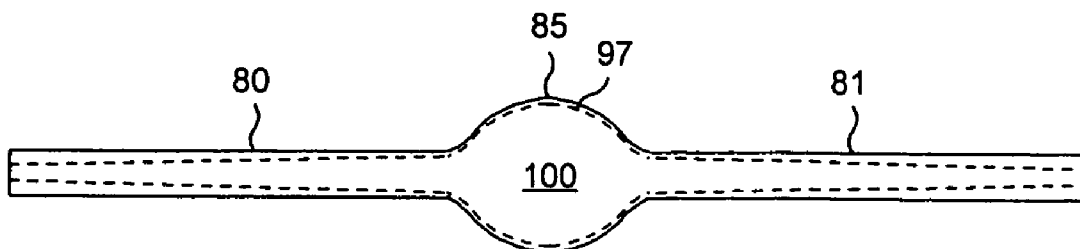




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RILEY et al.(10) **Pub. No.: US 2010/0065989 A1**(43) **Pub. Date: Mar. 18, 2010**(54) **RESORBABLE HOLLOW DEVICES FOR
IMPLANTATION AND DELIVERY OF
THERAPEUTIC AGENTS**(60) Provisional application No. 60/653,778, filed on Feb.
16, 2005, provisional application No. 60/672,839,
filed on Apr. 18, 2005.(75) Inventors: **SUSAN LYNN RILEY, SAN
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IRVINE, CA 92618 (US)**(57) **ABSTRACT**

A method of manufacturing a resorbable balloon designed to contain bone cement for vertebroplasty or kyphoplasty applications is described. The resorbable balloon can be inserted into a vertebral body following vertebral cavitation and filled with bone cement. The balloon remains in place in the vertebral body and resorbs over time. Methods and apparatus are also described for delivering therapeutic agents using collapsible, resorbable balloons. The balloons may be nested and filled with various therapeutic agents that are released over time at rates dependent upon structures and degradation rates of the balloons. Furthermore, the function of the hollow devices can encompass both encapsulation and therapeutic substance delivery roles simultaneously.

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Gladwyne, PA (US)(21) Appl. No.: **12/624,217**(22) Filed: **Nov. 23, 2009****Related U.S. Application Data**(63) Continuation of application No. 11/357,837, filed on
Feb. 16, 2006.

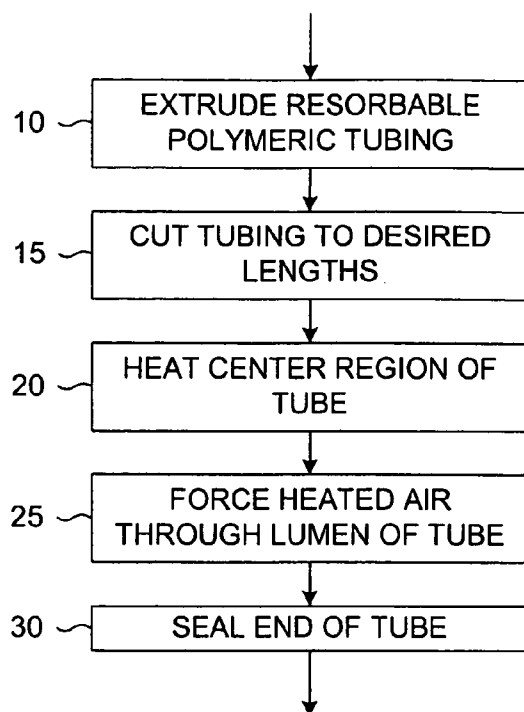


FIG. 1

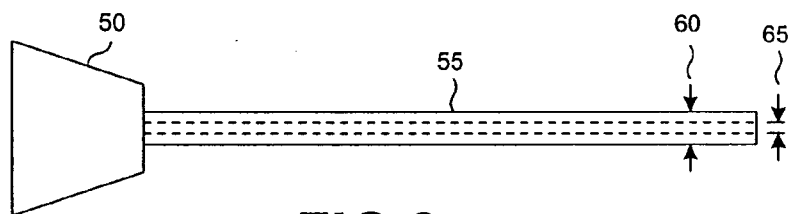


FIG. 2a

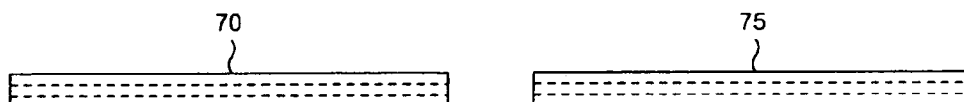


FIG. 2b

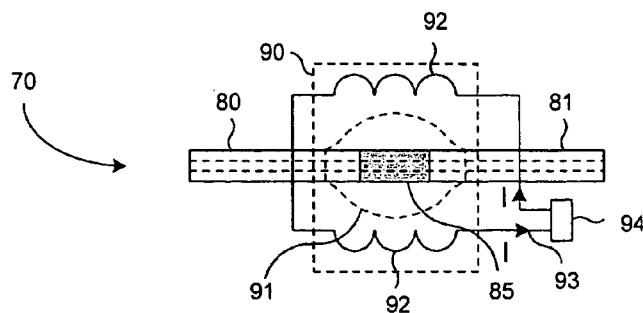


FIG. 2c

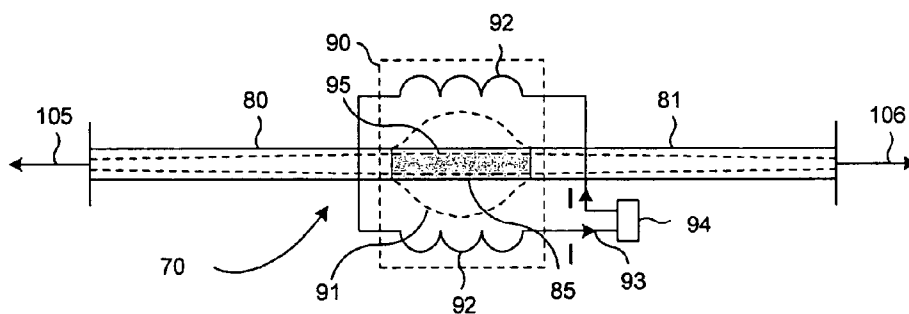


FIG. 2d

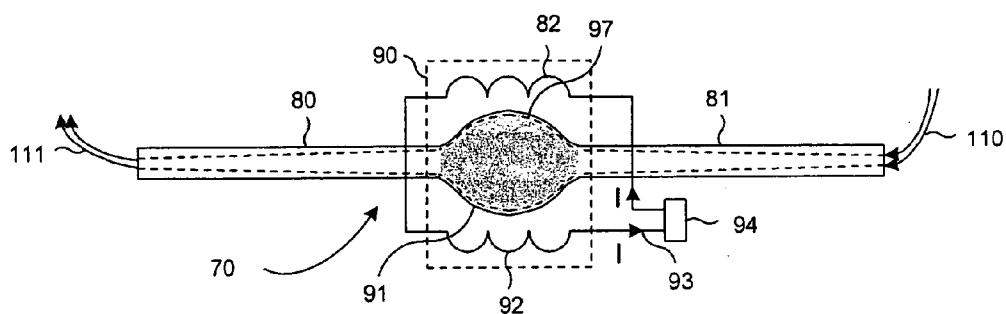


FIG. 2e

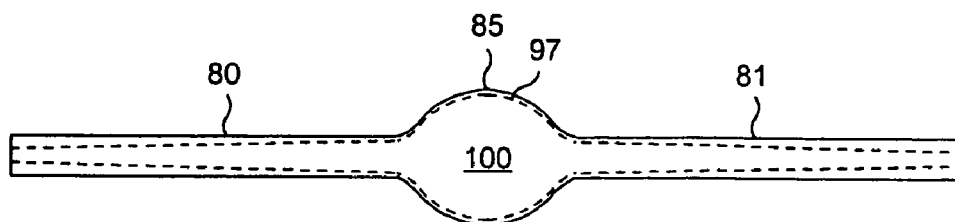


FIG. 2f

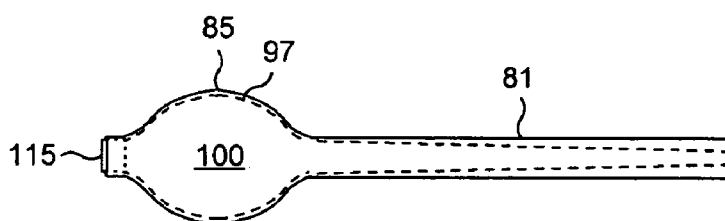


FIG. 2g

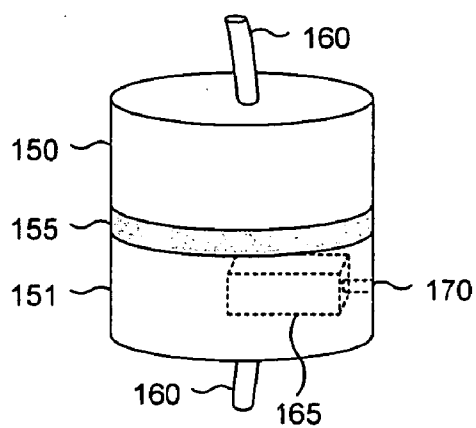
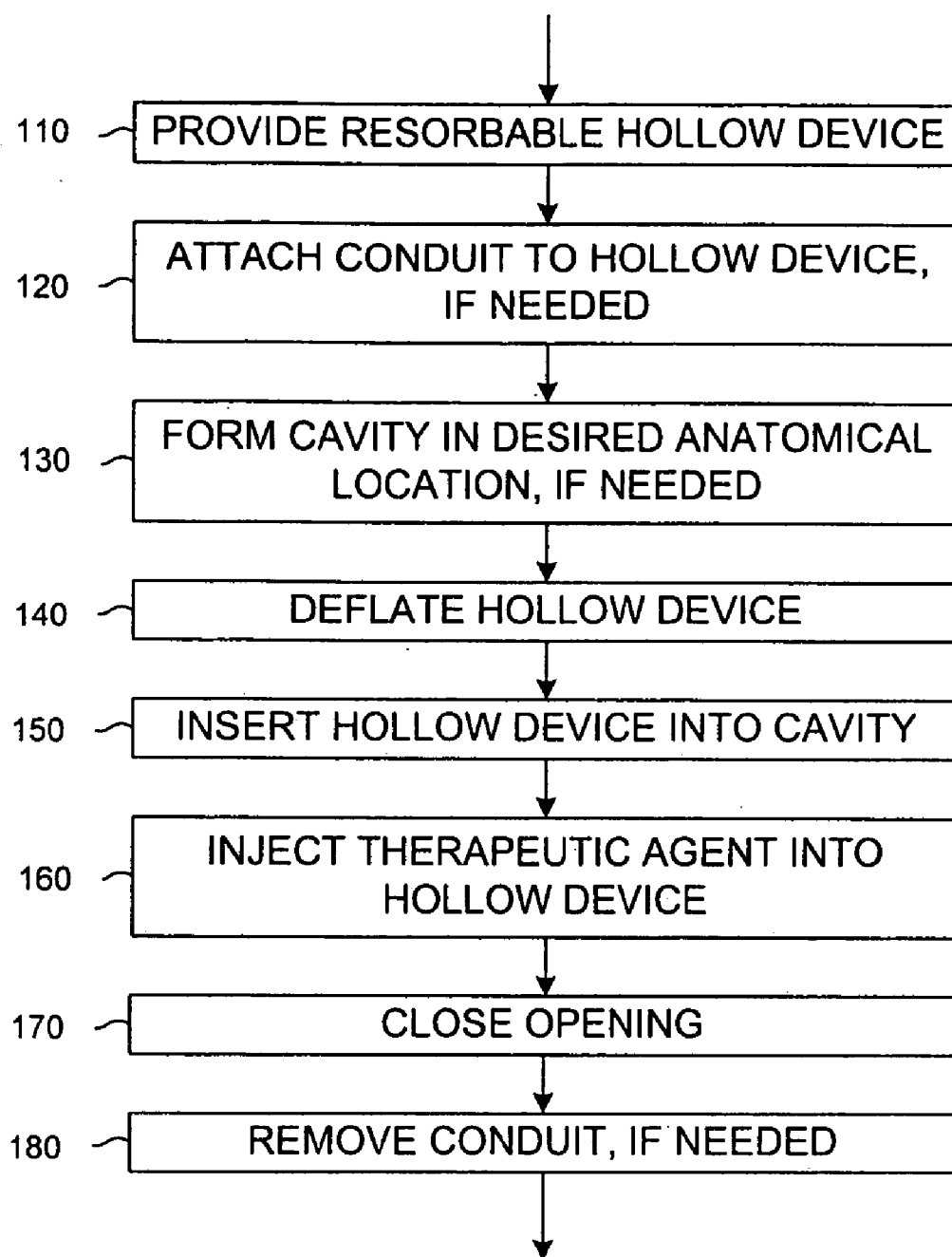


FIG. 3

**FIG. 4**

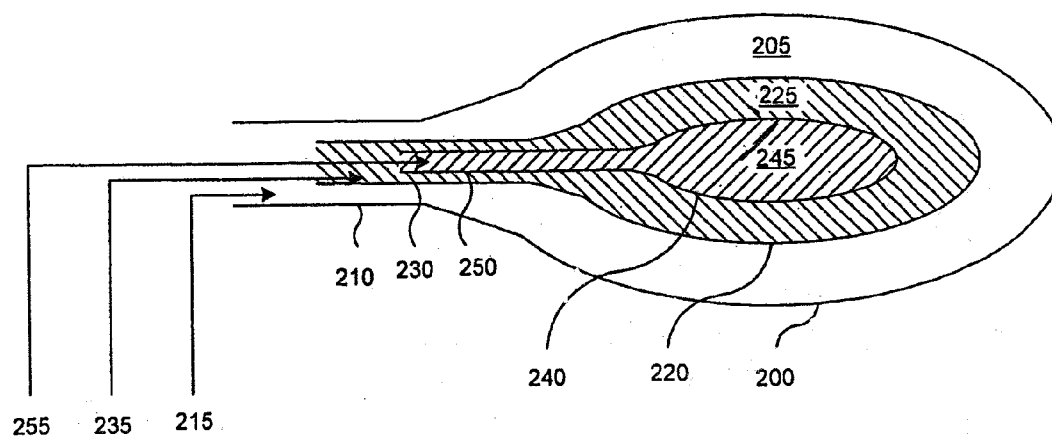


FIG. 5

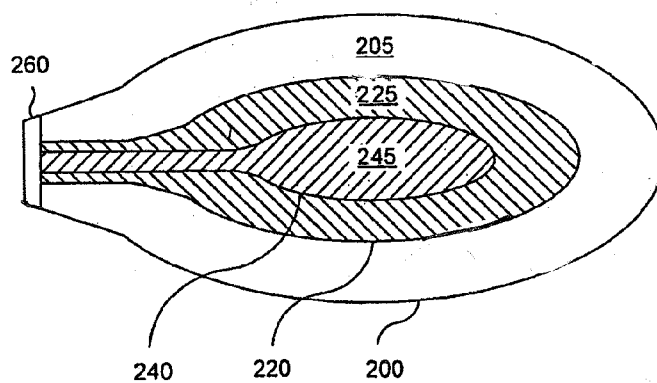


FIG. 6

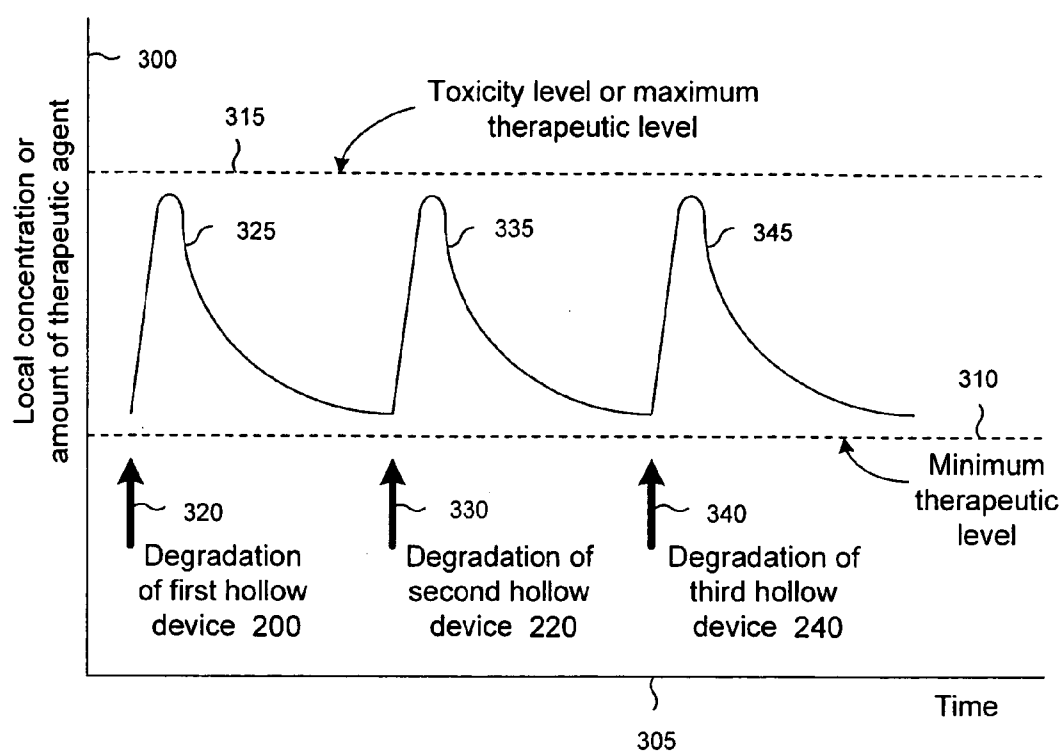


FIG. 7

RESORBABLE HOLLOW DEVICES FOR IMPLANTATION AND DELIVERY OF THERAPEUTIC AGENTS

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application is a continuation of U.S. application Ser. No. 11/357,837, filed Feb. 16, 2006 and entitled RESORBABLE HOLLOW DEVICES FOR IMPLANTATION AND DELIVERY OF THERAPEUTIC AGENTS. U.S. application Ser. No. 11/357,837 claims the benefit of U.S. Provisional Application No. 60/653,778, filed Feb. 16, 2005 and entitled RESORBABLE BALLOON FOR BIOMEDICAL IMPLANTATION, and U.S. Provisional Application No. 60/672,839, filed Apr. 18, 2005 and entitled RESORBABLE HOLLOW DEVICES FOR DELIVERY OF THERAPEUTIC AGENTS, the entire contents of both which are hereby incorporated by reference. This application also relates to U.S. application Ser. No. 10/129,214 (Docket MA9263P), filed Oct. 21, 2002 and entitled TIME-RELEASED SUBSTANCE DELIVERY DEVICE, the entire contents of which are hereby incorporated by reference.

BACKGROUND OF THE INVENTION

[0002] 1. Field of the Invention

[0003] The present invention relates generally to implants and, more particularly, to biomedical balloons and applications employing such balloons.

[0004] 2. Description of Related Art

[0005] Balloon catheters have been employed in angioplasty applications for many years. A catheter having an inflatable balloon formed therein may be inserted into an artery percutaneously, and the balloon guided to a treatment area. The balloon may then be inflated in order to mitigate the effect of plaque deposits in, for example, a coronary artery. In some cases a balloon catheter is employed to implant a stent into an artery of a patient in order to decrease the likelihood of a recurrence of arterial blockage. Balloon catheters used in angioplasty are commonly removed from the patient after use as a result of, for example, typically being meant only to temporarily inflate the vessel or temporarily block the vessel for delivery of a stent or drugs. Additionally, removal of the balloon is typically necessary in order to attenuate complications that may arise pertaining, for example, to long-term effects which may stem from contact between a material of the balloon and the patient's tissue.

[0006] Balloon devices have found utility in biomedical areas other than cardiovascular applications. For example, balloons may be used in kyphoplasty applications wherein the effect of a vertebral fracture from osteoporosis is treated by inserting a balloon into a cavity formed in the fracture. Inflating the balloon may cause pieces of the fracture to return to a positions or orientations approximating those existing before for example a traumatic event that caused the fracture. Bone cement may then be inserted into the cavity in order to stabilize the bone fragments. In other vertebroplasty applications, bone cement may be inserted into, for example, cavities formed in weakened or fractured bones in order to provide enhanced strength and stability.

[0007] Unfortunately, cement extravasation can be a problem in these kyphoplasty and vertebroplasty situations. For instance, cement inserted into bone may extrude into surrounding tissues and nerves, causing pain and other compli-

cations. One way to prevent cement extravasation is to insert a balloon into the treatment cavity, fill the balloon with bone cement, and allow the cement to harden inside the balloon while the balloon remains in the body of the patient. Such a solution may not always be viable due for example to confounding factors such as situations wherein the presence of the balloon may prevent bonding between the bone cement and the bone tissue of interest. Consequently, gaps may form between an outer surface of the balloon and surrounding bone, introducing for example attendant risks of infection, bone loss, and pain.

[0008] A need thus exists in the prior art for a method of preventing cement extravasation in vertebroplasty and kyphoplasty applications. A further need exists for enabling bonding between bone cement and bone tissue following vertebroplasty and kyphoplasty treatments.

[0009] A medicinal substance can be administered to a patient systemically or locally. A systemically administered medicinal substance enters into the blood stream, travels throughout the body, and, preferentially, reaches the part of the patient's body in need of treatment at an effective dose before being degraded by metabolism and excreted. The systemic administration of medicinal substances can be achieved by oral application (e.g., syrups, tablets, capsules and the like), needle injection, transdermal delivery (e.g., a medicinal substance incorporated into a skin patch), and subdermal delivery (e.g., a medicinal substance formulation in a metabolizable matrix placed beneath the skin to release, for example, nicotine or birth control drugs). Systemically delivered medicinal substances can be inefficient when only a small amount of the administered dose reaches the site sought for therapeutic action. Moreover, with systemic delivery a medicinal substance can enter parts of the body where it can actually do harm or produce a noxious side effect.

[0010] Medicinal substances can be delivered locally by injection (e.g., injection of anesthetic into a patient's gums) or topically (e.g., creams, ointments, and sprays). Although the local delivery of medicinal substances can in some instances overcome problems of dilution and migration associated with systemic administration, multiple injections may be required to achieve or sustain a therapeutically effective dose over time. To avoid a need for multiple injections, a therapeutic agent may be delivered locally by way of a timed-released or controlled delivery type device. In many cases, timed-released devices are formed as a mixture or dispersion of the therapeutic agent in a degrading or non-degrading delivery material or vehicle. In some cases the therapeutic agent is destroyed, denatured, or loses its activity when combined with the delivery vehicle or material. In other cases, controlled delivery devices rely on diffusion of the therapeutic agent from the delivery material or vehicle, but the therapeutic agent may be too large to diffuse through a delivery material matrix of the controlled delivery device at a reasonable rate. In cases where the volume of the therapeutic time-released agent is large, an open procedure may be required to insert a relatively large therapeutic time-release device to the desired anatomical location. To avoid an open procedure for the delivery of a large volume of therapeutic agent, many small devices may be inserted, such as microspheres. The microspheres, however, may be difficult to retrieve if there is a complication. Even when local delivery of medicinal substances to a target site is possible, an important consideration still remains of maximizing the therapeutic effectiveness of

the local drug delivery by controlling the proper dose and duration of the local delivery of the medicinal substance.

[0011] A need thus exists in the prior art for a delivery method or apparatus that can avoid undesirable activity losses of a therapeutic agent that may be associated with techniques that combine the therapeutic agent with a delivery material or vehicle. A further need exists for a method or apparatus that can avoid a requirement of diffusion of a therapeutic agent through a material of a delivery device. A still further need exists for methods or apparatus that may not require implantation of multitudes of small delivery devices and/or associated problems that may be presented of having to retrieve those small devices from an anatomical location upon the occurrence of complications, as well as methods or apparatus that may not require open surgical procedures for delivering large amounts of therapeutic agents.

SUMMARY OF THE INVENTION

[0012] The present invention provides a resorbable (e.g., bioresorbable, degradable, biodegradable, absorbable, bioabsorbable, erodible, bioerodible) balloon that can encapsulate cement in vertebroplasty and kyphoplasty applications until the cement has an opportunity to harden, thereby preventing incursion of the cement into soft tissue and nerves in a vicinity of bone being treated. The invention herein disclosed includes a method of forming a resorbable balloon comprising, according to an illustrative implementation, extruding resorbable tubing and cutting the tubing to desired lengths, thereby forming a plurality of tubes. A region of a tube is heated, and the tubing that forms the tube can be pulled along an axis of the tube, thereby thinning a wall of the tube at the heated region. Heated air is forced through a lumen of the tube while heating the region of the tube so that the tubing expands and forms a balloon in the heated region. An end of the tube is sealed by a thermal method or by gluing a resorbable plug into the lumen, and excess tubing beyond the sealed point is removed. According to an illustrative example, the resorbable balloon may be employed in a bone restoration procedure whereby a volume of bone is evacuated to form a cavity in the bone. A deflated resorbable balloon is inserted into the cavity, and the resorbable balloon is filled with bone cement, thereby inflating the balloon and filling the cavity. The resorbable balloon subsequently biodegrades to bring the bone cement into contact with bone within the cavity.

[0013] The present invention further provides apparatus and methods that may avoid problems associated with prior art methods of delivering therapeutic agents. Delivery methods and devices of various embodiments of the present invention may provide delivery of therapeutic agents while avoiding or attenuating problems associated with one or more of: combinations of the therapeutic agent with a delivery material or vehicle, diffusion through a material of the delivery device, implantation of multitudes of small delivery devices, and open surgical procedures. The invention herein disclosed thus can employ resorbable hollow devices which can be introduced into a desired anatomical location with, in many instances, a minimum of trauma. As an example, an implementation of a method according to the present invention can comprise a first collapsible resorbable hollow device, such as a resorbable balloon. A surgical procedure, which may be a laparoscopic procedure, may be performed to generate a cavity in a desired anatomical location of a body of a patient. The resorbable hollow device may be deflated, and subsequently inserted into the cavity. At least one therapeutic agent may be

injected into the first collapsible resorbable hollow device. According to another implementation of the method, a second collapsible resorbable hollow device may be provided, and the second device may be inserted into the first collapsible resorbable hollow device. At least one therapeutic agent then may be injected into the second collapsible resorbable hollow device. Various therapeutic agents may be injected according to typical implementations of the present invention. For example, a therapeutic agent may comprise one or more of a natural organic substance, a synthetic organic substance, an inorganic substance, and combinations thereof.

[0014] Furthermore, the function of the hollow devices can encompass both encapsulation and therapeutic substance delivery roles simultaneously. An embodiment of the present invention may further comprise a collapsible resorbable balloon formed of resorbable material such as, for example, aliphatic polyesters, polycarbonates, polyoxaesters, polyorthoesters, polyanhydrides, polyphosphoesters, polyphosphazenes, polypropylene fumarates, polyamino acids, other polyamides, pseudopoly(amino acids), polyamidoesters, polyarylates, polyoxaesters containing amine groups, polyalkylene oxalate, polyhydroxybutyrate, polyhydroxyvalerate, resorbable polyurethanes, resorbable starches, resorbable silk, chitan or chitosan, and combinations (co- or multi-polymers or blends) of any of the above with or without, for example, nonresorbable polymers and/or natural substances.

[0015] While the apparatus and methods of the present invention have or may be described for the sake of grammatical fluidity with functional explanations, it is to be expressly understood that the claims, unless expressly formulated under 35 U.S.C. 112, are not to be construed as necessarily limited in any way by the construction of "means" or "steps" limitations, but are to be accorded the full scope of the meaning and equivalents of the definition provided by the claims under the judicial doctrine of equivalents, and in the case where the claims are expressly formulated under 35 U.S.C. 112 are to be accorded full statutory equivalents under 35 U.S.C. 112.

[0016] Any feature or combination of features described herein are included within the scope of the present invention provided that the features included in any such combination are not mutually inconsistent as will be apparent from the context, this specification, and the knowledge of one skilled in the art. For purposes of summarizing the present invention, certain aspects, advantages and novel features of the present invention are described herein. Of course, it is to be understood that not necessarily all such aspects, advantages or features will be embodied in any particular embodiment of the present invention. Additional advantages and aspects of the present invention will be apparent in the following detailed description and claims that follow.

BRIEF DESCRIPTION OF THE DRAWINGS

[0017] FIG. 1 is a flow diagram describing an implementation of a method of manufacturing a resorbable balloon;

[0018] FIGS. 2a-2g are schematic diagrams illustrating results of applying steps of a method of manufacturing a resorbable balloon in accordance with an implementation of the present invention;

[0019] FIG. 3 is a simplified diagram illustrating a cavity in bone that may be filled with cement by employing a resorbable balloon according to the present invention;

[0020] FIG. 4 is a flow diagram describing an implementation of a method of delivering a therapy or therapeutic agent employing collapsible resorbable hollow devices;

[0021] FIG. 5 is a pictorial diagram illustrating three resorbable hollow devices according to an example of the present invention;

[0022] FIG. 6 is a pictorial diagram illustrating the three resorbable hollow devices of FIG. 5 with openings sealed or closed in some way, if needed, and conduits removed; and

[0023] FIG. 7 is a graphical chart illustrating timed-release delivery of therapeutic agents.

DETAILED DESCRIPTION OF THE INVENTION

[0024] Reference will now be made in detail to the presently preferred embodiments of the invention, examples of which are illustrated in the accompanying drawings. Wherever possible, the same or similar reference numbers may be used in the drawings and the description to refer to the same or like parts. It should be noted that the drawings are in simplified form and are not to precise scale. In reference to the disclosure herein, for purposes of convenience and clarity only, directional terms, such as, top, bottom, left, right, up, down, over, above, below, beneath, rear, and front, may be used with respect to the accompanying drawings. Such directional terms should not be construed to limit the scope of the invention in any manner.

[0025] Although the disclosure herein refers to certain illustrated embodiments, it is to be understood that these embodiments are presented by way of example and not by way of limitation. The intent of the following detailed description, although discussing exemplary embodiments, is to be construed to cover all modifications, alternatives, and equivalents of the embodiments as may fall within the spirit and scope of the invention as defined by the appended claims. It is to be understood and appreciated that the process steps and structures described herein do not cover complete process flows for the manufacture of resorbable balloons and methods of administration of time-release therapeutic agents using resorbable balloons. The present invention may be practiced in conjunction with various techniques that may be conventionally used in the art, and only so much of the commonly practiced process steps are included herein as necessary to provide an understanding of the present invention. The present invention has applicability in the field of resorbable balloons or hollow devices in general. For illustrative purposes, however, the following description is presented in the context of a biodegradable (e.g., resorbable, bioresorbable, degradable, absorbable, bioabsorbable, erodible, or bioerodible) balloon for vertebroplasty and kyphoplasty applications and methods of manufacturing a biodegradable balloon, and in the context of biodegradable (e.g., resorbable, bioresorbable, degradable, absorbable, bioabsorbable, erodible, or bioerodible) balloons for delivering therapeutic agents over a distributed time span.

[0026] Referring more particularly to the drawings, FIG. 1 is a flow diagram describing an implementation of the inventive methods of manufacturing a resorbable (e.g., bioresorbable, degradable, biodegradable, absorbable, bioabsorbable, erodible, bioerodible) balloon. This implementation will be described with reference to FIGS. 2a-2g, which illustrate a representative sequence of performing steps of the methods. The illustrated embodiment of the described inventive methods comprises extruding resorbable tubing at step 10. The tubing extruded may comprise, for example, polymeric tubing in a representative embodiment. FIG. 2a illustrates an example of a mold 50 from which is extruded tubing 55. In typical embodiments, the tubing 55 may have a circular cross-

section with an outer diameter 60 ranging, for example, from about 0.7 mm to about 15 mm and an inner diameter 65 that may range, for example, from about 0.5 mm to about 9 mm. That is, the tubing may exhibit a wall thickness of, for example, about 0.1 mm to about 3 mm in common embodiments. The tubing 55 may be cut into portions at step 15, wherein the portions may have various lengths according to varying intended applications. Tubes of resorbable material may thus be formed from the cutting performed at step 15. For example, a portion of tubing intended for use in angioplasty may range in length from, for example, about 50 mm to about 300 mm. A portion of tubing intended for use in vertebroplasty applications typically may be cut into lengths ranging in length from, for example, about 15 mm to about 100 mm. FIG. 2b illustrates two such tubes 70 and 75.

[0027] A portion of the tubing, e.g., tube 70 (FIG. 2b), then may be heated in a selected region at step 20. For example, a center region of the tube may be selected and heated. FIG. 2c illustrates a center region 85 of tube 70 being heated by an embodiment of an external heat source, which may comprise, for example, a mold formed, for example, of metal. In the illustrated embodiment, the mold comprises a heated mold 90. The heated mold 90 may comprise an internal chamber or cavity 91 having a shape and size equal or corresponding to, for example, one or more of a final balloon size and a final balloon shape. An exemplary embodiment of the heated mold 90 comprises electrical coils 92 through which may be passed a current 93 supplied from an electrical power source 94. Other internal heating means, and/or even external heating means, such as heating elements (e.g., flames) and/or electromagnetic energy (EM) emitting sources used for example with nonmetallic (e.g., non-EM blocking) molds, may be implemented in modified embodiments.

[0028] Regardless of the means used for providing heat, the heated mold 90 may in certain embodiments be configured to provide heat (and/or cooling), for example, in different amounts along one or more of: (a) at least one spatial dimension (e.g., along a longitudinal axis of the heated mold 90), and (b) a time dimension (e.g., at different points in time and/or for different durations). For example, when tubing is inserted into the heated mold 90 such that a longitudinal axis of the tubing is substantially aligned with a longitudinal axis of the heated mold 90, and when as in the illustrated embodiment tubing near the center of the cavity 91 is substantially further from walls of the heated mold 90 than tubing at ends of the cavity 91, greater amounts of heat energy may be provided near the center of the cavity 91 at certain points in time such as during the process of FIG. 2e. According to certain implementations, the tubing can be inserted into the heated mold 90 prior to any pre-stretching of the tubing.

[0029] Electrical coils in an illustrated embodiment of the heated mold 90 may be fabricated to have, for example, greater resistance in a center region of the heated mold 90 than at edges. Such an arrangement may provide greater I^2R heating of metal near the center of the heated mold 90, wherein I represents current and R represents resistance. Thus, in an illustrative embodiment wherein the heated mold 90 comprises a block of metal housing electrical coils 92, certain parts of the heated portions of electrical coils 92 may be formed to comprise greater resistances (or other heating structures) to thereby provide varying amounts of heat at the heated portions of the electrical coils 92.

[0030] In an exemplary operation, tubing may be fed down a middle of the heated mold 90, and current 93 then turned on

to raise a temperature of the heated mold **90**. Typically, the heated mold **90** heats the tubing material to a temperature greater than a glass transition temperature, but below a melting temperature, of a material (e.g., a polymer) forming the tubing.

[0031] The heated center region **85**, which is indicated in FIG. **2c** with shading, is bounded by relatively unheated regions **80** and **81** of tubing on either side of the heated center region **85**. According to an implementation of the methods of the present invention, after a condition has been met, such as an occurrence of one or more of a predetermined time period and a predetermined temperature, the material forming tube **70** may be pulled. In one embodiment, the material forming the tube **70** is pulled while being heated. When polymeric tubing is used, such pulling may accomplish one or more of strengthening and orienting a polymer or polymers of the tubing and causing the tubing wall to thin in the heated region. The pulling may increase the length of the heated center region of the tube **85** in a range of, for example, about 0 percent to about 1000 percent. The thickness of the thinned tubing wall **95** in the heated center region **85** may range from, for example, about 0.01 mm to about 0.5 mm when step **20** is concluded. FIG. **2d** is a pictorial representation of an implementation of the heating/pulling operation just described. The pulling may be implemented, for example, by applying axial forces **105** and **106** to opposite ends of the tube **70**.

[0032] A balloon may be formed in the resorbable tube by forcing heated air through a lumen of the tube at step **25** while, in the illustrated embodiment, continuing to apply external heat, thereby causing the tubing to expand in the selected region. FIG. **2e** illustrates the process. Fluid, such as air, which in the illustrated embodiment may comprise heated air **110**, is directed, e.g., forced, into the tube **70**. The directing of the fluid into the tube **70**, e.g., into one or more ends of the tube **70**, may result in one or more of further thinning of a wall **97** of the tube **70** and formation of a balloon **100** (FIG. **2f**). In the illustrated embodiment, the directing of fluid into the tube **70** causes a pressure increase inside the tube **70**. As presently embodied, the effect of the heat applied from the heated mold **90** and the heat of the heated air **110** can cause the tube **70** to expand in the center region **85**, which action may result in thinning of the wall **97** of the tube **70** and formation of a balloon **100**. According to certain implementations, fluid in the form of a gas or liquid may be directed through a lumen of the tube **70** prior to stretching of the tube **70**. In certain implementations, the mold may provide cooling only while fluid in the form of a gas or liquid is be directed through a lumen of the tube **70** causing expansion of the tube.

[0033] Exhaust air **111** may be directed out of the tube **70** via, for example, an end of the tube **70** that is opposite to an end through which the fluid is directed. According to this method, the thickness of the wall **97** of the balloon **100** may in the illustrated embodiment be reduced to a thickness of, for example, about 0.005 mm to about 0.1 mm. FIG. **2f** illustrates an example of a balloon **100** formed according to the aforementioned steps after the heated mold **90** and a source of forced heated air **110** have been removed. In certain embodiments, the heated mold **90** may be partially or substantially completely (e.g., below a glass transition temperature) cooled before removal of the balloon **100** from the heated mold **90**. Fabrication of the balloon **100** can then be completed by, for example, at least partially modifying, e.g., sealing, an end of the tube near the balloon **100** at step **30**. For example, in FIG. **2g**, a resorbable plug **115** is shown formed, e.g., integrally

formed using heat, or affixed, e.g., adhered or glued, to an end of the balloon **100**, thereby providing, for example, a seal at an end of the tube that is disposed in close proximity to the balloon **100**. Excess tubing, corresponding for example to a relatively unheated region **80** (FIG. **2f**), can be removed, e.g., cut off, beyond the sealed point as depicted in the embodiment of FIG. **2g**. According to an alternative implementation of the method, one end of the tube can be modified, e.g., heat crimped, plugged, or otherwise closed, before the balloon **100** is formed, i.e., before the performance of step **20**. Once formed, the balloon **100** may, for example, be deflated and configured, e.g., folded or twisted, to a cross-section of, for example, about the size of the relatively unheated region **81**.

[0034] FIG. **3** is a simplified diagram illustrating a cavity in bone that may be filled with cement by employing a resorbable balloon in accordance with an aspect of the present invention. Bone such as vertebral bodies of the spine in a patient is represented in FIG. **3** by two cylinders **150** and **151** separated by a cushioning disk **155**. A representation **160** of a spinal cord that passes through the vertebrae **150** and **151** and the disk **155** also is shown. A cavity **165** has been formed in vertebra **151** representing a cavity that may be formed in, for example, an injured or osteoporotic spine. An access passageway **170** formed in the vertebra **151** provides a means for access to the cavity **165**. In at least one implementation, a diameter, e.g., a maximum diameter, of the access passageway **170** is less than a diameter, e.g., a maximum diameter, of the cavity **165**. In other embodiments, however, a diameter of the access passageway **170** may be about equal to or greater than a corresponding, e.g., measured in the same or similar direction, diameter of the cavity **165**.

[0035] In accordance with an aspect of the present invention, tubing comprising a resorbable balloon that is similar to the balloon **100** illustrated in FIG. **2g** can be formed as described herein. A property, e.g., dimension such as diameter, of the tubing is chosen such that the tubing and the balloon in its deflated state are capable of being inserted through access passageway **170** and into the cavity **165**. For instance, properties of the tubing and/or balloon may be selected such that the tubing and balloon may be folded to facilitate insertion through the access passageway **170**. According to at least one implementation, the tubing and balloon are maneuvered through the access passageway **170** and into the cavity **165** using a catheter. Once inside the cavity **170**, a material such as bone cement may be inserted, e.g., injected, into a lumen of the tube. In implementations comprising a catheter, the material may be delivered directly into the balloon via the catheter, wherein, for example, the material does not contact internal surfaces of the tubing during transit to the balloon. Other implementations may comprise, for example, delivery of the material into the balloon via the tubing itself, wherein, for example, the material contacts the tubing during transit to the balloon. In one embodiment, insertion of the material at least partially fills, e.g., inflates, the balloon.

[0036] According to an illustrated embodiment, one or more of a size and a shape of the balloon can be chosen such that the balloon is capable of conforming to sides of the cavity **165** when, for example, the balloon is inflated. In implementations utilizing a catheter, once the material has been delivered into the balloon and, for example, the balloon has expanded to substantially fill the cavity **165**, the catheter may be removed from the resorbable balloon, whereby the balloon with the material remains inside the cavity. Thus, a resorbable

balloon can be positioned within a cavity and filled with a material to accomplish expansion and conformance of the balloon to interior dimensions of the cavity.

[0037] As presently embodied, with a passage of time at least a part of the balloon degrades, causing the material within the balloon to be delivered into contact with a corresponding interior surface or surfaces of or within the cavity. In particular implementations, the resorbable balloon is not removed and resorbs substantially completely within the cavity. Resorption of the balloon can be engineered to occur, for example, after the material has contacted and at least partially reacted, e.g., bonded, with interior surfaces within the cavity. In exemplary embodiments comprising a cavity formed in bone, material comprising bone cement can be positioned within a resorbable, expandable balloon, combined, in some implementations, with one or more of an antibiotic, analgesic, growth factor (such as Bone Morphogenetic Protein), or a combination thereof, to contact interior surfaces of a cavity formed within bone, thereby permitting one or more of reacting, hardening, and bonding to occur between the material and the bone upon resorption of the balloon. Consequently, risks of one or more of infection and pain can be attenuated or eliminated.

[0038] FIG. 4 is a flow diagram describing an implementation of a method of performing therapy employing collapsible resorbable hollow devices. According to the implementation described in the figure, a collapsible, resorbable hollow device, cavity, or balloon is provided at step **110**. A method of fabricating collapsible, resorbable hollow devices of a type appropriate to the implementation is described in U.S. Provisional Application No. 60/653,778, the entire contents of which are hereby incorporated by reference. Although step **110** of the implementation comprises providing a single collapsible, resorbable hollow device, other implementations may comprise providing two or more collapsible, resorbable hollow devices.

[0039] In other implementations, the collapsible, resorbable hollow devices may be nested as illustrated, for example, in FIG. 5. The collapsible, resorbable hollow devices may be designed to deliver or release at least one therapeutic agent. As part of the fabrication of the hollow device, a conduit or tube may be attached, if needed (e.g., suitable or desired), to an opening of the device at step **120** of the implementation. According to another embodiment, the conduit may be formed as a continuous part of the hollow device. The conduit (see, e.g., FIG. 5) may facilitate loading of the hollow device with at least one therapeutic agent. Additionally, the conduit may aid in positional manipulation of the hollow device.

[0040] A surgical procedure, which may be a laparoscopic procedure, may be performed, if needed (e.g., suitable or desired), at step **130** to identify a cavity in an anatomical location. As presently embodied, a cavity in a desired anatomical location may also be formed. For example, a cavity may be formed in soft tissue using a tissue expander. Alternatively, a cavity may be formed in a collapsed vertebra of the spine of a patient, wherein therapy is to be performed. As another example, a cavity may be identified in the abdomen or other part of the body of a patient near an abscess requiring antibiotic therapy. Once the cavity is formed or identified, the hollow device may, to the extent inflated, be at least partially deflated at step **140**, and the hollow device inserted into the cavity at step **150**. The attached conduit, for example, may facilitate insertion and positional manipulation of the hollow device. A therapeutic agent, such as an antibiotic, may be

injected into the hollow device at step **160**, thereby inflating the hollow device. Alternatively, the hollow device may be inflated before the therapeutic agent is injected. According to other implementations, the inflating may be performed by altering an internal or external physical or chemical environment of the device when the device is in living tissue. The conduit may also be used to transfer the therapeutic agent into the hollow device. The opening may be closed at step **170** after which the conduit may then be removed, if needed (e.g., suitable or desired), from the hollow device at step **180**. According to another implementation, the opening is closed after removal of the conduit. In yet another implementation, the opening is closed during removal of the conduit. In yet another implementation, the opening is not closed, as may occur when the device is used to transfer gelling or polymerizing substances as therapeutic agents.

[0041] The therapeutic agent may be delivered in a time-released manner according to specific properties of the hollow device. For example, the device may be fabricated with varying thicknesses or with relatively small perforations or holes, sizes of which may be adjusted to achieve a desired rate of delivery of the therapeutic agent. In other examples, more than one collapsible, resorbable hollow device may be employed. A second collapsible device may be inserted inside a first collapsible hollow device, the first device then being injected with one or more or a combination of therapeutic agents. The second collapsible device then may be inflated, and yet another therapeutic agent or combination thereof may be injected into the second device. This process may be continued by nesting a plurality of collapsible, resorbable hollow devices in a manner that should be clear to one skilled in the art from the disclosure provided herein. When a plurality of hollow devices or balloons is employed, openings of the hollow devices may be closed separately before, after, or during removal of conduits associated with each device. In some instances, the openings may be closed together. In still other examples, nested hollow devices may be made with differing materials or geometry (shapes). Alternatively, space, or lack of space, between the devices can be used to achieve desired patterns of release of therapeutic material.

[0042] FIG. 5 is a pictorial diagram illustrating an embodiment comprising a plurality of nested hollow devices according to the present invention. Although only three such devices are illustrated in the figure, one skilled in the art will understand that more or fewer hollow devices may be employed so that a description of three devices is by way of example and not by way of limitation. In the illustrated embodiment, a first collapsible, resorbable hollow device **200** is inflated and fully or partially filled with a first therapeutic agent **205**. That is, the first collapsible, resorbable hollow device **200** may, in some instances, be partially filled in order to leave room for insertion of subsequent hollow devices. As already noted, the first therapeutic agent, as well as below-referenced additional therapeutic agents, may comprise one or more or a combination of individual therapeutic agents. The first therapeutic agent **205** may be loaded into the first hollow device **200** through a first tube or first conduit **210** formed as part of the first hollow device. Loading of first therapeutic agent **205** is noted on the diagram by reference numeral **215**. A second collapsible, resorbable hollow device **220** may be inserted using second conduit **230** in deflated form, and the device **220** then may be partially or fully inflated. According to an exemplary embodiment, loading the second hollow device **220** with a second therapeutic material **225** through second con-

duit **230** as denoted by reference numeral **235** may serve to inflate the second hollow device **220**, thereby displacing or redistributing a portion of the first therapeutic agent **205** already loaded. Continuing, a third collapsible, resorbable hollow device **240** may likewise be inserted into the second device **220** and loaded using third conduit **250** as indicated by reference numeral **255**. Once in place, respective first, second, and third conduits **210**, **230**, and **250** may be removed using any of several methods well-known in the art, leaving, for example, seal **260** in place as illustrated in FIG. 6.

[0043] The collapsible, resorbable hollow devices **200**, **220**, and **240** illustrated in FIGS. 5 and 6 may be formed of various materials. For example, a representative hollow device can be made with a resorbable synthetic polymer including by way of example, and not by way of limitation, one or more of aliphatic polyesters (e.g., polyL-lactide, polyD-lactide, polyglycolide, poly epsilon-caprolactone, and the like), polycarbonates (e.g., polytrimethylene carbonate, tyrosine derived polycarbonates, and polyiminocarbonates), polyoxaesters (e.g., polyp-dioxanone), polyorthoesters, polyanhydrides, polyphosphoesters, polyphosphazenes, polypropylene fumarates, polyamides (e.g., polyaminoacids), pseudopoly(amino acids), polyamidoesters, polyarylates, polyoxaesters containing amine groups, polyalkylene oxalate, polyhydroxybutyrate, polyhydroxyvalerate, resorbable polyurethanes, resorbable starches, resorbable silk, chitin or chitosan and combinations (co- or multi-polymers or blends) of any of the above with or without, for example, nonresorbable polymers (e.g., polyethylene oxide, and polyvinyl alcohol) and/or natural substances, and other combinations thereof. Depending at least in part upon fabrication material, hollow devices may be made to resorb (e.g., bioresorb, degrade, biodegrade, absorb, bioabsorb, erode, or bioerode) over time periods ranging from a few days to a number of years according to a desired release rate of a therapeutic agent.

[0044] Therapeutic agents may have the consistency of, for example, one or more of a liquid, gel, powder, small granules, spheres or chips, a polymerizable substance, and combinations thereof, and likewise, may be chosen from a variety of possibilities. For example, a natural organic substance can be or include one or more of living biological agents (e.g., cells), proteins (e.g., growth factors such as Bone Morphogenetic Protein, and the like), other natural polymers (e.g., collagen, gelatin, fibrin, hyaluronic acid, polysaccharides, elastin, cellulose, polynucleotides), other biological materials, and the like. Combinations of these and similar materials also may be used. In other instances, the therapeutic agent may comprise a synthetic organic substance, such as, for example, one or more of a drug, antibiotic, steroid, glycerol, polymer (e.g., polyester, silicone, polyethylene oxide, polypropylene fumarate, pluronics, polyhydroxymethacrylate, or polymethylmethacrylate), and the like, and combinations thereof. In still other cases, the therapeutic agent may comprise an inorganic substance, such as, for example, one or more of calcium phosphate (e.g., beta-tricalcium phosphate or hydroxapatite), allograft bone, other ceramics or metals, and combinations thereof. The therapeutic agents may be made in combinations from any of the above components or groups or other suitable carrier(s), examples of which may include cells loaded in a pluronic gel or growth factors and antibiotics mixed with an inorganic substance.

[0045] FIG. 7 is a chart illustrating in graphical form an example of how release of a therapeutic agent may be con-

trolled through use of resorbable hollow devices in a repeat action dosage form. The chart illustrates a variation of local concentration or amount of a therapeutic agent on a vertical axis **300** during a time period drawn on a horizontal axis **305**. The amount of therapeutic agent to be released normally is to be kept between a minimum therapeutic level **310** and a maximum therapeutic level **315**. The maximum therapeutic level **315** may correspond as well to a toxicity level. The chart of FIG. 7 is keyed to the first, second, and third resorbable hollow devices **200**, **220**, and **240** depicted in FIGS. 5 and 6. In the example illustrated, first hollow device **200** becomes resorbed (i.e. degrades) at a first time **320** releasing a first wave **325** of the therapeutic agent. As time increases to the right, the level of therapeutic agent represented by first wave **325** decreases. At a second time **330**, second hollow device **220** degrades releasing a second wave **335** of the therapeutic agent. Similarly, third hollow device **240** degrades at a third time **340** releasing a third wave **345** of the therapeutic agent. The actual elapsed time between degradation of the first, second, and third hollow devices **200**, **220**, and **240** may be controlled, as noted above, by choosing materials from which the devices are fabricated, and/or constructions (e.g., designing the devices with small holes or perforations), or the like. The time intervals between times **320**, **330**, and **340** may be the same or different. First, second, and third therapeutic agents **205**, **225**, and **245** (FIGS. 5 and 6), likewise, may be the same or different in different embodiments of the present invention.

[0046] For example, first, second, and third resorbable hollow devices **200**, **220**, and **240** could be designed, respectively, to degrade slowly, at a medium rate, and quickly, and to therefore release, again respectively, first, second, and third therapeutic agents **205**, **225** and **245** after, still again, respectively, a long, medium, and short period of time. In one embodiment, first, second, and third therapeutic agents **205**, **225**, and **245** are different or comprise different combinations or concentrations of therapeutic agents. In another embodiment, first, second, and third therapeutic agents **205**, **225**, and **245** are the same agent, and the different degradation rates of the hollow devices **200**, **220**, and **240** serve to release the agent over a relatively long period of time, and/or possibly in short bursts, but, for example, above the therapeutic minimum level **310** and below the maximum therapeutic level or below the toxicity level **315**. In yet another embodiment, a hollow device, such as second hollow device **220**, can be made to have perforations or holes, or no perforations, and may be covered or layered with another hollow device, such as first hollow device **200** having a faster degradation rate. This arrangement may allow release of the second therapeutic agent **225** through the holes of the second hollow device **220** (i.e., the more slowly degrading device) when the first hollow device **200** (i.e., the more rapidly degrading device) degrades.

[0047] In view of the foregoing, it will be understood by those skilled in the art that the methods of the present invention can facilitate formation of resorbable balloons and control of time-release therapeutic agents using collapsible, resorbable hollow devices or balloons. The above-described embodiments have been provided by way of example, and the present invention is not limited to the described examples. Multiple variations and modifications to the disclosed embodiments will occur, to the extent not mutually exclusive, to those skilled in the art upon consideration of the foregoing description. For example, the resorbable balloon may be used for other implanting applications such as a bariatric balloon,

breast augmentation balloon, etc. Furthermore, modifications to the above-described manufacturing techniques may include, for example, a continuous extrusion and balloon forming method, and alternative implementations of such techniques may include, for example, extrusion of tubing with one closed end resembling the shape of, for example, a blow molding parison. Other combinations, omissions, substitutions and modifications will be apparent to the skilled artisan in view of the disclosure herein. Accordingly, the present invention is not intended to be limited by the disclosed embodiments, but is to be defined by reference to the appended claims.

What is claimed is:

1. A method of forming a resorbable balloon, comprising: placing a resorbable tube in a mold, the tube having two side parts and a region therebetween with a lumen and a lumen axis, and having a wall thickness of about 0.1 mm to about 3 mm; performing one or more of heating and cooling of the region and pulling the tube along the axis, thereby thinning the wall of the tube at the region, wherein the performing comprises cooling;
- forcing a gas or liquid through the lumen while heating the region, thereby causing the region to expand and form a balloon with the wall thickness being reduced to about 0.005 mm to about 0.1 mm;
- sealing one of the side parts in proximity to the balloon so that the lumen is obstructed only at the side part; and inserting a nonporous resorbable hollow device through the lumen near the other side part and into the balloon, the device being catheterless, expandable, and having a cavity extending from a first portion that is sealed to a second portion that is coaxial with the other side part.
2. The method as set forth in claim 1, wherein the performing is preceded by: extruding resorbable tubing; and cutting the extruded tubing to desired lengths, thereby forming the tube.
3. The method as set forth in claim 1, wherein the one side part is sealed before forcing a gas or liquid through the lumen of the tube.
4. The method as set forth in claim 3, wherein: the sealing comprises at least one of thermally welding or heat sealing the tube; and the sealing is followed by removing excess tubing beyond the sealed point.
5. The method as set forth in claim 1, wherein the performing comprises providing heat from an element in different, non-zero amounts along a direction of the element that is about parallel to the longitudinal axis of the tube.
6. The method as set forth in claim 1, wherein the liquid or gas is heated air.
7. A method of forming a resorbable balloon, comprising: providing a resorbable tube; supplying with an element one or more of heating and cooling emissions to a region of the resorbable tube, the region being disposed along a longitudinal axis of the resorbable tube and corresponding to a supplying portion of the element, the one or more of heating and cooling emissions being supplied from the supplying portion in different amounts along a dimension that is about parallel to the longitudinal axis and impinging on the region in different amounts along the longitudinal axis, wherein the supplying comprises cooling;

forcing a gas or liquid through a lumen of the resorbable tube while supplying the one or more of heating and cooling emissions to the region of the resorbable tube, thereby causing a portion of the resorbable tube to expand and form a balloon; and

disposing a nonporous resorbable hollow device in the lumen and the balloon, the device being catheterless, expandable, and having a cavity that extends without obstruction along the longitudinal axis from a sealed end to an opposing end and that is coaxial with the lumen whereby the cavity is obstructed only at the sealed end.

8. The method as set forth in claim 7, wherein the supplying comprises heating the region of the resorbable tube, the heating emissions contacting the region in different amounts along the longitudinal axis of the resorbable tube.

9. The method as set forth in claim 7, wherein: the providing comprises providing the resorbable tube with a wall thickness ranging from about 0.1 mm to about 3 mm; and

the forcing comprises forming a balloon with the wall thickness being reduced from the range of 0.1 mm to about 3 mm to a range from about 0.005 mm to about 0.1 mm.

10. The method as set forth in claim 9, wherein the supplying and the forcing are performed in a single mold.

11. The method as set forth in claim 9, wherein the supplying is performed by cooling the region of the resorbable tube, the cooling emissions contacting the region in different amounts along the longitudinal axis of the resorbable tube.

12. The method as set forth in claim 7, wherein the supplying comprises heating the region of the resorbable tube, the heating emissions contacting the region in different amounts along the longitudinal axis of the resorbable tube.

13. The method as set forth in claim 12, wherein the supplying and the forcing are performed in the same mold.

14. The method as set forth in claim 7, wherein the supplying comprises heating.

15. The method as set forth in claim 7, wherein the supplying comprises heating, which is preceded by:

extruding resorbable tubing; cutting tubing to desired lengths, thereby forming the plurality of resorbable tubes; and

the element is a heating coil with different resistances along the supplying portion thereof for causing the one or more heating and cooling emissions to be supplied from the supplying portion in different amounts along the dimension.

16. The method as set forth in claim 7, wherein the supplying is performed by cooling the region of the resorbable tube, the cooling emissions being provided in different amounts along the longitudinal axis of the resorbable tube.

17. A method of forming a resorbable balloon, comprising: providing a resorbable tube;

generating one or more of heating and cooling emissions along a first dimension of an element, the element having a longitudinal axis that is about parallel with the first dimension, and the one or more of heating and cooling emissions being received by the resorbable tube along a second dimension of the resorbable tube that is about parallel to a longitudinal axis of the resorbable tube, the one or more of heating and cooling emissions being generated in different amounts along the first dimension of the element, wherein an orientation of the longitudinal axis of the element is about the same as an orientation

of the longitudinal axis of the resorbable tube, wherein the generating comprises cooling;
forcing a gas or liquid through a lumen of the resorbable tube while generating the one or more of heating and cooling emissions, thereby causing a portion of the resorbable tube to expand and form a balloon; and
inserting a nonporous resorbable device through the lumen and into the balloon, the device being catheterless and expandable, and having two opposing ends and an unobstructed hollow interior extending therebetween along the longitudinal axis and coaxially with the lumen.

18. The method as set forth in claim **17**, wherein:
the providing comprises providing the resorbable tube with a wall thickness ranging from about 0.1 mm to about 3 mm; and

the forcing comprises forming a balloon with the wall thickness being reduced from the range of 0.1 mm to about 3 mm to a range from about 0.005 mm to about 0.1 mm.

19. The method as set forth in claim **17**, wherein the generating and the forcing are performed in a single mold.

20. The method as set forth in claim **17**, wherein the element is a coil with different resistances along the first dimension thereof for causing the one or more heating and cooling emissions to be generated in different amounts along the first dimension.

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