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(54) Titre : PISTON DE SERINGUE A JOINT D'ETANCHEITE DYNAMIQUE
(54) Title: SYRINGE PLUNGER WITH DYNAMIC SEAL

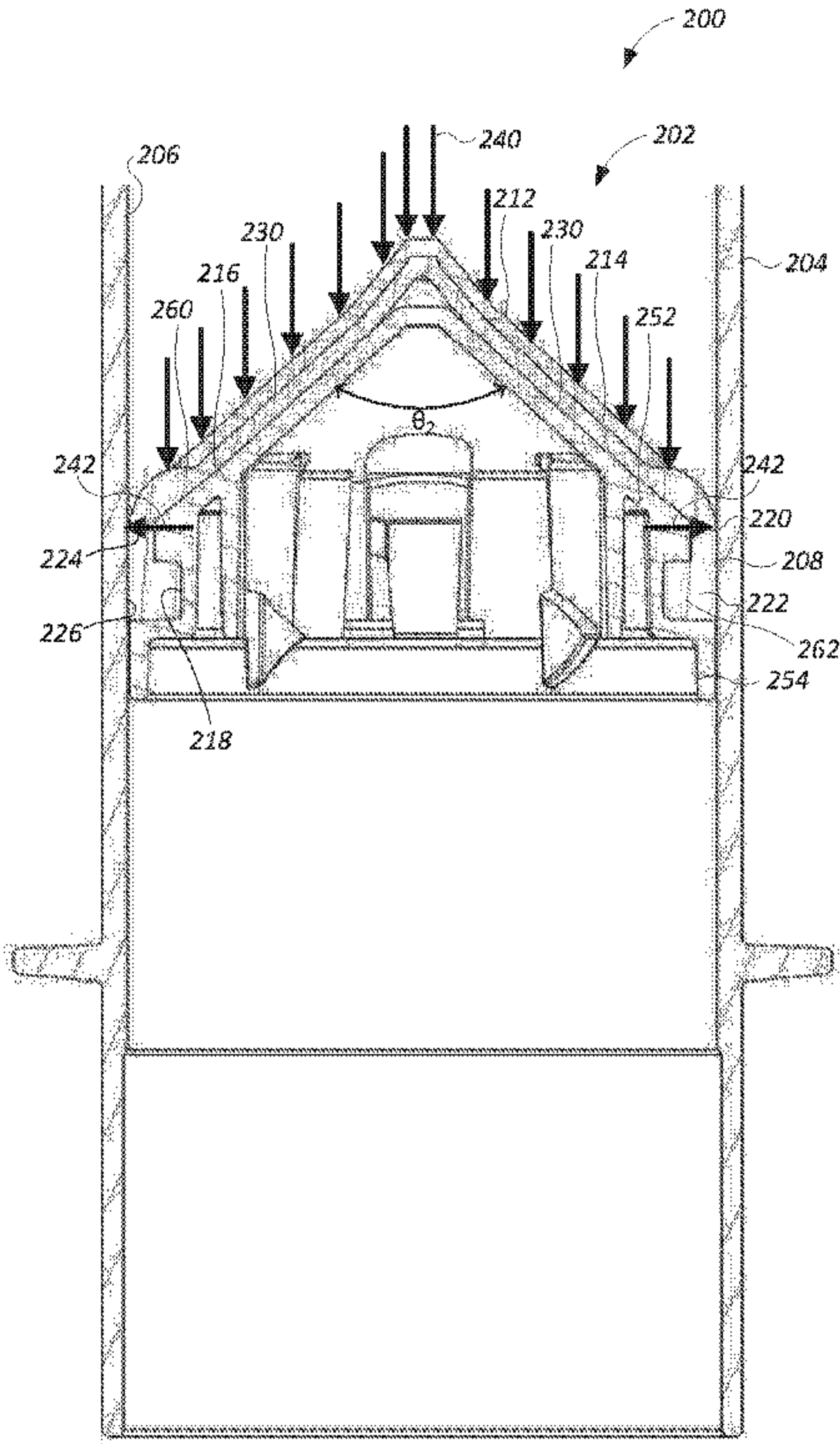


FIG. 5B

(57) **Abrégé/Abstract:**
A plunger, a syringe, and a method of making a plunger and a syringe are disclosed. The plunger includes a support ring and a cover disposed over and coupled to the support ring. A cavity defining a predetermined volume is defined between the support ring and the cover. The syringe includes a barrel defining an inner wall and the plunger inserted therein.

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(54) Title: SYRINGE PLUNGER WITH DYNAMIC SEAL

(57) Abstract: A plunger, a syringe, and a method of making a plunger and a syringe are disclosed. The plunger includes a support ring and a cover disposed over and coupled to the support ring. A cavity defining a predetermined volume is defined between the support ring and the cover. The syringe includes a barrel defining an inner wall and the plunger inserted therein.

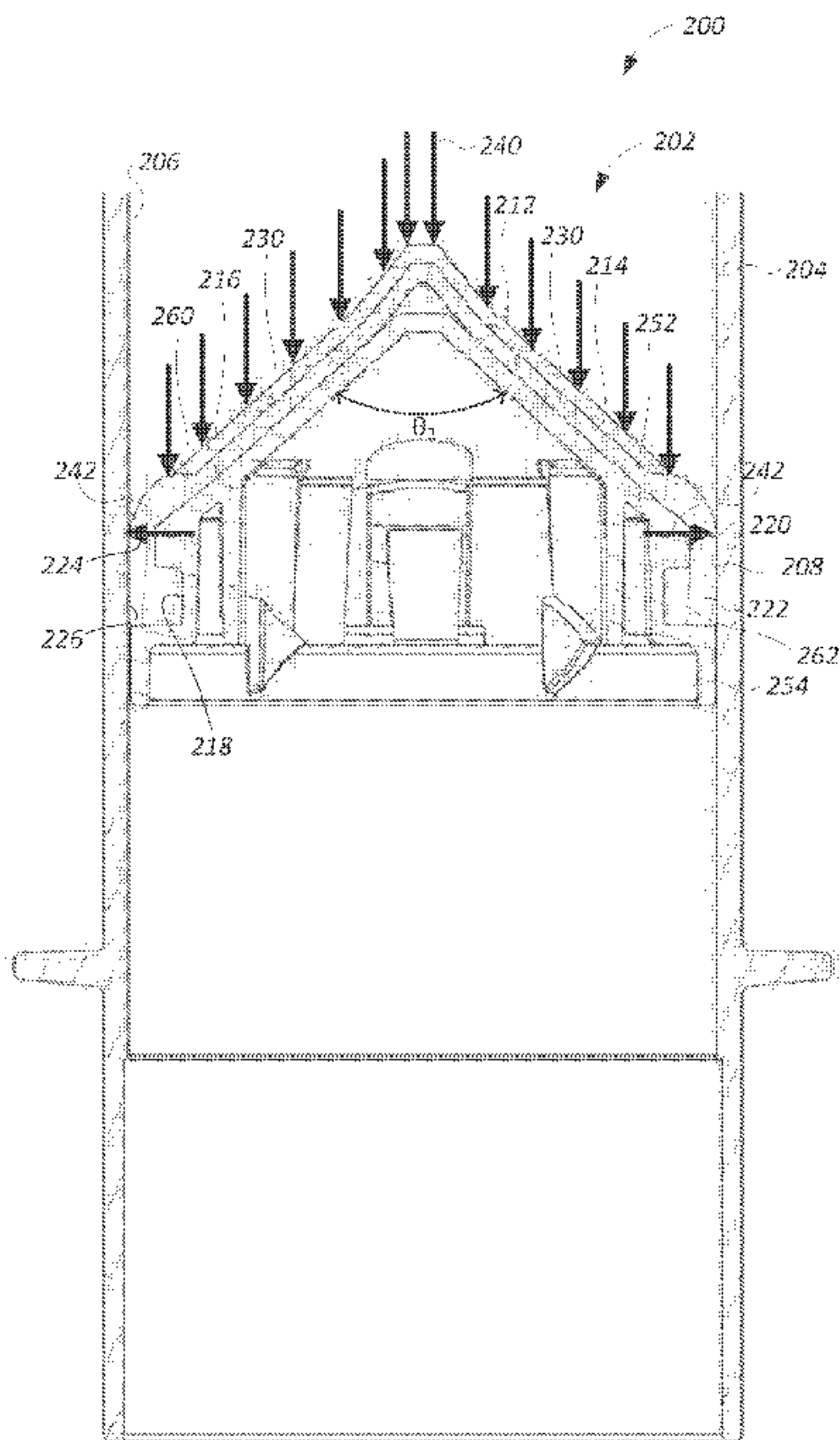


FIG. 5B

SYRINGE PLUNGER WITH DYNAMIC SEAL

CROSS REFERENCE TO RELATED APPLICATIONS

[0001] This application claims the benefit of U.S. Provisional Patent Application No. 62/443,302, filed 06 January 2017, the disclosure of which is hereby incorporated in its entirety by reference.

TECHNICAL FIELD

[0002] The present disclosure relates generally to medical fluid delivery applications, and, particularly, to fluid injection systems including a fluid injector, a syringe, and a plunger within the syringe. More particularly, the present disclosure is directed to a syringe plunger with a dynamic seal.

BACKGROUND

[0003] In many medical diagnostic and therapeutic procedures, a medical practitioner such as a physician injects a patient with a fluid. In recent years, a number of injector-actuated syringes and powered injectors for pressurized injection of fluids, such as contrast media, have been developed for use in imaging procedures such as angiography, computed tomography (CT), ultrasound, and magnetic resonance imaging. In general, these powered injectors are designed to deliver a preset amount of contrast and/or saline at a preset flow rate using one or more disposable or refillable syringes.

[0004] Automatic injection mechanisms typically include a syringe connected to a powered injector with a linear actuator. The linear actuator operates a moveable piston that is configured to engage a plunger inserted in the barrel of the syringe. The interface or engagement between the piston and plunger generally includes a reversible mechanical locking structure such as screw threads, undercuts, pins, swivels, snap fit connections, and the like for establishing and maintaining the connection between the piston and plunger.

[0005] The plunger/piston interface should be sufficiently strong to retract the plunger in a proximal direction through the barrel to draw fluid into the syringe, as well as to advance the plunger through the barrel in the distal direction to expel the fluid contained therein.

[0006] In addition to being sufficiently strong to maintain good connection between the piston and plunger during use, the interface should also be removable so that the syringe and plunger can be disposed of after use. With mechanical locking structures, to disengage the piston from the plunger, the user either orients the piston and plunger for disengagement, such as by rotating the syringe to properly align locking features on the piston and plunger, or pulls the piston away from the plunger with sufficient force to overcome the locking structure. Once the piston is disengaged from the plunger, the used syringe and plunger may be discarded.

[0007] A challenge with syringe plunger seals is insufficient sealing during injection procedures. It would be desirable to provide a syringe plunger with a dynamic seal enhance sealing during injection procedures where compression is generated when the syringe is under injection pressure conditions. Preloading compression is not desirable because over the shelf life of the syringe the plastic components undergo deformation or creep that impairs forming an adequate seal under injection pressure conditions. Furthermore, it is desirable to limit compression due to automated assembly process where it is desirable to have low pressure during manufacturing. Accordingly, various aspects of a syringe plunger with a dynamic seal described herein overcome these deficiencies.

SUMMARY

[0008] While automated injectors are well-known, improved fluid delivery systems which make the injection processes simpler for medical staff are always needed. With respect to the present disclosure, a syringe having a plunger with a dynamic seal is set forth. Desirably, the plunger with a dynamic seal which slides easily through the inner wall of the barrel of the syringe, but nevertheless is configured to provide a good effective seal against the inner wall of the barrel during an injection procedure to prevent leaking of the substance contained therein, is also needed.

[0009] In view of the foregoing, a need exists for a syringe having a plunger with a dynamic seal which can be used with an injector, such as a powered injector. According to one aspect of the disclosure, the plunger with dynamic seal generates compression under injection pressure conditions. Initially, under relatively low pressure conditions, the compression between the plunger and the inner wall of the barrel is low. The compression increases under injection pressure conditions of the fluid delivery system and thus increases the seal between the plunger and the inner wall of the barrel of the syringe.

[0010] In one aspect, a syringe plunger with a dynamic seal is provided. The syringe plunger with a dynamic seal comprises a support ring and a cover disposed over and coupled to the support ring, wherein an air cavity defining a predetermined volume is defined between the support ring and the cover.

[0011] In another aspect, a syringe comprising a plunger with a dynamic seal is provided. The syringe comprises a barrel defining an inner wall, and a plunger located within the inner of the barrel. The plunger comprises a support ring and a cover disposed over and coupled to the support ring, wherein an air cavity defining a predetermined volume is defined between the support ring and the cover.

[0012] In addition to the foregoing, various other method and/or system and/or program product aspects are set forth and described in the teachings, such as text (e.g., claims and/or detailed description) and/or drawings, of the present disclosure.

[0013] The various aspects of the present disclosure are also described in the following

clauses.

[0014] Clause 1: A plunger, comprising: a support ring; and a cover disposed over and coupled to the support ring, wherein the support ring and the cover define an air cavity therebetween, the air cavity defining a predetermined volume.

[0015] Clause 2: The plunger of clause 1, further comprising a conical cap disposed over the cover.

[0016] Clause 3: The plunger of clause 2, wherein the conical cap comprises an overmold element disposed over thereon.

[0017] Clause 4: The plunger of any of clauses 1 to 3, wherein the cover further comprises first and second annular ribs.

[0018] Clause 5: The plunger of any of clauses 1 to 4, wherein the cover comprises: conical cap; a cylindrical sidewall having at least one annular rib; and a flange to engage the support ring.

[0019] Clause 6: The plunger of any of clauses 1 to 5, wherein the support ring comprises a conical cap that defines an included angle greater than about 90°.

[0020] Clause 7: The plunger of clause 6, wherein the conical cap of the support ring defines an included angle greater than about 90° and less than about 120°.

[0021] Clause 8: The plunger of clause 6 or 7, wherein the conical cap of the support ring and the conical cap of the cover define an angle therebetween.

[0022] Clause 9: The plunger of clause 8, wherein the angle defined between the conical cap of the support ring and the conical cap of the cover is greater than 0° and less than about 30°.

[0023] Clause 10: The plunger of any of clauses 1 to 9, wherein the support ring comprises: a shoulder; and defines an annular groove between the shoulder and the conical cap to receive a flange defined by the cover.

[0024] Clause 11: The plunger of any of clauses 1 to 10, wherein the predetermined volume is selected in a range between 0.1 mL and 10 mL.

[0025] Clause 12: A syringe, comprising: a barrel defining an inner wall; and a plunger located within the inner wall of the barrel, the plunger comprising: a support ring; and a cover disposed over and coupled to the support ring, wherein an air cavity defining a predetermined volume is defined between the support ring and the cover.

[0026] Clause 13: The syringe of clause 12, wherein the plunger comprises a conical cap disposed over the cover.

[0027] Clause 14: The syringe of clause 13, wherein the conical cap comprises an overmold element disposed thereon.

[0028] Clause 15: The syringe of any of clauses 12 to 14, wherein the cover further comprises first and second annular ribs that form a seal with the inner wall of the barrel.

[0029] Clause 16: The syringe of any of clauses 12 to 15, wherein the cover comprises: conical cap; a cylindrical sidewall having at least one annular rib; and a flange to engage the support ring.

[0030] Clause 17: The syringe of any of clauses 12 to 16, wherein the support ring comprises a conical cap that defines an included angle greater than about 90°.

[0031] Clause 18: The syringe of clause 17, wherein the conical cap of the support ring defines an included angle greater than about 90° and less than about 120°.

[0032] Clause 19: The syringe of clause 17 or 18, wherein the conical cap of the support ring and the conical cap of the cover define an angle therebetween.

[0033] Clause 20: The syringe of clause 19, wherein the angle defined between the conical cap of the support ring and the conical cap of the cover is greater than 0° and less than about 30°.

[0034] Clause 21: The syringe of any of clauses 12 to 20, wherein the support ring comprises: a shoulder; and defines an annular groove between the shoulder and the conical cap to receive a flange defined by the cover.

[0035] Clause 22: The syringe of any of clauses 12 to 21, wherein the predetermined volume is selected in a range between 0.1 mL and 10 mL.

[0036] Clause 23: A method of making a plunger, the method comprising: providing a support ring, the support ring comprising a first conical cap, a shoulder, and defines an annular groove between the shoulder and the conical cap; attaching a cover to the support ring, the cover comprising a second conical cap, a cylindrical sidewall, and a flange to engage the annular groove of the support ring; and attaching a third conical cap to the second conical cap of the cover.

[0037] Clause 24: A method of making a syringe, comprising: providing a syringe barrel; making a plunger in accordance with a method, the method comprising: providing a support ring, the support ring comprising a first conical cap, a shoulder, and defines an annular groove between the shoulder and the conical cap; attaching a cover to the support ring, the cover comprising a second conical cap, a cylindrical sidewall, and a flange to engage the annular groove of the support ring; and attaching a third conical cap to the second conical cap of the cover; and inserting the plunger in the syringe barrel.

[0038] The foregoing is a summary and thus may contain simplifications, generalizations, inclusions, and/or omissions of detail; consequently, those skilled in the art will appreciate that the summary is illustrative only and is NOT intended to be in any way limiting. Other aspects, features, and advantages of the devices and/or processes and/or other subject matter described herein will become apparent in the teachings set forth herein.

[0039] Further, it is understood that any one or more of the following-described forms, expressions of forms, examples, can be combined with any one or more of the other

following-described forms, expressions of forms, and examples.

[0040] The foregoing summary is illustrative only and is not intended to be in any way limiting. In addition to the illustrative aspects, aspects, and features described above, further aspects, aspects, and features will become apparent by reference to the drawings and the following detailed description.

FIGURES

[0041] The novel features of the described forms are set forth with particularity in the appended claims. The described forms, however, both as to organization and methods of operation, may be best understood by reference to the following description, taken in conjunction with the accompanying drawings in which:

[0042] **FIG. 1** is a side view of a syringe, according to one aspect of the present disclosure;

[0043] **FIG. 2** is a schematic cross-sectional view of a syringe interface having a piston and plunger, according to one aspect of the present disclosure;

[0044] **FIG. 3** is a sectional view of a syringe plunger system, according to one aspect of the present disclosure;

[0045] **FIG. 4** is a section view of one aspect of a syringe plunger system with a dynamic seal, according to one aspect of the present disclosure;

[0046] **FIG. 5A** is a section view of one aspect of the syringe plunger system with a dynamic seal shown in **FIG. 4** in an initial compression state, according to one aspect of the present disclosure;

[0047] **FIG. 5B** is a section view of one aspect of the syringe plunger system with a dynamic seal shown in **FIG. 5A** in a compressed state, according to one aspect of the present disclosure;

[0048] **FIGS. 6-11** illustrate several views of a support ring structure that includes an included angle, where:

[0049] **FIG. 6** is a perspective view of the support ring, according to one aspect of the present disclosure;

[0050] **FIG. 7** is a perspective view of the support ring, according to one aspect of the present disclosure;

[0051] **FIG. 8** is a plan view of the supporting ring, according to one aspect of the present disclosure;

[0052] **FIG. 9** is an elevational view of the support ring, according to one aspect of the present disclosure;

[0053] **FIG. 10** is a bottom view of the support ring, according to one aspect of the present disclosure;

[0054] **FIG. 11** is a sectional view of the support ring taken along section line **11--11**, as shown in **FIG. 10**, according to one aspect of the present disclosure;

[0055] **FIG. 12** is a sectional view of the syringe plunger system with dynamic seal in a shipping configuration, according to one aspect of the present disclosure;

[0056] **FIG. 13** is a sectional view of the syringe plunger system with dynamic seal shown in **FIG. 12** under an initial state of compression, according to one aspect of the present disclosure;

[0057] **FIG. 14** is a sectional view of the syringe plunger system with a dynamic seal shown in **FIG. 12** under operating injection pressure, according to one aspect of the present disclosure;

[0058] **FIG. 15** is a sectional view of the syringe plunger system **200** with a dynamic seal shown in **FIG. 12** under a state of compression near or beyond maximum injection pressure, according to one aspect of the present disclosure;

[0059] **FIG. 16** is a graphical representation of the maximum pressure that the syringe plunger system described in connection with **FIGS. 4-15** withstands after a sustained period of pressurization, according to one aspect of the present disclosure;

[0060] **FIG. 17** is a graphical representation of how the maximum pressure that the syringe plunger system described in connection with **FIGS. 4-15** withstands after a sustained period of pressurization, according to one aspect of the present disclosure;

[0061] **FIG. 18** is a graphical representation of the relationship of sealing pressure as a function of included angle of the plunger, according to one aspect of the present disclosure; and

[0062] **FIG. 19** is a graphical representation of an optimal gap size of an air cavity described for dynamic seal of a syringe plunger system, according to one aspect of the present disclosure.

DESCRIPTION

[0063] Before explaining various forms of syringe plungers with dynamic seals in detail, it should be noted that the illustrative forms are not limited in application or use to the details of construction and arrangement of parts illustrated in the accompanying drawings and description. The illustrative forms may be implemented or incorporated in other forms, variations and modifications, and may be practiced or carried out in various ways. Further, unless otherwise indicated, the terms and expressions employed herein have been chosen for the purpose of describing the illustrative forms for the convenience of the reader and are not for the purpose of limitation thereof.

[0064] Further, it is understood that any one or more of the following-described forms, expressions of forms, examples, can be combined with any one or more of the other following-described forms, expressions of forms, and examples.

[0065] Various forms are directed to syringe plungers with dynamic seals to provide enhanced sealing during injection procedures under injection pressure conditions. With

reference to **FIG. 1**, in one aspect, a syringe **10** includes a barrel **12**, a plunger **14**, and a plunger rod **17**. The plunger **14** is slideably inserted in the barrel **12**. The plunger **14** may be removable or non-removably or integrally connected to the plunger rod **17**. A proximal end **15** of the plunger rod **17** extends outward from a proximal end **13** of the barrel **12** and is configured to form an interface with an external piston (not shown) configured to be driven by a fluid injector, such as a powered or automatic injector. The interface between the plunger rod **17** of the syringe **10** and an external piston may include a connecting surface structure, such as a mating element **20**, extending from the proximal end **15** of the plunger rod **17**. The mating element **20** is configured to engage with the external piston. The external piston may include a piston rod (not shown). In alternate aspects, plunger **14** may directly interface with the external piston.

[0066] In use, the external piston is brought into contact with the mating element **20** of the syringe **10** and engages the mating element **20**. In one aspect, the syringe may be disposable. Various techniques may be employed to engage the external piston with the mating element **20**. Once engagement is established, the external piston can be retracted to fill the syringe **10** with fluid or driven in the proximal direction to eject fluid contained therein. Once the fluid is ejected, a slider (not shown) is moved in the proximal direction to disengage the external piston from the mating element **20**. Once disengaged, a user can dispose of the syringe **10**. Additional examples of syringes can be found in commonly assigned US Publication No. 2016/0151570, filed July 9, 2014, and titled VACUUM SYSTEM FOR SYRINGE INTERFACE, U.S. Patent Nos. 9,173,995; 9,199,033; and 9,700,670, and U.S. Application Serial No. 15/541,573, the disclosures of which are incorporated herein by reference.

[0067] Referring to **FIG. 2**, the syringe **10** includes a barrel **12** that may be cylindrical, and a plunger **14**, as well as a method of pushing and retracting the plunger **14** through the barrel **12** as described in connection with **FIG. 1**. The syringe **10** generally includes the barrel **12**, a plunger **14**, and a piston **18** for advancing and retracting the plunger **14** through the barrel **12**. The piston **18** may include a piston head **16** for engaging the plunger **14**. The piston **18** optionally may include a handle (not shown) allowing a user to manually advance the plunger **14**. Alternatively, the piston **18** is connected to a mechanical mechanism, such as a powered injector, powered linear actuator, or fluid injector, for automatically driving the piston head **16** and plunger **14** through the barrel **12**. The piston **18** can be made of a rigid plastic. Examples of piston to plunger engagement mechanisms may be found, for example, in U.S. Patent Nos. 9,480,797 and 7,666,169, the disclosures of which are incorporated herein by reference.

[0068] The barrel **12** is adapted to contain a fluid F, such as a medicament, biological solution, saline, or contrast agent, to be injected to a patient. The barrel **12** extends

longitudinally from a proximal end **21**, near the injector apparatus, to a distal end **22** and is configured to expel the fluid F from the distal end **22** of the barrel **12**. The distal end **22** may include an outflow port **24**, such as a nozzle, needle cannula, or catheter tubing. The barrel **12** may be formed from any suitable biocompatible and medical grade material including glass, metal, ceramic, plastic, rubber, or combinations thereof.

[0069] The plunger **14** is adapted to be slidably inserted in the barrel **12**, and includes a cylindrical body **26** formed of elastomeric material, a sidewall **28**, and a conical cap **30**. The plunger **14** has an external diameter ED that corresponds to an inner diameter ID of the barrel **12**, such that a fluid seal is formed between the sidewall **28** and an inner wall **29** of the barrel **12**. In certain aspects, the sidewall **28** includes one or more annular ribs **32** extending radially from the sidewall **28**. The annular ribs **32** are adapted to contact and compress against the inner wall **29** to form a fluid tight seal and are adapted to slide against the inner wall **29** of the barrel **12** as the plunger **14** is advanced or retracted while maintaining the fluid tight seal. The annular ribs **32** reduce the contact surface area against the inner wall **29** of the barrel **12**, which lessens the frictional forces between the barrel **12** and plunger **14** and allows the plunger **14** to slide through the barrel **12** more easily.

[0070] The plunger **14** may further include an annular shoulder **42** or ring positioned on a proximal end of the plunger **14**. The annular shoulder **42** contacts a corresponding portion of the piston **18** or piston head **16** for imparting additional pushing force against the plunger **14**.

[0071] The sidewall **28** is flexible and can deform outwards to increase the size of the opening and cavity defined by an inner portion of the plunger **14**, to accept the piston head **16** and/or support ring **116**. In certain aspects, a portion of the sidewall **28** may essentially be hollow and include an annular channel (not shown) to reduce the structural integrity of the sidewalls **28**, thereby further increasing the flexibility.

[0072] In use, the piston head **16** is inserted into the cavity defined by the plunger **14** establishing a removable engagement therebetween. The engagement is sufficient to maintain the connection between the plunger **14** and piston head **16** both as the plunger **14** is advanced through and retracted from the barrel **12**. As such, the engagement must be strong enough to counteract both the initial frictional breakaway force created by the contact between the sidewall **28** and/or annular ribs **32** of the plunger **14** and the inner surface of the barrel **12**, as well as the dynamic frictional forces created as the plunger **14** slides through the barrel **12** and at least partial vacuum that is created as plunger **14** is retracted to draw liquid F into the syringe.

[0073] **FIG. 3** is a sectional view of a syringe plunger system **100** according to one aspect. The syringe plunger system **100** includes an included angle θ_1 about 90° , for example from 85° to 95° . As used herein the term “about” when referencing an angle of the plunger system means plus or minus 5° . The syringe plunger system **100** includes a plunger **102** disposed

within a barrel **104** of the syringe. The barrel **104** defines an inner wall **106** configured to slideably receive the plunger **102**. The plunger **102** includes a support ring **116**, a cover **114** disposed and snap fit over the support ring **116**, and a conical cap **110** disposed over the cover **114**. When the plunger **102** is under injection pressure conditions, the plunger **102** is axially deflected and the cover **114** is radially deflected towards the inner wall **106** of the barrel **104** to provide greater seal under injection pressure conditions. In certain aspects, the conical cap **110** may include an overmold element **112**.

[0074] The cover **114** includes a cylindrical sidewall **108**, a conical cap **160**, and a flange **162** such as a projecting rim or edge for coupling the cover **114** to the support ring **116**. The cover **114** includes one or more annular ribs, such as a first annular rib **120** and a second annular rib **122**. The first annular rib **120** is received in a first annular slot **124** defined by the inner wall **106** of the barrel **104** and the second annular rib **122** is received in an annular slot **126** also defined by the inner wall **106** of the barrel **104**.

[0075] The support ring **116** includes an annular shoulder **154**, a conical cap **152**, and an annular groove **118** defined therebetween to receive the flange **162** of the cover **114**. The conical cap **152** of the support ring **116** defines an included angle θ_1 of about 90° and an annular groove **118** to receive the cover **114** portion of the conical cap **110**. The support ring **116** defines an inner volume **132** within the conical cap **160**. At least one aperture **134** is defined by the support ring **116** to provide an exit path for the air between the cover **114** and the support ring **116** during injection pressurization. The air is vented through the at least one aperture **134** back outside of the barrel **104** of the syringe and away from the path of the fluid.

[0076] An air cavity **128** is defined between the tip **150** of the conical cap **152** of the support ring **116** and the conical cap **160** of the cover **114**. The conical cap **160** of the cover **114** is in contact with and supported by the conical cap **152** of the support ring **116** at an interface **130**. There is no a gap or air cavity defined at the interface **130**.

[0077] **FIG. 4** is a sectional view of a syringe plunger system **200** with a dynamic seal according to another aspect. The syringe plunger system **200** is shown prior to injection pressurization. The syringe plunger system **200** includes an included angle θ_2 greater than about 90° . As will be described hereinbelow, an increase in the included angle θ_2 above about 90° increases the sealing pressure limits of the syringe plunger system **200**.

Alternatively, the syringe plunger system **200** includes an included angle θ_2 of about 90° on the conical cap **252** of the support ring **216** and an included angle of less than about 90° on the conical cap **260** of the cover **214**. The syringe plunger system **200** includes a plunger **202** disposed within a syringe barrel **204** of the syringe. The syringe barrel **204** defines an inner wall **206** configured to slideably receive the plunger **202**. The plunger **202** includes a support ring **216**, a cover **214** disposed over and coupled to the support ring **216**,

and a conical cap **210** disposed over the cover **214**. In one aspect, the cover **214** may be snap fit to the support ring **216**. When the plunger **202** is under injection pressure conditions, the plunger **202** is axially deflected and the cover **214** is radially deflected towards the inner wall **206** of the syringe barrel **204** to provide a greater seal under injection pressure conditions. The conical cap **210** may include an overmold element **212**.

[0078] The cover **214** includes a cylindrical sidewall **208**, a conical cap **260**, and a flange **262** such as a projecting rim or edge for coupling the cover **214** to the support ring **216**. The cover **214** includes a first annular rib **220** and a second annular rib **222**. The first annular rib **220** is received in a first annular slot **224** defined by the inner wall **206** of the syringe barrel **204** and the second annular rib **222** is received in a second annular slot **226** also defined by the inner wall **206** of the syringe barrel **204**.

[0079] The support ring **216** includes an annular shoulder **254**, a conical cap **252**, and an annular groove **218** defined therebetween to receive the flange **262** of the cover **214**. The conical cap **252** of the support ring **216** defines an included angle θ_2 greater than about 90° and an annular groove **218** to receive the cover **214** portion of the conical cap **210**. In the illustrated example, the included angle θ_2 is 96° , although the disclosure is not limited in this context, as the included angle θ_2 can be calculated to produce an optimal effect of the dynamic seal. The support ring **216** defines an inner volume **232** within the conical cap **252**. At least one aperture **234** is defined by the support ring **216** to provide an exit path for the air between the cover **214** and the support ring **216** during injection pressurization. The air is vented through the at least one aperture **234** back outside of the syringe barrel **204** of the syringe and away from the path of the fluid.

[0080] The conical cap **252** of the support ring **216** and the conical cap **260** of the cover define a gap or air cavity **230** therebetween. The air cavity **230** or “gap” is defined between the support ring **216** and the cover **214** along the conical portion of the plunger **202**. An angle θ_3 is defined between the support ring **216** and the cover **214** and defines the air cavity **230**. The angle θ_3 can vary from a value greater than 0° to less than about 30° , for example, and nominally is about 6° . The air cavity **230** defines a predetermined compliance volume such that when the syringe plunger system **200** undergoes injection pressurization, the overmold element **212** and the cover **214** deform and flex into the compliance volume defined by the air cavity **230**. The injection pressure applies an axial force to the overmold element **212** and the cover **214** causing them to deform and compress the air cavity **230**, which applies a radial force to the first and second annular ribs **220**, **222** to engage the respective first and second annular slots **224**, **226** and/or against the side wall **206** to create a dynamic seal under injection pressure conditions. The volume of the air cavity **230** increases as the included angle θ_2 is increased. The volume of the air cavity **230** can be optimized by suitable selection of the included angle θ_2 . Thus, the compliance volume can be

increased or decreased based on the included angle θ_2 . The included angle θ_2 can vary from a value greater than about 90° to less than about 120°, for example, and nominally is about 96°. The compliance volume can vary from about 0.1 mL to 10 mL, for example. With an included angle θ_2 of about 96°, as shown in **FIG. 4**, the compliance volume is about 1 mL. The size of the air cavity **230** or “gap” translates to sealing pressure of the dynamic seal. The optimal size of the air cavity **230** can be calculated to produce an optimal dynamic seal for a particular injector/syringe application. This optimal effect may be equivalent to a maximum added compression for sealing, for example.

[0081] While the term “air cavity” is used herein to describe the compressible volume between the conical cap **252** of the support ring **216** and the conical cap **260** of the cover, other compressible materials may also be included in the volume between the conical cap **252** of the support ring **216** and the conical cap **260** of the cover. For example, in certain aspects, the volume between conical cap **252** and conical cap **260** may be filled with a bladder containing a compressible fluid, for example a compressible gas or other fluid. In another aspect, the volume between conical cap **252** and conical cap **260** may be filled with a compressible material, such as an elastic material with a low modulus that can deform under the pressure loads associated with an injection procedure. Non-limiting examples may include a compressible or deformable material, such as thermoplastic elastomer or a foam material, which compresses to allow for a dynamic seal under pressure loads typical of an injection procedure. In certain aspects, predictable compression and thereby, predictable control of the dynamic seal between the plunger side wall and the interior wall of the syringe may be achieved by selecting a material having a certain strain or compression factor under a desired pressure load. In certain aspects, the compression of the material would reverse in the absence of the pressure load of the injection procedure.

[0082] In one aspect the body of the syringe barrel **204** can be made of polyethylene terephthalate commonly abbreviated PET such as Eastman MN052 PET, for example. The support ring **216** can be made of a polycarbonates (PC) thermoplastic polymer or any suitable medical grade polymer that is strong, tough, and may be optically transparent and can be easily worked, molded, and thermoformed, such as Lexan 141, for example. The cover **214** may be made of a thermoplastic elastomer (TPE), sometimes referred to as thermoplastic rubbers, or other mix of polymers such as plastic and a rubber with both thermoplastic and elastomeric properties, such as Santoprene 181-5, for example. The cover **214** may be optically transparent or translucent. Thermoplastics may be desirable due to their relatively easy of use in manufacturing and ability of being injected molded. The overmold element **212** may be made of polypropylene (PP), also known as polypropylene thermoplastic polymer, such as polypropylene P5M4K-046, for example, and may be optically transparent or translucent. The syringe barrel **204**, the support ring **216**, the cover

214, and the overmold element **212** are made of medical grade plastics and materials.

[0083] **FIG. 5A** is a section view of one aspect of the syringe plunger system **200** with a dynamic seal shown in **FIG. 4** in an initial compression state. In the example illustrated in **FIG. 5A**, the included angle θ_2 is about 96° . Nevertheless, as described in connection with **FIG. 4**, the included angle θ_2 may be varied to optimize the dynamic seal. The compliance volume defined by the air cavity **230** is an initial compression state upon the initial application of injection pressure **240**, represented by the vertical arrows, and causes axial deflection of the plunger **202** in the direction indicated by the vertical arrows. The injection pressure **240** applied to the overmold element **212** causes the cover **214** to deform or change shape. The change in shape of the cover **214** applies a radial force **242**, represented by the horizontal arrows, and causes radial deflection of the plunger **202** in the direction indicated by the horizontal arrows, against the inner wall **206** of the syringe barrel **204** to provide greater seal pressure. The radial force **242** pushes the first and second annular ribs **220**, **222** into the respective first and second annular slots **224**, **226** to create a dynamic seal against the inner wall **206** of the syringe barrel **204**. Accordingly, the seal force between the plunger **202** and the inner wall **206** of the syringe barrel **204** is a dynamic function of the injection pressure **240**. Accordingly, syringe barrel **204** swell due to creep is managed since the higher seal force is present only for short durations of time during injections. This function can be employed to define a pressure withstand requirement for the syringe plunger system **200** of injection pressure (PSI) versus time (mS). In one aspect, the syringe plunger system **200** can withstand injection pressures greater than or equal to 355 psi for 30 seconds and can withstand injection pressures greater than or equal to 405 psi for 1 second, as shown in **FIG. 16**, for example. Elasticity of the plunger **202** enhances the importance of the dynamic seal. Pressure ranges include 0 to 2000 PSI depending on material and type of injection (e.g., CT or CV). For CT injection, maximum injection pressure is about 500 PSI and nominal operating pressure is about 150-350 PSI. For CV injection, maximum injection pressure is about 1500 PSI and nominal operating pressure is about 300-800 PSI.

[0084] **FIG. 5B** is a section view of one aspect of the syringe plunger system **200** with a dynamic seal shown in **FIG. 5A** in a compressed state. As shown, the injection pressure **240** applied to the overmold element **212** causes the cover **214** to deform or change shape. The change in shape of the cover **214** applies a radial force **242**, represented by the horizontal arrows, and causes radial deflection of the plunger **202** in the direction indicated by the horizontal arrows, against the inner wall **206** of the syringe barrel **204** to provide greater seal pressure. The radial force **242** pushes the first and second annular ribs **220**, **222** into the respective first and second annular slots **224**, **226** and/or against the side wall **206** to create a dynamic seal against the inner wall **206** of the syringe barrel **204**.

[0085] **FIGS. 6-11** illustrate several views of one aspect of a support ring **216** structure that

includes a conical cap **252** that defines an included angle θ_2 . Further details of support rings such as **216** may be found in U.S. Patent Nos. 7,666,169; and 9,480,797, incorporated by reference herein. **FIGS. 6 and 7** are perspective views of the support ring **216**. **FIG. 8** is a plan view of the support ring **216**. **FIG. 9** is an elevational view of the support ring **216**. **FIG. 10** is a bottom view of the support ring **216** and **FIG. 11** is a sectional view of the support ring **216** taken along section line **11--11** as shown in **FIG. 10**. With reference to **FIGS. 6-10**, the support ring **216** includes a tip **250**, a conical cap **252**, and an annular shoulder **254**. The conical cap **252** defines an included angle θ_2 that is greater than about 90° and less than about 120° . In the illustrated example, the included angle θ_2 is about 96° , although the included angle θ_2 may be optimized to achieve a predetermined dynamic seal force between the plunger **202** and the barrel (**FIGS. 4 and 5A,B**). The conical cap **252** may define a one or more or even a plurality of apertures **234** to vent air back outside the syringe barrel **204** and away from the fluid path. An annular groove **218** is defined between the conical cap **252** and the annular shoulder **254**. The annular groove **218** is configured to snap fit receive the cover **214** (**FIGS. 4 and 5A,B**). The conical cap **252** of the support ring **216** defines an inner volume **232**. While one embodiment of the support ring **216** is illustrated in **FIGS. 6-11**, other embodiments and configurations of support ring **216** are considered, for example support rings with different piston engagement mechanisms (such as described in U.S. Patent No. 7,666,169) and/or with configurations having no apertures **234** in the conical cap **252** or, alternatively having one aperture **234**. In aspects having no apertures **234** in the conical cap **252**, compression during an injection procedure may compress the air in the air cavity **230** or, alternatively force the air in the air cavity **230** out between the plunger cover **214** and the support ring **216**.

[0086] FIG. 12 is a sectional view of the syringe plunger system **200** with a dynamic seal in a shipping configuration. In the shipping configuration, the plunger **202** is under a pressure that is significantly lower than a nominal injection pressure. The syringe plunger system **200** includes a syringe barrel **204** defining an inner wall **206** and a plunger **202** disposed within the syringe barrel **204**. The plunger **202** includes a support ring **216** that defines an included angle θ_2 that is greater than about 90° , and in one example is approximately about 96° . As previously described, the included angle θ_2 may have a value between about 90° and about 120° , for example. The support ring **216** includes engagement features for reversible engagement with a piston of a medical injector, which reciprocates the plunger **202** within the syringe barrel **204**. The support ring **216** defines at least one aperture **234** to vent air back outside of the syringe barrel **204** and away from the fluid path. The plunger **202** further includes a cover **214** that is configured to snap fit over the support ring **216** into the annular groove **218** defined by the support ring **216**. The cover **214** also includes first and second annular ribs **220**, **222** configured to be received within respective first and second annular

slots **224**, **226** defined in the inner wall **206** of the syringe barrel **204** to form a dynamic seal under injection pressure conditions. An overmold element **212** may be disposed over the cover **214**.

[0087] As shown in **FIG. 12**, an angle θ_3 is defined between the support ring **216** and the cover **214** to define an air cavity **230** therebetween. The air cavity **230** defines a predetermined compliance volume such that when the syringe plunger system **200** is under injection pressure, the cover **214** and the overmold element **212** are subjected to axial forces and flexibly distort to compress the compliance volume defined by the air cavity **230**. Under injection pressure conditions, the distortion applies a radial force to push the first and second annular ribs **220**, **222** into the respective first and second annular slots **224**, **226** and/or against the side wall **206** of the syringe barrel to form primary and secondary dynamic seals, respectively. As previously discussed, the air cavity **230** may be configured to define a predetermined volume ranging from 0.1 mL to 10 mL. A gap **258** is defined between the support ring **216** and the inner wall **206** of the syringe barrel **204** when the plunger **202** is in a shipping configuration and not under injection pressure. Configurations of the syringe plunger system **200** shown in **FIG. 12** under various states of compression are described hereinbelow in connection with **FIGS. 13-15**.

[0088] **FIG. 13** is a sectional view of the syringe plunger system **200** with a dynamic seal shown in **FIG. 12** under an initial state of compression. A typical initial pressure range can vary from just above 0 to 100 PSI, for example. Under an initial state of compression, the angle θ'_3 defined between the support ring **216** and the cover **214** is smaller than the angle θ_3 shown in **FIG. 12** due to the applied pressure of the fluid against the plunger cover **214**. As shown in **FIG. 13**, the gap **258'** defined between the support ring **216** and the inner wall **206** of the syringe barrel **204** is smaller than the gap **258** shown in **FIG. 12** due to lateral forces exerted against the first and second annular slots **224**, **226** by the first and second annular ribs **220**, **222**. The included angle θ_2 remains substantially the same as the included angle θ_2 shown in **FIG. 12**.

[0089] **FIG. 14** is a partial sectional view of the syringe plunger system **200** with a dynamic seal shown in **FIG. 12** under operating injection pressure. Operating injection pressures can vary from 150 to 800 PSI, depending on material and type of injection (e.g., CT or CV). Under operating pressure, the angle θ''_3 defined between the support ring **216** and the cover **214** is smaller than the angle θ'_3 defined between the support ring **216** and the cover **214** when the plunger **202** is in the initial state of compression. Accordingly, the gap **258''** defined between the support ring **216** and the inner wall **206** of the syringe barrel **204** when the plunger **202** is under operating injection pressure is smaller than the gap **258'** shown in **FIG. 13** because of the additional radial forces exerted against the first and second annular slots **224**, **226** by the first and second annular ribs **220**, **222**. Under operating injection pressures,

the first and second annular ribs **220**, **222** press against the side wall **206** to create a dynamic seal. As shown, the included angle θ_2 remains substantially the same as the included angle θ_2 shown in **FIGS. 12** and **13**.

[0090] FIG. 15 is a partial sectional view of the syringe plunger system **200** with a dynamic seal shown in **FIG. 12** under a state of compression near or beyond maximum injection pressure. Maximum injection pressure may vary from 500 to 1500 PSI, depending material and type of injection (e.g., CT or CV) and in some instances can be as high as 2000 PSI. Under high pressure conditions, the dynamic seal formed by the first and second annular ribs **220**, **222** pressing against the side wall **206** may begin to leak. The threshold pressure at which this occurs is known as blow-by pressure. As shown in **FIG. 15**, under a maximum injection pressure conditions, the angle θ'''_3 defined between the support ring **216** and the cover **214** is relatively small or near zero. As shown, the gap **258'''** between the support ring **216** and the cover **214** has been reduced to near zero and substantially the entire air cavity **230** has been eliminated under the maximum injection pressure. As shown in **FIG. 15**, under maximum injection pressure conditions, the included angle θ_2 remains substantially the same as the included angle θ_2 shown in **FIGS. 12-14**.

[0091] FIG. 16 is a graphical representation **300** of the maximum pressure that the syringe plunger system **200** described in connection with **FIGS. 4-15** can withstand after a sustained period of pressurization in accordance with one aspect. Pressure (PSI) is shown along the vertical axis and Time (mS) is shown along the horizontal axis. The tip **250** of the support ring **216** (**FIGS. 6-11**) was nominally about 0.005". The curve **302** represents the application of pressure to the syringe plunger system **200**. During a first period T1, the pressure applied to the syringe plunger system **200** is ramped up (increased) from 0 PSI to about 355 PSI, which is approximately the operating pressure for one type of syringe plunger system **200**. During a second period T2, the pressure of 355 PSI is held on the syringe plunger system **200**. After a sustained period T2, during a third period T3, the pressure is ramped up (increased) until a failure, e.g., leaks, occurs. As shown by the curve **302**, failure occurs at about 420 PSI during the third period T3.

[0092] FIG. 17 is a graphical representation **350** of the maximum pressure that the syringe plunger system **200** described in connection with **FIGS. 4-15** can withstand after a sustained period of pressurization in accordance with another aspect. Pressure (PSI) is shown along the vertical axis and Time (mS) is shown along the horizontal axis. The tip **250** of the support ring **216** (**FIGS. 6-11**) was nominally about 0.005". The curve **352** represents the application of pressure to the syringe plunger system **200**. During a first period T1, the pressure applied to the syringe plunger system **200** is ramped up (increased) from 0 PSI to a about 365 PSI, which is approximately the operating pressure for one type of syringe plunger system **200**. During a second period T2, the pressure of 365 PSI is held on the syringe plunger system

200. After a sustained period T2, during a third period T3, the pressure is ramped up (increased) until a failure, e.g., leaks, occurs. As shown by the curve **352**, failure occurs at about 400 PSI during the third period T3.

[0093] FIG. 18 is a graphical representation **400** of the relationship of sealing pressure as a function of included angle of the plunger system **200** described in connection with **FIGS. 4-15** according to one aspect. Pressure (PSI) is shown along the vertical axis and Plunger Included Angle θ_2 (Degrees) is shown along the horizontal axis. In this context, the plunger included angle is the included angle θ_2 defined by the support ring **216** as described in connection with **FIGS. 4-5B, 9, 11, and 12-15**, for example. The bar graph **402** illustrates the maximum pressure that the syringe plunger system **200** can withstand as a function of the included angle θ_2 of the support ring **216**. As shown, at an included angle θ_2 of 90° the maximum pressure is about 505 PSI. At an included angle θ_2 of 92° the maximum pressure is about 520 PSI. At an included angle θ_2 of 94° the maximum pressure is about 575 PSI. At an included angle θ_2 of 96° the maximum pressure is about 590 PSI. At an included angle θ_2 of 98° the maximum pressure is about 580 PSI. And at an included angle θ_2 of 100° the maximum pressure is about 575 PSI. Accordingly, for the example depicted in **FIGS. 4-15**, the data shows that an included angle θ_2 in the range of 90° - 100° , the optimal included angle θ_2 is about 96° since this angle produces a dynamic seal that can withstand the maximum seal pressure required for certain applications. It will be appreciated, however, that the included angle θ_2 can be optimized to provide dynamic seals that can withstand a variety of maximum injection pressures. Accordingly, the specific values of the included angle θ_2 and corresponding maximum withstand pressure disclosed herein should not be considered as limiting the scope of the present disclosure.

[0094] Accordingly, the volume of the air cavity **230** (see **FIGS. 4, 5A, and 12-15**), which is defined by the included angle θ_2 of the support ring **216** translates to sealing pressure of the dynamic seal. Another way to measure the effect of the dynamic seal is to increase the volume of air cavity **230** and measure the sealing pressure limit of the syringe plunger system **200**. The graphical representation **400** shown in **FIG. 18** shows how increasing the included angle θ_2 of the support ring **216** increases (increasing the volume of the air cavity **230**) the dynamic pressure seal limits of the syringe plunger system **200**. The plunger **202** sealing capability eventually surpasses the material strength of the syringe barrel **204** at 96° , leading to a plateau in sealing pressure limit.

[0095] FIG. 19 is a graphical representation **500** of an optimal gap size of the air cavity **230** described in connection with **FIGS. 4, 5A, and 12-15** for dynamic seal of the syringe plunger system **200** described in connection with **FIGS. 4-15** according to one aspect of the present disclosure. Radial deflection (inches) is shown along the vertical axis and axial deflection (inches) is shown along the horizontal axis. The data points of the curve **502** can be used to

develop an n^{th} order polynomial equation that represents the conical dynamic seal for the syringe plunger system **200** according to one aspect of the present disclosure. The optimal gap size of the air cavity **230** can be calculated to produce the optimal effect of the dynamic seal. This optimal effect is equivalent to maximum added compression for sealing. One non-limiting example of this calculation is shown below. As the gap size of the air cavity **230** is increased, a peak compression is reached before the component collapses in on itself and the compression is actually reduced. Equation (1) below is one example of a 2nd order equation derived from the data points of the curve **502** for a seal radius of 0.9944 inches.

$$y = 1.3722x^2 + 0.2746x - 0.001 \quad (1)$$

[0096] While various details have been set forth in the foregoing description, it will be appreciated that the various aspects of the syringe plunger with dynamic seal may be practiced without these specific details. For example, for conciseness and clarity selected aspects have been shown in schematic form rather than in detail.

[0097] It is worthy to note that any reference to “one aspect,” “an aspect,” “one form,” or “a form” means that a particular feature, structure, or characteristic described in connection with the aspect is included in at least one aspect. Thus, appearances of the phrases “in one aspect,” “in an aspect,” “in one form,” or “in a form” in various places throughout the specification are not necessarily all referring to the same aspect. Furthermore, the particular features, structures or characteristics may be combined in any suitable manner in one or more aspects.

[0098] Although various forms have been described herein, many modifications, variations, substitutions, changes, and equivalents to those forms may be implemented and will occur to those skilled in the art. Also, where materials are disclosed for certain components, other materials may be used. It is therefore to be understood that the foregoing description and the appended claims are intended to cover all such modifications and variations as falling within the scope of the disclosed forms. The following claims are intended to cover all such modification and variations.

[0099] All of the above-mentioned U.S. patents, U.S. patent application publications, U.S. patent applications, foreign patents, foreign patent applications, non-patent publications referred to in this specification and/or listed in any Application Data Sheet, or any other disclosure material are incorporated herein by reference, to the extent not inconsistent herewith. As such, and to the extent necessary, the disclosure as explicitly set forth herein supersedes any conflicting material incorporated herein by reference. Any material, or portion thereof, that is said to be incorporated by reference herein, but which conflicts with existing definitions, statements, or other disclosure material set forth herein will only be incorporated to the extent that no conflict arises between that incorporated material and the existing disclosure material.

[0100] One skilled in the art will recognize that the herein described components (e.g., operations), devices, objects, and the discussion accompanying them are used as examples for the sake of conceptual clarity and that various configuration modifications are contemplated. Consequently, as used herein, the specific exemplars set forth and the accompanying discussion are intended to be representative of their more general classes. In general, use of any specific exemplar is intended to be representative of its class, and the non-inclusion of specific components (e.g., operations), devices, and objects should not be taken limiting.

[0101] With respect to the use of substantially any plural and/or singular terms herein, those having skill in the art can translate from the plural to the singular and/or from the singular to the plural as is appropriate to the context and/or application. The various singular/plural permutations are not expressly set forth herein for sake of clarity.

[0102] While particular aspects of the present subject matter described herein have been shown and described, it will be apparent to those skilled in the art that, based upon the teachings herein, changes and modifications may be made without departing from the subject matter described herein and its broader aspects and, therefore, the appended claims are to encompass within their scope all such changes and modifications as are within the true spirit and scope of the subject matter described herein. It will be understood by those within the art that, in general, terms used herein, and especially in the appended claims (e.g., bodies of the appended claims) are generally intended as “open” terms (e.g., the term “including” should be interpreted as “including but not limited to,” the term “having” should be interpreted as “having at least,” the term “includes” should be interpreted as “includes but is not limited to,” etc.). It will be further understood by those within the art that if a specific number of an introduced claim recitation is intended, such an intent will be explicitly recited in the claim, and in the absence of such recitation no such intent is present. For example, as an aid to understanding, the following appended claims may contain usage of the introductory phrases “at least one” and “one or more” to introduce claim recitations. However, the use of such phrases should not be construed to imply that the introduction of a claim recitation by the indefinite articles “a” or “an” limits any particular claim containing such introduced claim recitation to claims containing only one such recitation, even when the same claim includes the introductory phrases “one or more” or “at least one” and indefinite articles such as “a” or “an” (e.g., “a” and/or “an” should typically be interpreted to mean “at least one” or “one or more”); the same holds true for the use of definite articles used to introduce claim recitations.

[0103] In addition, even if a specific number of an introduced claim recitation is explicitly recited, those skilled in the art will recognize that such recitation should typically be interpreted to mean at least the recited number (e.g., the bare recitation of “two recitations,”

without other modifiers, typically means at least two recitations, or two or more recitations). Furthermore, in those instances where a convention analogous to “at least one of A, B, and C, etc.” is used, in general such a construction is intended in the sense one having skill in the art would understand the convention (e.g., “a system having at least one of A, B, and C” would include but not be limited to systems that have A alone, B alone, C alone, A and B together, A and C together, B and C together, and/or A, B, and C together, etc.). In those instances where a convention analogous to “at least one of A, B, or C, etc.” is used, in general such a construction is intended in the sense one having skill in the art would understand the convention (e.g., “a system having at least one of A, B, or C” would include but not be limited to systems that have A alone, B alone, C alone, A and B together, A and C together, B and C together, and/or A, B, and C together, etc.). It will be further understood by those within the art that typically a disjunctive word and/or phrase presenting two or more alternative terms, whether in the description, claims, or drawings, should be understood to contemplate the possibilities of including one of the terms, either of the terms, or both terms unless context dictates otherwise. For example, the phrase “A or B” will be typically understood to include the possibilities of “A” or “B” or “A and B.”

[0104] Although various forms have been described herein, many modifications, variations, substitutions, changes, and equivalents to those forms may be implemented and will occur to those skilled in the art. Also, where materials are disclosed for certain components, other materials may be used. It is therefore to be understood that the foregoing description and the appended claims are intended to cover all such modifications and variations as falling within the scope of the disclosed forms. The following claims are intended to cover all such modification and variations.

[0105] In summary, numerous benefits have been described which result from employing the concepts described herein. The foregoing description of the one or more forms has been presented for purposes of illustration and description. It is not intended to be exhaustive or limiting to the precise form disclosed. Modifications or variations are possible in light of the above teachings. The one or more forms were chosen and described in order to illustrate principles and practical application to thereby enable one of ordinary skill in the art to utilize the various forms and with various modifications as are suited to the particular use contemplated. It is intended that the claims submitted herewith define the overall scope.

CLAIMS

1. A plunger, comprising:
a support ring; and
a cover disposed over and coupled to the support ring, wherein the support ring and the cover define an air cavity therebetween, the air cavity defining a predetermined volume.
2. The plunger of claim 1, further comprising a conical cap disposed over the cover.
3. The plunger of claim 2, wherein the conical cap comprises an overmold element disposed over thereon.
4. The plunger of any of claims 1 to 3, wherein the cover further comprises first and second annular ribs.
5. The plunger of any of claims 1 to 4, wherein the cover comprises:
conical cap;
a cylindrical sidewall having at least one annular rib; and
a flange to engage the support ring.
6. The plunger of any of claims 1 to 5, wherein the support ring comprises a conical cap that defines an included angle greater than about 90°.
7. The plunger of claim 6, wherein the conical cap of the support ring defines an included angle greater than about 90° and less than about 120°.
8. The plunger of claim 6 or 7, wherein the conical cap of the support ring and the conical cap of the cover define an angle therebetween.
9. The plunger of claim 8, wherein the angle defined between the conical cap of the support ring and the conical cap of the cover is greater than 0° and less than about 30°.
10. The plunger of any of claims 1 to 9, wherein the support ring comprises:
a shoulder; and
defines an annular groove between the shoulder and the conical cap to receive a flange defined by the cover.

11. The plunger of any of claims 1 to 10, wherein the predetermined volume is selected in a range between 0.1 mL and 10 mL.
12. A syringe, comprising:
 - a barrel defining an inner wall; and
 - a plunger located within the inner wall of the barrel, the plunger comprising:
 - a support ring; and
 - a cover disposed over and coupled to the support ring, wherein an air cavity defining a predetermined volume is defined between the support ring and the cover.
13. The syringe of claim 12, wherein the plunger comprises a conical cap disposed over the cover.
14. The syringe of claim 13, wherein the conical cap comprises an overmold element disposed thereon.
15. The syringe of any of claims 12 to 14, wherein the cover further comprises first and second annular ribs that form a seal with the inner wall of the barrel.
16. The syringe of any of claims 12 to 15, wherein the cover comprises:
 - conical cap;
 - a cylindrical sidewall having at least one annular rib; and
 - a flange to engage the support ring.
17. The syringe of any of claims 12 to 16, wherein the support ring comprises a conical cap that defines an included angle greater than about 90°.
18. The syringe of claim 17, wherein the conical cap of the support ring defines an included angle greater than about 90° and less than about 120°.
19. The syringe of claim 17 or 18, wherein the conical cap of the support ring and the conical cap of the cover define an angle therebetween.
20. The syringe of claim 19, wherein the angle defined between the conical cap of the support ring and the conical cap of the cover is greater than 0° and less than about 30°.
21. The syringe of any of claims 12 to 20, wherein the support ring comprises:

- a shoulder; and
defines an annular groove between the shoulder and the conical cap to receive a flange defined by the cover.
22. The syringe of any of claims 12 to 21, wherein the predetermined volume is selected in a range between 0.1 mL and 10 mL.
23. A method of making a plunger, the method comprising:
providing a support ring, the support ring comprising a first conical cap, a shoulder, and defines an annular groove between the shoulder and the conical cap;
attaching a cover to the support ring, the cover comprising a second conical cap, a cylindrical sidewall, and a flange to engage the annular groove of the support ring; and
attaching a third conical cap to the second conical cap of the cover.
24. A method of making a syringe, comprising:
providing a syringe barrel;
making a plunger in accordance with a method, the method comprising:
providing a support ring, the support ring comprising a first conical cap, a shoulder, and defines an annular groove between the shoulder and the conical cap;
attaching a cover to the support ring, the cover comprising a second conical cap, a cylindrical sidewall, and a flange to engage the annular groove of the support ring;
and
attaching a third conical cap to the second conical cap of the cover; and
inserting the plunger in the syringe barrel.

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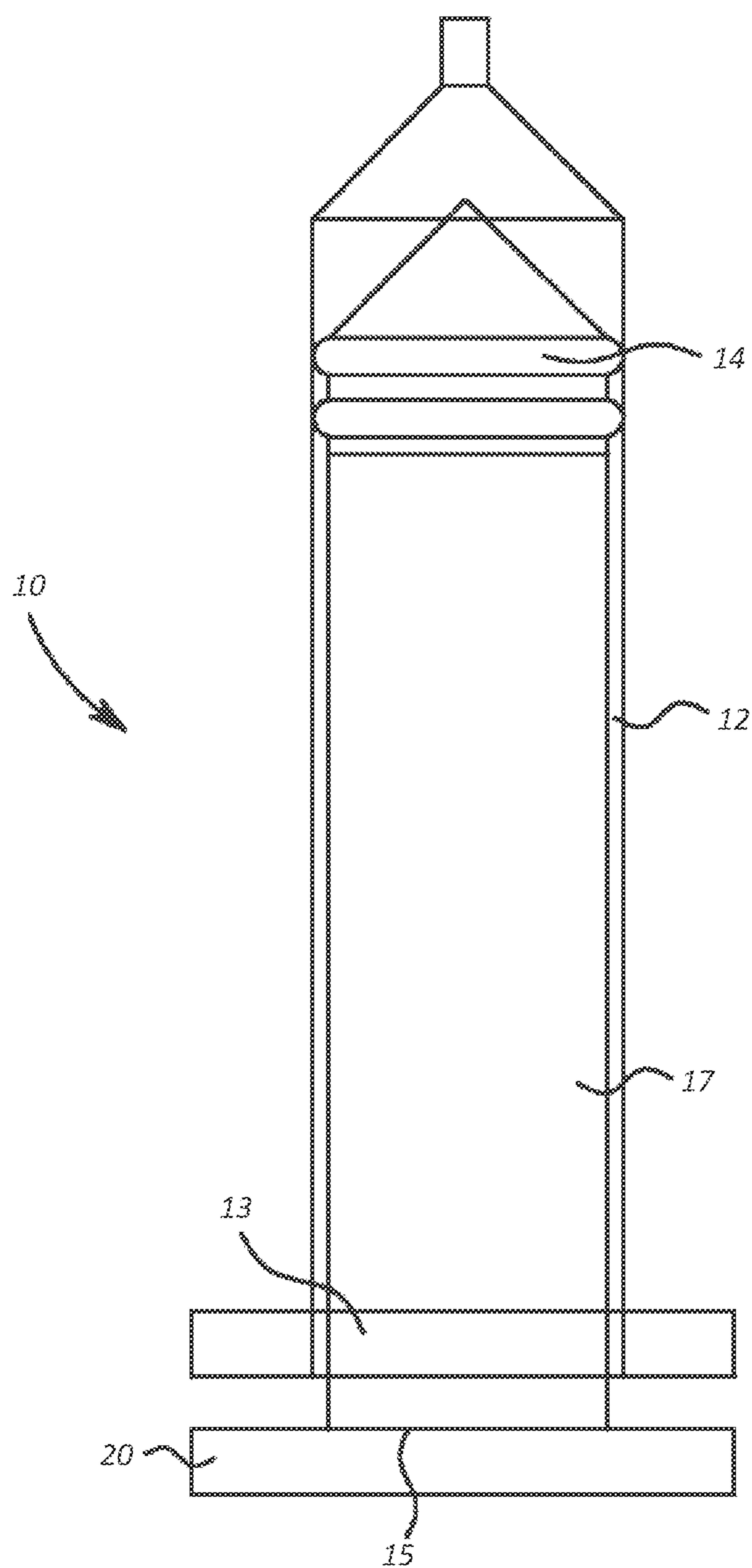


FIG. 1

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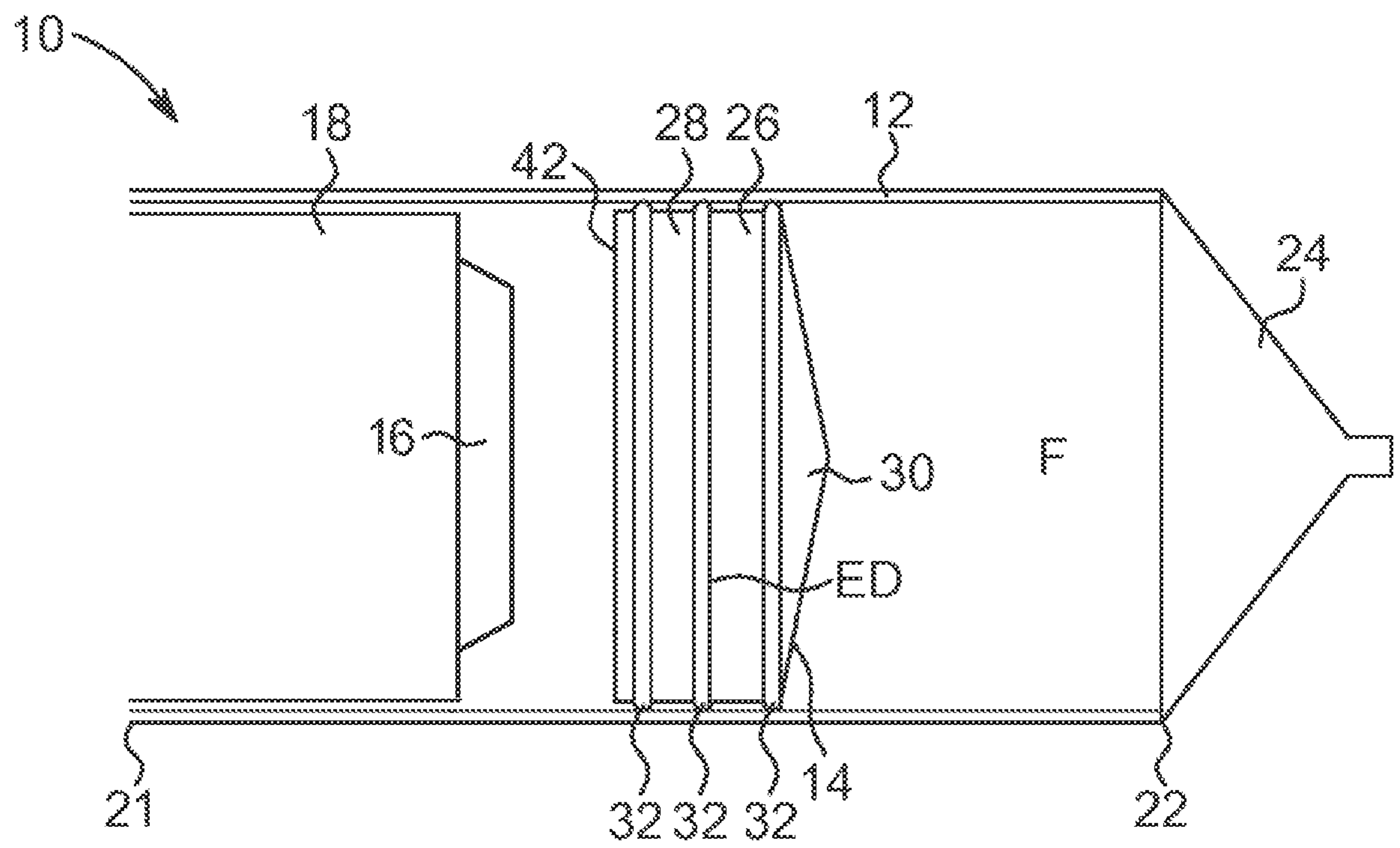


FIG. 2

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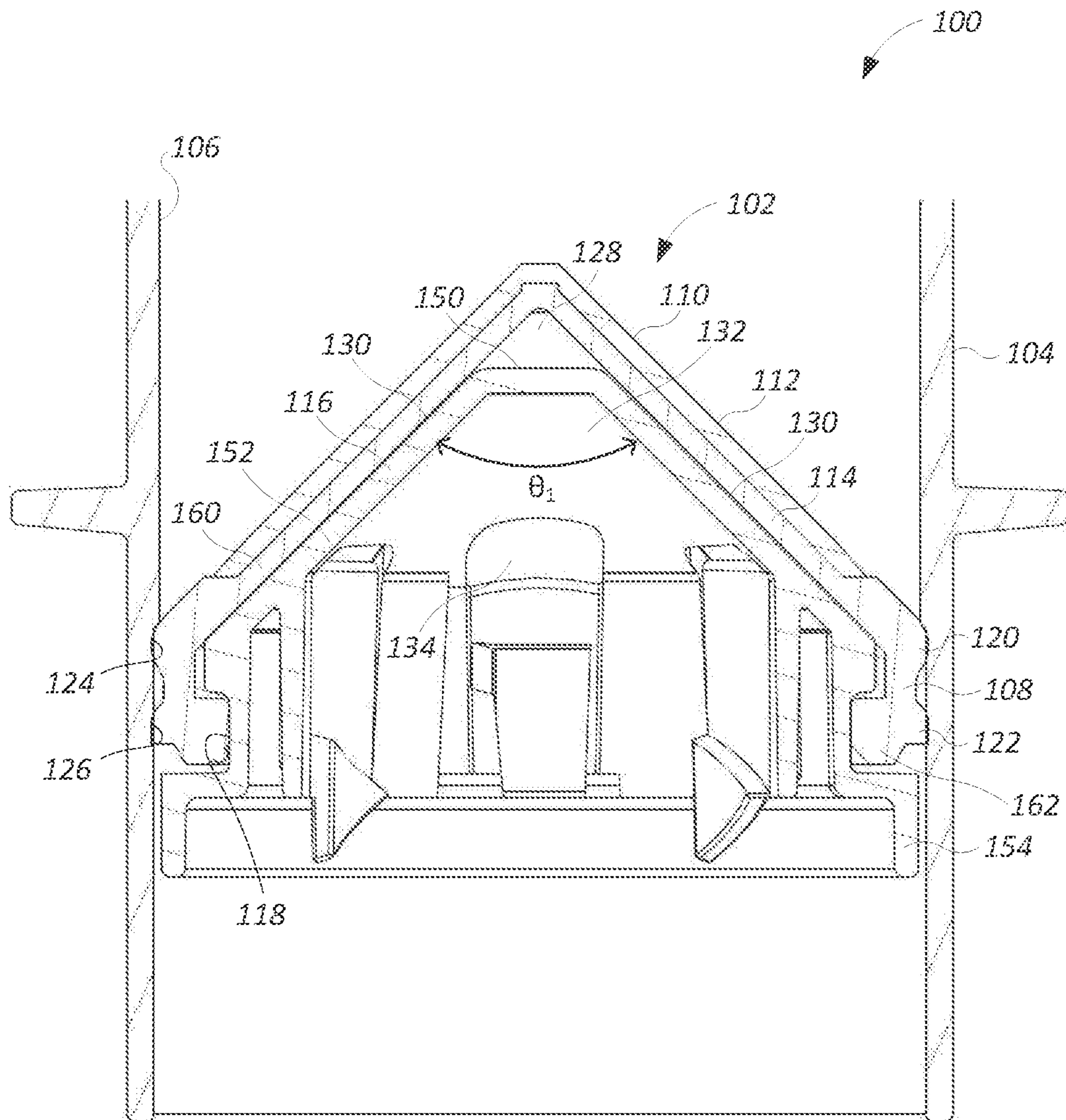


FIG. 3

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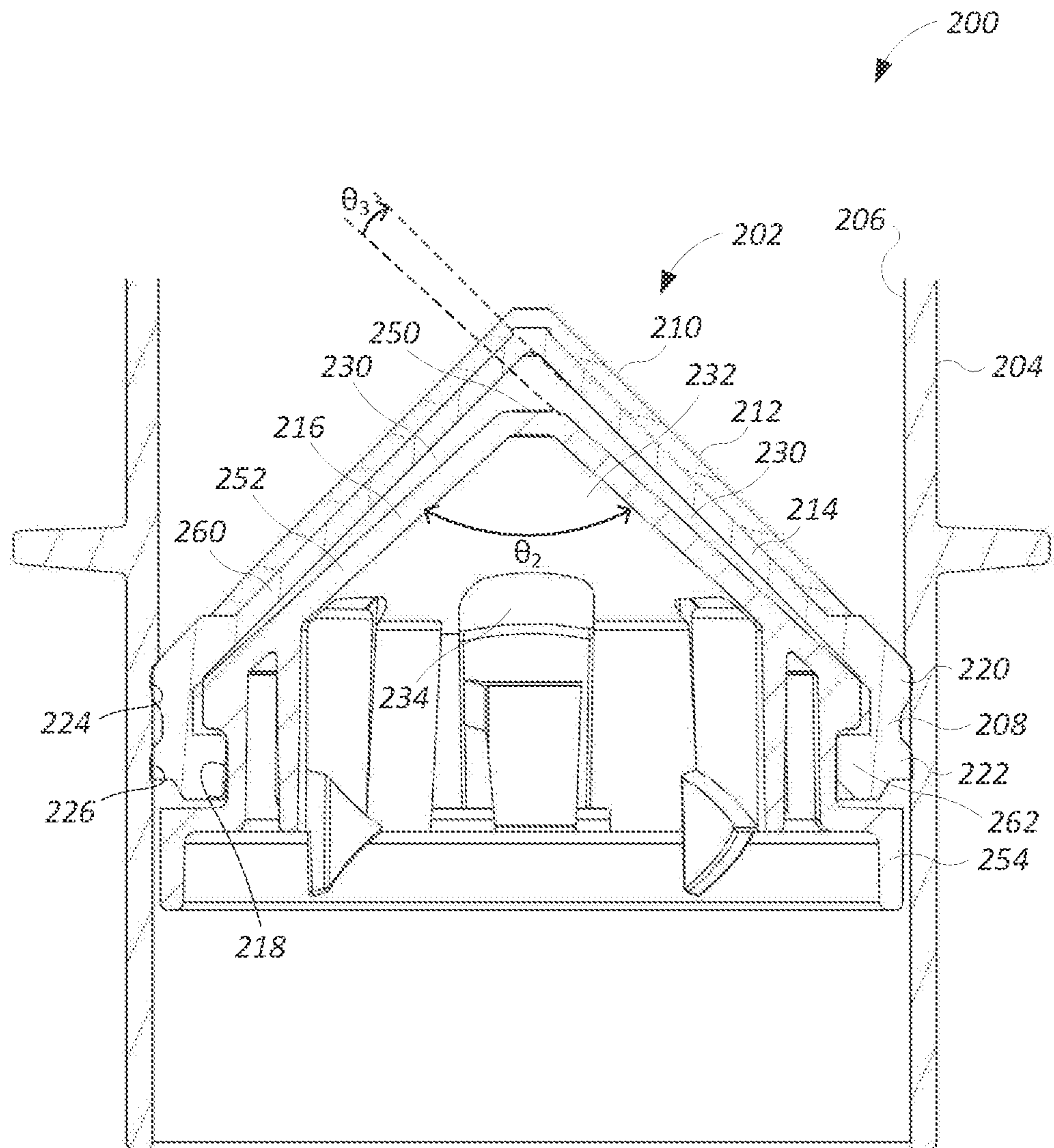


FIG. 4

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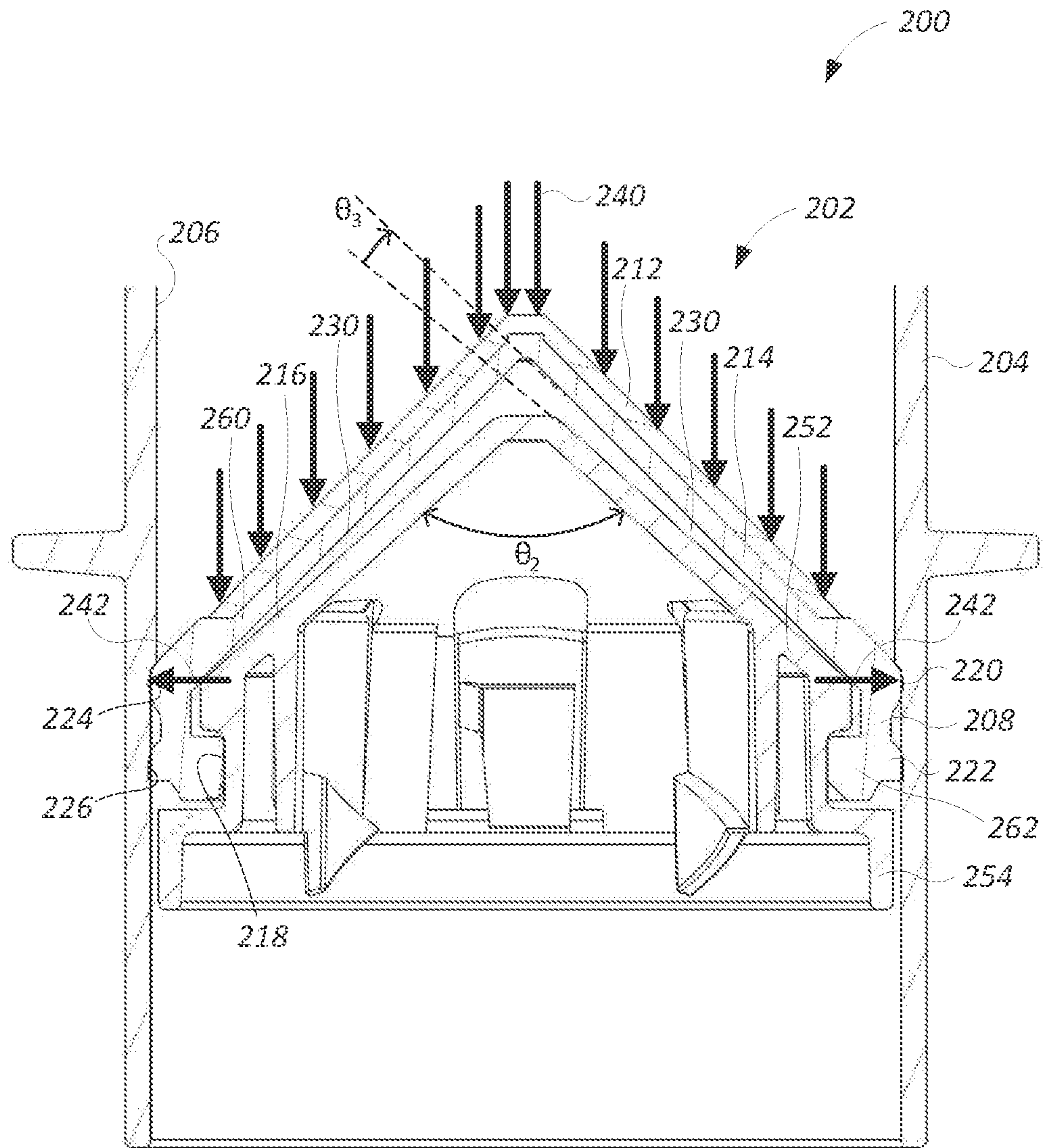


FIG. 5A

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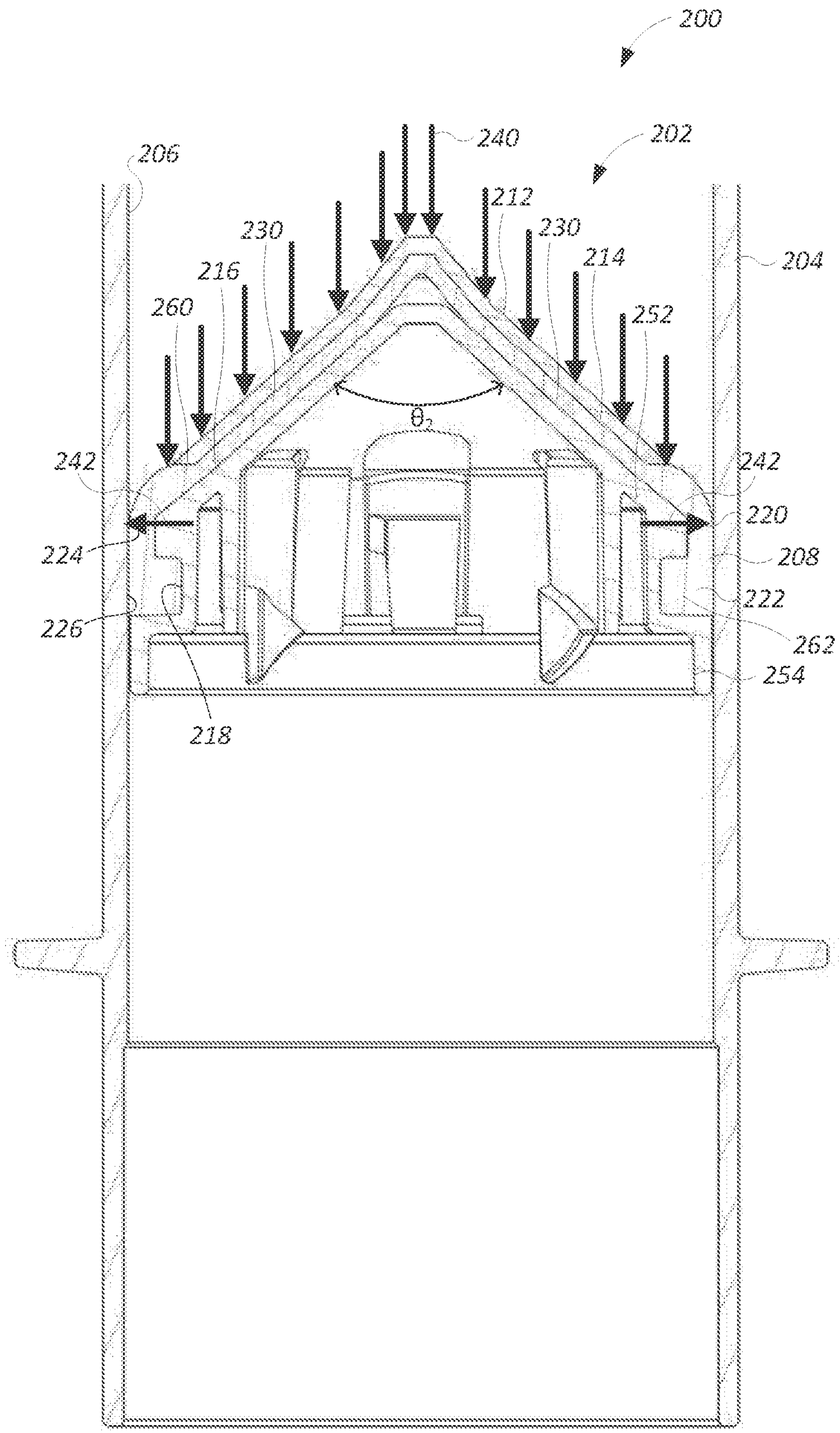


FIG. 5B

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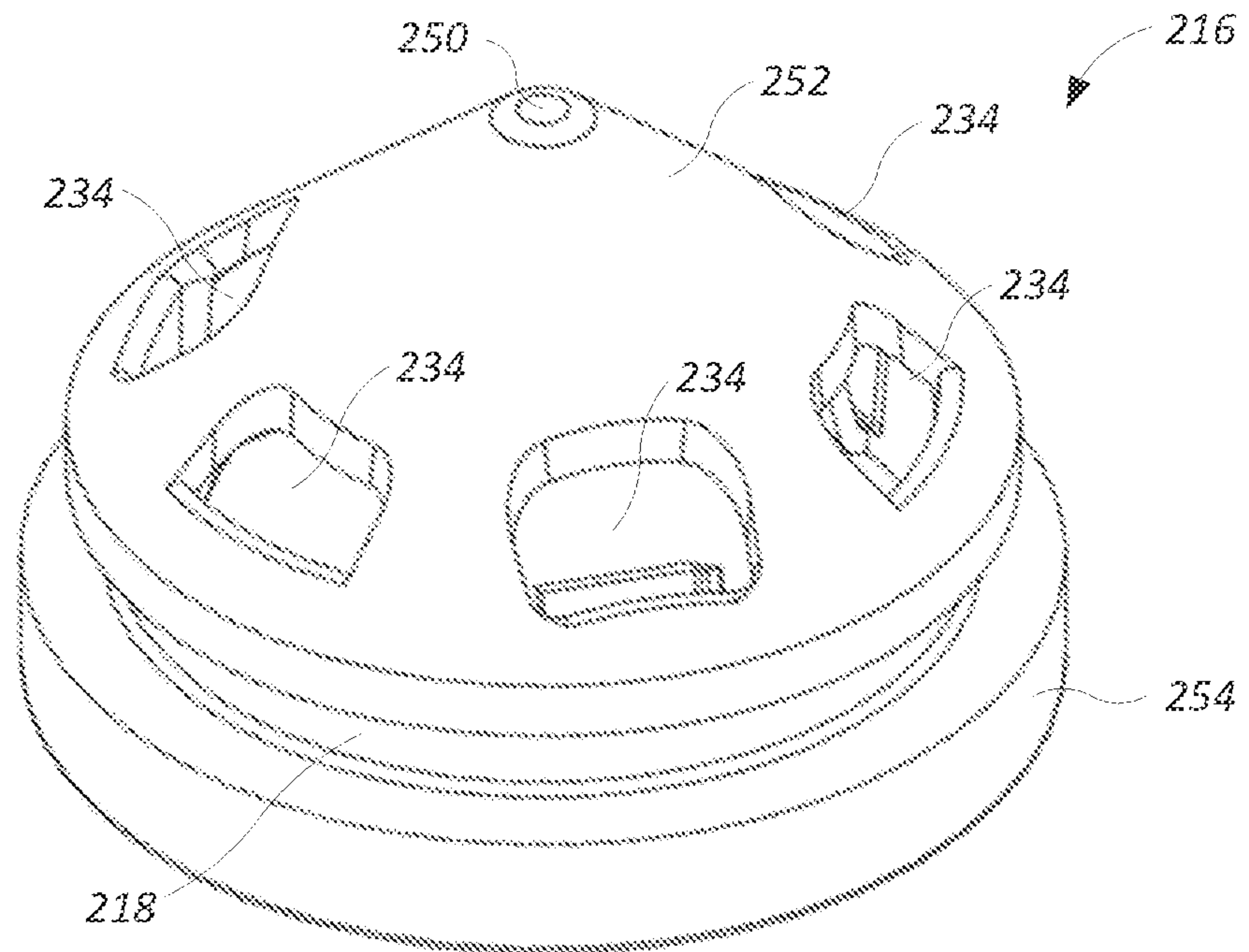


FIG. 6

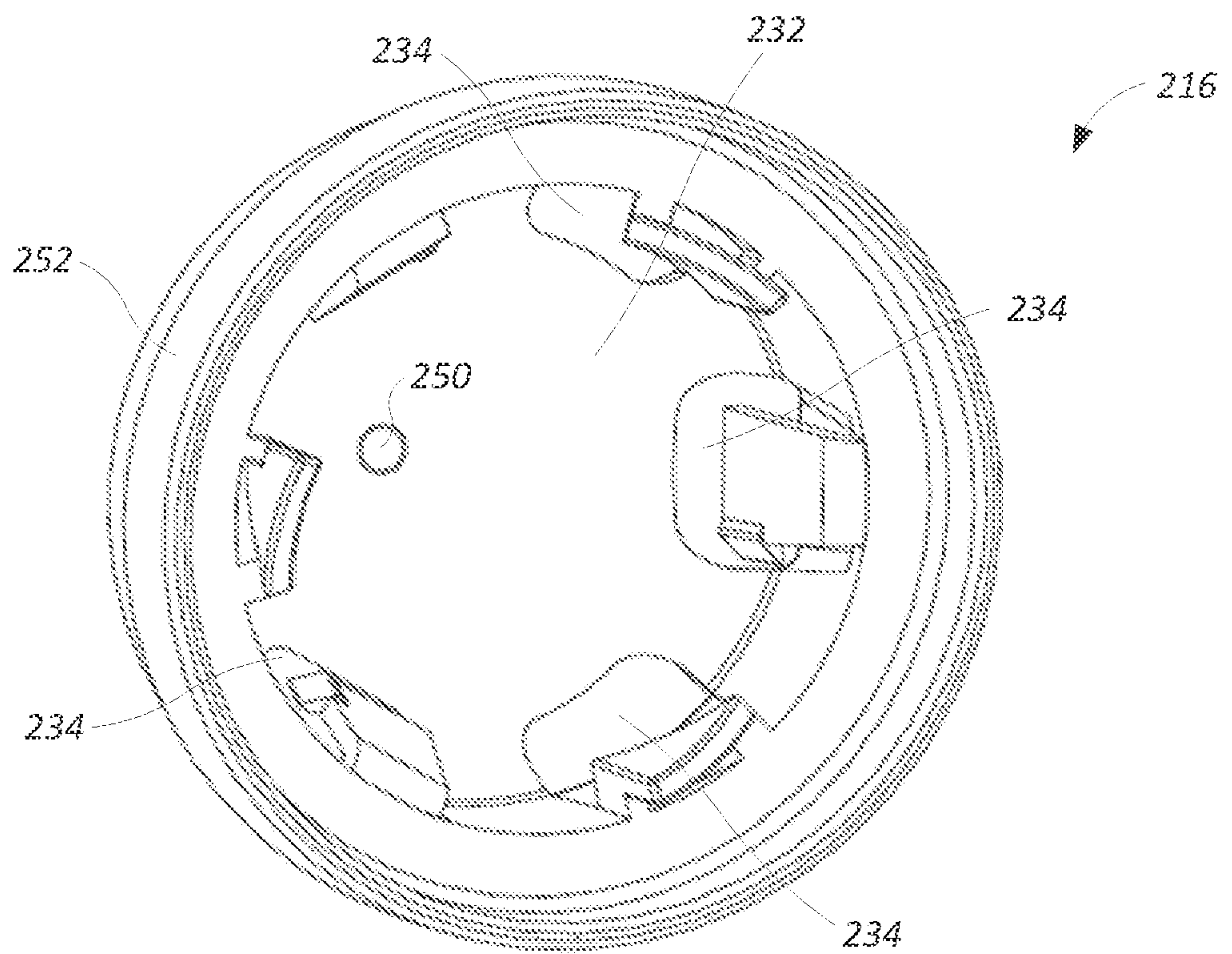


FIG. 7

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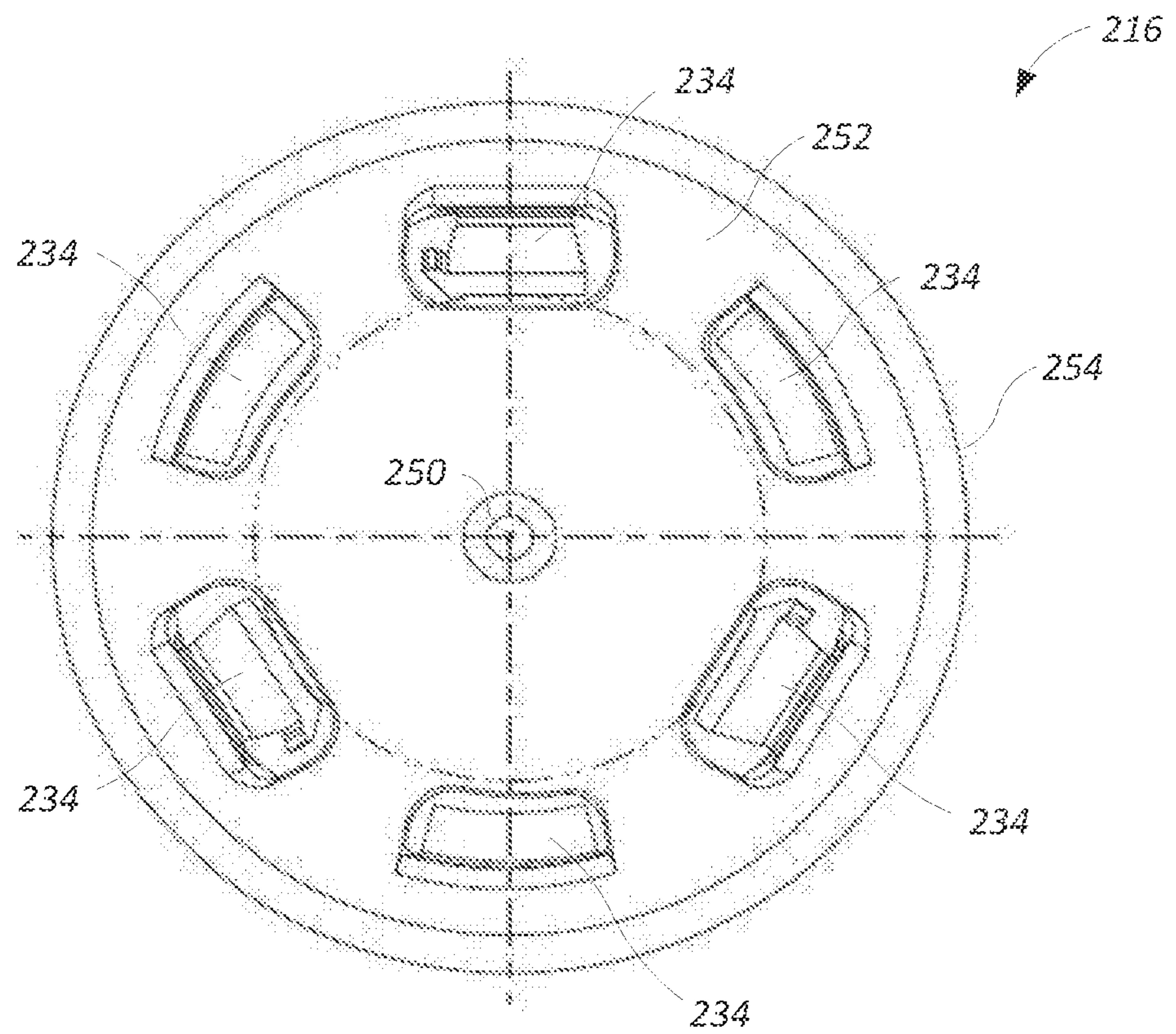


FIG. 8

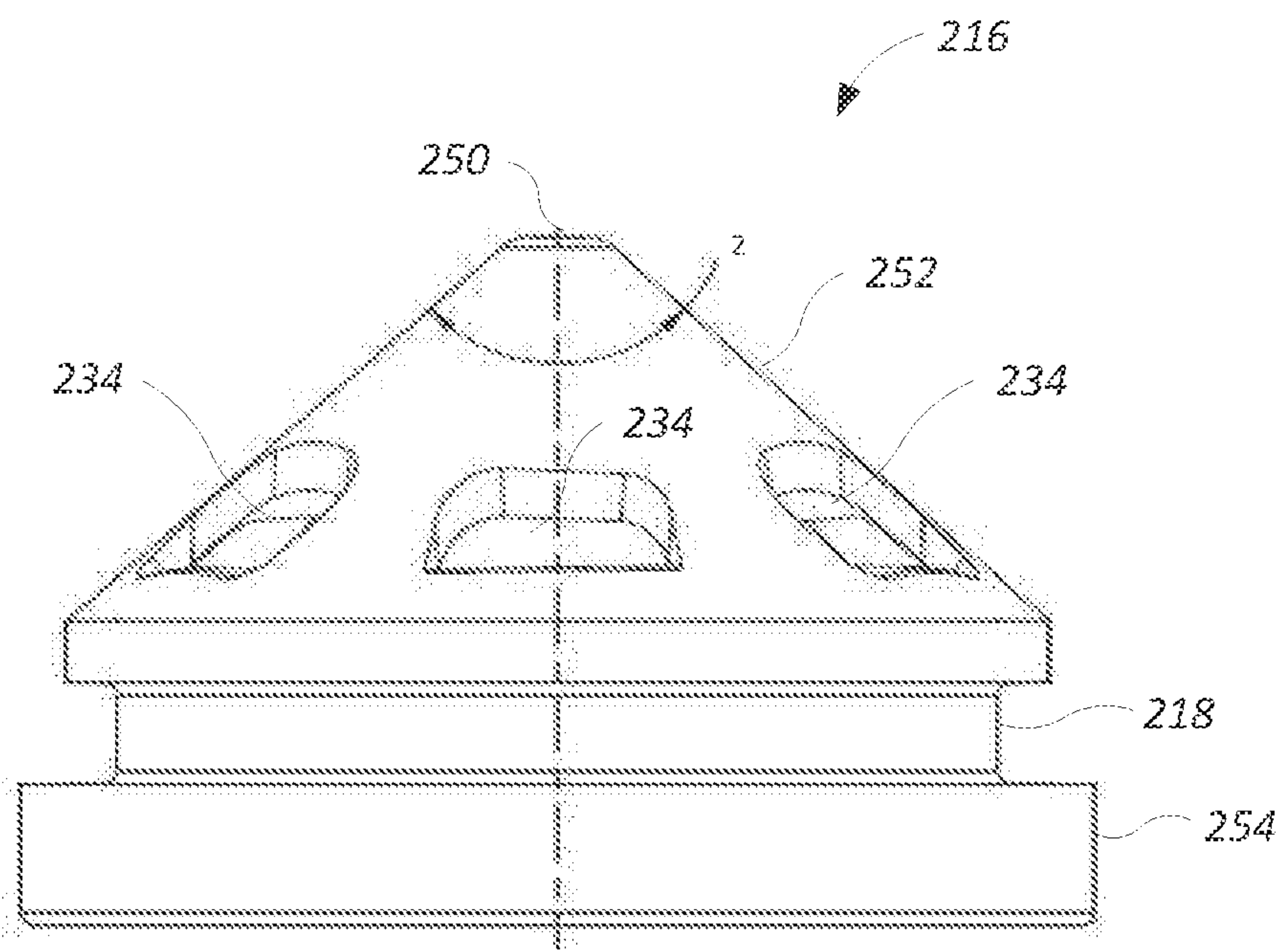


FIG. 9

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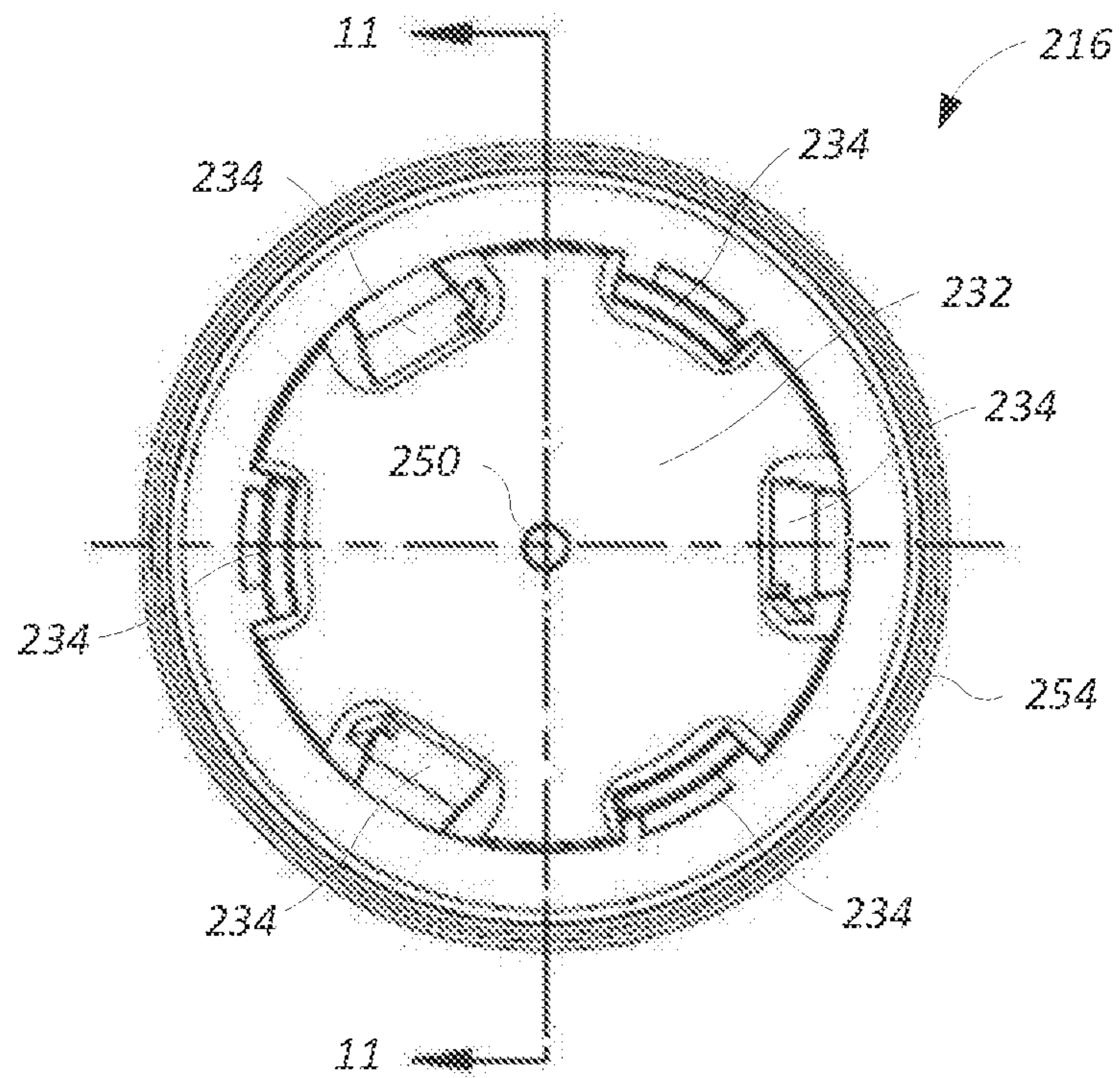


FIG. 10

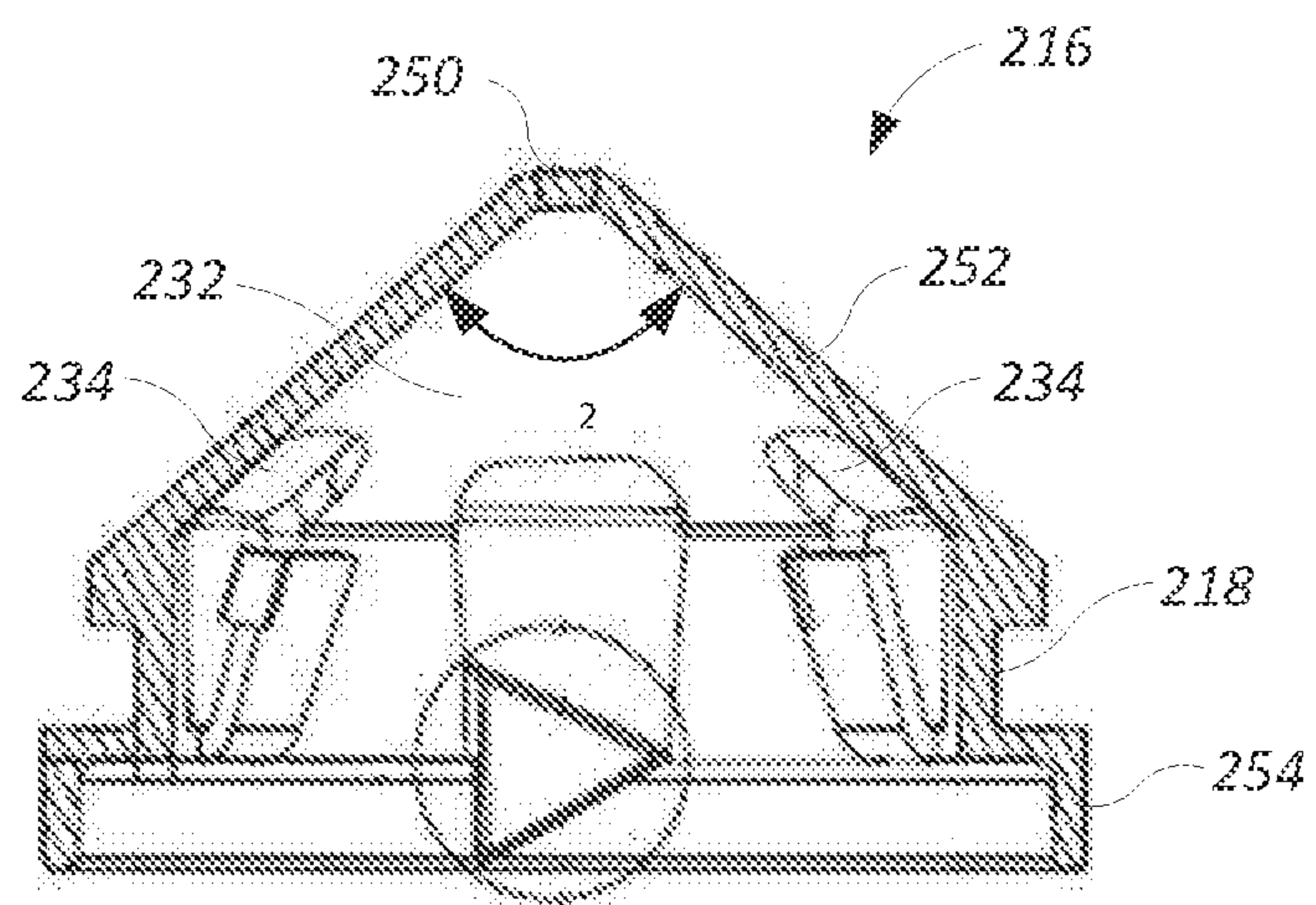


FIG. 11

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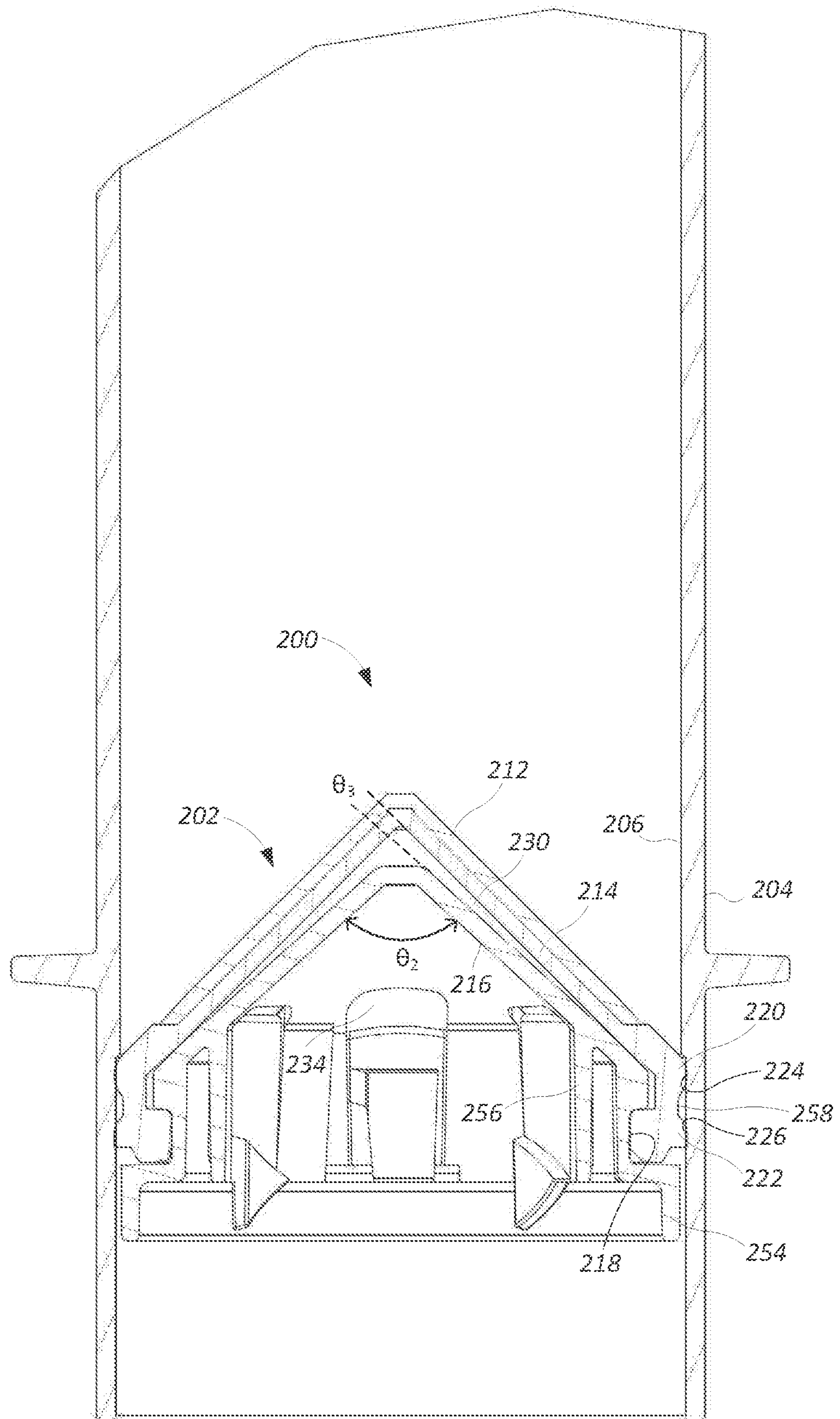


FIG. 12

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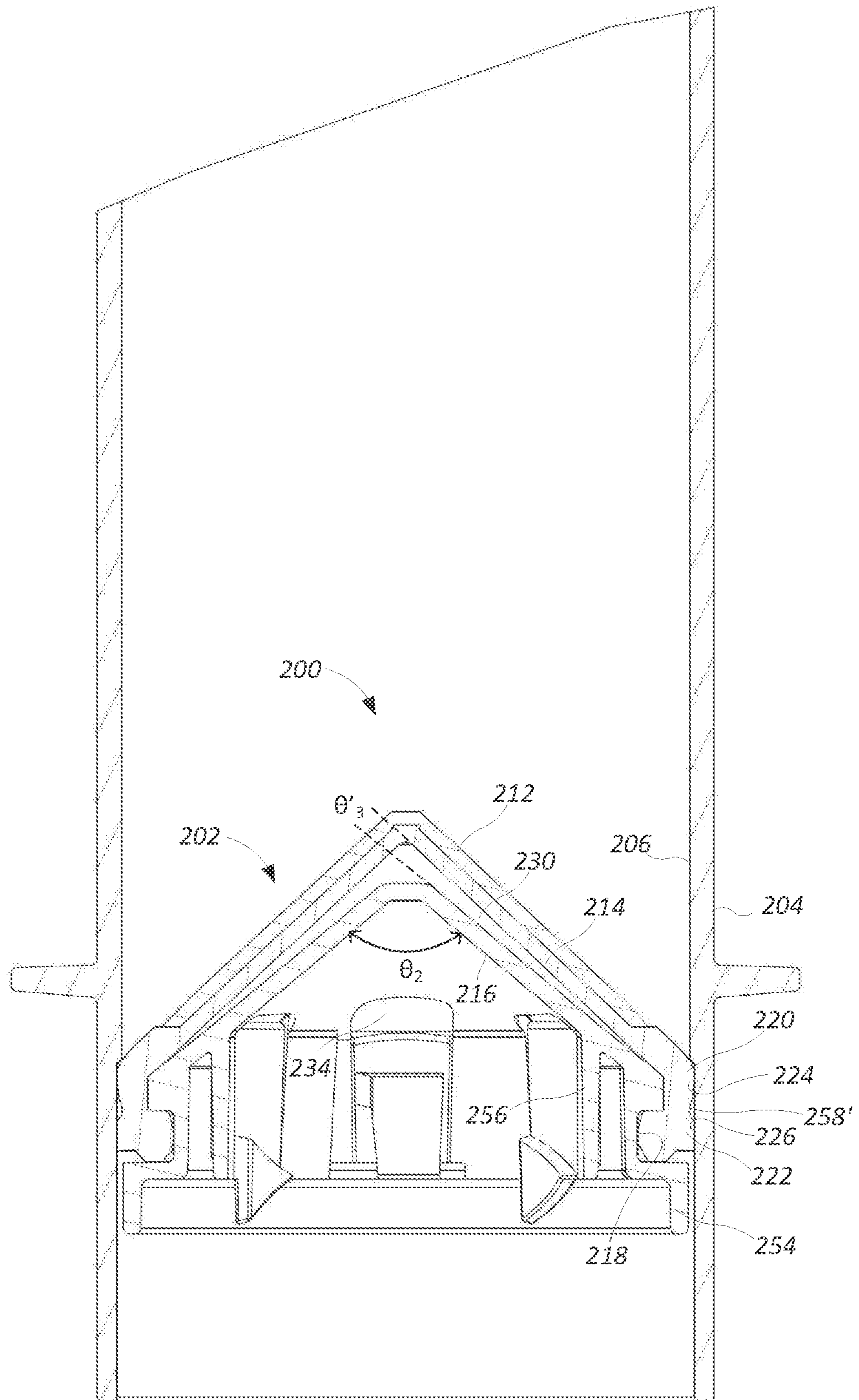


FIG. 13

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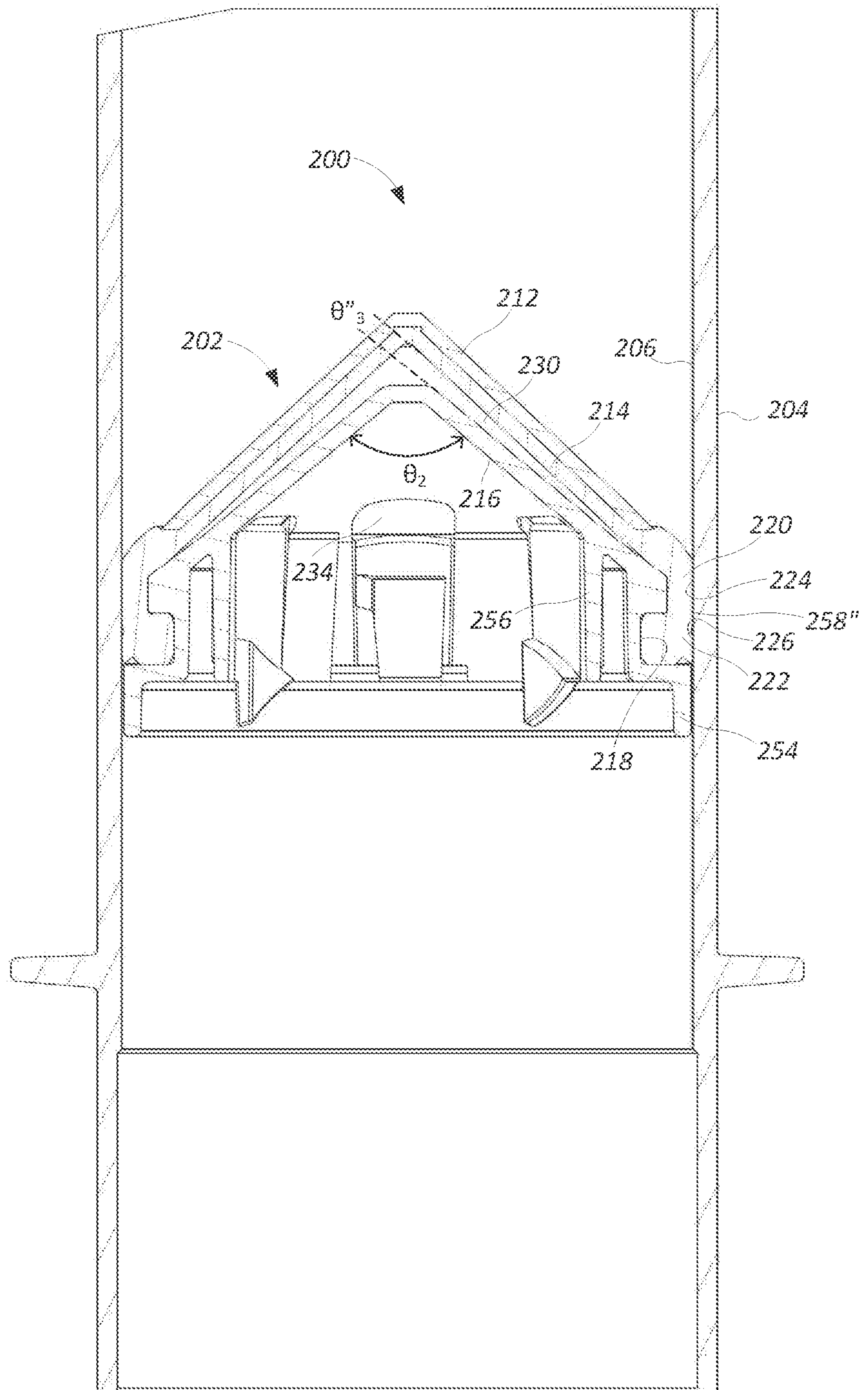


FIG. 14

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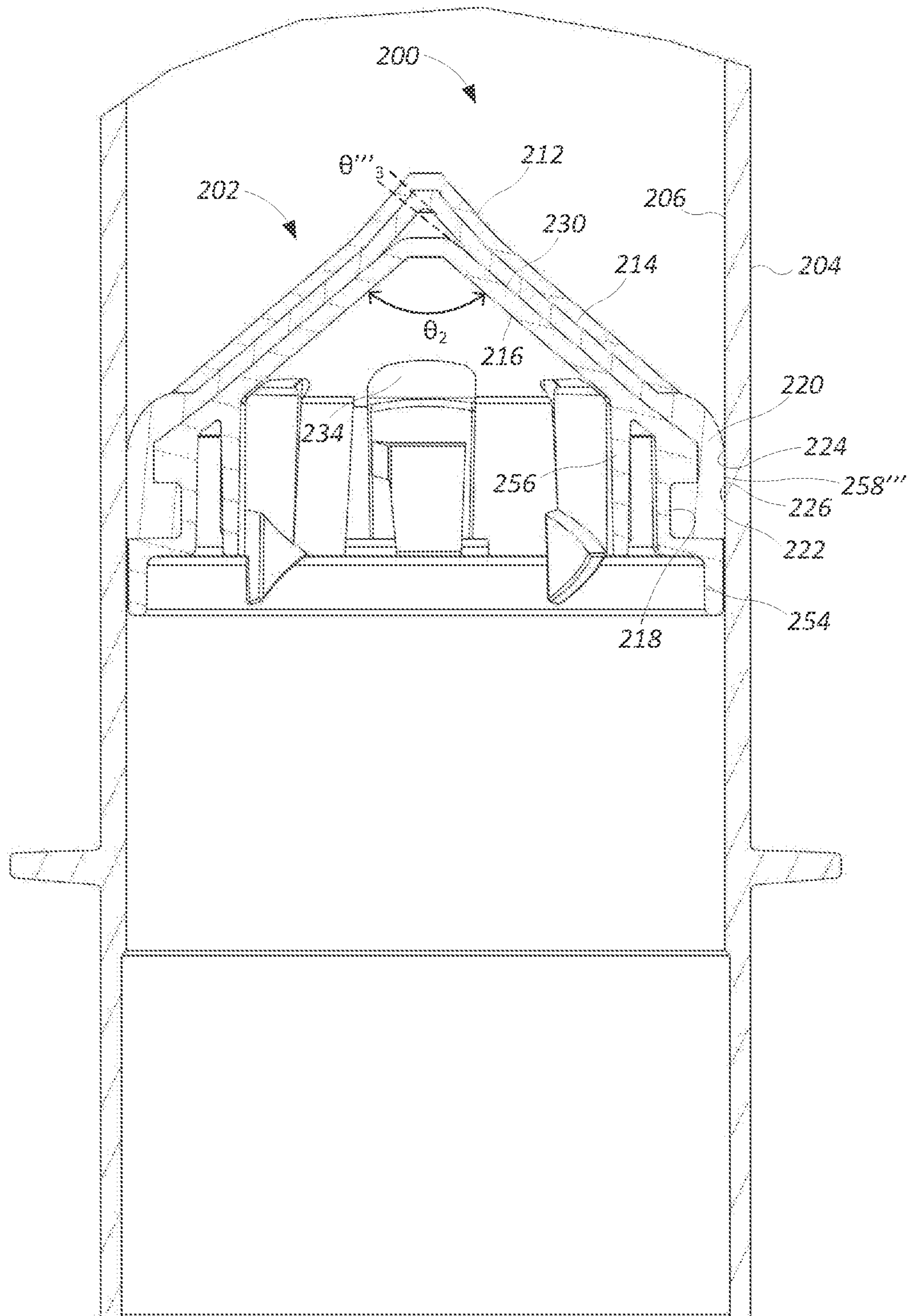


FIG. 15

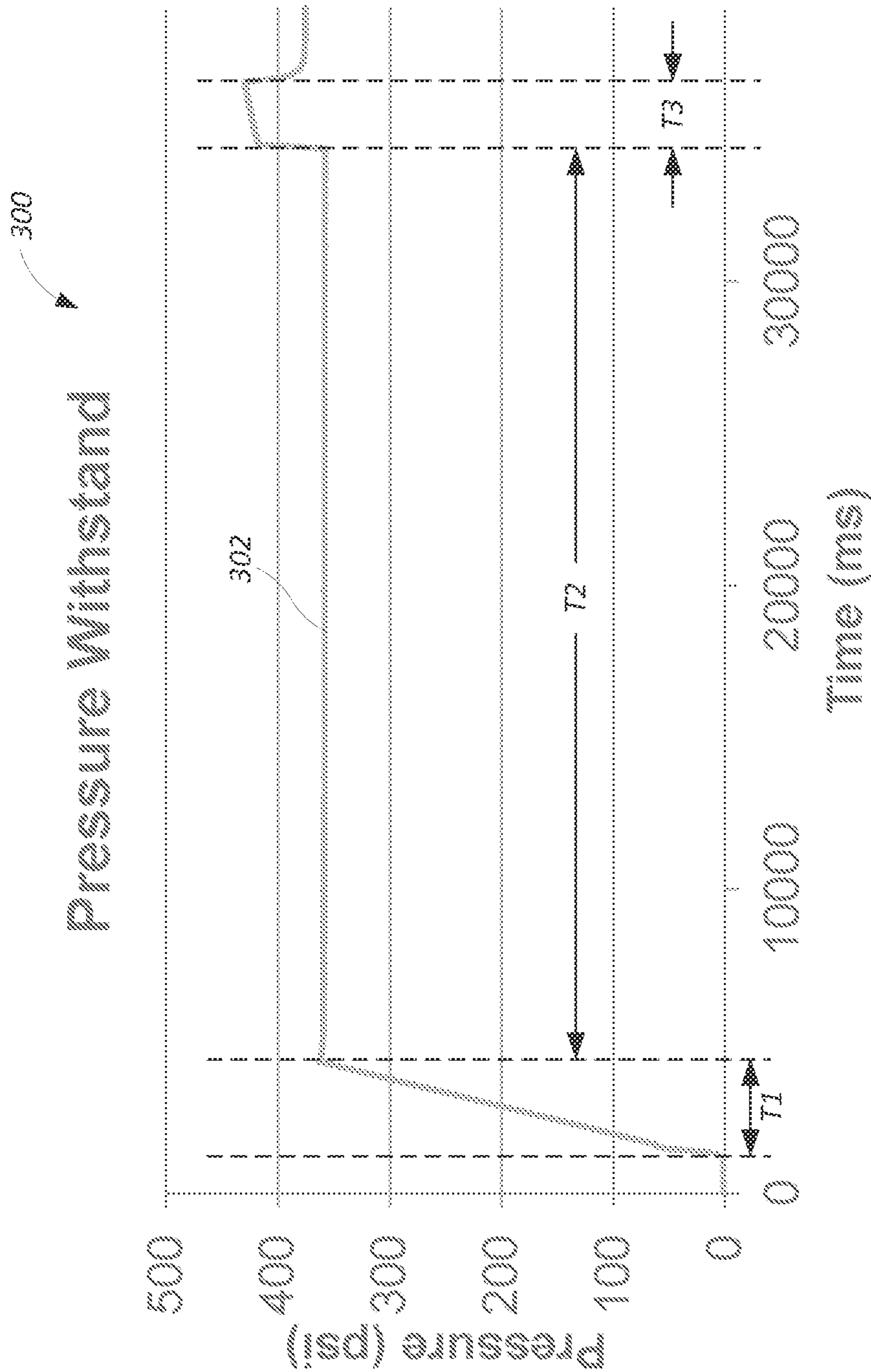


FIG. 16

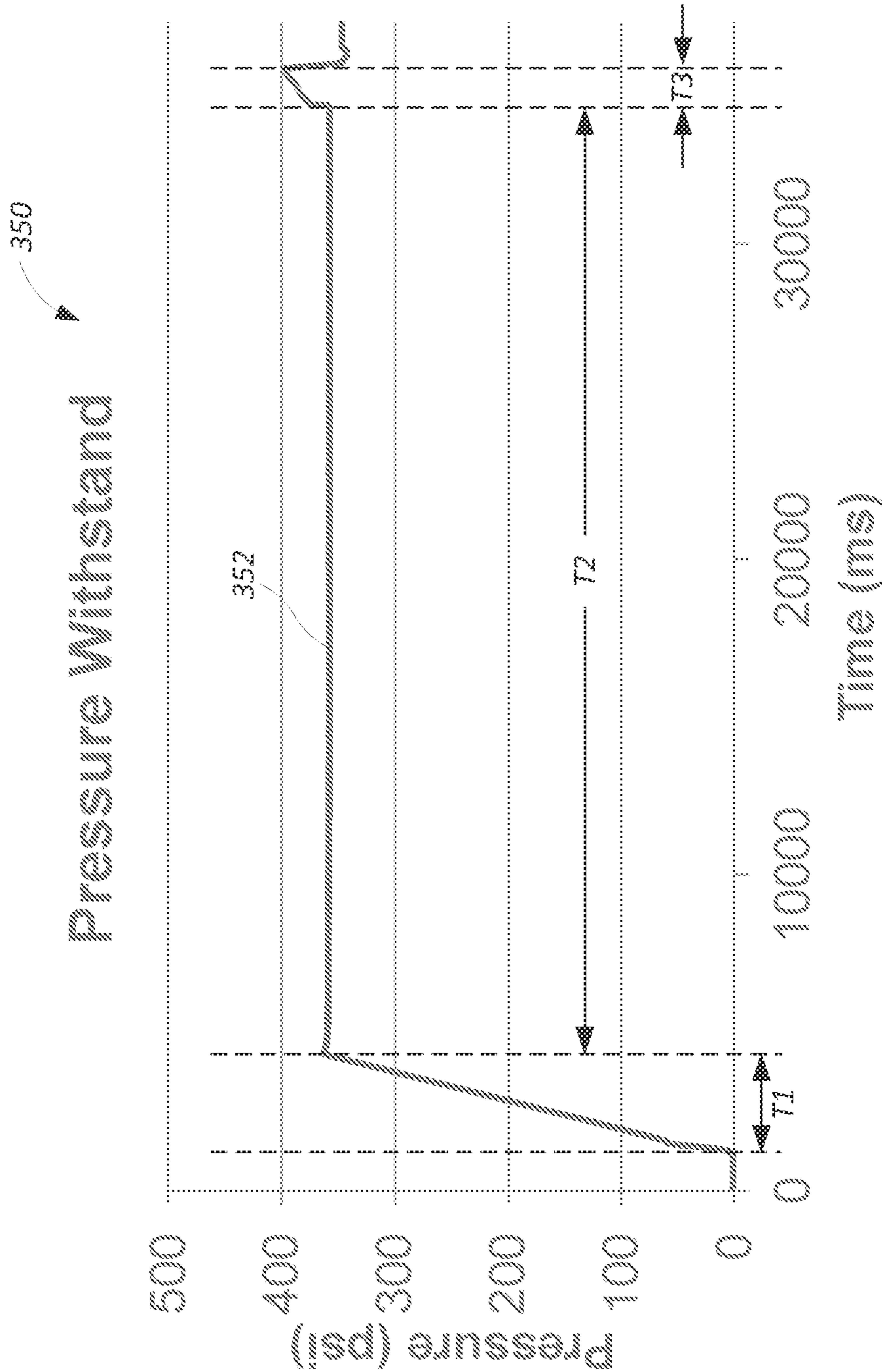


FIG. 17

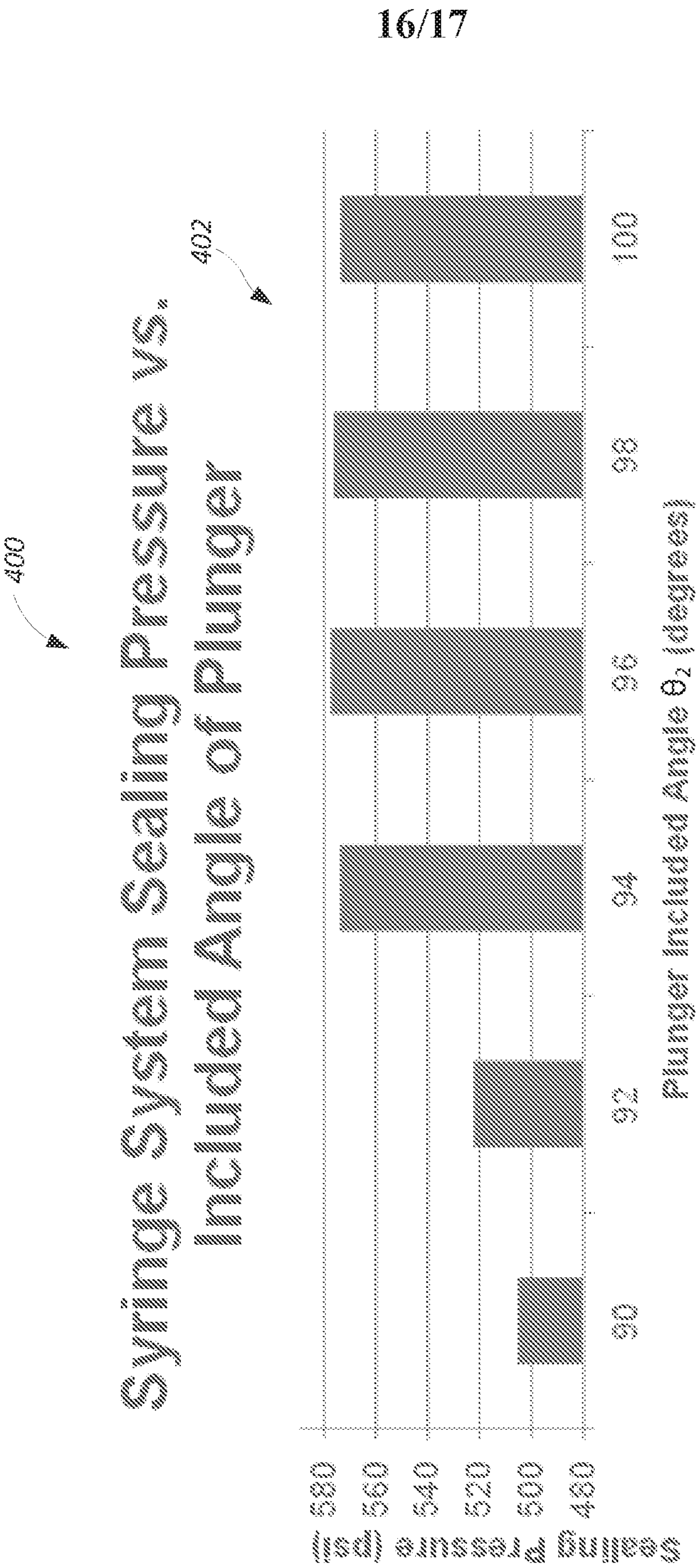


FIG. 18

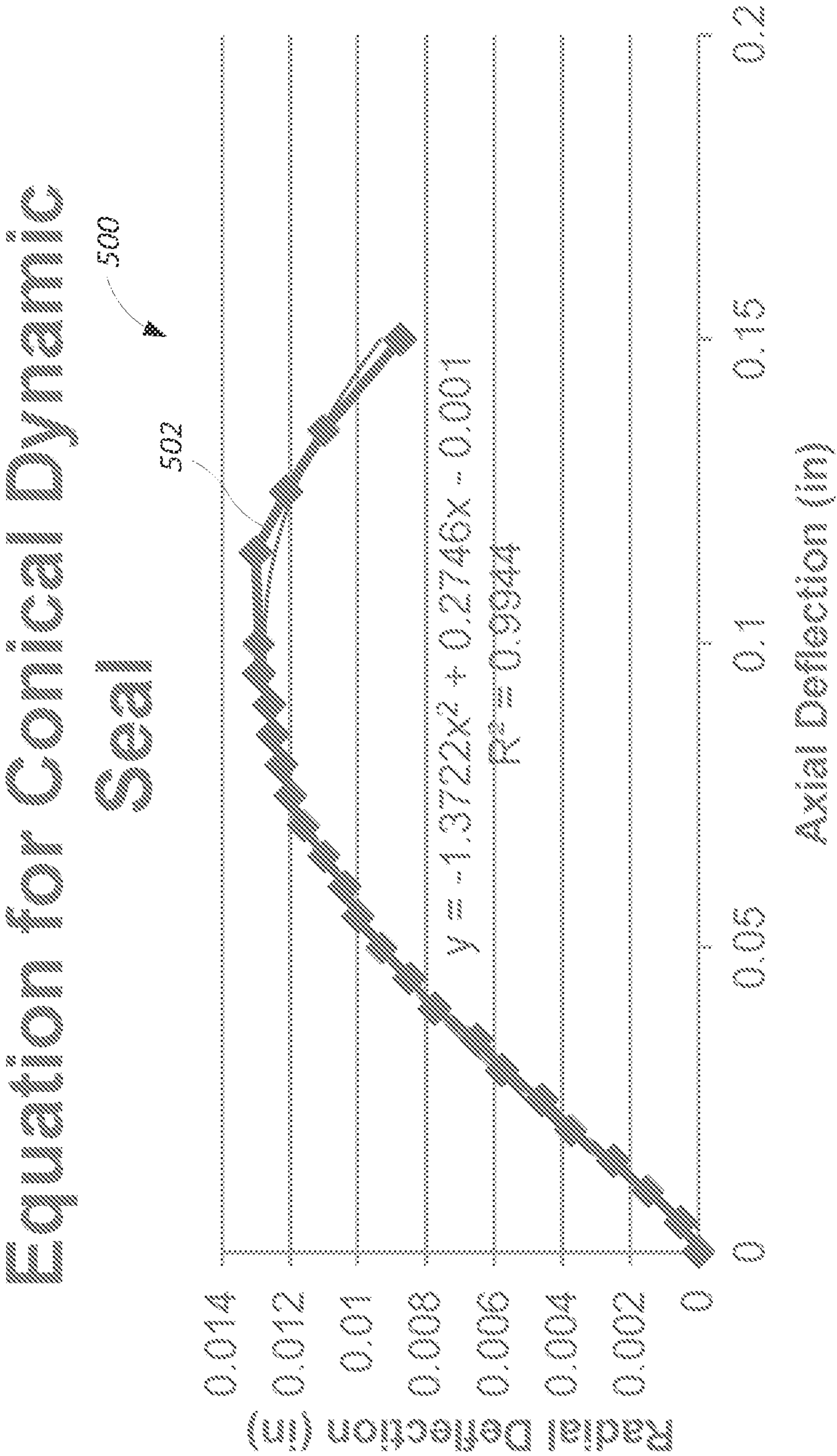


FIG. 19

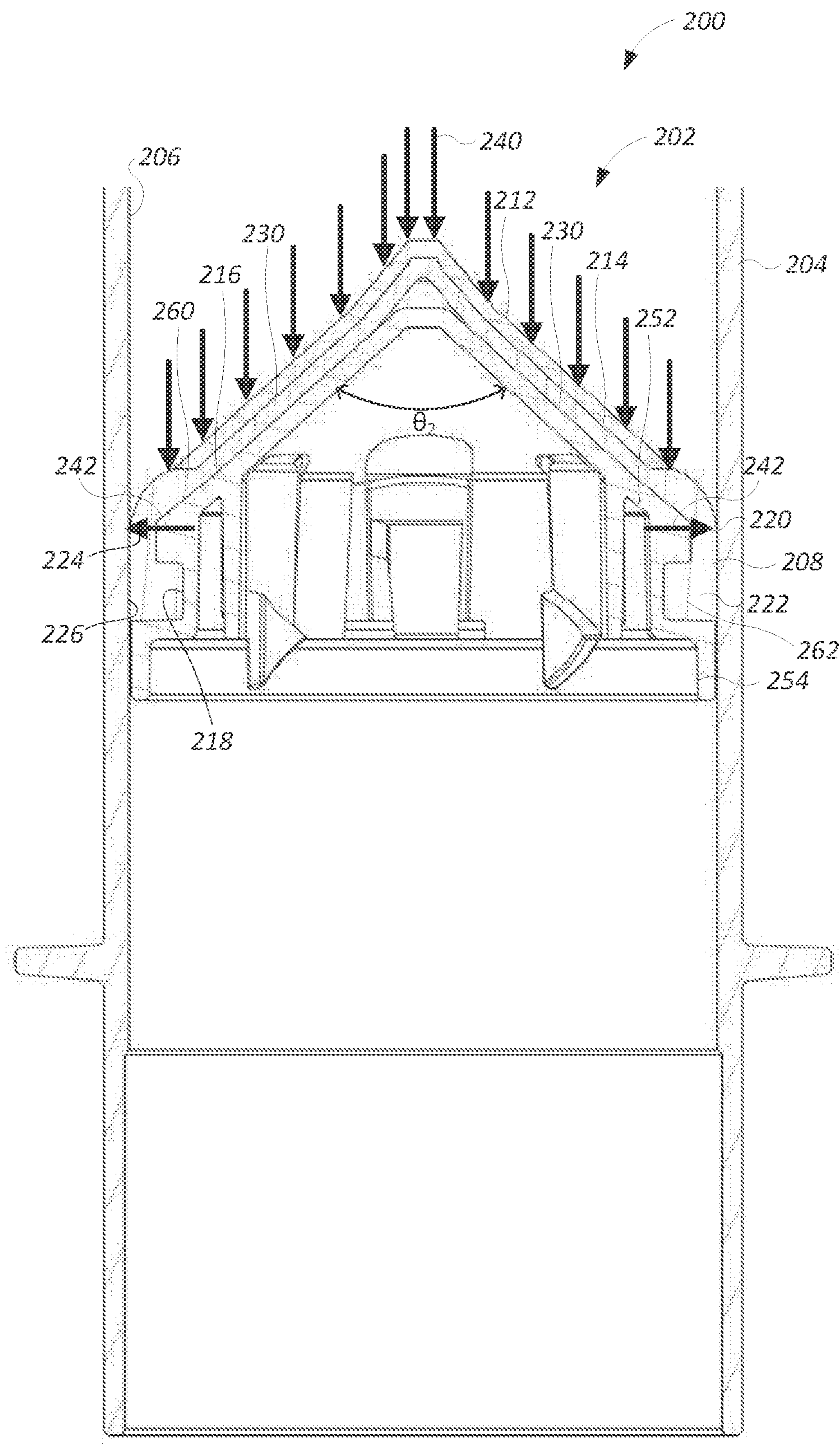


FIG. 5B