inch thick aluminum sheet. As described in more detail below, the plate functions as a heat sink to absorb and dissipate heat from the LED module. As such, the base plate **106** is preferably formed as large as is practicable, given aesthetic and installation concerns.

As discussed above, the lighting apparatus **100** is especially adapted to be mounted on an end panel **110** of a row of theater chairs **102** in order to illuminate an adjacent aisle **104**. As shown in FIGS. **13** and **14**, the base plate **106** is preferably installed in a vertical orientation. Such vertical orientation aids conductive heat transfer from the base plate **106** to the environment.

The base plate **106** includes three holes **112** adapted to facilitate mounting. A ratcheting barb **116** (see FIG. **15**) secures the plate **106** to the panel **110**. The barb **116** has an elongate main body **118** having a plurality of biased ribs **120** and terminating at a domed top **122**.

To mount the apparatus on the end panel **110**, a hole is first formed in the end panel surface on which the apparatus is to be mounted. The base plate holes **112** are aligned with mount surface holes and the barbs **116** are inserted through the base plate **106** into the holes. The ribs **120** prevent the barbs **116** from being drawn out of the holes once inserted. Thus, the apparatus is securely held in place and cannot be easily removed. The barbs **116** are especially advantageous because they enable the device to be mounted on various surfaces. For example, the barbs will securely mount the illumination apparatus on wooden or fabric surfaces.

With reference next to FIGS. **16–19**, a mount tab **130** is provided as an integral part of the base plate **106**. The mounting tab **130** is adapted to receive an LED module **30** mounted thereon. The tab **30** is preferably plastically deformed along a hinge line **132** to an angle θ between about 20° – 45° relative to the main body **134** of the base plate **106**. More preferably, the mounting tab **130** is bent at an angle θ of about 33° . The inclusion of the tab **130** as an integral part of the base plate **106** facilitates heat transfer from the tab **130** to the main body **134** of the base plate. It is to be understood that the angle θ of the tab **130** relative to the base plate body **134** can be any desired angle as appropriate for the particular application of the lighting apparatus **100**.

A cut out portion **136** of the base plate **106** is provided surrounding the mount tab **130**. The cut out portion **136** provides space for components of the mount tab **130** to fit onto the base plate **106**. Also, the cut out portion **136** helps define the shape of the mount tab **130**. As discussed above, the mount tab **130** is preferably plastically deformed along the hinge line **132**. The length of the hinge line **132** is determined by the shape of the cut out portion **136** in that area. Also, a hole **138** is preferably formed in the hinge line **132**. The hole **138** further facilitates plastic deformation along the hinge line **132**.

Power for the light source assembly **100** is preferably provided through a power cord **78** that enters the apparatus **100** through a back side of the base plate **106**. The cord **78** preferably includes two 18 AWG conductors surrounded by an insulating sheet. Preferably, the power supply is in the low voltage range. For example, the power supply is preferably a 12-volt alternating current power source. As

depicted in FIG. **18**, power is preferably first provided through a full wave ridge rectifier **140** which rectifies the alternating current in a manner known in the art so that substantially all of the current range can be used by the LED module **30**. In the illustrated embodiment, the LEDs are preferably not electrically connected to a current-limiting resistor. Thus, maximum light output can be achieved. It is to be understood, however, that resistors may be desirable in some embodiments to regulate current. Supply wires **142** extend from the rectifier **140** and provide rectified power to the LED module **30** mounted on the mounting tab **130**.

With reference again to FIGS. **9–12**, **16** and **17**, the housing **108** is positioned on the base plate **106** and preferably encloses the wiring connections in the light source assembly **100**. The housing **108** is preferably substantially semi-spherical in shape and has a notch **144** formed on the bottom side. A cavity **146** is formed through the notch **144** and allows visual access to the light source assembly **100**. A second cavity **148** is formed on the top side and preferably includes a plug **150** which may, if desired, include a marking such as a row number. In an additional embodiment, a portion of the light from the LED module **30**, or even from an alternative light source, may provide light to light up the aisle marker.

The housing **108** is preferably secured to the base plate **106** by a pair of screws **152**. Preferably, the screws **152** extend through countersunk holes **154** in the base plate **106**. This enables the base plate **106** to be substantially flat on the back side, allowing the plate to be mounted flush with the mount surface. As shown in FIG. **17**, threaded screw receiver posts **156** are formed within the housing **108** and are adapted to accommodate the screw threads.

The LED module **30** is attached to the mount tab **130** by the pop rivets **72**. The module **30** and rivets **72** conduct heat from the LEDs **32** to the mount tab **130**. Since the tab **130** is integrally formed as a part of the base plate **106**, heat flows freely from the tab **130** to the main body **134** of the base plate. The base plate **106** has high heat conductance properties and a relatively large surface area, thus facilitating efficient heat transfer to the environment and allowing the base plate **106** to function as a heat sink.

As discussed above, the first reflective strip **80** of the LED module **30** is preferably bent so as to form a convex trough about the LEDs. The second reflector strip **82** is attached to the base plate mount tab **130** at a point immediately adjacent the LED lamps **32**. Thus, light from the LEDs is collimated and directed out of the bottom cavity **146** of the housing **108**, while minimizing the number of reflections the light must make between the reflectors (see FIG. **6**). Such reflections may each reduce the intensity of light reflected.

A lens or shield **160** is provided and is adapted to be positioned between the LEDs **32** and the environment outside of the housing cavity **108**. The shield **160** prevents direct access to the LEDs **32** and thus prevents harm that may occur from vandalism or the like, but also transmits light emitted by the light source **100**.

FIG. **20** shows an embodiment of the shield **160** adapted for use in the present invention. As shown, the shield **160** is substantially lenticularly shaped and has a notch **162** formed on either end thereof. With reference back to FIG. **18**, the mounting tab **130** of the base plate **106** also has a pair of notches **164** formed therein.

As shown in FIG. **16**, the lens/shield notches **162** are adapted to fit within the tab notches **164** so that the shield **160** is held in place in a substantially arcuate position. The shield thus, in effect, wraps around one side of the LEDs **32**. When the shield **160** is wrapped around the LEDs **32**, the

shield **160** contacts the first reflector film **80**, deflecting the film **80** to further form the film in a convex arrangement. The shield **160** is preferably formed of a clear polycarbonate material, but it is to be understood that the shield **160** may be formed of any clear or colored transmissive material as desired by the user.

The LED module **30** of the present invention can also be used in applications using a plurality of such modules **30** to appropriately light a lighting apparatus such as a channel illumination device. Channel illumination devices are frequently used for signage including borders and lettering. In these devices, a wall structure outlines a desired shape to be illuminated, with one or more channels defined between the walls. A light source is mounted within the channel and a translucent diffusing lens is usually arranged at the top edges of the walls so as to enclose the channel. In this manner, a desired shape can be illuminated in a desired color as defined by the color of the lens.

Typically, a gas-containing light source such as a neon light is custom-shaped to fit within the channel. Although the diffusing lens is placed over the light source, the light apparatus may still produce "hot spots," which are portions of the sign that are visibly brighter than other portions of the sign. Such hot spots result because the lighting apparatus shines directly at the lens, and the lens may have limited light-diffusing capability. Incandescent lamps may also be used to illuminate such a channel illumination apparatus; however, the hot spot problem typically is even more pronounced with incandescent lights.

Both incandescent and gas-filled lights have relatively high manufacturing and operation costs. For instance, gas-filled lights typically require custom shaping and installation and therefore can be very expensive to manufacture. Additionally, both incandescent and gas-filled lights have high power requirements.

With reference next to FIG. 21, an embodiment of a channel illumination apparatus **170** is disclosed comprising a casing **172** in the shape of a "P." The casing **172** includes a plurality of walls **174** and a bottom **176**, which together define at least one channel. The surfaces of the walls **174** and bottom **176** are diffusely-reflective, preferably being coated with a flat white coating. The walls **174** are preferably formed of a durable sturdy metal having relatively high heat conductivity. A plurality of LED lighting modules **30** are mounted to the walls **174** of the casing **172** in a spaced-apart manner. A translucent light-diffusing lens (not shown) is preferably disposed on a top edge **178** of the walls **174** and encloses the channel.

With next reference to FIG. 22, the pop rivets **72** hold the LED module **30** securely onto a heat conductive mount tab **180**. The mount tab **180**, in turn, may be connected, by rivets **182** or any other fastening means, to the walls **174** of the channel apparatus as shown in FIG. 23. Preferably, the connection of the mount tab **180** to the walls **174** facilitates heat transfer from the tab **180** to the wall **174**. The channel wall has a relatively large surface area, facilitating efficient heat transfer to the environment and enabling the channel wall **174** to function as a heat sink.

In additional embodiments, the casing **172** may be constructed of materials, such as certain plastics, that may not be capable of functioning as heat sinks because of inferior heat conductance properties. In such embodiments, the LED module **30** can be connected to its own relatively large heat sink base plate, which is mounted to the wall of the casing. An example of such a heat sink plate in conjunction with an LED lighting module has been disclosed above with reference to the self-contained lighting apparatus **100**.

With continued reference to FIGS. 22 and 23, the LED modules **30** are preferably electrically connected in parallel relative to other modules **30** in the illumination apparatus **170**. A power supply cord **184** preferably enters through a wall **174** or bottom surface **176** of the casing **172** and preferably comprises two **18** AWG main conductors **186**. Short wires **188** are attached to the first and last contacts **62**, **64** of each module **30** and preferably connect with respective main conductors **186** using insulation displacement connectors (IDCs) **190** as shown in FIG. 23.

Although the LEDs **32** in the modules **30** are operated at currents higher than typical LEDs, the power efficiency characteristic of LEDs is retained. For example, a typical channel light employing a neon-filled light could be expected to use about 60 watts of power during operation. A corresponding channel illumination apparatus **170** using a plurality of LED modules can be expected to use about 4.5 watts of power.

With reference again to FIG. 23, the LED modules **30** are preferably positioned so that the LEDs **32** face generally downwardly, directing light away from the lens. The light is preferably directed to the diffusely-reflective wall and bottom surfaces **174**, **176** of the casing **172**. The hot spots associated with more direct forms of lighting, such as typical incandescent and gas-filled bulb arrangements, are thus avoided.

The reflectors **80**, **82** of the LED modules **30** aid in directing light rays emanating from the LEDs toward the diffusely-reflective surfaces. It is to be understood, however, that an LED module **30** not employing reflectors can also be appropriately used.

The relatively low profile of each LED module **30** facilitates the indirect method of lighting because substantially no shadow is created by the module when it is positioned on the wall **174**. A higher-profile light module would cast a shadow on the lens, producing an undesirable, visibly darkened area. To minimize the potential of shadowing, it is desired to space the modules **30** and accompanying power wires **186**, **188** a distance of at least about $\frac{1}{2}$ inch from the top edge **178** of the wall **174**. More preferably, the modules **30** are spaced more than one inch from the top **178** of the wall **174**.

The small size and low profile of the LED modules **30** enables the modules to be mounted at various places along the channel wall **174**. For instance, with reference to FIGS. 21 and 24, light modules **30** must sometimes be mounted to curving portions **192** of walls **174**. The modules **30** are preferably about 1 inch to $1\frac{1}{2}$ inch long, including the mounting tab **180**, and thus can be acceptably mounted to a curving wall **192**. As shown, the mounting tab **180** may be separated from the curving wall **192** along a portion of its length, but the module is small enough that it is suitable for riveting to the wall.

In an additional embodiment shown in FIG. 25, the module **30** comprises the circuit board without the mount tab **180**. In such an embodiment, the circuit board **50** may be mounted directly to the wall, having an even better fit relative to the curved surface **192** than the embodiment using a mount tab. In still another embodiment, the LED module's main body **56** is formed of a bendable material, which allows the module to fit more closely and easily to the curved wall surface.

Although the LED modules **30** disclosed above are mounted to the channel casing wall **174** with rivets **182**, it is to be understood that any method of mounting may be acceptably used. With reference next to FIGS. 26A-C, an additional embodiment comprises an LED module **30** mounted to a mounting tab **200** which comprises an elongate

body portion 202 and a clip portion 204. The clip portion 204 is urged over the top edge 178 of the casing wall 172, firmly holding the mounting tab 200 to the wall 174 as shown in FIG. 26B. The lens 206 preferably has a channel portion 208 which is adapted to engage the top edge 178 of the casing wall 174 and can be fit over the clip portion 204 of the mount tab 200 as shown in FIGS. 26B and 26C. This mounting arrangement is simple and provides ample surface area contact between the casing wall 174 and the mounting tab 200 so that heat transfer is facilitated.

In the embodiment shown in FIG. 21, the casing walls 174 are about 3 to 4 inches deep and the width of the channel is about 3 to 4 inches between the walls. In an apparatus of this size, LED modules 30 positioned on one side of the channel can provide sufficient lighting. The modules are preferably spaced about 5–6 inches apart. As may be anticipated, larger channel apparatus will likely require somewhat different arrangements of LED modules, including employing more LED modules. For example, a channel illumination apparatus having a channel width of 1 to 2 feet may employ LED modules on both walls and may even use multiple rows of LED modules. Additionally, the orientation of each of the modules may be varied in such a large channel illumination apparatus. For instance, with reference to FIG. 26D, some of the LED modules may desirably be angled so as to direct light at various angles relative to the diffusely reflective surfaces.

In order to avoid creating hot spots, a direct light path from the LED 32 to the lens 206 is preferably avoided. However, it is to be understood that pre-packaged LED lamps 32 having diffusely-reflective lenses may advantageously be directed toward the channel letter lens 206.

Using LED modules 30 to illuminate a channel illumination apparatus 170 provides significant savings during manufacturing. For example, a number of LED modules, along with appropriate wiring and hardware, can be included in a kit which allows a technician to easily assemble a light by simply securing the modules in place along the wall of the casing and connecting the wiring appropriately using the IDCs. Although rivet holes may have to be drilled through the wall, there is no need for custom shaping, as is required with gas-filled bulbs. Accordingly, manufacturing effort and costs are significantly reduced.

Individual LEDs emit generally monochromatic light. Thus, it is preferable that an LED type be chosen which corresponds to the desired illumination color. Additionally, the diffuser is preferably chosen to be substantially the same color as the LEDs. Such an arrangement facilitates desirable brightness and color results. It is also to be understood that the diffusely-reflective wall and bottom surfaces may advantageously be coated to match the desired illumination color.

Although this invention has been disclosed in the context of certain preferred embodiments and examples, it will be understood by those skilled in the art that the present invention extends beyond the specifically-disclosed embodiments to other alternative embodiments and/or uses of the invention and obvious modifications and equivalents thereof. In addition, while a number of variations of the invention have been shown and described in detail, other modifications, which are within the scope of this invention, will be readily apparent to those of skill in the art based upon this disclosure. It is also contemplated that various combinations or subcombinations of the specific features and aspects of the embodiments may be made and still fall within the scope of the invention. Accordingly, it should be understood that various features and aspects of the disclosed embodiments can be combined with or substituted for one

another in order to form varying modes of the disclosed invention. Thus, it is intended that the scope of the present invention herein disclosed should not be limited by the particular disclosed embodiments described above, but should be determined only by a fair reading of the claims that follow.

What is claimed is:

1. An illumination module, comprising:

a dielectric layer having first and second sides;

a light emitting diode (LED);

a plurality of electrically-conductive contacts on the first side of the dielectric layer, the plurality of contacts being configured to mount the LED such that the LED is electrically connected to the contacts;

a heat conductive body on the second side of the dielectric layer;

a heat conductive tab comprising a heat conductive surface in communication with the heat conductive body, the heat conductive surface having a surface area substantially greater than a surface area of the heat conductive body;

wherein heat from the LED is communicated through the contacts, dielectric layer, and heat conductive body to the heat conductive surface.

2. The illumination module of claim 1, wherein the heat conductive tab behaves as a heat sink.

3. The illumination module of claim 2, wherein the heat conductive body has a first side and a second side, the first side communicating with the second side of the dielectric layer, and the heat conductive surface is substantially complementary to the second side of the heat conductive body.

4. The illumination module of claim 3, wherein the dielectric member is substantially planar.

5. The illumination module of claim 3, wherein the heat conductive surface is significantly larger than the second side of the heat conductive body.

6. The illumination module of claim 5, wherein substantially the entire second side of the body communicates with the heat conductive surface.

7. The illumination module of claim 6, wherein the tab is angled relative to an adjacent portion of the heat conductive body.

8. The illumination module of claim 3, wherein the heat conductive surface has a thermal conductivity greater than about 100 W/mK.

9. The illumination module of claim 8, wherein the heat conductive surface comprises a metal.

10. The illumination module of claim 9, wherein the heat conductive surface comprises aluminum.

11. The illumination module of claim 8, wherein the body has a thermal conductivity greater than about 100 W/mK.

12. The illumination module of claim 8, wherein the heat conductive surface is substantially rigid.

13. The illumination module of claim 3, wherein the body is connected to the heat conductive surface so that heat flows from substantially the entire second side of the body to the heat conductive surface.

14. The illumination module of claim 13, wherein the second side of the body is attached substantially flush to the heat conductive surface by an adhesive.

15. The illumination module of claim 1, wherein heat is dissipated from the heat conductive surface to the surrounding environment.

16. The illumination module of claim 1, wherein the heat conductive body is generally flat.

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17. The illumination module of claim 16, wherein the contacts are substantially flat and coplanar relative to each other.

18. The illumination module of claim 17, wherein the body is substantially parallel to the contacts.

19. The illumination module of claim 1, wherein each of the LEDs comprises a lead, and the leads are configured to be mounted to respective contacts.

20. A method of making an illuminated display, comprising:

- providing a housing having at least one wall surface;
- providing a plurality of the illumination modules of claim 1; and
- mounting the plurality of illumination modules onto the at least one wall surface.

21. The method of claim 20 additionally comprising mounting an illumination module so that at least a portion of the heat conductive tab is not in contact with the housing wall surface.

22. An illumination apparatus, comprising:

- a housing;
- a heat conductive tab comprising a heat conductive surface arranged in an interior of the housing; and
- an illumination module mounted on the heat conductive surface, the illumination module comprising:
 - a dielectric having a first side and a second side;
 - a light emitting diode (LED);
 - a plurality of electrically conductive contacts on the first side of the dielectric, the plurality of contacts being configured to mount a lead of the LED such that the LED is electrically connected to the contacts; and
 - a heat conductive body on the second side of the dielectric;

wherein heat from the LED flows through the contacts and dielectric to the heat conductive body, and from the body to the heat conductive surface.

23. The apparatus of claim 22, wherein the contacts communicate heat to the heat conductive body through a first thermal engagement area, and an engagement surface of the body communicates heat to the heat conductive surface through a second thermal engagement area that is larger than the first thermal engagement area, and the heat conductive surface is significantly larger than the engagement surface of the heat conductive body.

24. The apparatus of claim 23, wherein the heat conductive body contacts the heat conductive surface.

25. The apparatus of claim 23, wherein the engagement surface of the heat conductive body is connected to the heat conductive surface via an adhesive.

26. The apparatus of claim 25, wherein substantially the entire engagement surface engages the heat conductive surface so that the second thermal engagement area is substantially the same as the engagement surface area.

27. The apparatus of claim 22, wherein the heat conductive body is substantially flat.

28. The apparatus of claim 22, wherein the heat conductive tab is larger than the heat conductive body.

29. The apparatus of claim 28, wherein the housing comprises a wall surface, and the heat conductive surface is attached to the wall surface.

30. The apparatus of claim 29, wherein the heat conductive tab is disposed at an angle relative to the housing wall surface.

31. The apparatus of claim 28, wherein the heat conductive surface is substantially flat.

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32. The apparatus of claim 28, wherein the heat conductive tab comprises a material having a thermal conductivity greater than about 100 W/mK.

33. The apparatus of claim 22, wherein the housing comprises a wall surface, and at least a portion of the heat conductive surface is spaced from the wall surface.

34. The apparatus of claim 33, wherein the heat conductive surface is configured to draw LED-generated heat from the module for dissipation in the housing.

35. An illumination apparatus, comprising:

- a housing comprising a plurality of wall surfaces that define a channel;
- a heat conductive surface arranged in an interior of the housing; and
- an illumination module mounted on the heat conductive surface, the illumination module comprising:
 - a dielectric having a first side and a second side;
 - a light emitting diode (LED);
 - a plurality of electrically conductive contacts on the first side of the dielectric, each of the plurality of contacts being configured to mount a lead of the LED such that the LED is electrically connected to the contacts; and
 - a heat conductive body on the second side of the dielectric;

wherein heat from the LED flows through the contacts and dielectric to the heat conductive body, and from the body to the heat conductive surface.

36. The apparatus of claim 35, wherein a translucent cover extends over the channel.

37. The apparatus of claim 36, wherein heat from the LED is drawn to the heat conductive surface and dissipated from the surface into the channel.

38. The apparatus of claim 35 additionally comprising a heat sink within the housing, and the heat conductive surface is integrally formed with the heat sink.

39. The apparatus of claim 38, wherein the heat conductive surface is generally flat, and at least a portion of the heat sink extends at an angle relative to the heat conductive surface.

40. An illumination apparatus, comprising:

- a heat conductive body having a first side and a second side;
- a thin dielectric portion on a first side of the heat conductive body;
- a plurality of light emitting diodes (LEDs); and
- a plurality of electrically-conductive contacts on a first side of the dielectric portion, the LEDs being mounted to the contacts such that the LEDs are electrically connected to one another, the contacts thermally communicating with the dielectric portion through a first thermal communication area between the contacts and the first side of the dielectric portion;

wherein a second side of the dielectric portion is arranged on the first side of the heat conductive body so that the first side of the body is in thermal communication with the contacts through the dielectric portion;

wherein the first side of the body has a surface area larger than the thermal communication area;

a heat conducting surface;

wherein the second side of the body has a surface generally complementary to the heat conducting surface, and the second side of the body thermally communicates with the heat conducting surface through a second thermal communication area between the body and the heat conducting surface; and

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wherein the second thermal communication area has a greater area than the first thermal communication area; whereby heat is thermally conducted from the LEDs to the heat conducting surface.

41. The illumination apparatus of claim 40, wherein the second side of the body has a generally flat surface.

42. The illumination apparatus of claim 41, wherein the contacts are substantially flat and coplanar relative to each other.

43. The illumination apparatus of claim 42, wherein a first side of the body is substantially flat and parallel to the contacts.

44. The illumination apparatus of claim 43, wherein the dielectric portion is substantially flat.

45. The illumination apparatus of claim 40, wherein the heat conductive body has a thermal conductivity greater than about 100 W/mK.

46. The illumination apparatus of claim 40, wherein the heat conductive surface has a thermal conductivity greater than about 100 W/mK.

47. An illumination module for mounting on a heat conducting surface that is larger than the module, the module comprising:

a heat conductive body having a first side and a second side;

a thin dielectric portion on a first side of the heat conductive body;

a plurality of light emitting diodes (LEDs); and

a plurality of electrically-conductive contacts on a first side of the dielectric portion, the LEDs being mounted to the contacts such that the LEDs are electrically connected to one another, the contacts thermally communicating with the dielectric portion through a thermal communication area between the contacts and the first side of the dielectric portion; and

wherein a second side of the dielectric portion is arranged on the first side of the heat conductive body so that the first side of the body is in thermal communication with the contacts through the dielectric portion; and

wherein the first side of the body has a surface area larger than the thermal communication area, and the second side of the body has a surface generally complementary to the heat conducting surface to provide thermally conductive contact with the heat conducting surface; whereby heat is thermally conducted from the LEDs to the heat conducting surface; and additionally comprising a heat conductive tab that comprises the heat conductive surface.

48. The illumination module of claim 47, wherein the heat conductive tab is larger than the heat conductive body.

49. An illumination device, comprising:

a light emitting diode (LED) module in combination with a heat sink member, the LED module attached to the heat sink member, the LED module comprising: at least one LED;

a dielectric layer having first and second sides;

plural electrically-conductive contacts on the first side of the dielectric layer, the contacts being configured to mount the at least one LED such that the at least one LED is electrically connected to the contacts; and

a heat conductive body having a first and second face, the first face being on the second side of the dielectric layer, the body being in thermal communication with the plural contacts through the dielectric layer, the first face having a surface area at least the same as an aggregate surface area of one side of the contacts;

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wherein the second face of the heat conductive body is attached to the heat sink member so that heat flows from the body to the heat sink member, at least an engagement portion of the second face from the body to the heat sink member, the engagement portion having a surface area at least the same as the aggregate surface area of one side of the contact;

wherein the heat sink member has a surface area greater than a surface area of the heat conductive body.

50. An illumination device as in claim 49, wherein the heat sink member has a mount portion configured to accept the LED module, and the LED module is attached to the mount portion.

51. An illumination device as in claim 50, wherein the mount portion is integrally formed with the heat sink member.

52. An illumination device as in claim 51, wherein the mount portion is disposed at an angle relative to an adjacent portion of the heat sink member.

53. An illumination device as in claim 51, wherein the LED module is fastened to the mount portion using rivets.

54. An illumination device as in claim 51, wherein the LED module is fastened to the mount portion by an adhesive.

55. An illumination device as in claim 54, wherein the adhesive comprises a heat conductive adhesive.

56. An illumination device as in claim 54, wherein the heat conductive body comprises a flat aluminum plate.

57. An illumination device as in claim 56, wherein substantially the entire second face of the body portion is connected to the mount portion.

58. An illuminated display apparatus, comprising:

a plurality of the illumination devices recited in claim 49 electrically connected to one another in an electrically parallel arrangement; and

a display member having a wall surface;

wherein at least one of the plurality of illumination devices is arranged on the wall surface.

59. An illumination display apparatus as in claim 58, comprising a pair of electrical supply wires, wherein each of the plurality of illumination devices is electrically connected to the pair of electrical supply wires.

60. An illumination display apparatus as claim 59, wherein the illumination devices employ insulation displacement connectors to electrically connect to the pair of electrical supply wires.

61. An illuminated display apparatus as in claim 58, wherein the display member comprises a channel defined by a plurality of walls, and the illumination devices are disposed within the channel.

62. An illuminated display apparatus as in claim 58, wherein the wall surface is configured to function as a heat sink.

63. An illumination apparatus, comprising:

an illumination device as recited in claim 49; and

a housing, the housing having a light outlet aperture and being attached to the heat sink member so as to generally enclose the LED module;

wherein the apparatus is adapted so that light from the LED module is directed out of the housing aperture.

64. An illumination apparatus as in claim 63 additionally comprising an optical element for directing light from the LED module in a desired direction.

65. An illumination apparatus as in claim 64, comprising a lens.

66. An illumination apparatus as in claim 64, comprising at least one reflector.

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67. An illumination apparatus, comprising:
 a substantially enclosed housing comprising a housing wall and a light-transmissive portion;
 a heat sink having a mount portion, the mount portion disposed within the enclosed housing;
 a lighting module comprising:
 a light emitting diode (LED);
 a dielectric having first and second sides;
 plural electrically-conductive contacts on the first side of the dielectric, the contacts being configured to mount the LED so that the LED is electrically connected to the contacts; and
 a heat conductive body on the second side of the dielectric, the heat conductive body having opposing first and second faces, the first face being connected to the dielectric;

wherein the heat conductive body second face is attached to the heat sink mount portion so that heat from the LED flows through the dielectric to the heat conductive body, and from the body to the heat sink via the mount portion.

68. The apparatus of claim 67, wherein substantially the entire second face is connected to the mount portion.

69. The apparatus of claim 67, wherein the body is connected to the mount portion using a mechanical fastener.

70. The apparatus of claim 67, wherein the body is connected to the mount portion by an adhesive.

71. The apparatus of claim 67, wherein the mount portion is integrally formed with the heat sink.

72. The apparatus of claim 71, wherein the mount portion is disposed at an obtuse angle relative to an adjacent portion of the heat sink.

73. The apparatus of claim 67, wherein the apparatus comprises a plurality of heat sinks, each heat sink having a mount portion, and at least one lighting module is attached to each mount portion so that the second face of the respective module heat conductive body is connected to the respective heat sink mount portion.

74. The apparatus of claim 73, wherein each body is connected to the respective mount portion by an adhesive.

75. The apparatus of claim 74 additionally comprising a pair of electrical supply wires, an elongate portion of the pair of electrical supply wires arranged within the housing, wherein each of the lighting modules is electrically connected to the elongate portion of the pair of electrical supply wires.

76. An illumination apparatus, comprising:
 a substantially enclosed housing comprising a housing wall and a light-transmissive portion;
 at least one heat sink having a mount portion, the mount portion disposed within the enclosed housing;
 a plurality of lighting modules, each lighting module comprising:
 a light emitting diode (LED);
 a dielectric having first and second sides;
 plural electrically-conductive contacts on the first side of the dielectric, the contacts being configured to mount the LED so that the LED is electrically connected to the contacts; and
 a heat conductive body on the second side of the dielectric; and
 a pair of electrical supply wires, an elongate portion of the pair of electrical supply wires arranged within the housing, wherein each of the lighting modules is electrically connected to the elongate portion of the pair of electrical supply wires; and

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wherein the heat conductive body of each of the plurality of lighting modules is attached to a corresponding mount portion so that heat from the LED flows through the dielectric to the heat conductive body, and from the body to the heat sink via the mount portion.

77. The apparatus of claim 76, wherein the lighting modules employ insulation displacement connectors to electrically connect to the pair of electrical supply wires.

78. An illumination apparatus, comprising:
 a substantially enclosed housing comprising a housing wall and a light-transmissive portion;

a heat sink having a mount portion, the mount portion disposed within the enclosed housing;

a lighting module comprising:
 a light emitting diode (LED);
 a dielectric having first and second sides;

plural electrically-conductive contacts on the first side of the dielectric, the contacts being configured to mount the LED so that the LED is electrically connected to the contacts, the contacts thermally communicating with the dielectric through a thermal communication area between the contacts and the first side of the dielectric; and

a heat conductive body on the second side of the dielectric, the body comprising first and second sides, the first side being connected to the second side of the dielectric;

wherein the second side of the heat conductive body is connected to the mount portion, a thermal communication area between the second side of the body and the mount portion being greater than the thermal communication area between the contacts and the first side of the dielectric; and

wherein heat from the LED flows through the dielectric to the heat conductive body, and from the body to the heat sink via the mount portion.

79. The apparatus of claim 78, wherein substantially the entire second face is connected to the mount portion.

80. The apparatus of claim 78, wherein the housing wall comprises at least part of the heat sink.

81. The apparatus of claim 78, wherein a current modifying device is disposed adjacent the heat sink, the apparatus additionally comprising electrical wires adapted to deliver an AC electrical power to the current modifying device, the current modifying device adapted to deliver a modified electrical power to the lighting module.

82. The apparatus of claim 81, wherein the current modifying device comprises a rectifier.

83. The apparatus of claim 82, wherein the current modifying device is enclosed within the housing.

84. An illumination device, comprising:

a light emitting diode (LED) module in combination with a heat sink member, the LED module attached to the heat sink member, the LED module comprising:

at least one LED;
 a dielectric layer having first and second sides;
 plural electrically-conductive contacts on the first side of the dielectric layer, the contacts being configured to mount the at least one LED such that the at least one LED is electrically connected to the contacts; and

a heat conductive body on the second side of the dielectric layer, the body being in thermal communication with the plural contacts through the dielectric layer;

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wherein the heat conductive body is attached to the heat sink member so that heat flows from the body to the heat sink member; and

wherein the heat sink member comprises:

a surface area greater than a surface area of the heat conductive body; and

a mount portion integrally formed with the heat sink member and configured to accept the LED module, the mount portion being disposed at an angle relative to an adjacent portion of the heat sink member;

wherein the LED module is attached to the mount portion.

85. An illumination device as in claim **84**, wherein the LED module is fastened to the mount portion by an adhesive.

86. An illuminated display apparatus, comprising:

a plurality of the illumination devices recited in claim **84** electrically connected to one another in an electrically parallel arrangement; and

a display member having a wall surface;

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wherein at least one of the plurality of illumination devices is arranged on the wall surface.

87. An illumination display apparatus as in claim **86**, wherein the wall surface is configured to function as a heat sink.

88. An illumination apparatus, comprising:

an illumination device as recited in claim **84**; and

a housing, the housing having a light outlet aperture and being attached to the heat sink member so as to generally enclose the LED module;

wherein the apparatus is adapted so that light from the LED module is directed out of the housing aperture.

89. An illumination apparatus as in claim **88** additionally comprising an optical element for directing light from the LED module in a desired direction.

90. An illumination apparatus as in claim **88**, comprising a lens.

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