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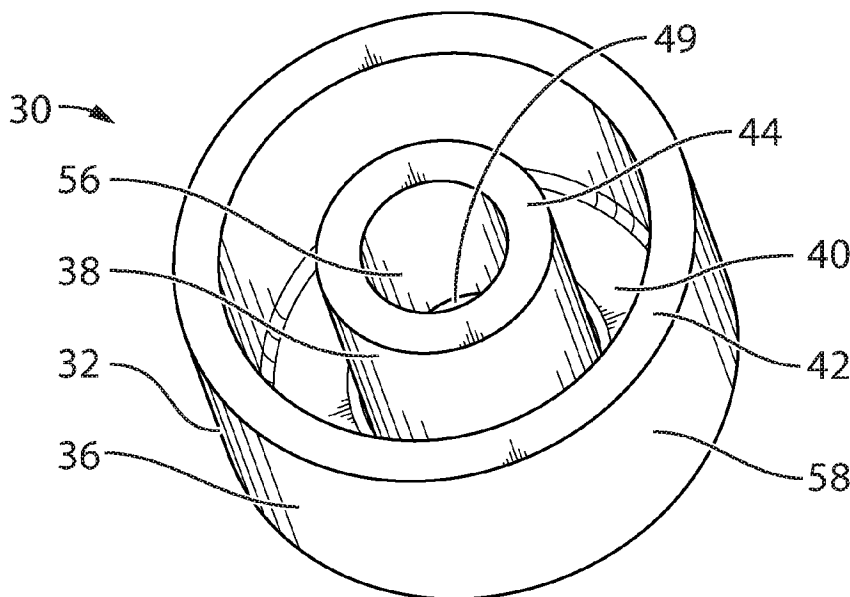
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(57) Abrégé/Abstract:

A gas release cell for use with pneumatically actuated sharps-containing medical devices. The gas release cell has a rigid outer shell and a sealing membrane sealingly engaged with the rigid outer shell. A compressed propellant is retained within the gas release cell by the sealing membrane, and the sealing membrane is rupturable to actuate the medical device by releasing compressed propellant from the gas release cell.

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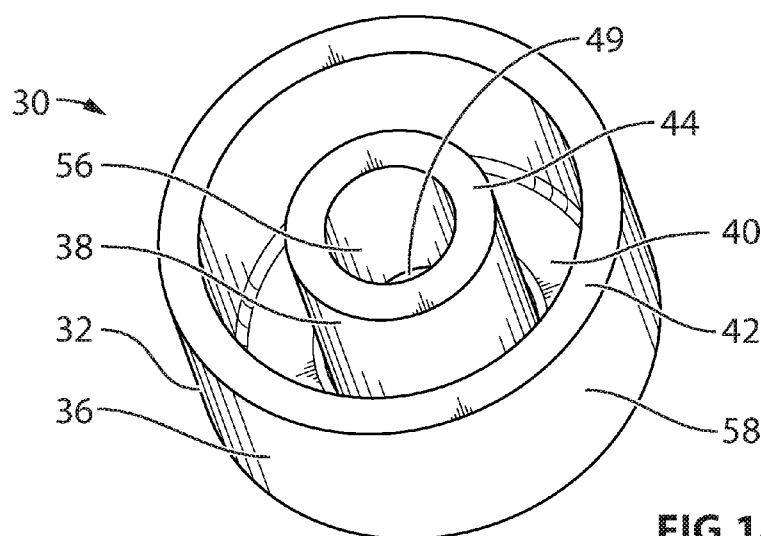


FIG.1a

(57) Abstract: A gas release cell for use with pneumatically actuated sharps-containing medical devices. The gas release cell has a rigid outer shell and a sealing membrane sealingly engaged with the rigid outer shell. A compressed propellant is retained within the gas release cell by the sealing membrane, and the sealing membrane is rupturable to actuate the medical device by releasing compressed propellant from the gas release cell.

GAS RELEASE CELL

Technical Field

5 [0001] This application relates to a gas release cell for releasing compressed propellant. In some embodiments, the gas release cell is used to actuate a pneumatically-actuated retractable sharps-containing medical device such as a pneumatically-actuated retractable-needle syringe.

10 Background

[0002] It is well known that many dangerous communicable diseases are spread through contacting the body fluids of an infected person. After use of a syringe, residual body fluids are likely to remain on or within the syringe needle. For this reason, syringes are typically intended for a single use only. In order to be handled
15 safely after use, the needle of a syringe must be covered to prevent it from accidentally stabbing a person who is, for example, collecting the syringe for disposal, thereby releasing residual body fluids into such person. Typically, a protective cap is provided with the syringe, which after use of the syringe can be used to cover the tip of the needle. However, it sometimes happens that persons attempting to cap a used
20 needle miss the cap and accidentally stab themselves, resulting in potential exposure to communicable diseases.

[0003] Accordingly, it is desirable to provide a syringe wherein the needle can be retracted into the syringe following use. Syringes including retractable needles
25 wherein the retraction of the needle is accomplished by means of pneumatic actuation have been developed, as exemplified by U.S. Patent No. 5,868,713 to Klippenstein and U.S. Patent No. 7,811,259 to Klippenstein.

[0004] Syringes utilizing pneumatic actuation must have some mechanism for
30 causing the pneumatic activation. In the syringe designs described in U.S. Patent

No. 5,868,713 and U.S. Patent No. 7,811,259, the mechanism for causing the pneumatic activation is a gas release cell that contains a compressed propellant, and is ruptured at an appropriate point in time to release compressed propellant and retract the needle within the syringe. A design for gas release cells for use in such devices
5 that can be reliably and rapidly manufactured in an automated, cost-effective manner and easily assembled into the finished device in an automated fashion has not heretofore been available.

[0005] There remains a need for gas release cells that can retain compressed
10 propellant for release at a desired time, which can be reproducibly and rapidly manufactured, and/or which can be easily assembled into a finished medical device, including pneumatically actuated retractable-needle syringes such as those described in U.S. patent Nos. 5,868,713 and 7,811,259.

15 [0006] The foregoing examples of the related art and limitations related thereto are intended to be illustrative and not exclusive. Other limitations of the related art will become apparent to those of skill in the art upon a reading of the specification and a study of the drawings.

20

Summary

[0007] The following embodiments and aspects thereof are described and illustrated in conjunction with systems, tools and methods which are meant to be exemplary and illustrative, not limiting in scope. In various embodiments, one or more of the
25 above-described problems have been reduced or eliminated, while other embodiments are directed to other improvements.

[0008] One example embodiment provides a gas release cell for use with a pneumatically-actuated sharps containing medical device. The gas release cell has
30 an inner wall comprising a rigid material and defining an aperture through the gas release cell. An outer wall comprising a rigid material extends around the inner

5 wall. A base is coupled to the inner and outer walls in sealing engagement therewith. A rupturable membrane is coupled to the inner and outer walls in sealing engagement therewith, so that the rupturable membrane, inner and outer walls and base define a sealed propellant chamber. A compressed propellant is contained within the propellant chamber.

[0009] In some embodiments, the gas release cell has surface features for preventing formation of a seal between the gas release cell and one or more adjacent components of a medical device in which the gas release cell is used. In some embodiments, the surface features are ribs, channels, or a component shape that is not complementary to the shape of a component of the medical device that contacts the gas release cell.

[0010] In some embodiments, the medical device is a pneumatically-actuated retractable-needle syringe.

15 [0011] In addition to the exemplary aspects and embodiments described above, further aspects and embodiments will become apparent by reference to the drawings and by study of the following detailed descriptions.

20 Brief Description of Drawings

[0012] Exemplary embodiments are illustrated in referenced figures of the drawings. It is intended that the embodiments and figures disclosed herein are to be considered illustrative rather than restrictive.

25 [0013] Figure 1A shows a partial perspective view of a gas release cell according to one example embodiment in which the membrane has been omitted for clarity.

[0014] Figure 1B shows a cross-sectional view of the gas release cell of Figure 1.

30

[0015] Figure 2A shows a perspective view of a gas release cell according to a second example embodiment.

5 [0016] Figure 2B shows a top view of a gas release cell according to a third example embodiment.

[0017] Figure 2C shows a top view of a gas release cell according to a fourth example embodiment.

10 [0018] Figure 2D shows a top view of a gas release cell according to a fifth example embodiment.

[0019] Figure 2E shows a top view of a gas release cell according to a sixth example embodiment.

15 [0020] Figure 2F shows a perspective view of a gas release cell according to a seventh example embodiment.

[0021] Figure 3 shows an example embodiment of a pneumatically-actuated
20 retractable-needle syringe incorporating a gas release cell according to one example embodiment.

[0022] Figure 4 shows a partial cross-sectional view of the syringe of Figure 3.

25 [0023] Figure 5 shows an exploded view of select components of the syringe of Figure 3.

[0024] Figure 6 shows a partial cross-sectional view of the syringe of Figure 3 in the assembled configuration.

30

[0025] Figure 7 shows a partial cross-sectional view of the syringe of Figure 3 at the end of the injection stroke.

[0026] Figure 8 shows a partial cross-sectional view of the syringe of Figure 3 during
5 the application of a post-injection force by a user.

[0027] Figure 9 shows a partial cross-sectional view of the syringe of Figure 3 in the retracted position.

10 Description

[0028] Throughout the following description specific details are set forth in order to provide a more thorough understanding to persons skilled in the art. However, well known elements may not have been shown or described in detail to avoid unnecessarily obscuring the disclosure. Accordingly, the description and drawings
15 are to be regarded in an illustrative, rather than a restrictive, sense.

[0029] In this specification, “seals” or “sealingly engages” means that two elements are engaged with sufficient sealing capability that the function for which the sealing is provided can be effectively performed.

20 [0030] “Distal” means the direction towards the tip of the needle when the hypodermic syringe assembly is in the assembled state. “Proximal” means the direction opposite of distal, i.e. the direction away from the tip of the needle when the hypodermic syringe assembly is in the assembled state.

25 [0031] “Injection force” means a force that would typically be applied by a user to the plunger of a syringe to inject a medicament into a patient.

[0032] “Post-injection force” means a force that is applied to activate the gas-actuated
30 retraction mechanism described below after a user has completed injection of the

medicament. In some embodiments, the post-injection force is greater than the injection force.

5 [0033] “Loading force” means a force typically applied by a user when drawing medicament into a syringe in preparation for administering that medicament to a patient.

10 [0034] Although the invention is described with reference to an exemplary embodiment of pneumatically-actuated retractable-needle hypodermic needle and syringe (which may be used in medical, dental or veterinary applications), some embodiments of the invention have application in other devices where gas release cells may be used. For example, pneumatic retraction may also be used in sharps-containing medical devices such as blood collection syringe systems, intravenous syringe systems, pneumatically-actuated retractable scalpels, radiological 15 syringes, spinal syringe systems, and the like. Some embodiments of gas release cells according to some embodiments of the present invention may be useful in such devices.

20 [0035] According to some embodiments, a gas release cell for use with pneumatically actuated sharps-containing medical devices is provided. The gas release cell has a rigid outer shell and a sealing membrane sealingly engaged with the rigid outer shell. A compressed propellant is retained within the gas release cell by the sealing membrane, and the sealing membrane is rupturable to actuate retraction of a retractable sharp in the sharps-containing medical device by releasing compressed 25 propellant from the gas release cell.

30 [0036] With reference to Figures 1A and 1B, in one example embodiment a gas release cell **30** has a shell **32** and a sealing membrane **34** (not shown in Figure 1A for clarity). Shell **32** is generally cylindrically shaped, having a generally cylindrical outer wall **36** and a generally cylindrical inner wall **38**. In the illustrated embodiment, outer wall **36** and inner wall **38** are axially aligned. Outer wall **36** and

inner wall **38** are connected at a first end by a base **40**. In some embodiments, including the illustrated embodiment, outer wall **36**, inner wall **38** and base **40** are integrally formed. In some embodiments, the outer wall **36**, inner wall **38** and base **40** could be formed as separate elements and joined together in any suitable manner, for example by welding, use of suitable adhesives, or the like.

[0037] For clarity in the present description, the first end of gas release cell **30** defined by base **40** is described in a relative sense as the “bottom”, and the end of gas release cell **30** opposite base **40** is described in a relative sense as the “top” for ease of reference to the drawings. However, it will be appreciated that gas release cell **30** can adopt any of a variety of different orientations, such that the “top” might be below the “bottom” in some orientations, and the use of these terms is not intended to be limiting to one specific orientation of gas release cell **30**. For example, in the illustrated embodiment of Figure 4, the exemplary gas release cell **134** is oriented with the top facing towards the base or distal end of the syringe **124**.

[0038] At the top of gas release cell **30**, an outer sealing edge **42** is defined by the upper edge of outer wall **36**, and an inner sealing edge **44** is defined by the upper edge of inner wall **38**.

[0039] Outer wall **36**, inner wall **38**, base **40** and membrane **34** define a sealed cavity **48** with a central aperture **49** extending through the gas release cell. Sealed cavity **48** contains the propellant **46** to be released by gas release cell **30**.

[0040] With reference to Figure 2A, an alternative embodiment of a gas release cell **50A** is illustrated. Gas release cell **50A** is substantially similar to gas release cell **30** except for the presence of interior ribs **52A** on the inner surface **56A** of the inner wall of the gas release cell **50A**. Ribs **52A** extend in a generally axial direction within the inside circumference of the shell of gas release cell **50A** as defined by inner surface **56A**, and project radially inwardly from the inner surface **56A** of the inner wall of gas release cell **50A**. In some embodiments in which gas release cell **50A** is used in a

medical device, for example in the pneumatically-actuated retractable-needle syringe as described in greater detail below, ribs **52A** can facilitate more reliable retraction of the needle by preventing the formation of a seal between the inner circumference of gas release cell **50A** and other adjacent components of the syringe. That is, ribs **52A** are surface features of gas release cell **50A** configured to provide a gas passage between gas release cell **50A** and one or more adjacent components of the medical device. The exact position and number of ribs **52A** is not critical, so long as at least one rib is positioned in a manner that makes it difficult for the inner circumference of gas release cell **50A** to form an airtight seal with at least one adjacent component of a pneumatically-actuated sharps-containing medical device. As an example, in the illustrated embodiment, ribs **52A** can assist in preventing formation of an airtight seal between inner surface **56A** and a generally cylindrical component of a medical device extending through central aperture **62A** of gas release cell **50A**.

[0041] Other configurations of the surface of the gas release cell can be used to provide a gas passage between the gas release cell and other adjacent components of the sharps-containing medical device. For example, as illustrated in Figure 2B, in an example embodiment of a gas release cell **50B**, a plurality of channels **60** have been provided on the inner surface **56B** of the inner wall of gas release cell **50B**. Channels **60** extend generally axially through the inner surface **56B** of the inner wall of gas release cell **50B**. Channels **60** are configured to provide a gas passage between the gas release cell and other adjacent components of a medical device, by preventing formation of a seal between inner surface **56B** and one or more adjacent components of a medical device. As an example, in the illustrated embodiment, channels **60** can assist in preventing the formation of an airtight seal between inner surface **56B** and a generally cylindrical component of a medical device that extends through central aperture **62B** of gas release cell **50B**.

[0042] While in the illustrated embodiment three channels **60** have been shown spaced apart by approximately equal distances, the number and position of channels **60** could be varied and still provide a gas passage between the gas release cell and

other components of a pneumatically-actuated sharps-containing medical device. In alternative embodiments, channels are provided on the outer surface of the outer wall of a gas release cell, or on both the inner and outer surfaces of the inner and outer walls, respectively, of the gas release cell, to prevent formation of an airtight seal
5 between one or more components of a medical device in which the gas release cell is used.

[0043] With reference to Figure 2C, a further alternative embodiment of a gas release cell **50C** is illustrated. Gas release cell **50C** has an inner surface **56C** with a shape
10 that does not form a sealing engagement with an adjacent generally cylindrical component of a medical device extending through the central aperture **62C** of the gas release cell **50C**. In the illustrated embodiment, inner surface **56C** is provided with a generally hexagonal cross-sectional shape. The generally hexagonal cross-sectional shape does not form a seal with a generally cylindrical component of a medical device
15 inserted through the central aperture **62C** of gas release cell **50C**. Inner surface **56C** could alternatively be provided with other shapes that do not form a seal with a generally cylindrical component of a medical device inserted through the central aperture **62C** of gas release cell **50C**, for example, inner surface **56C** could be provided with an asymmetrical cross-section; a triangular, square, pentagonal or other
20 polygonal shaped cross-section; a pear-shaped cross-section; an oval cross-section and so on. Any cross-sectional shape that facilitates formation of a gas passage between the inner surface of gas release cell **50C** and a component of a medical device inserted through central aperture **62C** of gas release cell **50C** could be used.

25 [0044] The shape of inner surface **56C** can be selected to be a shape that does not form a sealing engagement with other components of a pneumatically-actuated sharps-containing medical device in which gas release cell **50C** is used based on the shape of a component to be inserted through the central aperture **62C** of gas release cell **50C**. For example, if the component to be inserted through the central aperture
30 **62C** of gas release cell **50C** has a generally square cross-section, then the cross-sectional shape of inner surface **56C** should be selected to be a shape other than

a square, to provide a gas passage between gas release cell **50C** and the components of the medical device in which it is used.

[0045] In alternative embodiments, the shape of the outer surface **58C** of the gas
5 release cell could be modified in a similar manner to that described for inside surface
56C, so that outer surface **58C** does not form an airtight seal with one or more
adjacent components of a pneumatically-actuated sharps-containing medical device in
which the gas release cell is used. For example, in an embodiment in which the gas
release cell sits within a generally cylindrical component of a medical device (e.g. the
10 barrel of a syringe), the outer surface of the gas release cell could be provided with a
generally hexagonal or other cross-sectional shape (e.g. an asymmetrical
cross-section; a triangular, square, pentagonal or other polygonal shaped
cross-section; a pear-shaped cross-section; an oval cross-section; and so on), so that
the outer surface of the gas release cell does not form an airtight seal with the
15 cylindrical component of the medical device. In some embodiments, the
cross-sectional shape of both the inner surface and the outer surface of the gas release
cell could be modified as described above to prevent formation of an airtight seal
between the gas release cell and one or more adjacent components of a medical
device.

20
[0046] In some alternative embodiments, as illustrated with respect to an example gas
release cell **50D** in Figure 2D, axially extending radially outwardly projecting ribs
52D analogous to ribs **52A** are provided on the outer surface **58D** of the outside
circumference of the gas release cell to prevent formation of a seal between the gas
25 release cell and one or more adjacent components of a pneumatically-actuated
sharps-containing medical device. While in the illustrated embodiment five ribs **52D**
that are approximately symmetrically distributed about the outer surface **58D** of gas
release cell **50D** have been illustrated, the number, distribution and configuration of
ribs **52D** could be varied, so long as ribs **52D** are configured to provide a gas passage
30 between gas release cell **50D** and one or more components of a medical device. For
example, gas release cell **50D** could be used within a cylindrical barrel of a

pneumatically-actuated sharps-containing medical device to prevent formation of a sealing engagement between the outer surface **58D** of gas release cell **50D** and the inner surface of the cylindrical barrel. In the illustrated embodiment, the inner surface **56D** of gas release cell **50D** is smoothly curved and circular in shape. In some embodiments, ribs **52A**, **52D** are provided on both the inside and outside circumferences of the same gas release cell to prevent formation of a seal between the gas release cell and one or more components of a pneumatically-actuated sharps-containing medical device.

[0047] In some alternative embodiments, for example as illustrated with respect to an example gas release cell **50E** in Figure 2E, axially extending channels analogous to channels **60** of gas release cell **50B** are provided on the outer surface **58E** of the outside circumference of the gas release cell to prevent formation of a seal between the gas release cell and one or more adjacent components of a pneumatically-actuated sharps-containing medical device. While in the illustrated embodiment six channels **60E** that are approximately symmetrically distributed around the outer surface **58E** of gas release cell **50E** have been illustrated, the number, distribution and orientation of channels **60E** could be varied, so long as channels **60E** are configured to provide a gas passage between gas release cell **50E** and one or more components of a pneumatically-actuated sharps-containing medical device.

[0048] In some alternative embodiments, surface features that prevent formation of a sealing engagement between the gas release cell and one or more adjacent components of a pneumatically-actuated sharps-containing medical device are provided on multiple surfaces of the gas release cell. For example, in some embodiments, such features can be provided on both the inside and outside surfaces of the gas release cell. For example, in some embodiments, the features of any or all of Figures 2A, 2B, 2C, 2D, 2E or 2F could be combined in any number of different permutations.

[0049] In some alternative embodiments, surface features that prevent formation of a sealing engagement between the gas release cell and one or more adjacent components of a pneumatically-actuated sharps-containing medical device are provided on the base **40** of the gas release cell. For example, as illustrated in Figure 2F, channels **60F** are provided on the outside surface **58F** of gas release cell **50F**, and channels **60F** extend through the base **40F** of gas release cell **50F**. Such an example gas release cell **60F** could potentially be used, for example, in a pneumatically-actuated retractable syringe as illustrated in Figures 3-9, in which the gas release cell could potentially form a sealing engagement with two components of the syringe, in this example embodiment the interior surface of the syringe barrel (**144**) and the engagement ring (**160**), as described in greater detail below. While an example embodiment having four channels **60F** has been illustrated, the number and position of channels **60F** could be varied to be provided in any shape, size or number, so long as channels **60F** can provide a gas passageway between gas release cell **50F** and one or more adjacent components of a pneumatically-actuated sharps-containing medical device.

[0050] While exemplary embodiments have been described in which the gas release cell is provided with surface features that can be used to prevent formation of an airtight seal between the gas release cell and one or more adjacent components of a pneumatically-actuated sharps-containing medical device, in alternative embodiments, surface features could be provided on one or more components of a medical device that are adjacent a gas release cell to prevent formation of an airtight seal between the gas release cell and the one or more adjacent components of the medical device.

[0051] In some embodiments, for example as illustrated in Figure 1A, no surface features are provided on the gas release cell for preventing formation of a seal between the gas release cell and one or more adjacent components of a pneumatically-actuated sharps-containing medical device. For example, as illustrated in Figure 1A, the inner surface **56** of the inner wall and the outer surface **58** of the outer wall are generally smooth and of symmetrical cross-sectional shape

(circular in the illustrated embodiment). In some such embodiments, the dimensions of the gas release cell and/or of the components of the medical device are selected to allow sufficient tolerance that formation of a complete seal between the gas release cell and one or more components of the medical device is unlikely.

5

[0052] As best seen in Figure 1B, in some embodiments, the top surfaces of inner and outer sealing edges **44**, **42** are provided with a curved radius **54**. In some embodiments, curved radius **54** facilitates coupling of shell **32** and sealing membrane **34**, including for example in embodiments in which sealing membrane **34** is sealed to shell **32** using a thermal or heat sealing process. In some embodiments, the top surfaces of inner and outer sealing edges **42**, **44** comprise a flat surface.

[0053] Gas release cell **30** and gas release cell **50** can be made from any suitable materials. In one example embodiment, at least outer wall **36** and inner wall **38** of shell **32** are made from a rigid material. In some embodiments, the rigid material is a suitable polymer, homopolymer or co-polymer, for example, polypropylene, polyethylene, high density polyethylene (HDPE), polyethylene terephthalate, polystyrene, polycarbonate, acrylic, polyvinyl chloride, polyester, a polyamide such as nylon, or the like. In some embodiments, shell **32** is made from laminated layers of two or more of the foregoing materials. In some embodiments, shell **32** is made from laminated layers of a suitable polymer, homopolymer or copolymer, or multiple layers thereof, and a metal foil, for example, aluminum foil. In some embodiments, use of a rigid material to form at least outer and inner walls **36**, **38** of shell **32** assists in the reliable rupture of sealing membrane **34** when the gas release cell is in use.

25

[0054] In some embodiments, the material(s) used to manufacture gas release cell **30** or gas release cell **50** are selected for their biocompatibility and/or compliance with regulatory requirements. For example, in some jurisdictions, polyvinyl chloride, or plasticizers or phthalates incorporated into a polymer, are believed to be carcinogenic, and therefore the use of such materials in embodiments intended for use with a medical device may be restricted.

30

[0055] Shell **32** of the gas release cell can be formed in any suitable manner, for example extrusion, injection molding, compression molding, or the like. In some embodiments, shell **32** of the gas release cell is formed by injection molding. In
5 some embodiments, shell **32** of the gas release cell could be formed by additive manufacturing processes such as 3D-printing.

[0056] The thickness of shell **32** can be selected based on the volume and intended use of the gas release cell (for example, considering the desired shelf-life of gas cell
10 **30**, and/or the anticipated pressures and temperatures to which gas cell **30** is expected to be subjected, and/or the amount of propellant to be contained within gas cell **30** to exert a desired retraction force or the like). In some embodiments intended for use in a pneumatically-actuated retractable-needle syringe having a volume of 3 cc in which gas release cell **30** has a volume in the range of 50 mm³ to 175 mm³, or any
15 value therebetween, e.g. 75, 100, 125 or 150 mm³, shell **32** has a thickness in the range of 0.30 to 0.70 mm, or any value therebetween, e.g. 0.40, 0.50 or 0.60 mm. In one example embodiment intended for use with a pneumatically-actuated retractable-needle syringe having a volume of 3 cc, the gas release cell has an overall diameter of approximately 7.5 mm. The dimensions provided herein are exemplary
20 only, and are not intended to be limiting.

[0057] The materials selected to manufacture sealing membrane **34** and shell **32** should be selected so that membrane **34** can be sealingly secured to shell **32** to provide sealed cavity **48**. In some embodiments, the sealing membrane **34** is made,
25 in whole or in part, from the same material as shell **32**. In some embodiments, sealing membrane **34** is made from a different material than shell **32**, but the different material is selected so that it can still be securely adhered to shell **32**.

[0058] In some embodiments, sealing membrane **34** is made from any suitable
30 polymer, homopolymer or co-polymer, or multiple layers thereof, for example, polypropylene, polyethylene, high density polyethylene (HDPE), polyethylene

terephthalate, polystyrene, acrylic, polyvinyl chloride, polyester, a polyamide such as nylon, or the like. In some embodiments, sealing membrane **34** is made in any suitable manner, for example by extrusion or co-extrusion. In some embodiments, sealing membrane **34** is any suitable multi-layer film. In some embodiments, sealing membrane **34** is made from a laminated polymer-foil using a polymer, homopolymer or co-polymer, or multiple layers thereof, laminated with a metal foil. In some embodiments, the metal foil is aluminum foil. In some embodiments, sealing membrane **34** is made from any suitable laminate comprising a polymer, homopolymer or co-polymer. In some embodiments, sealing membrane **34** may be sprayed with a micro-thin polymer coating (for example, polyester or nylon), to provide desired properties to sealing membrane **34**. For example, in some embodiments, the metal foil is sprayed with a polyester or other suitable polymer coating to enhance the abrasion resistance of the metal foil.

[0059] In some embodiments, use of a multilayer film for sealing membrane **34** enables the use of a thinner membrane than would be used if sealing membrane **34** comprised only a single layer of film. Without being bound by theory, use of a multilayer film can increase the tensile strength of the sealing membrane, which may increase the resistance of the sealing membrane to rupturing, for example due to forces applied by compressed gas contained within the gas release cell. In some embodiments, at least one layer of the multilayer film is selected for its ability to act as a migration barrier, i.e. as a barrier to the passage of moisture, gas and/or compressed propellant through the membrane, which may enhance retention of compressed propellant in the gas release cell (e.g. to extend the shelf life of the gas release cell).

[0060] In some embodiments, sealing membrane **34** is made from a laminated polymer-foil using a polymer, homopolymer or co-polymer, or multiple layers thereof, and shell **32** is made from the same polymer, homopolymer or co-polymer as is used in sealing membrane **34**.

[0061] The thickness of sealing membrane **34** should be selected to be suitable for a given application, for example, to be sufficiently thick to allow propellant **46** to be captured and contained within the gas release cell during manufacture and storage, but sufficiently thin to permit sealing membrane **34** to be ruptured to release propellant **46** when in use. In some embodiments intended for use in a pneumatically-actuated retractable-needle syringe wherein the gas release cell has a volume in the range of about 50 mm³ to 175 mm³, including any value therebetween, e.g. 75, 100, 125 or 150 mm³, the thickness of sealing membrane is in the range of 0.05 mm to 0.15 mm, including any value therebetween, e.g. 0.06, 0.07, 0.08, 0.09, 0.10, 0.11, 0.12, 0.13 or 0.14 mm.

[0062] In some embodiments, sealing membrane **34** is adhered to shell **32** after propellant **46** has been placed in the cavity defined inside shell **32** to form sealed cavity **48**. In some embodiments, propellant **46** is placed in the cavity defined inside shell **32** in a liquid state, and sealed cavity **48** is formed by placing sealing membrane **34** over shell **32** containing liquid propellant **46** and adhering sealing membrane **34** to shell **32**.

[0063] Sealing membrane **34** can be adhered to shell **32** in any suitable manner, for example through the use of suitable adhesives, including adhesives activated by ultraviolet (UV) or other light sources, by solvent welding, or through a thermal or heat sealing process such as direct contact or impulse sealing, ultrasonic welding, laser welding, radiofrequency (RF) welding (also called dielectrical sealing or high frequency welding), or one or more methods of heat sealing or adhesives in combination with mechanical sealing, or the like. In some embodiments, sealing membrane **34** is adhered to shell **32** using ultrasonic welding. In some embodiments, a method of heat sealing is used in combination with mechanical force to adhere sealing membrane **34** to shell **32**. In some embodiments, adhesives in combination with mechanical force are used to adhere sealing membrane **34** to shell **32**.

[0064] The propellant **46** used in the gas release cell should be selected to have properties suited to the range of conditions and uses to which the gas release cell will be exposed. Characteristics used to select a suitable propellant **46** may include one or more of: the ability of the propellant to voluminously expand when the sealing
5 membrane of the gas release cell is punctured, low toxicity, biocompatibility, and the like. In one embodiment, propellant **46** is selected so as to be compressible to a liquid state, and to remain in a liquid state, within the gas release cell under an expected range of operating and storage conditions (e.g. -5°C to 50°C or any value therebetween, e.g. 0, 5, 10, 15, 20, 25, 30, 35, 40 or 45 °C, and standard atmospheric
10 pressure, e.g. approximately 760 mm Hg absolute pressure prevailing in the environment outside the gas release cell, although standard atmospheric pressure can vary with weather and elevation, and might reasonably be expected to range between 730 mm Hg to 790 mm Hg or any value therebetween, e.g. 740, 750, 760, 770 or 780 mm Hg under normal conditions). Propellant **46** expands into a gaseous state,
15 thereby producing a pneumatic force when the gas release cell is ruptured. An example of a propellant **46** that is used in some embodiments of a gas release cell is a pharmaceutical-grade hydrofluorocarbon such as 1,1,1,2-tetrafluoroethane. In some other embodiments, medical grade nitrogen may be used to provide propellant **46**. In some embodiments, carbon dioxide (CO₂) may be used to provide propellant **46**.

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[0065] In one example embodiment intended for use in a pneumatically-activated retractable-needle syringe, the gas release cell has a volume of approximately 125 mm³, and holds approximately 0.1 mL (approximately 0.1 g) of propellant.

25 [0066] With reference to Figure 3, in one embodiment of a pneumatically-activated retractable-needle syringe incorporating an example embodiment of a gas release cell, a hypodermic needle **122** may be coupled to a syringe **124** for use in administration of a medicament to a patient using a plunger **128**. As shown in Figure 4, syringe **124**
has a barrel **126**, a plunger **128** slidingly and sealingly engageable within the barrel
30 **126**, and a retractable needle **122**. The overall assembly of syringe **124**, plunger **128** and needle **122** provides a syringe assembly **121**.

[0067] A medicament chamber **130** is defined between retractable needle **122**, the distal end of plunger **128** and an interior surface **144** of syringe barrel **126** for containing the medicament to be administered to the subject. Medicament chamber **130** is in fluid communication with needle **122** when syringe assembly **121** is in the assembled configuration, and plunger **128** is sealingly and slideably engaged within barrel **126** to move fluid within medicament chamber **130** through needle **122**.

[0068] A gas release cell **134** is provided within barrel **126** within a gas release chamber **136**, and a rupturing mechanism **138** for rupturing gas release cell **134** upon application of a post-injection force by a user is provided. In some embodiments, rupturing mechanism **138** is provided within gas release chamber **136**.

[0069] In some embodiments of the present invention, including the illustrated embodiment, the plunger may be locked at or near the distal-most point of its travel and the needle is received within the plunger. With reference to Figure 4, to facilitate needle retraction in this manner, plunger **128** includes a retraction lumen **129** therewithin for receiving needle **122** when needle **122** is retracted and a needle port seal **131** at a distal end of plunger **128** for assisting in the retraction of needle **122** by engaging with a needle header **132** in the manner described below.

[0070] Syringe **124** preferably includes a flange **125** formed therewith or attached thereto to facilitate grasping and usage of syringe assembly **121** by a user. Flange **125** may be provided at or near the proximal end of syringe **124**. Flange **125** may be any suitable shape, for example a generally circular extension projecting radially outwardly from the barrel of syringe **124** or a pair of opposed projecting tabs serving as finger grips to facilitate manipulation of syringe **124** relative to plunger **128** by a user.

[0071] In some embodiments, including the illustrated embodiment, syringe **124** includes an internal radial wall **127** therein (Figure 4). Internal radial wall **127** is

provided towards the distal end of syringe **124** to stop movement of plunger **128** after injection of medicament into a subject in the manner described below.

[0072] Needle **122** projects from the distal end of syringe **124** and the hollow interior of needle **122** is in fluid communication with medicament chamber **130**. Needle **122** is securely but releasably retained by a needle header **132** so that needle **122** is securely retained in place when syringe assembly **121** is in normal use, i.e. during loading of medicament into medicament chamber **130** and during injection of medicament into a subject. Needle **122** is releasable (via release of needle header **132** as described below) in response to force applied by the rupture of gas release cell **134** so that needle **122** can be retracted into the body of syringe **124** upon the application of a post-injection force by a user, as described below.

[0073] In some embodiments, a needle cover **150** is provided to cover needle **122** prior to use. Needle cover **150** may be laminated, cemented or otherwise affixed to the distal portion of syringe barrel **126** to secure it in place prior to use. Needle cover **150** can be twisted off or otherwise removed in any suitable manner to expose needle **122** for use. In some embodiments, needle cover **150** includes radially extending tabs **155** or other surface features to facilitate removal of needle cover **150**.

[0074] In the illustrated embodiment, needle **122** is releasably retained in its initial position via needle header **132**, as described below. Needle header **132** is provided at or near the proximal end of needle **122**. Needle header **132** may be formed integrally with or separately from needle **122**. In some embodiments, needle **122** may be crimped in, cemented to, or otherwise securely fixed to needle header **132**. Needle header **132** securely retains needle **122** in place against the distally applied injection force of medicament being injected into a patient or against a proximal loading force when medicament is drawn into medicament chamber **130**, but is releasable in the proximal direction in response to pressure produced by the release of a propellant from a gas release cell **134** as described below.

- [0075] In the illustrated embodiment, needle header **132** engages with needle port seal **131** (provided in the distal tip of plunger **128** as described below) on or shortly before the application of a post-injection force by a user. Needle header **132** and/or needle port seal **131** provide a distal bearing surface for the application of proximally directed force created by gas pressure upon rupture of gas release cell **134**. Needle port seal **131**, alone or in combination with needle header **132**, acts as a needle carrier to pull needle **122** into retraction lumen **129** through the force applied by compressed propellant released from gas release cell **134**.
- [0076] Needle **122** is hollow and has a downstream tip **152** for injection of medicament into a subject and an upstream intake opening **154** (Figure 5) for receiving medicament from medicament chamber **130**. In some embodiments, a needle membrane **156** (Figure 5) is provided to cover the distal end of syringe **124**. In some embodiments, needle membrane **156** more tightly seals gas release chamber **136** by sealingly engaging against needle **122**. In some embodiments, needle membrane **156** is secured to the base **182** of perforator assembly **180** in any suitable manner, for example by suitable adhesives. In some embodiments, needle membrane **156** may assist in retaining needle **122** within syringe **124** once needle **122** has been retracted by providing a barrier to needle re-emergence. In some embodiments, needle membrane **156** may help to prevent any medicament from dripping off the end of needle **122** and into the surrounding environment after use.
- [0077] Needle membrane **156** may be made of a soft, flexible material. In some embodiments, needle membrane **156** is made from silicon or rubber. In some embodiments, needle membrane **156** is made from a soft surgical-grade rubber or silicon such that, when needle **122** is retracted, needle membrane **156** tends to flow into itself and seal the hole left by needle **122**. In some embodiments, needle membrane **156** is formed with a small, slightly conical hole that has a taper of approximately 30° relative to the longitudinal axis of syringe **124** positioned just at the point where needle **122** passes through needle membrane **156**.

[0078] With particular reference to Figure 4, a gas release cell **134** is contained within syringe barrel **126** distally of needle header **132**, within gas release chamber **136**. In the illustrated embodiment, gas release chamber **136** is defined between the distal tip of syringe barrel **126** and needle header **132**. Depending on the configuration of the components of syringe assembly **121**, the gas release chamber **136** could be defined between other components of the assembly. For example, in embodiments in which perforator assembly **180** described below is sealingly engaged by perforator mount **186** (Figure 6) at the distal end of syringe barrel **126**, gas release chamber **136** may be defined between the interior surfaces of the distal portion of syringe barrel **126**, the needle header **132**, and the base **182** of perforator assembly **180**.

[0079] Gas release cell **134** has a shell **146** and a sealing membrane **148**. Gas release cell **134** is oriented within gas release chamber **136** so that sealing membrane **148** faces towards puncture lances **138**. In the illustrated embodiment, the elongate central neck **184** of perforator assembly **180** (described below) has a generally cylindrical shape, and is received within a central aperture **149** (Figure 5) of gas release cell **134**. In the illustrated embodiment, a plurality of axially-extending interior channels **151** are provided on the inside surface of gas release cell **134**, to assist in preventing formation of an airtight seal between the central aperture **149** of gas release cell **134** and the cylindrical elongate central neck **184** of perforator assembly **180**. In some embodiments, interior channels **151** are omitted. For example, in some embodiments, the tolerance between the inside surface of shell **146** and the elongate central neck **184** of perforator assembly **180** is sufficient to prevent the formation of an airtight seal between central aperture **149** of gas release cell **134** and elongate central neck **184**.

[0080] Needle membrane **156** optionally assists in the sealing of gas release chamber **136** to prevent the escape of compressed propellant when gas release cell **134** is ruptured. In some embodiments, the sealing between the components that define gas release chamber **136** is sufficiently tight to generally seal gas release chamber **136** and

facilitate retraction of needle **122** without the need for additional sealing components such as needle membrane **156**.

5 [0081] In the illustrated embodiment, needle header **132** is retained in place against the distal force applied by a user during the injection phase (an "injection force") by an engagement ring **160**. Engagement ring **160** has a central opening **162** (Figure 5) through which needle **122** passes. In some embodiments, central opening **162** is cylindrically shaped. Engagement ring **160** is frictionally but slidably engaged with the interior surface **144** of syringe barrel **126**. Engagement ring **160** is axially
10 slidable within barrel **126** in response to the application of a post-injection force, but is retained in place within barrel **126** during the application of an injection force. Engagement ring **160** is also retained in place within barrel **126** during the application of a force in the proximal direction required to load medicament into medicament chamber **130** (i.e. a loading force).

15 [0082] In some embodiments, engagement ring **160** is frictionally secured in syringe barrel **126**. Engagement ring **160** could be secured in place in any suitable manner that is sufficiently strong to retain engagement ring **160** in place during the application of an injection or loading force, but releasable in response to the
20 application of a post-injection force. For example, engagement ring **160** could be held in place by breakable tabs or weakly secured with an adhesive. In the illustrated embodiment, engagement ring **160** assists in puncturing gas release cell **134** in response to the application of a post-injection force, as described below.

25 [0083] Engagement ring **160** allows needle header **132** (and thus needle **122**) to move proximally into syringe **124** (within retraction lumen **129**) when gas release cell **134** is ruptured. Needle header **132** is also secured with engagement ring **160** in a manner that is sufficiently strong to ensure that needle header **132** does not separate from engagement ring **160** until after the rupture of gas release cell **134**. For example,
30 some loading force may be exerted against needle header **132** in the proximal direction when medicament is being loaded into syringe **124**, and an injection force

will be applied against needle header **132** in the distal direction when the medicament is injected. The engagement between needle header **132** and engagement ring **160** should be sufficiently strong so as not to separate during the application of a loading force in the proximal direction, but sufficiently weak that needle header **132** can
5 separate from engagement ring **160** when gas release cell **134** is ruptured. Needle header **132** can be secured to engagement ring **160** in any suitable manner that provides such a releasable engagement, such as by sufficiently strong friction fit, sufficiently weak adhesive to allow release when gas release cell **134** is ruptured, easily frangible connectors, easily releasable connectors, or the like. In the
10 illustrated embodiment, needle header **132** is secured within engagement ring **160** by a compression fit. In some embodiments, needle header **132** is sized to be of sufficiently large diameter that needle header **132** cannot physically pass through engagement ring **160** in the distal direction.

15 **[0084]** In some embodiments, plunger **128** and syringe barrel **126** include a plunger locking feature to retain plunger **128** in a position at or near the distal limit of travel of plunger **128**. In the illustrated embodiment, the plunger locking feature is provided by a plunger verge **166** and syringe barrel lock **168** (Figure 4) which are positioned and configured to allow one-way sliding motion therebetween.

20 **[0085]** Plunger verge **166** is a radially outwardly extending circumferential protrusion on the outside surface of plunger **128**. Syringe barrel lock **168** is a radially inwardly extending circumferential protrusion on the inside surface of syringe barrel **126**. Both plunger verge **166** and syringe barrel lock **168** are sized so as not to interfere
25 with the axial sliding motion between plunger **128** and syringe **124**. However, plunger verge **166** and syringe barrel lock **168** are dimensioned and positioned so that after plunger verge **166** has been slid distally past syringe barrel lock **168**, plunger verge **166** cannot thereafter be slid in a proximal direction past syringe barrel lock **168**. This configuration essentially locks plunger **128** in a position at or near its
30 distal-most point of travel, making it very difficult to separate plunger **128** from

syringe **124** after use. This ensures needle **122** remains securely within retraction lumen **129** after use of syringe **124**.

[0086] To achieve a one-way sliding motion, the distal surface of plunger verge **166** and/or the proximal surface of syringe barrel lock **168** may be angled or otherwise shaped so that plunger verge **166** may be readily slid past syringe barrel lock **168** in the distal direction. That is, plunger verge **166** may have an inclined surface progressively increasing in diameter from its distal-most portion and/or syringe barrel lock **168** may have an inclined surface progressively increasing in diameter from its proximal-most portion. This configuration allows plunger verge **166** to be easily slid past syringe barrel lock **168** in the distal direction. In some embodiments, the proximal surface of plunger verge **166** and the distal surface of syringe barrel lock **168** is flat, i.e. parallel or nearly parallel to a notional radial cross-section of syringe barrel **126**, so that plunger verge **166** cannot readily be slid past syringe barrel lock **168** in the proximal direction.

[0087] In some embodiments, plunger **128** includes an opening **170** at its proximal end (Figure 4). Opening **170** receives a removable plunger plug **172** in sealing engagement therein, so that needle **122** can be retained in retraction lumen **129** when needle **122** has been retracted. Plunger plug **172** may facilitate assembly of syringe assembly **121**. In some embodiments, after assembly of syringe assembly **121**, plunger plug **172** is permanently secured in place, e.g. with a suitable adhesive. In some embodiments, opening **170** is not provided and plunger plug **172** is not used.

[0088] In some embodiments, plunger **128** includes an orifice such as vent hole **174** therein (Figure 3), for example on the proximal or side surface of plunger **128** or through the top of plunger **128**. In some embodiments, vent hole **174** may allow release of air from retraction lumen **129** upstream of needle header **132** and needle port seal **131** when needle **122** is retracted. Vent hole **174** should be positioned proximally at or close to the upstream limit of travel of needle port seal **131**, to avoid a loss of pressure that could stop the upstream travel of needle **122** before it has been

fully retracted as could occur if, for example, vent hole **174** is positioned too far distally of the upstream limit of travel of needle port seal **131**. In some embodiments, a vent hole may be provided in plunger plug **172** instead of through plunger **128**.

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[0089] In some embodiments, the fit between plunger plug **172** and opening **170** is sufficiently tight to retain plunger plug **172** within opening **170**, but is not airtight, so that air can be released upstream of needle header **132** when needle **122** is retracted.

10 [0090] In some embodiments, plunger **128** includes a plunger end flange **176** to provide a bearing surface for the fingers of a user, e.g. to facilitate withdrawal of plunger **128** from syringe barrel **126** to draw liquid into medicament chamber **130** and/or administration of medicament using syringe assembly **121**.

15 [0091] In some embodiments, gas release cell **134** is initially secured within gas release chamber **136** in any suitable manner to minimize the risk that sealing membrane **148** may be prematurely ruptured by rupturing mechanism **138**. For example, the outer surface of shell **146** of gas release cell **134** may be frictionally engaged with the inner surface **144** of syringe barrel **126**, or with perforator neck **184**
20 (described below), or gas release cell **134** may be initially affixed to engagement ring **160**, or perforator neck **184** in any suitable manner, such as by adhesives. In embodiments including the illustrated embodiment in which movement of gas release cell **134** is required to rupture gas release cell **134** upon application of a post-injection force, the adhesives used should be sufficiently weak to allow gas release cell **134** to
25 move upon application of a post-injection force, but sufficiently strong to retain gas release cell **134** in position during application of a loading force or an injection force.

[0092] In some embodiments, gas release cell **134** is not specifically secured within gas release chamber **136** in any manner (i.e. gas release cell **134** is free floating), and
30 the material that sealing membrane **148** is made from is sufficiently strong that mere contact with rupturing mechanism **138** (e.g. as might occur during shipping or loading

of syringe assembly **121**) in the absence of force applied by a user as a post-injection force is not sufficient to rupture gas release cell **134**.

[0093] The pressure and volume of propellant in gas release cell **134** should be
5 sufficient to ensure that needle **122** is fully retracted within retraction lumen **129**
when gas release cell **134** is ruptured. Gas release cells intended for use with a
larger volume of syringe may have a larger volume (and thus contain more
compressed propellant) than gas release cells intended for use with a smaller volume
of syringe. The appropriate pressure and volume of propellant to be included in gas
10 release cell **134** can be determined by one skilled in the art based on the propellant to
be used and the anticipated range of temperatures at which syringe assembly **121** will
be used.

[0094] A mechanism for rupturing sealing membrane **148** of gas release cell **134** in
15 response to a post-injection force is provided within gas release chamber **136**. In the
illustrated embodiment, a gas release trigger in the form of one or more puncture
lances **138** is provided. Puncture lances **138** are secured within syringe barrel **126** in
any suitable manner. In the illustrated embodiment, puncture lances **138** are secured
to a perforator mount **180** secured at a distal portion of syringe barrel **126**. In
20 alternative embodiments, puncture lances **138** are secured directly to the distal end of
syringe barrel **126**.

[0095] Puncture lances **138** could alternatively be mounted to appropriate portions of
engagement ring **160**, or to the distal end of plunger **128** (with corresponding holes
25 provided through engagement ring **160** to receive the puncture lances), or integrally
formed with such components, such that puncture lances **138** are positioned and
disposed to be operable to puncture gas release cell **134** in response to application of a
post-injection force, as described below. In such embodiments, the orientation of
gas release cell **134** would be reversed by 180°, so that sealing membrane **148** is
30 oriented towards puncture lances **138** to facilitate rupture upon application of a
post-injection force.

[0096] In the illustrated embodiment, six puncture lances are shown. However, any suitable number of puncture lances could be used, for example, two, three, four or more puncture lances.

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[0097] In the illustrated embodiment, a perforator assembly **180** includes a base **182** on which puncture lances **138** are mounted and an elongate central neck **184**

projecting proximally from the base **182**. Needle **122** extends through central neck **184**. In some embodiments, base **182**, puncture lances **138**, and central neck **184**

10 may be machined as a single piece, or may be separately manufactured and then joined in any suitable manner, for example by adhesives, welding, or the like. Base **182** may be secured to a perforator mount **186** at the distal end of syringe barrel **126**. In some embodiments, the dimensions and materials of base **182** and perforator mount **186** are such that base **182** mates tightly with perforator mount **186**, thereby impeding

15 leakage of gases or other fluids from gas release chamber **136**. Perforator assembly **180** includes a needle aperture **188** (Figure 5). In some embodiments, needle aperture **188** is dimensioned to firmly hold needle **122** during the injection phase. In some embodiments, needle aperture **188** sealingly engages with needle **122**. In some embodiments, needle membrane **156** is secured to cover needle aperture **188**.

20

[0098] In the illustrated embodiment, perforator assembly **180** and engagement ring **160** are axially aligned so that a proximal portion of neck **184** extends within the central opening **162** of engagement ring **160**. The distal edge of neck **184** contacts needle header **132**. Gas release cell **134** extends around neck **184**, as described

25 above.

[0099] In the illustrated embodiment as best seen in Figure 5, needle header **132** has a downstream hollow cylindrical body **190**, a collar **192**, and an upstream hollow end knob **194**. Needle **122** is crimped in, cemented to, or otherwise securely fixed within

30 body **190** of needle header **132**. In the illustrated embodiment, needle header **132** is positioned within central opening **162** of engagement ring **160**. In some

embodiments, needle header **132** is positioned such that knob **194** is approximately flush with the upstream end of engagement ring **160**. Hollow cylindrical body **190** of needle header **132** is inserted into central opening **162** of engagement ring **160** on the proximal side thereof. Needle header **132**, including collar **192**, is inserted
5 within central opening **162** with a fit approaching a snug fit (i.e. a tight fit). Needle header **132** sealingly engages with engagement ring **160** to prevent leakage of medicament or other fluids between needle header **132** and engagement ring **160**.

[0100] In some embodiments, the proximal tip of needle header **132** is positioned
10 above engagement ring **160**, such that hollow end knob **194** projects in the proximal direction from engagement ring **160**. In such embodiments, corresponding adjustments can be made to recess needle port seal **131** slightly further in the proximal direction within plunger **128**. Embodiments wherein needle header **132** is initially positioned within engagement ring **160** as described above may reduce the likelihood
15 that needle header **132** may be accidentally dislodged prior to use, for example due to forces that may be applied in the course of shipping or handling of syringe assembly **121**.

[0101] To facilitate retraction of needle **122**, plunger **128** includes a narrowed distal
20 plunger neck **196** (Figure 6). Narrowed distal plunger neck **196** includes at its distal end a needle port seal **131**. Needle port seal **131** is frictionally and sealingly engaged within the inner surface of distal plunger neck **196** with a snug fit that prevents movement of needle port seal **131** in response to a loading force or an injection force, but that permits movement of needle port seal **131** in the proximal
25 direction within retraction lumen **129** under pressure applied by the rupture of gas release cell **134**. Needle port seal **131** also prevents medicament from entering retraction lumen **129** when syringe assembly **121** is in use.

[0102] In some embodiments, needle port seal **131** is positioned within distal plunger
30 neck **196** so that needle port seal **131** engages with needle header **132** at or just before the end of the application of an injection force by a user, or at the start of the

application of a post-injection force to plunger **128** by a user. In the illustrated embodiment, needle port seal **131** is mounted within distal plunger neck **196** so that the distal end of needle port seal **131** is flush with the distal portion of distal plunger neck **196**. Needle port seal **131** is shaped and configured to engage with needle header **132** without being obstructed by engagement ring **160**. In the illustrated embodiment, needle port seal **131** includes a grasping ledge **135** that extends radially inwardly from the distal end of needle port seal to grasp knob **194** of needle header **132**.

10 **[0103]** The diameter of the outer portion of needle port seal **131** is selected so that needle port seal **131** frictionally engages the inner surface of distal plunger neck **196** and of retraction lumen **129**. In some embodiments, at least the outermost circumferential portion of needle port seal **131** that engages with these surfaces is made from resilient material, so that needle port seal **131** can expand in diameter to fill the full cross-section of retraction lumen **129** during retraction of needle **122**. In the illustrated embodiment, needle port seal **131** includes a sealing portion **133** made from a resilient material that sealingly engages with the walls of retraction lumen **129** to facilitate gas-driven retraction of needle **122**.

20 **[0104]** In some embodiments, retraction lumen **129** is tapered, such that the proximal portion of retraction lumen **129** has a larger diameter than the distal portion of retraction lumen **129**. In such embodiments, the resilient outermost circumferential portion of needle port seal **131** expands as needle port seal **131** moves proximally within retraction lumen **129**, to maintain sealing engagement within retraction lumen **129**.

[0105] To facilitate injection of medicament from medicament chamber **130**, in the illustrated embodiment a hollow deformable plunger seal **198** is provided on plunger **128**. Plunger seal **198** surrounds distal plunger neck **196** with a tight fit.

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[0106] In some embodiments, plunger seal **198** is constrained from axial movement during normal use of syringe assembly **121** by engagement of a radially outwardly extending collar **100** on distal plunger neck **196** with an annular recess **102** formed on the inside surface of plunger seal **198**, or in any other suitable manner. The fit,
5 dimensions and material used for plunger seal **198** are selected so that plunger seal **198** slidingly but sealingly engages the inner wall of barrel **126** with some resistance.

[0107] Internal radial wall **127** defines an opening that is dimensioned so that distal plunger neck **196** can pass therethrough, but so that plunger seal **198** cannot. Thus,
10 movement of plunger seal **198** in the distal direction is stopped when seal **198** abuttingly engages radial wall **127**. Application of a post-injection force thus causes distal plunger neck **196** to move in the distal direction, while plunger seal **198** is forced slidingly in the proximal direction (relative to plunger neck **196**) along distal plunger neck **196**. In the illustrated embodiment, engagement of plunger seal **198**
15 with a radially extending shoulder **104** (Figure 6) formed where the main body **106** of plunger **128** meets distal plunger neck **196** prevents further movement of plunger seal **198** in the proximal direction relative to plunger **128** after the post-injection force has been applied.

[0108] In use, needle cover **150** may be twisted off or otherwise removed in any
20 suitable manner to expose needle **122**. Downstream force is applied by a user to the upstream plunger end flange **125** and/or to plunger plug **172** to eject air out of medicament chamber **130**, if necessary. When nearly all of the air has been forced out of medicament chamber **130**, but before plunger verge **166** engages with syringe
25 barrel lock **168**, the tip **152** of needle **122** can be submerged in liquid medicament contained in a supply vial, which may be of a conventional type.

[0109] Medicament or other liquid for injection is drawn into medicament chamber **130** by withdrawing plunger **128** proximally relative to syringe barrel **126** in the same
30 manner as a conventional syringe. After medicament chamber **130** has been filled with the desired volume of medicament, air may be removed in the conventional

manner by inverting syringe assembly **121** so that needle **122** is pointing upwardly, tapping syringe **124** to displace any air therewithin and allowing the air to float above the medicament, and applying a distally-directed force to the plunger **128** so that residual air is forced out through needle **122**.

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[0110] Needle **122** is positioned at an injection site of a subject in the conventional manner. Medicament can be discharged from chamber **130** by applying a distally-directed force on plunger end flange **176** and/or plunger plug **172** in a conventional manner, thus causing plunger seal **198** to exert a distal biasing pressure on the medicament contained in chamber **130**. The distally-directed biasing pressure is sufficient to force medicament through needle **122**. However, the pressure is not sufficient to overcome the frictional force securing engagement ring **160** to the inner surface of syringe barrel **126**, nor is the corresponding upstream pressure on the tip of plunger **128** sufficient to overcome the frictional force between needle carrier **131** and distal plunger neck **196**.

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[0111] With reference to Figures 7 and 8, after all or substantially all of the medicament has been injected into a subject, a user continues to apply force, now a post-injection force, in the distal direction against plunger **128**. Movement of distal plunger neck **196** in the distal direction past internal radial wall **127** causes distal plunger neck **196** to impinge on engagement ring **160**. Needle port seal **131** is forced onto hollow end knob **194** of needle header **132**, thereby sealing needle header **132** so that no medicament or other fluids may be passed through needle **122**. Engagement of needle port seal **131** with hollow end knob **194** forms needle retraction assembly **108** (shown in dotted outline in the retracted position in Figure 9), which includes needle port seal **131**, needle header **132**, and needle **122**. Further motion of plunger seal **198** in the distal direction is prevented by internal radial wall **127**.

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[0112] Engagement of needle header **132** with central neck **184** of perforator assembly **180** prevents movement of needle retraction assembly **108** in the distal

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direction. Continued application of a post-injection force causes distal plunger neck **196** to move axially past internal radial wall **127** and to impinge on engagement ring **160**. The post-injection force overcomes the frictional engagement between engagement ring **160** and the interior surface of syringe barrel **126**, causing
5 engagement ring **160** to move in the distal direction (Figure 8). Continued motion of engagement ring **160** also forces gas release cell **134** in the distal direction, causing gas release cell **134** to impinge on puncture lances **138**. Gas release cell **134** is ruptured, thereby releasing propellant into gas release chamber **136**.

10 **[0113]** The released propellant remains under pressure within the confines of the gas release chamber **136**, and therefore a proximal force is applied against needle retraction assembly **108**. In embodiments in which the compressed propellant comprises a liquid phase, the propellant will transition to the gas phase when gas release cell **134** is ruptured. The proximal force applied by the released gas is
15 sufficiently strong to overcome the frictional force securing the needle header **132** within the central opening **162** of engagement ring **160**, and also to overcome the frictional force securing needle port seal **131** within distal plunger neck **196**. The proximally-directed biasing pressure causes needle retraction assembly **108** to slide proximally into retraction lumen **129**, thus retracting needle **122** inside retraction
20 lumen **129** (Figure 9). The volume and pressure of propellant in gas release cell **134** should be sufficient to retract the full length of needle **122** inside retraction lumen **129**.

[0114] Suitable materials for the manufacture of syringe assembly **121** may be
25 selected by one skilled in the art. For example, syringe barrel **126** and plunger **128** may be made from a plastic material, such as appropriate polymers, homopolymers or copolymers. Plunger seal **198** may be made from any suitable material, for example elastomers or rubber. In some embodiments, plunger seal **198** may be a
self-lubricating seal. In some embodiments, syringe barrel **126** and/or plunger seal
30 **198** may be treated with a medical grade lubricant. Needle **122** may be made of medical grade needle tubing. The compressed propellant used in gas release cell **134**

may be any suitable propellant, for example a pharmaceutical-grade hydrofluorocarbon such as 1,1,1,2-tetrafluoroethane or medical-grade nitrogen. Suitable materials for manufacture of gas release cell 134 include suitable polymers such as, for example, nylon, polyethylene, polypropylene, polystyrene or the like, or suitable copolymers thereof. Components may be sterilized prior to packaging in any suitable manner, for example with e-beam radiation, γ -radiation, or ethylene oxide (EtO) gas. The materials selected for manufacture of syringe assembly 121 should be compatible with the medicament to be administered to the subject.

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[0005] In some embodiments, syringe 124 is a prefilled syringe, i.e. syringe 124 has been filled with a predetermined quantity of a specified medicament. In use, prefilled syringe 124 does not need to be loaded with medicament, but can simply be used to inject the medicament already contained therein in a subject in the manner

15 described above.

[0006] While the exemplary embodiment of a pneumatically-actuated retractable-needle syringe incorporating gas release cell 134 described above is similar to that described in U.S. Patent No. 7,811,259 to Klippenstein, embodiments of the present invention include gas release cells suitable for use in syringes similar to

20 those described in U.S. Patent No. 5,868,713, or modular gas-actuated retractable-needle assemblies such as those described in Patent Cooperation Treaty application No. PCT/CA2012/050184 filed 26 March 2012.

25 [0007] While a number of exemplary aspects and embodiments have been discussed above, those of skill in the art will recognize certain modifications, permutations, additions and sub-combinations thereof. Without limitation, such modifications may include:

- While inner and outer walls of the shell of the gas release cell have been

30 described as being made of rigid material, in some embodiments the base of the gas release cell need not be made from a rigid material.

- The relative orientation of puncture lances **138** and gas release cell **134** could be reversed, so that puncture lances **138** are provided on the distal side of engagement ring **160**.
- The shape of the gas release cell could be modified based on the desired application. For example, while gas release cell **30** has been described as generally cylindrical in shape, for example to fit within the generally cylindrical barrel of a hypodermic syringe, other shapes are possible. For example, the gas release cell could be provided with a square rather than circular cross-section if it was desired to use the gas release cell within a component having a square-shaped cross-section.

Accordingly, the scope of the claims should not be limited by the preferred embodiments set forth in the description, but should be given the broadest interpretation consistent with the specification as a whole.

WHAT IS CLAIMED IS:

1. A gas release cell for use with a pneumatically-actuated sharps-containing medical device comprising:
 - an inner wall comprising a rigid material, the inner wall defining an aperture through the gas release cell;
 - an outer wall comprising a rigid material extending around the inner wall;
 - a base coupled to the inner and outer walls and in sealing engagement therewith;
 - a rupturable membrane coupled to the inner and outer walls and in sealing engagement therewith, so that the rupturable membrane, inner and outer walls and base define a sealed propellant chamber; and
 - compressed propellant contained within the propellant chamber.
2. A gas release cell as defined in claim 1, wherein the base is integrally formed with the inner and outer walls.
3. A gas release cell as defined in claim 1 or claim 2, wherein the inner wall is cylindrical in shape; wherein the outer wall is cylindrical in shape; or wherein the inner and outer walls are in axial alignment.
4. A gas release cell as defined in any one of claims 1 to 3, wherein the gas release cell is toroidal in shape.
5. A gas release cell as defined in any one of claims 1 to 4, wherein the base is coupled to a first end of the inner and outer walls.
6. A gas release cell as defined in any one of claims 1 to 5, wherein the rupturable membrane is coupled to a second end of the inner and outer walls.

7. A gas release cell as defined in any one of claims 1 to 6, wherein a surface of the inner or outer walls that is coupled to the rupturable membrane comprises a curved radius.
8. A gas release cell as defined in any one of claims 1 to 6, wherein a surface of the inner or outer walls that is coupled to the rupturable membrane comprises a flat surface.
9. A gas release cell as defined in any one of claims 1 to 8, comprising surface features for preventing formation of a seal between the gas release cell and one or more adjacent components of a medical device in which the gas release cell is used.
10. A gas release cell as defined in claim 9, wherein the gas release cell comprises axially-extending ribs formed on the interior circumference or on the exterior circumference of the gas release cell.
11. A gas release cell as defined in any one of claims 9 or 10, wherein the gas release cell comprises axially-extending channels formed on the interior circumference or on the exterior circumference of the gas release cell.
12. A gas release cell as defined in any one of claims 9 to 11, wherein the inner wall or the outer wall is provided with a cross-sectional shape that provides a gas passage between the gas release cell and one or more components of a medical device in which the gas release cell is used.
13. A gas release cell as defined in claim 12, wherein the cross-sectional shape comprises asymmetrical, pear-shaped, oval, triangular, square, pentagonal, hexagonal or other polygonal shape.

14. A gas release cell as defined in any one of claims 12 or 13, wherein the one or more components of the gas release cell comprise a generally cylindrical shape.
15. A gas release cell as defined in any one of claims 1 to 14, wherein the inner and outer walls comprise a polymer, homopolymer or co-polymer.
16. A gas release cell as defined in claim 15, wherein the base comprises the polymer, homopolymer or co-polymer.
17. A gas release cell as defined in any one of claims 15 or 16, wherein the polymer, homopolymer or co-polymer comprises polypropylene, polyethylene, high density polyethylene, polyethylene terephthalate, polystyrene, polycarbonate, acrylic, polyvinyl chloride, polyester, or a polyamide.
18. A gas release cell as defined in claim 17, wherein the polyamide comprises nylon.
19. A gas release cell as defined in any one of claims 15 to 18, wherein the inner and outer walls comprise a multi-layer film.
20. A gas release cell as defined in claim 19, wherein the base comprises the multi-layer film.
21. A gas release cell as defined in any one of claims 19 or 20, wherein the multi-layer film comprises a laminate.
22. A gas release cell as defined in claim 21, wherein the laminate comprises the polymer, homopolymer or co-polymer, or multiple layers thereof, and a metal foil.
23. A gas release cell as defined in claim 22, wherein the metal foil comprises aluminum foil.

24. A gas release cell as defined in any one of claims 1 to 23, wherein the inner and outer walls and the base are integrally formed by extrusion, injection molding or compression molding.
25. A gas release cell as defined in any one of claims 1 to 24, wherein the rupturable membrane comprises a polymer, homopolymer or co-polymer.
26. A gas release cell as defined in claim 25 wherein the polymer, homopolymer or co-polymer comprises polypropylene, polyethylene, high density polyethylene, polyethylene terephthalate, polystyrene, acrylic, polyvinyl chloride, polyester or a polyamide.
27. A gas release cell as defined in claim 26 wherein the polyamide comprises nylon.
28. A gas release cell as defined in any one of claims 25 to 27, wherein the rupturable membrane comprises a multi-layer film.
29. A gas release cell as defined in claim 28 wherein the multi-layer film comprises a laminate.
30. A gas release cell as defined in claim 29 wherein the laminate comprises the polymer, homopolymer or co-polymer, or multiple layers thereof, and a metal foil.
31. A gas release cell as defined in claim 30 wherein the metal foil comprises aluminum foil.
32. A gas release cell as defined in any one of claims 25 to 31, wherein the inner and outer walls and the base comprise the same polymer, homopolymer or co-polymer as the rupturable membrane.

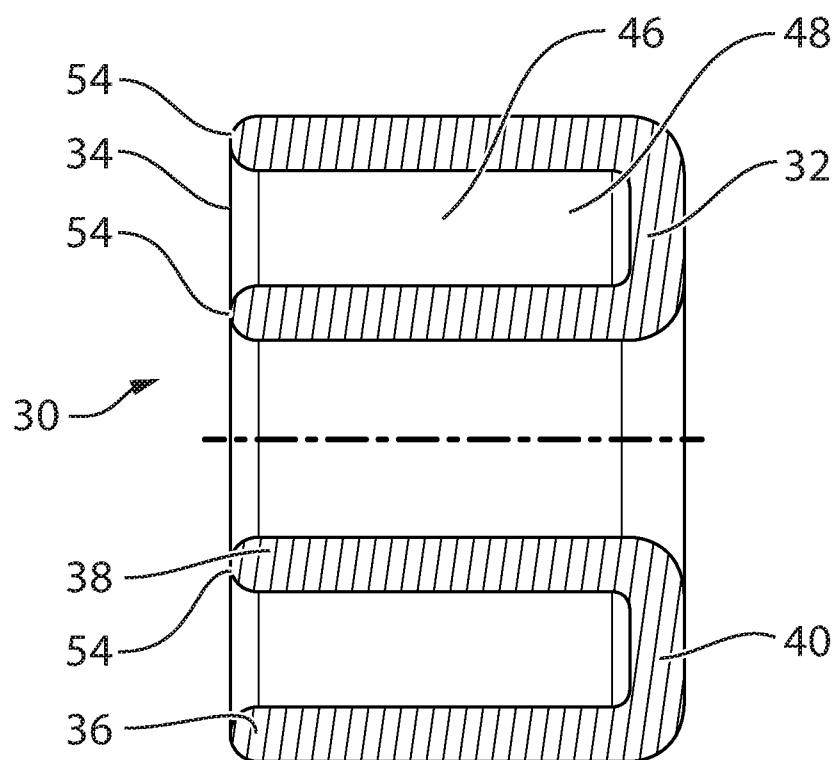
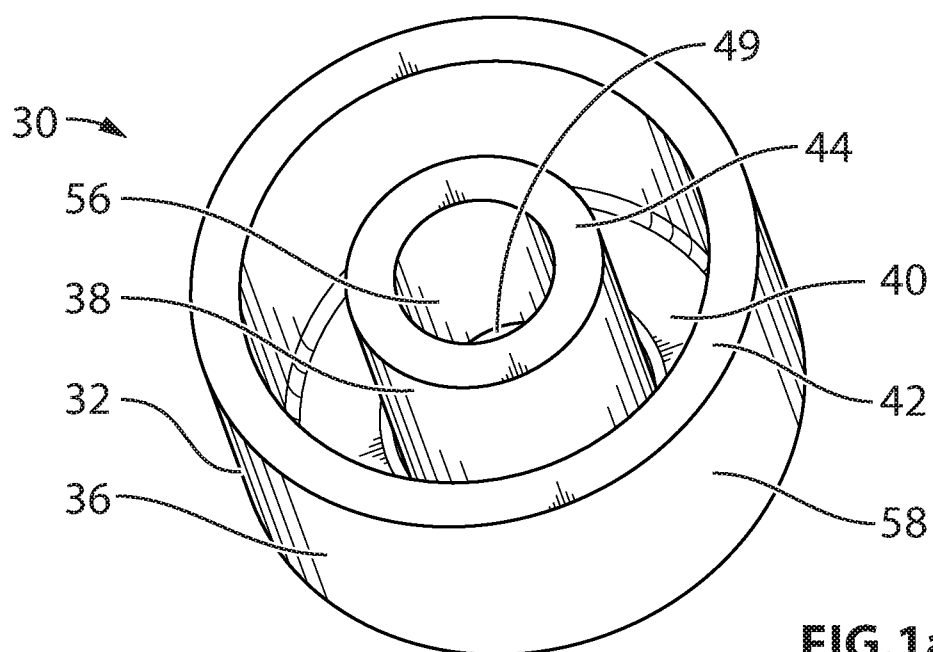
33. A gas release cell as defined in any one of claims 1 to 32, wherein the rupturable membrane is coupled to the inner and outer walls by suitable adhesives, by solvent welding, or by a thermal sealing process.
34. A gas release cell as defined in claim 33 wherein mechanical force is used in combination with the heat sealing or with the adhesives to couple the rupturable membrane to the inner and outer walls.
35. A gas release cell as defined in any one of claims 33 to 34, wherein the thermal sealing process comprises impulse sealing, direct contact sealing, ultrasonic welding, laser welding, or radiofrequency welding.
36. A gas release cell as defined in any one of claims 1 to 35, wherein the propellant is contained within the propellant chamber in liquid form.
37. A gas release cell as defined in any one of claims 1 to 36, wherein the propellant comprises a pharmaceutical-grade hydrofluorocarbon.
38. A gas release cell as defined in any one of claims 1 to 37, wherein the propellant comprises 1,1,1,2-tetrafluoroethane.
39. A gas release cell as defined in any one of claims 1 to 37, wherein the propellant comprises medical grade nitrogen or carbon dioxide.
40. A gas release cell as defined in any one of claims 1 to 39, wherein the rupturable membrane comprises the same material as the inner and outer walls and the base.
41. A gas release cell as defined in any one of claims 1 to 40, for use in a pneumatically-actuated retractable-needle syringe.

42. A pneumatically-activated retractable sharps-containing medical device comprising a gas release cell as defined in any one of claims 1 to 40.
43. A pneumatically-activated retractable sharps-containing medical device as defined in claim 42 wherein the medical device comprises a hypodermic-needle syringe, a blood collection syringe system, an intravenous syringe system, a pneumatically-actuated retractable scalpel, a radiological syringe, or a spinal syringe system.
44. A pneumatically-activated retractable sharps-containing medical device as defined in any one of claims 42 or 43, wherein the pneumatically-activated retractable sharps-containing medical device is intended for veterinary or dental use.
45. A syringe having a pneumatically-activated retractable-needle, the syringe comprising:
- a syringe barrel;
 - a needle disposed at a distal end of the syringe barrel, the needle having a needle header for holding the needle in place within the syringe barrel;
 - a plunger slideable within the syringe barrel for injecting medicament and having a retraction lumen for receiving the needle when the needle is retracted;
 - a needle carrier sealingly engaged within a distal end of the plunger, the needle carrier having a distal bearing surface against which gas under pressure may bear and being initially retained in a fixed position relative to the plunger, the needle carrier being slideable within the retraction lumen in response to force applied by gas under pressure;
 - a gas release cell as defined in any one of claims 1 to 41 located within the syringe barrel distally of the needle carrier; and
 - gas release trigger means located within the syringe barrel distally of the needle carrier for rupturing the rupturable membrane of the gas release cell in response to the application of a post-injection force to the plunger by a user

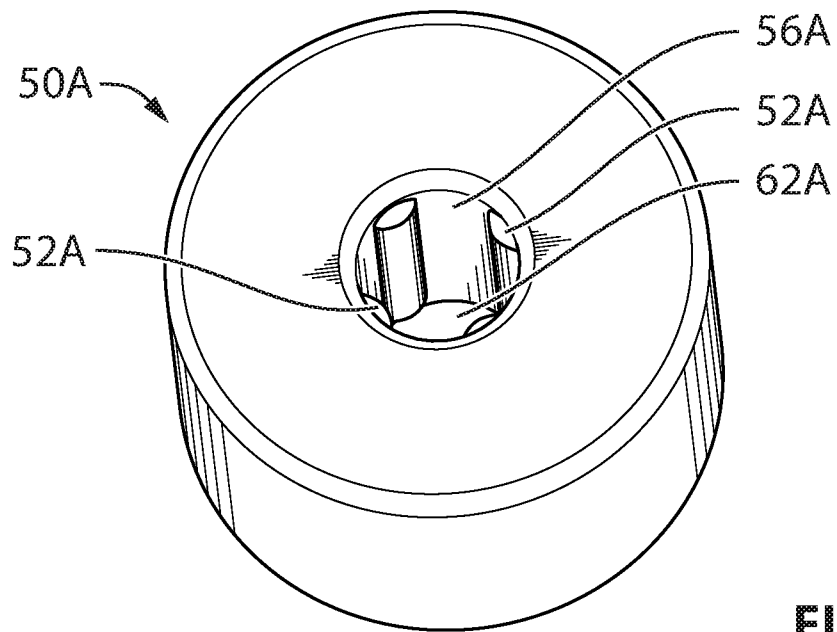
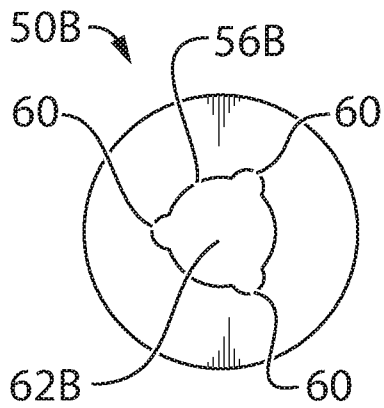
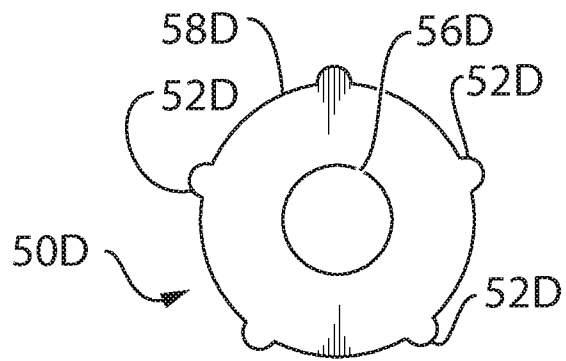
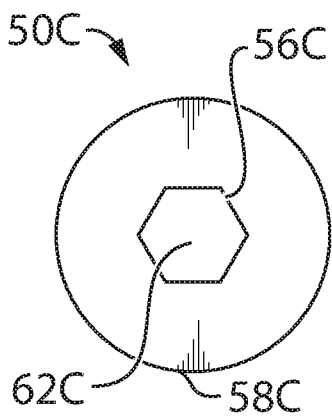
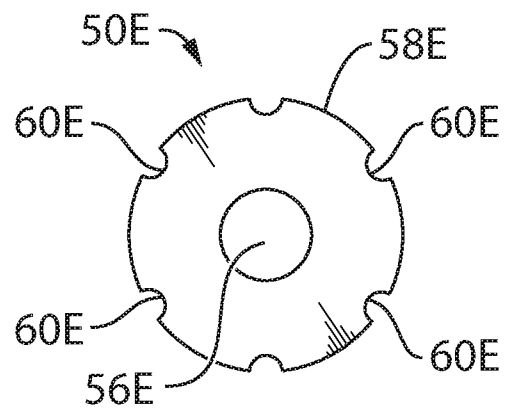
to release compressed gas in a gas release chamber confined by the syringe barrel and the needle carrier,
wherein the needle carrier is engageable with the needle header to retract the needle into the plunger lumen under force applied by released gas when the gas release cell is ruptured.

46. A pneumatically-activated retractable sharps-containing medical device comprising:
a gas release cell having a rigid outer wall extending around a rigid inner wall defining an aperture through the gas release cell, the rigid inner wall being coupled to the rigid outer wall by a base at a first end of the gas release cell, and a sealing membrane being sealingly engaged with the rigid outer wall and the rigid inner wall at a second end of the gas release cell to contain a compressed propellant therein.
47. A pneumatically-activated retractable sharps-containing medical device as defined in claim 46 wherein the medical device comprises a hypodermic-needle syringe, a blood collection syringe system, an intravenous syringe system, a pneumatically-actuated retractable scalpel, a radiological syringe, or a spinal syringe system, or wherein the pneumatically-activated retractable sharps-containing medical device is intended for veterinary or dental use.
48. A syringe or medical device as defined in any one of claims 42 to 47, wherein one or more components of the syringe or medical device adjacent the gas release cell comprises surface features to prevent formation of an airtight seal between the one or more components of the syringe or medical device and the gas release cell.

1/10



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**FIG. 2A****FIG. 2B****FIG. 2D****FIG. 2C****FIG. 2E**

3/10

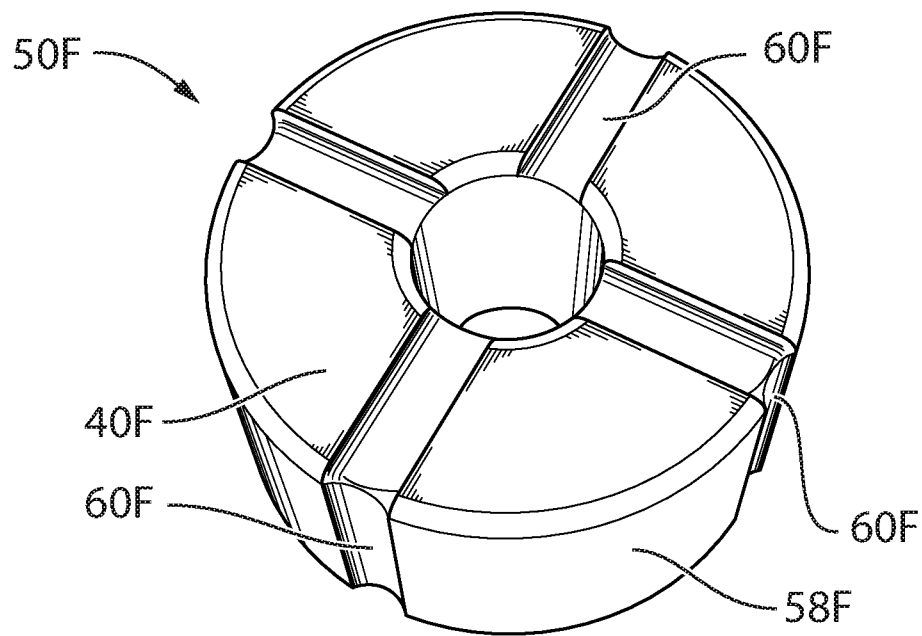


FIG. 2F

4/10

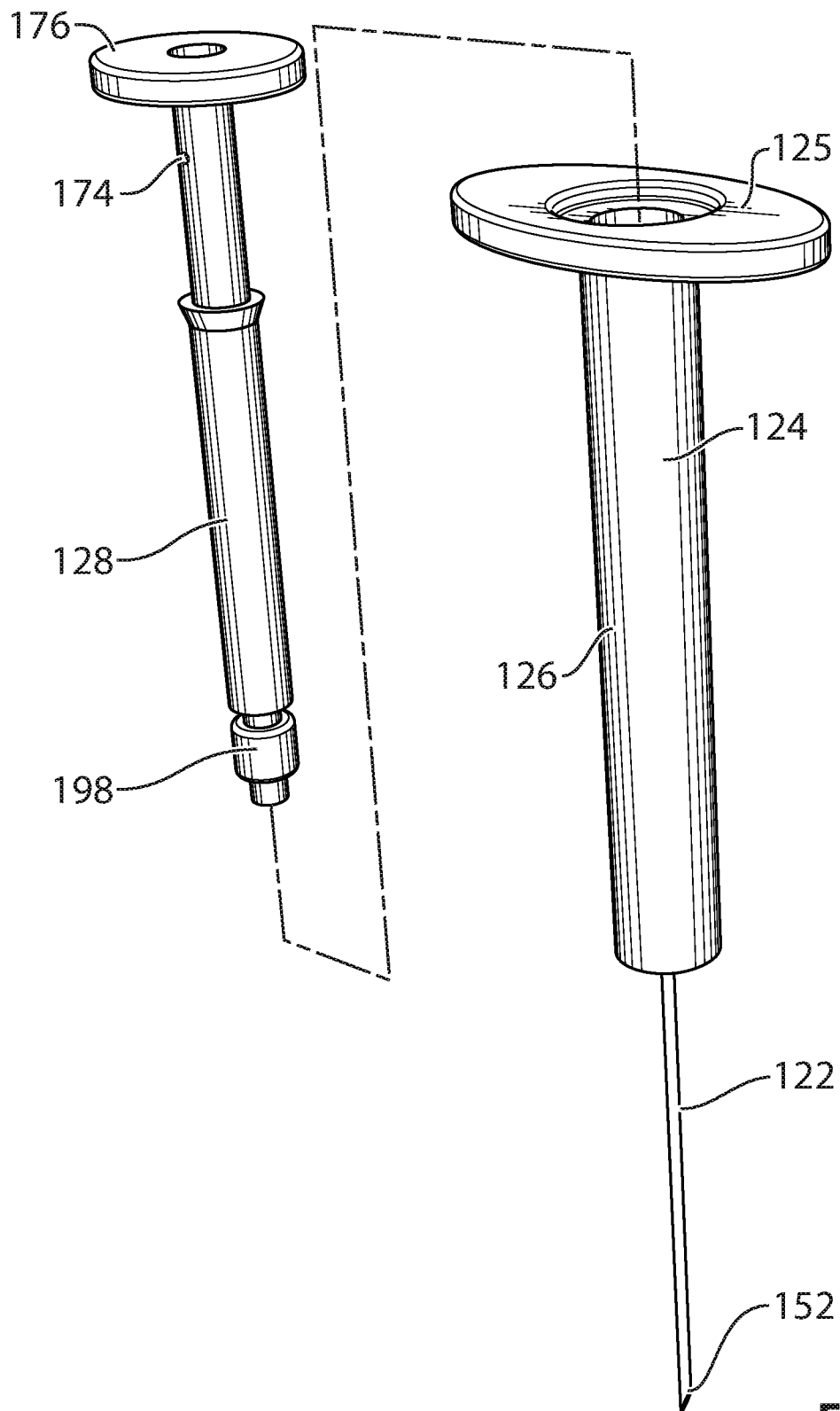
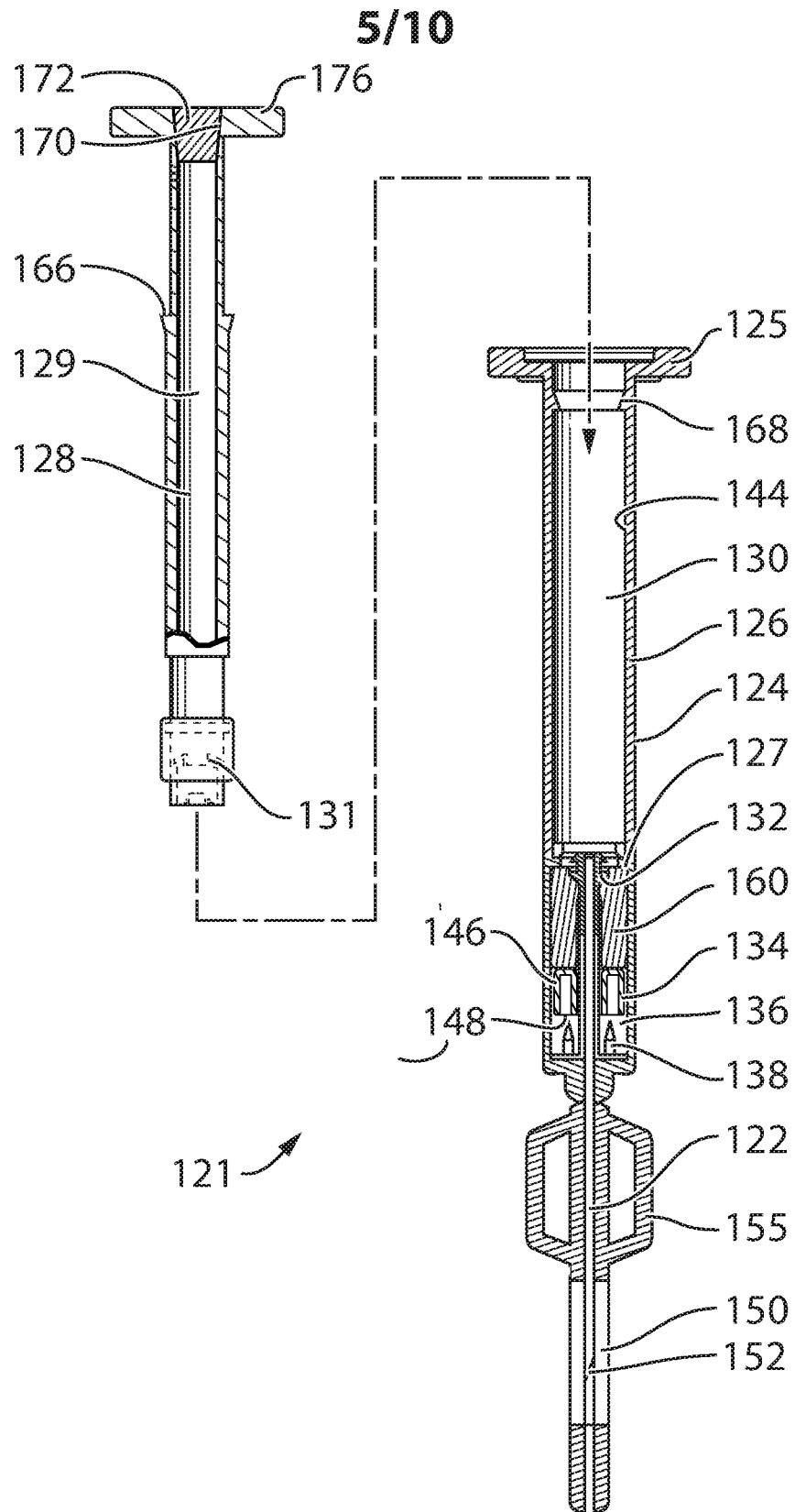


FIG.3

**FIG. 4**

6/10

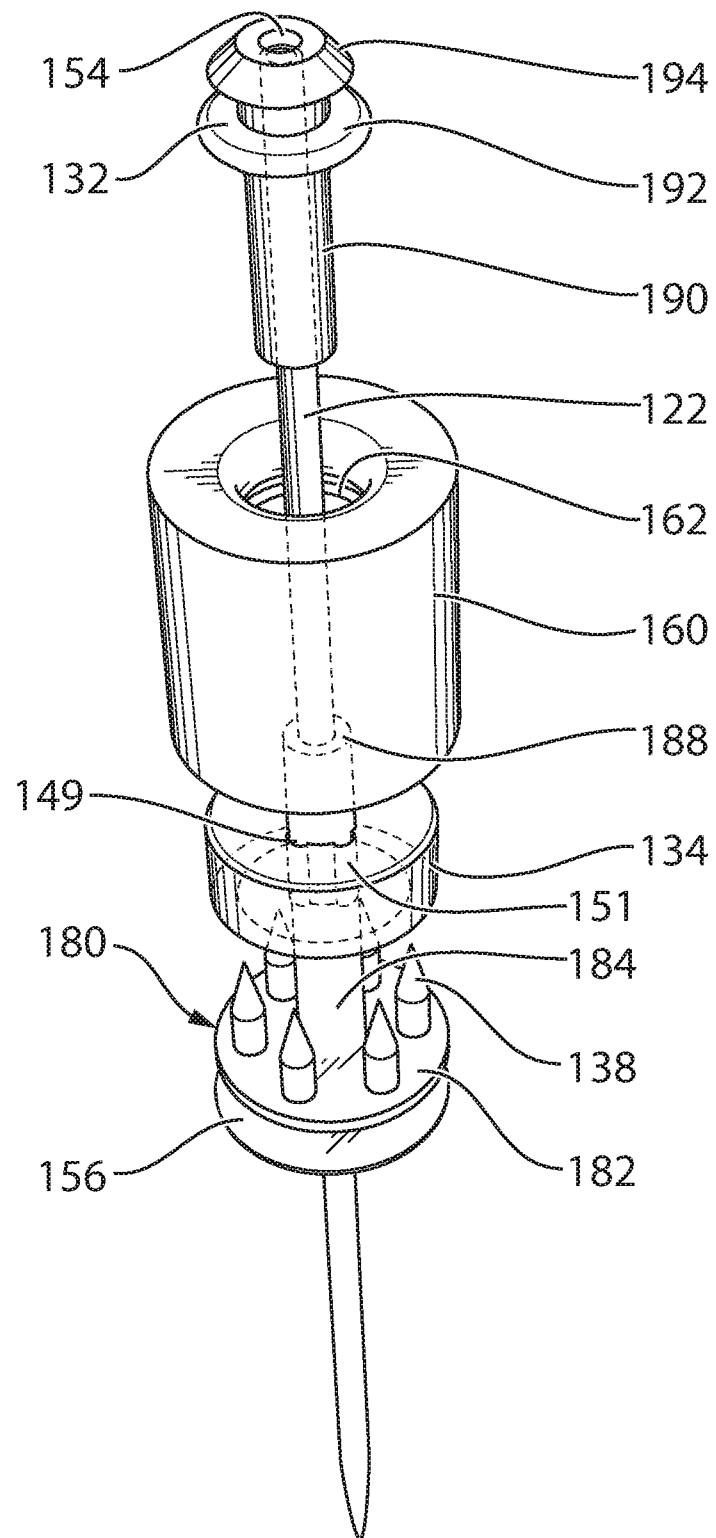


FIG.5

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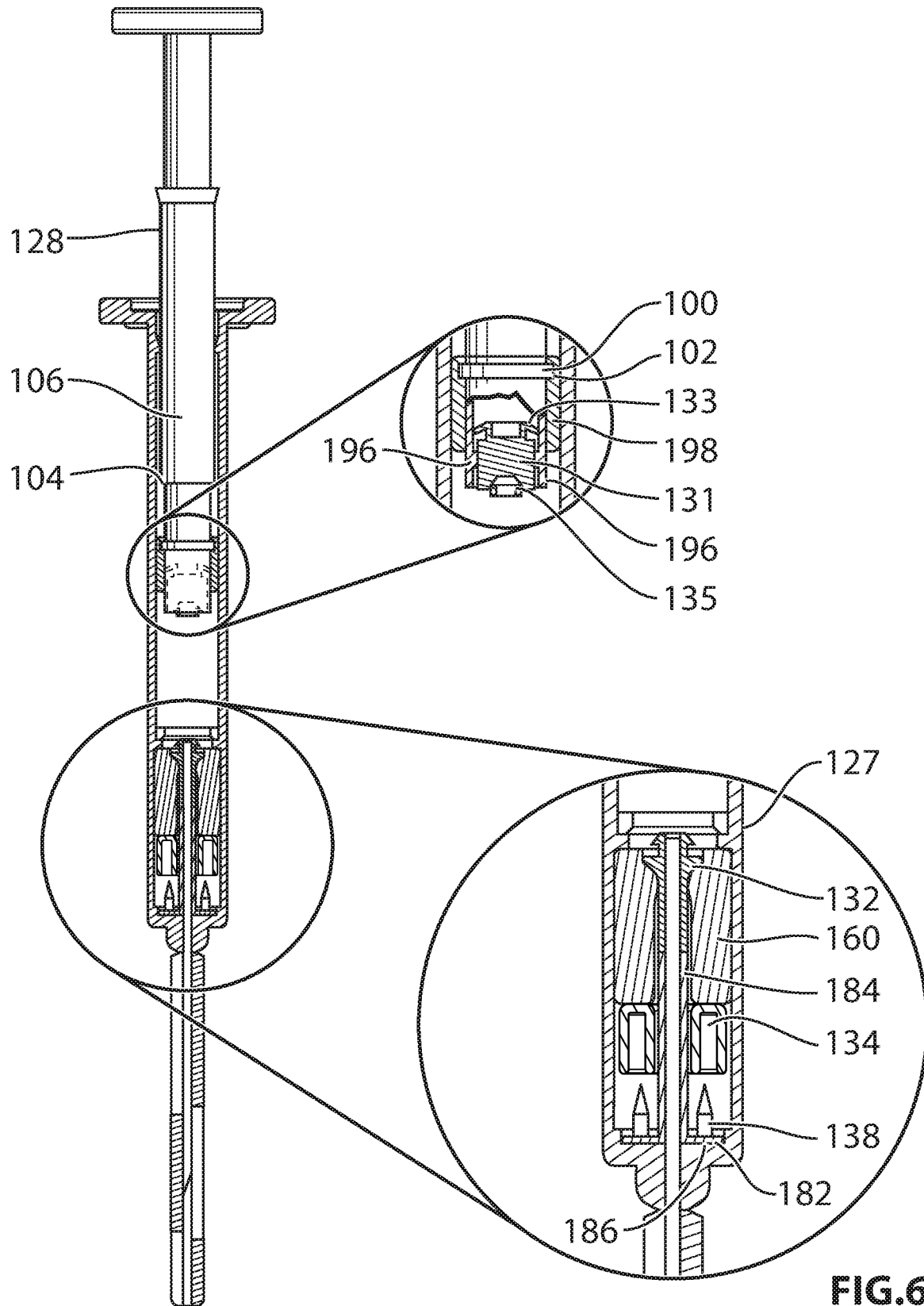


FIG. 6

8/10

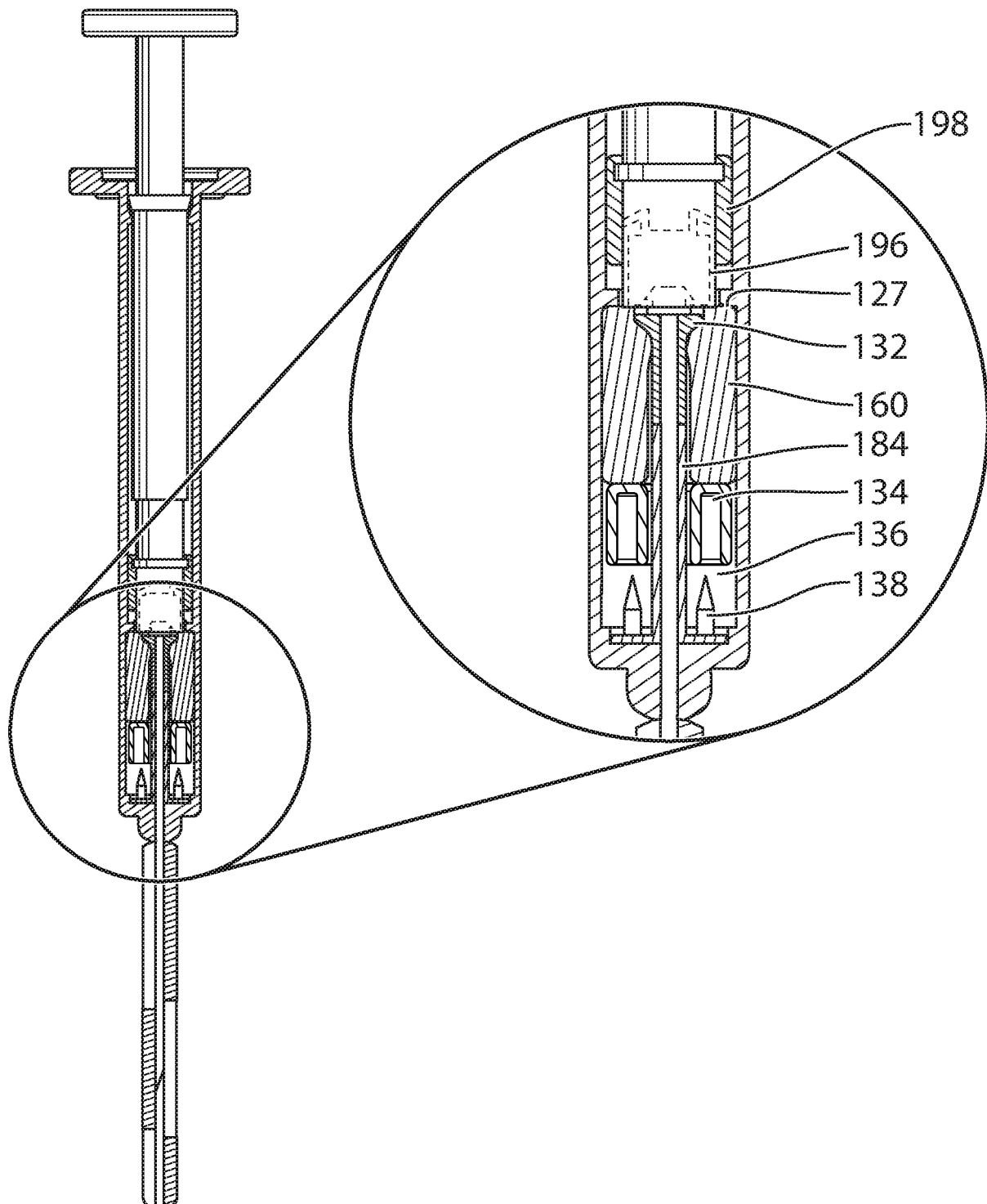


FIG. 7

9/10

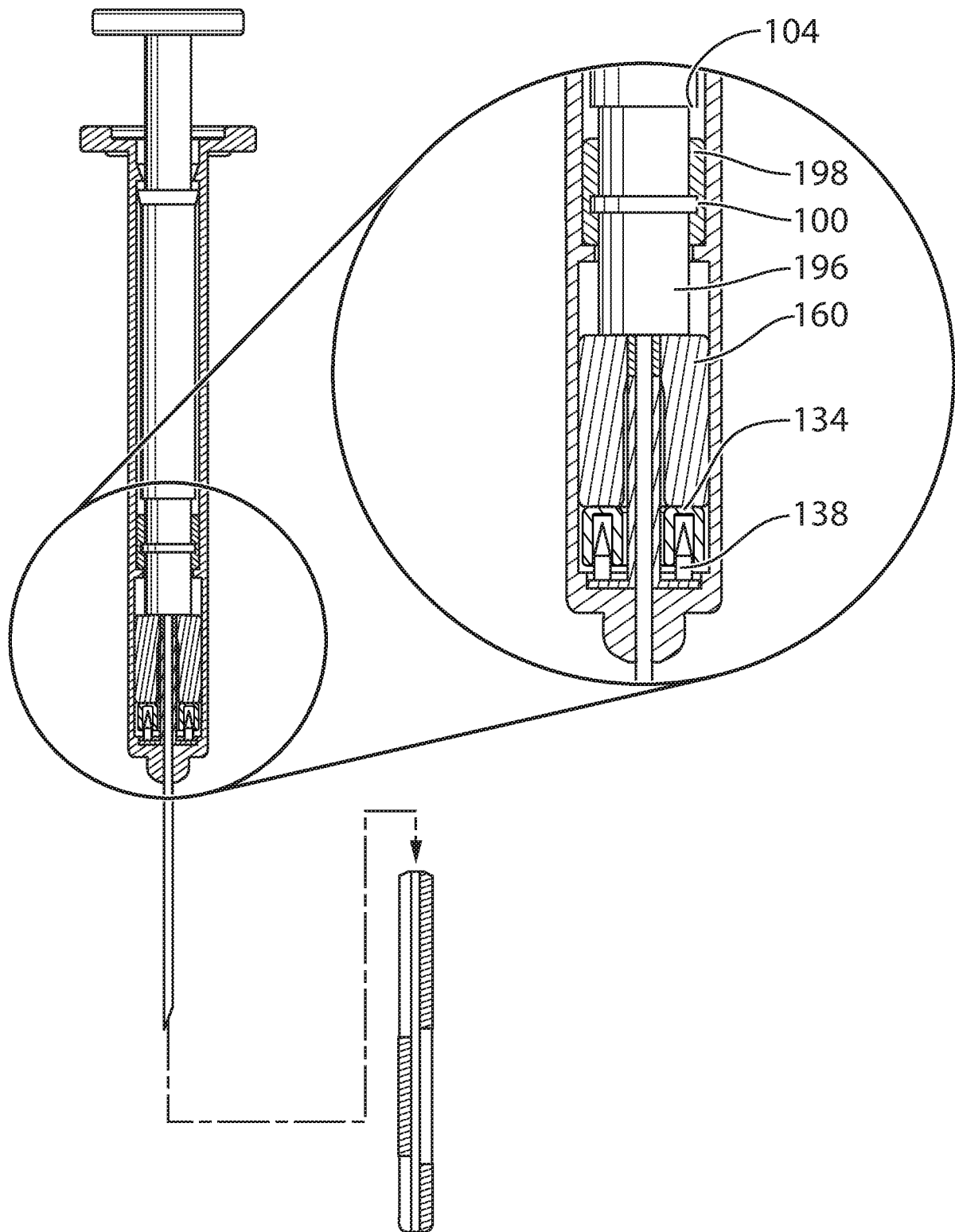


FIG. 8

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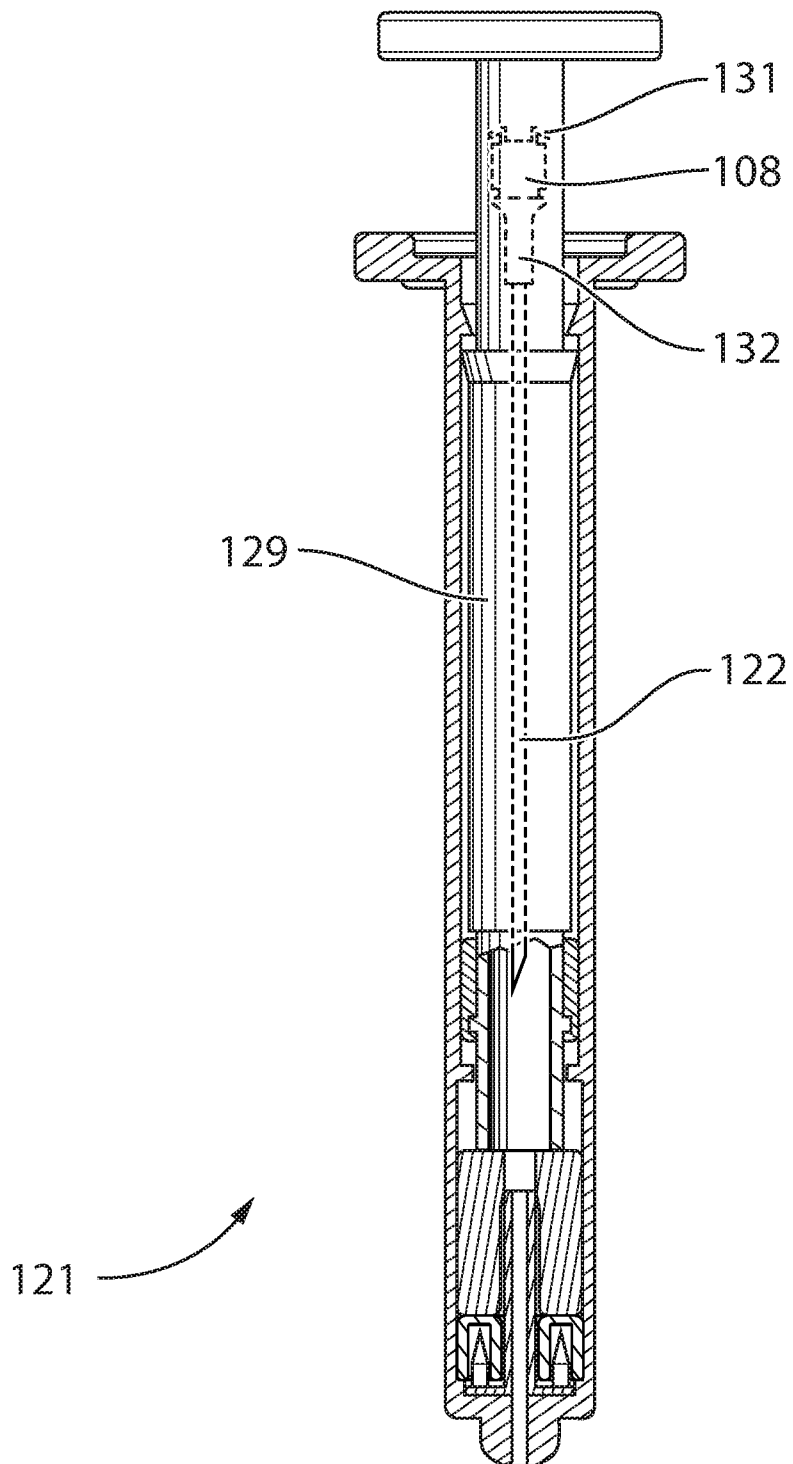


FIG. 9

