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(54) Title: MULTILUMEN CATHETER SHAFT WITH REINFORCEMENT (57) Abstract <p>This invention is a surgical device. In particular, this invention is directed to a multilumen catheter for accessing the vascular system of a body. The multilumen catheter includes a catheter shaft, at least a portion of which includes at least one lumen reinforced with a support member which may include a polymeric or metallic braid, coil or knit material. The reinforced lumen may further include a thin-walled liner or coating of lubricious material. The reinforced lumen may have a circular cross section adapted to receive a guidewire. The interior surface of the reinforced lumen may have a smooth and continuous surface or a non-uniform surface.</p>		

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MULTILUMEN CATHETER SHAFT WITH REINFORCEMENT

FIELD OF THE INVENTION

5 This invention is a surgical device. In particular, this invention is directed to a multilumen catheter accessing the vascular system of a body. The multilumen catheter includes a catheter shaft, at least a portion of which includes at least one lumen reinforced with a polymeric or metallic braid, coil or knit material and may further include a liner or coating of lubricious material.

BACKGROUND OF THE INVENTION

10 Catheters are used in a variety of procedures to treat vascular maladies throughout the body. Catheters are used to place various treatment materials, drugs, and devices within remote regions of the human body. Catheters with distal balloons are used to treat
15 narrowed regions in the arterial system via percutaneous transluminal angioplasty (PTA) by expanding the balloon in the region of the plaque narrowing a vessel lumen and pressing the plaque into the vessel wall.

20 Often, the target which one desires to access by catheter is within a soft tissue such as the liver or brain. Such sites are extremely difficult to reach by way of the vasculature system because the remote arterial pathways are increasingly narrow and have tortuous pathways with sharp bends or curves often winding back on themselves.

25 Catheters designed to traverse such pathways must provide the desired balance between the flexibility required to allow passage of the catheter tip through the sharp bends of the increasingly narrow blood vessels and the stiffness required to allow sufficient pushability and torqueability as the catheter is inserted into the body and advanced through the tortuous pathways. It is commonplace for modern high performance catheters to have a number of sections of different flexibilities along its length.

30 In many cases, the catheter is designed to be used as a unit with a torqueable guidewire. The guidewire is typically bent at its distal end and may be guided by rotating and advancing the wire along a tortuous, small vessel pathway, to a target site. The catheter is constructed to slide over the guidewire and traverse the path established by the

guidewire. Typically the guidewire and catheter are advanced along the tortuous pathway by alternately advancing the wire along a region of the pathway, then advancing the catheter axially over the advanced wire portion. Further details on the problems and an early, but yet effective, catheter designed for such traversal may be found in U.S. Patent
5 No. 4,739,768 to Engelson.

One problem that may be encountered as the guidewire and catheter are advanced as described above, is that the guidewire can become stuck or jammed against the internal tubular surface or walls of the lumen. This problem is caused, at least in part, by the distortion of lumen walls against the guidewire, unfavorable friction properties between the
10 guidewire and the lumen surfaces, and/or unfavorable geometrical positioning of the guidewire relative to the inner surfaces of the catheter lumen. Typically, the problem arises when a sharp bend is encountered or where two or more sharp bends occur in succession. When the catheter and wire become locked together in this manner it may be impossible to either advance or withdraw the wire relative to the catheter. In such cases, the wire and
15 catheter must be withdrawn together until both are straight enough to allow the wire to be moved freely axially within the catheter, and often, it may not then be possible to reach the targeted site. This same problem may be encountered when other types of instruments (i.e., an angioscope) is advanced through a catheter lumen.

In a number of procedures, it may be necessary that the catheter have two or more
20 lumens extending within at least a portion of the catheter shaft. For example, the catheter may have one lumen adapted for use with a guidewire to position the catheter, and one or more additional lumen for balloon inflation or deflation, irrigation, delivery of drugs or other treatments, or to facilitate the insertion of other surgical devices, such as for example, an angioscope. The lumen employed may have any suitable cross-sectional shape as
25 required for the particular use.

Such multilumen catheter designs are particularly susceptible to kinking or ovalization of the cross-sectional shapes of the various lumen when the catheter is exposed to high flexure or high torsion, such as when the catheter is traversed through the bends in the vasculature. While a certain small amount of distortion of the interior cross-sectional
30 shapes of a lumen may be acceptable in some applications, such distortions of the interior shapes of the lumen may result in a lumen being kinked or closed off or may result in the

wall of the lumen being forced against any element that has been inserted into the lumen as described above. For example, ovalization of a normally round shaped guidewire lumen causes the lumen walls to pinch the guidewire thus prohibiting free relative movement between the guidewire and the guidewire lumen. Multilumen catheters known in the art do not tend to provide a suitable shaft design to ensure the free relative movement of an element (i.e., a guidewire) placed within a guidewire lumen.

While some of these disadvantages may be somewhat alleviated by increasing the thickness of the catheter lumen walls, it is not desirable to do so for a number of reasons. Increased wall thickness may adversely decrease flexibility, increase the overall size of the catheter profile, or decrease the internal space available for necessary lumens. In addition, increased wall thicknesses typically result in increased mass. Increased mass increases the tendency of the catheter to force the guidewire out of a bent or curved configuration as the catheter is advanced over the guidewire. This may be critical in the distal tip region of some over-the-wire catheters because a relatively low mass at the distal tip region of the catheter may be necessary for tracking the catheter over the increasing flexible guidewires necessary to access the more tortuous vascular pathways.

To some extent, the problem of catheter collapse has been addressed in multilumen hemodialysis catheter designs using a reinforced construction. For example, U.S. Patent 5,190,520 to Fenton, Jr. et al. discloses a reinforced dual lumen catheter having a cylindrical portion with a central axis and a substantially rectangular divider within the cylindrical portion which defines two internal D-shaped lumens. A wire reinforcement filament is embedded in the cylindrical portion in a helical pattern about the central axis. The reinforced multilumen catheter disclosed in U.S. Patent No. 5,221,255 to Mahurkar et al. discloses similar cylindrical tube having a septum extending therein which defines two D-shaped lumens. To minimize kinking the catheter has a spiral of relatively stiff material embedded in the cylindrical wall of the catheter which tends to hold the outer wall of the catheter in a cylindrical shape. The catheter further has a reinforcing member extending along the full length of at least one of the lumens, preferably the reinforcing member is embedded in the septum.

An extrusion method for producing a reinforced multilumen tubing is disclosed in U.S. Patent No. 5,063,018 to Fontirroche et al. The disclosed extrusion method involves

first extruding an inner tube over a wire mandrel, adding a braided tube if desired, and then extruding an outer tube over the inner braided tube. The wire mandrel forms a first lumen within the braided tube and a second lumen is formed in the outer tube during extrusion. Of course, the resulting tubing construction is limited to materials which are suitable for
5 extrusion and to tubing sizes and thicknesses obtainable by the extrusion process.

None of these constructions, however, provide a low-profile, high flexibility catheter shaft having a reinforced lumen which resists cross-sectional distortion and provides for free axial movement of an inserted element relative to the lumen as the catheter device is advanced through the curves and sharp bends of a vascular pathway as
10 described in detail below. Further, none of these devices have a reinforced lumen having a low profile, low mass, low friction construction as described below.

SUMMARY OF THE INVENTION

This invention is a multilumen catheter shaft section having use in wide array of catheter designs. The catheter shaft section generally includes a tubular elongate outer
15 shaft member defining at least a first lumen, a tubular inner shaft member disposed within the outer shaft member defining a second lumen generally parallel to the first lumen, and a support member generally concentric with and exterior to said tubular inner shaft member.

The tubular inner shaft member may be of a relatively thin walled construction. In one embodiment the tubular inner shaft member has a wall thickness of less than about
20 0.001 inches, more preferably less than about 0.0005 inches. The tubular inner shaft member may be made from any suitable biologically compatible material, but preferably is made from a low-friction or lubricious material. In one embodiment, the tubular inner shaft member comprises PTFE, FEP, or their mixtures.

The tubular outer shaft member may be made from any suitable biologically
25 compatible material. In one embodiment, the tubular outer shaft member comprises nylon, Pebax, polyethylene, polypropylene, polyvinylchloride, polyurethane, silicone, or their blends, alloys, and copolymers

The support member may comprise a polymeric or metallic braid, coil or knit material. In one embodiment the support member comprises a braided material, preferably
30 of polymeric fibers. The braided material may also include metallic wires or ribbons. A braided support member generally has a braid of discrete braid elements (such as, for

example, fibers, wires, ribbons, threads, etc.) having interstices between the discreet braid elements, the exact configuration of which depends upon the braid or winding pattern. The support member may instead comprise a spirally wound material. In one aspect of the present invention, the support member has an outside diameter of less than about 0.050 inches.

The second lumen generally comprises an interior surface. In one embodiment, the interior surface is substantially smooth and continuous and may further include an optional hydrophilic coating. The interior surface of the second lumen may comprise a non-uniform surface. The non-uniformities may take the form of alternating high regions and low regions. In one aspect of the present invention, the desired non-uniformities are formed as the tubular inner shaft member conforms to the profile of the braided support member.

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 shows a catheter device, including a catheter having a catheter shaft section constructed according to the principles of the present invention.

Figures 2 and 3 show, respectively, transverse and longitudinal cross-sectional views of a catheter shaft section made according to the principles of the present invention.

Figure 4 shows a transverse, cross-sectional view of a catheter shaft having an alternate configuration.

Figure 5 shows an illustration in partial cross-section of a portion of the core element assembly used to make a multilumen catheter shaft according to the principles of the present invention.

Figure 6 is a diagrammatic representation of the an extrusion process suitable for producing a multilumen catheter shaft.

Figure 7 shows a longitudinal cross-section of a catheter shaft having a non-uniform inner lumen surface according to the present invention.

Figure 8 shows a longitudinal cross-section of a catheter shaft having a inner coating according to the present invention.

DESCRIPTION OF THE INVENTION

This invention is a catheter shaft section having a reinforced lumen and a catheter incorporating such a section. The reinforced lumen may incorporate a section constructed to have structural features which aid in preventing the sticking or locking of the internal walls surfaces of the lumen against any element positioned for relative movement within the lumen. The catheter shaft section may be a multilumen device having at least one reinforced lumen constructed to aid in preventing the sticking or locking of the internal surfaces of the lumen against an element positioned for relative movement within the lumen. The invention includes the method of making the catheter shaft sections.

A typical catheter device **10** which may incorporate the concepts of this invention is shown in Figure 1. The device includes a catheter **12** in the form of an elongated tubular member which will be described below, and a guidewire **14**. The catheter device is designed for accessing a target site which can be reached only along a small tunnel-like pathway. The catheter **12** includes an elongate outer tubular surface **16** having proximal end **18** connected to fitting **28** and distal end **20**. The area inside tube **12** has one or more longitudinal hollow areas or lumen extending between the two ends. Fitting **28** is constructed to allow guidewire **14** to pass through and may optionally include seal **30** to prevent leakage around the guidewire while still allowing the guidewire to be rotated and advanced relative to the catheter as required during use. Fitting **28** may also include bifurcated port **32** which may be used to access one or more of the catheter lumens.

The tubular member **12** can be between about 50-300 cm in length, and is typically and more preferably between about 100-200 cm in length. The guidewire is positioned in a lumen that is typically between about 1-7 mils (1 mil is equal to 0.001 inch) greater than the diameter of the guidewire. Additional lumen for a variety of purposes known in the art may or may not be provided. The lumen or lumens may have a substantially uniform cross-sectional area along its length or may vary along the catheter length.

A typical catheter device may include a number of sections having different structural characteristics along its length. Catheter or tubular member **12**, for example, is shown having a proximal or first section **24** and a relatively more flexible distal section **26** terminating at distal end **20**. Typically, proximal segment **24** makes up between about 70-

90% of the total length of tubular member **12**, and relatively flexible distal segment **26** makes up the remaining 10% -30% of the length.

The catheter device may have a number of lumen configurations including both single lumen configurations and multilumen configurations. It is desirable for such catheter devices to have a shaft portion which is constructed to allow the lumen to maintain its cross-sectional shape during its intended use, provide an internal lumen structure that does not inhibit free axial movement of any element positioned therein, and yet maintains the desired flexibility, pushability, torqueability and low profile required for its intended use. To this end, a catheter shaft having a reinforced lumen and an internal lumen structure which allows axial movement of a longitudinal element within the lumen using minimal force is described below. Although the invention is not intended to be so limited, the examples discussed below are directed to multilumen catheter shaft configurations.

An exemplar multilumen catheter construction made according to the principles of the present invention is shown in cross-section in Figures 2 and 3. At least a section of catheter **100** is constructed to have outer member **125** having outer tubular surface **105**, inner member **130**, and support member **135**. Inner member **135** defines lumen **110** which has a generally circular cross-sectional shape as shown. Outer member **125** is preferably an extruded member having a main lumen **120** formed therein during extrusion. In a preferred embodiment, lumen **110** has a circular cross-sectional shape to accept a guidewire (such as guidewire **14** as discussed with reference to Figure 1) or other longitudinal element. Main lumen **120** is shown having a crescent shape, but could be any desired shape suitable for balloon inflation/deflation, infusion of drugs or other fluids, or delivery of other surgical devices such as vaso-occlusive coils, angioscopes, etc. The lumens may have a substantially uniform cross-sectional area along their length, or may vary along the catheter length, for example the distal end may taper toward a smaller diameter in a direction away from the proximal end.

Outer member **125** may be made from any suitable biologically compatible catheter material or may be extruded from a number of different materials along its length as described in U.S. Patent No. 5,542,937 to Chee et al., the entirety of which is hereby incorporated by reference. Suitable polymers include thermoplastics such as nylon, Pebax, polyethylene, polypropylene, polystyrene, polyurethanes, polyethylene terephthalate,

polyesters, polyvinyl chloride, silicone and lubricious polymers such as polyfluorocarbons or polysulfones.

5 Inner member **130** is of a relatively thin construction and, although many common biologically compatible polymers would be suitable, it is preferably made from a durable, lubricious material having a low coefficient of friction to minimize the magnitude of force required to slide the guidewire axially within lumen **110**. Suitable polymers includes polyurethane, high density polyethylene (HDPE), low density polyethylene (LDPE), polyvinylchloride, fluoropolymers including PTFE, FEP, vinylidene fluoride, and their mixtures, alloys, copolymers, and block copolymers. Most preferably, inner member **130** is
10 made from PTFE, FEP, or their mixtures. The wall thickness of the material and its specific properties may depend in part upon whether the catheter shaft portion is proximally located on the catheter device (thus requiring more stiffness) or distally located on the catheter device (thus requiring a flexible material of suitable softness and modulus of elasticity). It is may also be desirable to choose polymers for the inner member **130** and the
15 outer member **125** which adhere to each other or are miscible with each other under appropriate conditions so that an optimum bond is obtained at the interface of the outer member **125**, inner member **130** and support member **135**. Although outer member **125** and inner member **130** are described generally as discreet elements, when the same polymers are used for both outer member **125** and inner member **130** the final product will
20 be substantially unitary having only the support member **135** embedded therein.

The support member **135** may be of a variety of different materials and configurations designed to impart the desired stiffness to the catheter shaft section and in particular ensure that the cross-sectional shape of the lumen remains substantially
25 undistorted as in undergoes the high flexure encountered during traversal of the sharp bends in the vascular pathway. The reinforcing and stiffening properties of the support member **135** allows the inner member to be extraordinarily thin walled and yet maintain the integrity of the lumen cross-sectional shape. Inner member **135** may be as thin as about 0.0002 inches, more preferably between about 0.0002 inches to about 0.001 inches, but may be as thick as about 0.010 inches or more depending on the desired overall flexibility
30 of the catheter shaft portion. Most preferably, inner member **135** has a thickness of about 0.0005 inches or less.

Suitable support member constructions include metallic and non-metallic fibers, wires, and ribbons which may be configured in a single or multiple spirals, braids or knits as is known in the art. Support member **135** is shown generally as a ribbon material which may be a metallic material, such as super-elastic alloys or stainless steel, or non-metallic materials such as those made of polyaramids, carbon fibers, Dacron, Nylon, or liquid crystal polymer and may even be made using natural fibers such as silk and cotton. Specifics of spiral wound ribbon constructions suitable for this invention can be found, for example, in U.S. Patent No. 5,695,483 to Samson, the entirety of which is herein incorporated by reference. Support member **225**, as shown in Figure 4, is shown generally of a wire or thread material which may be of any of the same materials. Support member **330** shows a preferred braided construction. Preferably the braid material is made of metallic or non-metallic wire, fiber or ribbons. In a preferred embodiment, support member **330** is braided polymeric fibers, most preferably liquid crystal polymer fibers. Different braid materials as well as winding densities may be employed along the length of the catheter shaft to allow the stiffness of the catheter device to be "tuned" according to the desired performance requirements.

One important aspect of this multilumen catheter shaft construction is that this construction allows support member **135** to be relatively small in diameter compared to the diameter of the catheter as a whole. When lumen **110** is configured to receive a guidewire, the support member concentrically disposed about the inner member will preferably have an outside diameter of about 50 mil or less, preferably about 10 mil to about 35 mil. This allows maximum lumen integrity surrounding the guidewire while allowing the catheter shaft portion as a whole to remain quite flexible. The small diameter support member **135** also allows for reduced mass in the area of the distal tip which enhances the ability of the catheter to track over a tortuous vascular pathway established by the guidewire. The ability of lumen **110** to maintain its original circular cross-sectional shape during use minimizes the potential that the lumen walls would be distorted or deflected against the guidewire. Such lumen distortion or deflection would inhibit free relative motion of the guidewire within lumen **110**.

Another important aspect of this catheter shaft construction is that inner member **130** is a very thin walled construction. This allows the use of materials having superior

frictional properties to be selected with only minimal effect on the stiffness as compared to thicker walled constructions that would preclude the use of certain stiffer materials because of the stiffness effects of a thicker walled construction. In addition, minimizing the thickness of inner member **130** likewise reduces the overall diameter of the support member **135** resulting in the advantages described above. Accordingly, inner member **130** preferably has a thickness of about 0.00075 inches or less, more preferably about 0.0005 inches or less.

As mentioned above, the multilumen catheter shaft using the principles of the present invention may be constructed with any number of suitable lumen shapes and configurations tailored to the requirements of a particular application. For purposes of further example, Figure 4 shows an alternate multilumen catheter shaft construction. Catheter **200** having outer tubular surface **205** is constructed from outer member **210**, inner member **230**, and support member **225**. Inner member **230** defines lumen **240** which has a generally circular cross-sectional shape for accepting a guidewire. Outer member **210** is preferably an extruded member having a first lumen **220** and a second lumen **222**. If desired, either or both of first lumen **220** and second lumen **222** could also be provided with a surrounding support member and or inner member to maintain the cross-sectional shape of the lumen and provide improved frictional properties.

The preferred method of making the multilumen shaft constructions as described above generally involves two steps. First, an inner core element is constructed and second, an outer member is extruded over the inner core element. Figure 5 shows a preferred inner core element **300** which comprises mandrel wire **310**, inner member **320**, and support member **330** in the form of a braided wire or fiber. Inner member **320** is manufactured onto mandrel wire **310** by way of an extrusion, coating, spraying, or dipping process which allows a very thin, uniform layer to be placed over mandrel wire **310**. Mandrel wire **310** may be coated and spooled for later feeding into the extruder. After inner member **320** is applied to mandrel wire **310**, support member **320** is braided (or otherwise wound or applied) over inner member **320** by known conventional techniques. The resulting inner core element **300** can then be fed into an extruder to complete the multilumen catheter shaft assembly.

The inventive multilumen catheter shaft is preferably completed using an extruder of typical design and configuration shown schematically in Figure 6. In this depiction, a conventional extruder **410** feeds an extruder head or die **480**. The extruder may be of known design such as a screw extruder and use, for instance, screws typically chosen for the polymers selected to make the catheter shaft. The extruder **410** has a control valve **420** which can be operated either as a proportional valve or as a cut-off valve. The valve either supplies the polymer to the extruder head **480** or to a dump region **430**, potentially for regrind or recycle. The inner core element **440** is supplied to a central orifice through the die in the extruder head. Air **450** is also supplied to the extruder head and is connected to each lumen being extruded. The purpose of air **450** is to ensure that the extruded lumen remains open until the molten plastic has had sufficient time to set. Alternatively, the lumen formed during the extrusion process could be created with full length wire mandrels, which would require subsequent removal.

The polymer from the extruder **410** enters the extruder head **480** and is applied in the desired shape over the inner core element **300**. The assembly exits through the die face which forms the catheter shaft's final shape including any desired lumen. The semi-molten catheter shaft with inner core element **300** is then pulled through a water bath **460** typically using a puller **470**. The mandrel wire portion of core element **300** is then removed.

This process of forming the inventive multilumen catheter shaft is particularly advantageous in that it allows for an extremely thin inner polymeric layer and allows long lengths of the inner core element to be spooled for continuous feeding into the extruder.

In addition, this manufacturing process makes it possible to structure the inside surface of the reinforced inner lumen in such a manner as to further reduce the amount of force required to advance a guidewire or other such element through the lumen. This is accomplished by creating a non-uniform interior lumen surface structure. An example of a catheter shaft section having such a structure is shown in cross-section in Figure 7. Similar to the catheter shaft construction of Figures 2 and 3, catheter **500** has outer member **525** having main lumen **520** and inner member **560** which includes inner lumen **550** for receiving a guidewire or the like for axial movement therein. Support member **535**, preferably in the form of a braided member as described above, is captured between outer member **525** and inner member **560**.

As support member **535** was braided onto thin-walled inner member **560** in the manner described with reference to Figure 5, the winding tension maintained in the braid resulted in a desirable deformation of inner member **560** as the inner member polymeric material deformed into and around the interstices of the braid material.. Where the tension of the braid acted locally on the inner member **560**, it created a non-uniform or structured inner surface having high regions **545** and low regions **540** corresponding to the geometry of the braid used. The ability to form these structural features is facilitated, at least in part, to the use of the thin-walled inner member construction. The application of heat to the inner core element may result in more pronounced structural features.

These structural features are important in that they lower the overall area of contact between the guidewire and the inner surface of lumen **550** and provide some ability to deflect normal forces which will be applied by the guidewire against the internal tubular surface so as to prevent jamming, sticking, or locking of the guidewire against the surface. When the guidewire is advanced within lumen **550** and contacts these structural features, the guidewire is deflected so that the guidewire does not provide substantial forces normal to the surface of the internal lumen wall and therefore does not become jammed or locked into position on the surface of the internal lumen wall, particularly when the catheter sections are sharply bent. These structural features in combination with the use of a proper low friction inner member material (i.e., PTFE or FEP), and a reinforced lumen construction to resist any distortion of the cross-sectional shape of the guidewire lumen results in a particularly desirable guidewire lumen for use in a flexible multilumen catheter shaft as herein described.

The frictional properties between the guidewire (or other inserted instrument or device) and the lumen walls may be further improved by the addition of an internal lubricious coating as shown in catheter **600** with reference to Figure 8. Similar to the constructions above, catheter **600** has an outer member **625** defining main lumen **620** and an inner member **630** defining lumen **640**. The interior of lumen **640** may be coated with a lubricous, preferably hydrophilic coating **650** by way of forcing the coating material into the lumen by pressure, or drawn in by gravity or vacuum. Examples of suitable coating materials may be found, for example, in U.S. Patent No. 5,603,991 to Kupiecki et al. and U.S. Patent No. 5,538,512 to Zenson et al., the entirety of both are herein incorporated by

reference. Use of such coatings may allow the use of a wider range of inner member materials as their base lubricious properties will not be as critical.

While preferred embodiments of the invention have been described herein, it will be recognized that a variety of changes and modifications can be made without departing from the spirit of the invention as found in the appended claims.

5

WE CLAIM AS OUR INVENTION:

1. A multilumen catheter shaft section comprising an elongate tubular outer shaft member defining at least a first lumen, an elongate tubular inner shaft member disposed
5 within said outer shaft member and defining a second lumen, said second lumen substantially parallel to and external to said first lumen, and a support member concentric with and exterior to said tubular inner shaft member, said tubular inner shaft member having a wall thickness of less than about 0.001 inches.
2. The catheter shaft section of claim 1, wherein the tubular inner shaft member
10 comprises a polymer selected from the group consisting of PTFE, FEP, and their mixtures.
3. The catheter shaft section of claim 2, wherein said wall thickness of said tubular inner shaft member is less than about 0.0005 inches.
4. The catheter shaft section of claim 2, wherein the outer shaft member comprises one or more materials selected from the group consisting of nylon, Pebax, polyethylene,
15 polypropylene, polyvinyl chloride, polyurethane, silicone, their blends, alloys, and copolymers.
5. The catheter shaft section of claim 1 wherein said support member comprises a braided material.
6. The catheter shaft section of claim 5, wherein said braided material comprises
20 polymeric fibers.

7. The catheter shaft section of claim 5, wherein said braided material comprises a material selected from the group consisting of metallic wires and metallic ribbons.

8. The catheter shaft section of claim 1 wherein said support member comprises a spirally wound material.

5 9. The catheter shaft section of claim 1 wherein said support member comprises a knit material.

10. The catheter shaft section of claim 1, wherein said second lumen comprises an interior surface which is substantially smooth and continuous.

10 11. The catheter section of claim 10, wherein at least a portion of said interior surface further included a hydrophilic coating.

12. The catheter shaft section of claim 1, wherein said second lumen comprises a non-uniform interior surface.

13. The catheter shaft section of claim 12 wherein said non-uniform interior surface comprises alternating high regions and low regions.

15 14. The catheter shaft section of claim 1 wherein said support member has an outside diameter less than about 0.05 inches.

15. A multilumen catheter shaft comprising:

- a). a flexible elongate tubular outer shaft member defining at least a first lumen;
- b). an elongate tubular inner shaft member disposed within said outer shaft

member, said tubular inner shaft member having an outer surface and an inner surface, said
5 inner surface defining a guidewire lumen substantially parallel to and external to said first
lumen;

- c). a support member concentric to and contacting said outer surface, said
support member comprising a braid of discrete braid elements having interstices between
said discrete braid elements; and

- d). said tubular inner shaft member conforming to the profile of the discrete
10 elements and the interstices of said braid such that said inner surface is non-uniform.

16. The catheter shaft section of claim 15, wherein the tubular inner shaft member
comprises a polymer selected from the group consisting of PTFE, FEP, and their mixtures.

17. The catheter shaft section of claim 16, wherein said tubular inner shaft member
15 has a wall thickness of less than about 0.001 inches.

18. The catheter shaft section of claim 16, wherein the outer shaft member
comprises one or more materials selected from the group consisting of nylon, Pebax,
polyethylene, polypropylene, polyvinyl chloride, polyurethane, silicone, their blends,
alloys, and copolymers.

20

19. The catheter shaft section of claim 1, wherein said elongate tubular outer shaft member further defines a third lumen.

5 20. The catheter shaft section of claim 15, wherein said elongate tubular outer shaft member further defines a third lumen.

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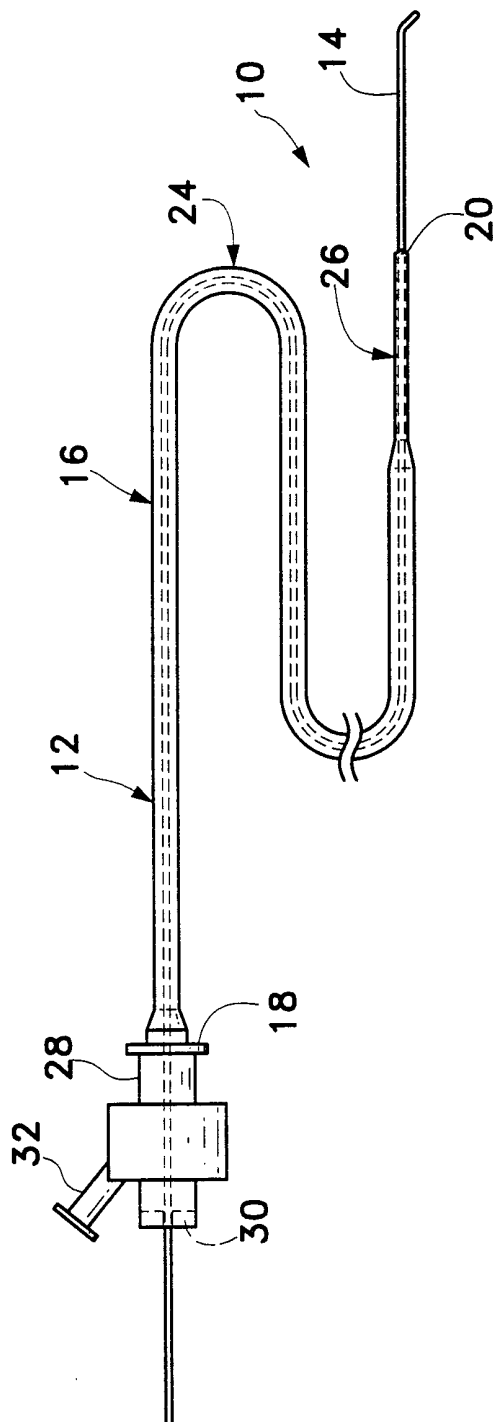


FIG. 1

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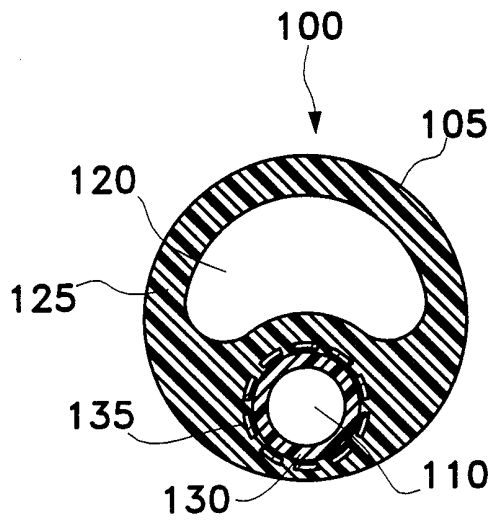


FIG. 2

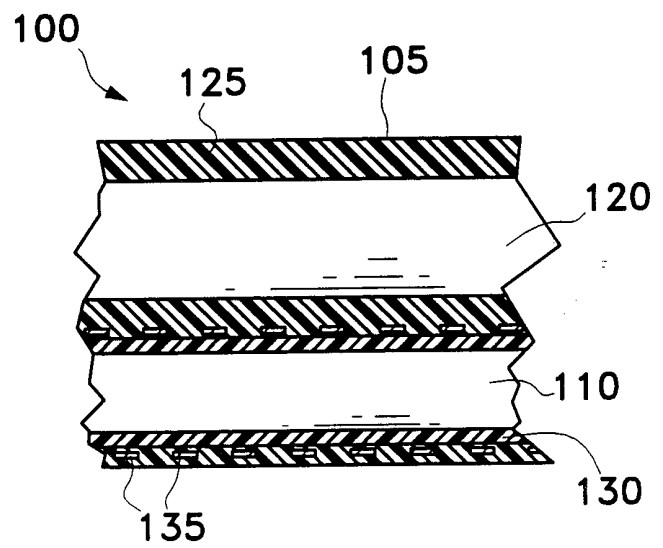


FIG. 3

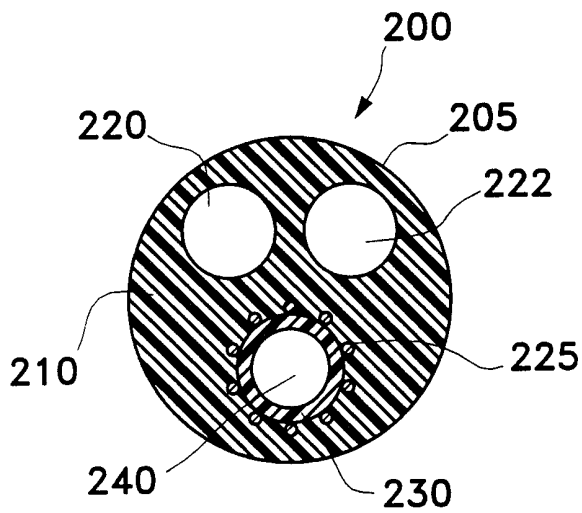


FIG. 4

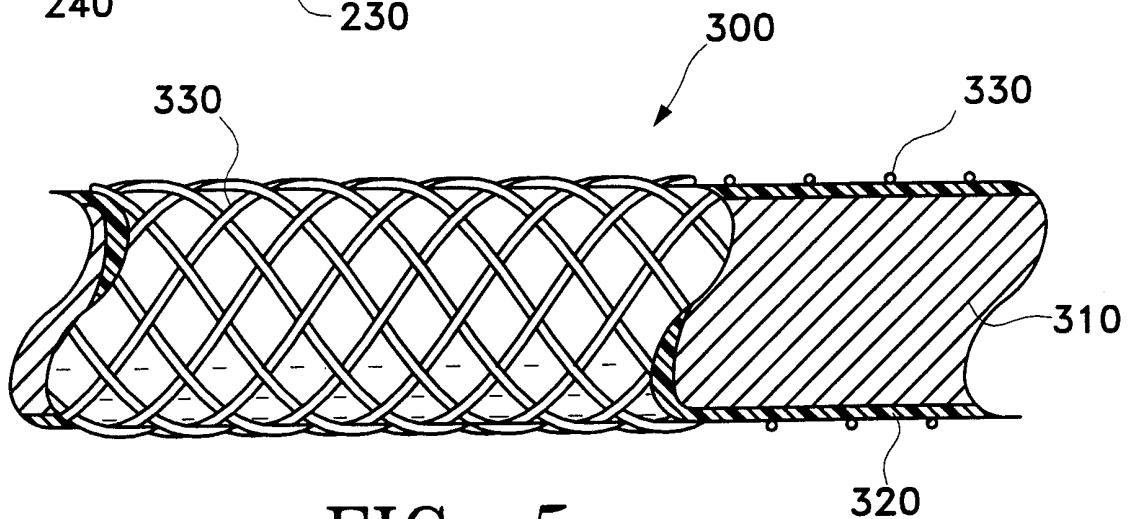


FIG. 5

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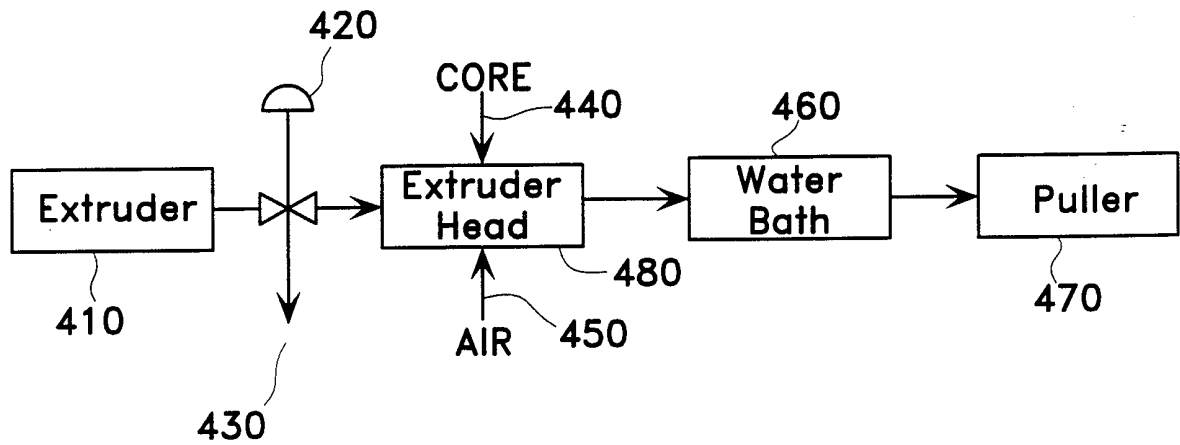


FIG. 6

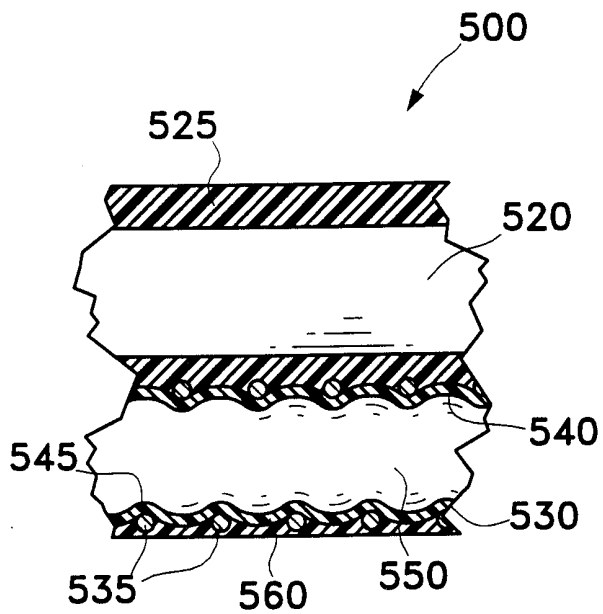


FIG. 7

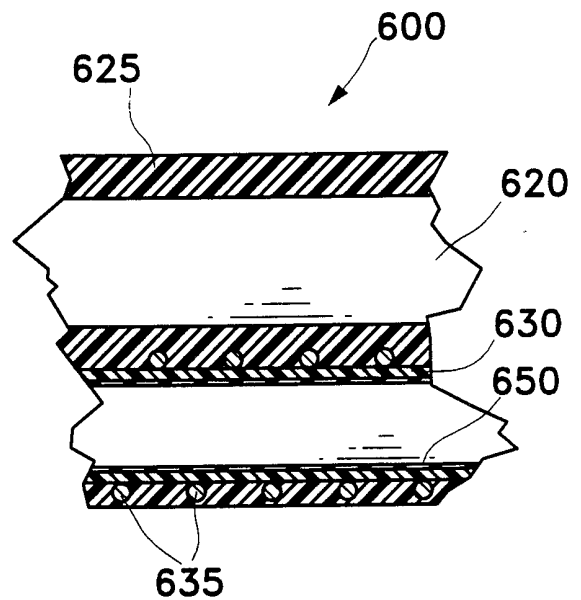


FIG. 8