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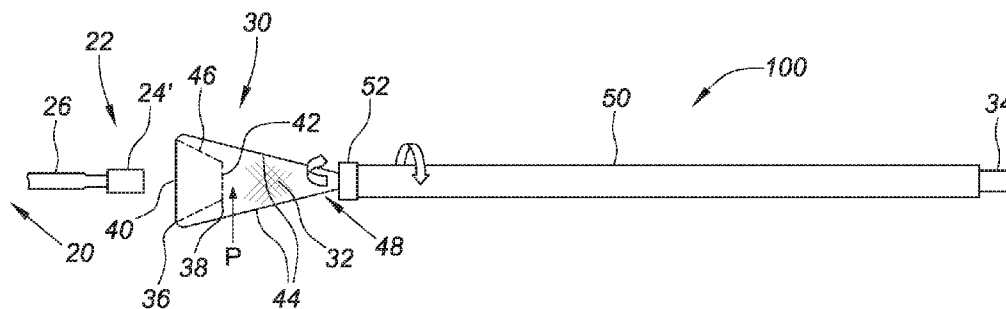
(57) **ABSTRACT**

Funnel-trap type delivery and/or retrieval devices for Inferior Vena Cava (IVC) filters or other medical implants are described in which the devices comprise two layers of braid with an axially support member. The support member may be interposed between braid layers or set inside the braid layers but interposed between heatset features. Delivery and/or retrieval devices, kits in which they are included, methods of use and methods of manufacture are all contemplated herein.

(22) Filed: **Dec. 10, 2015**

Related U.S. Application Data

(60) Provisional application No. 62/091,433, filed on Dec. 12, 2014.



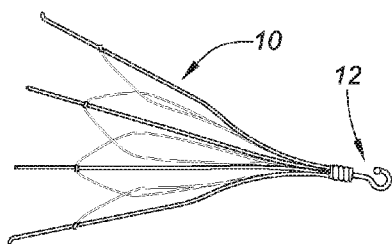


FIG. 1A

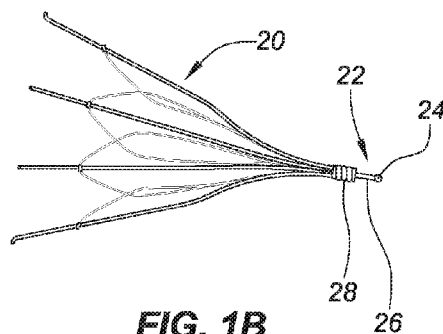


FIG. 1B

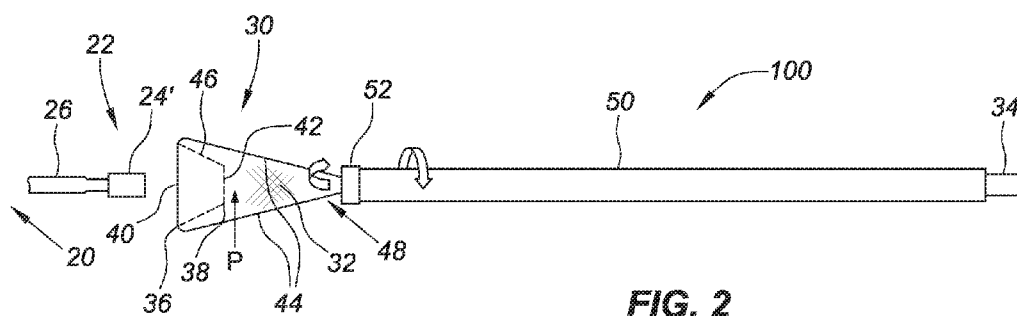


FIG. 2

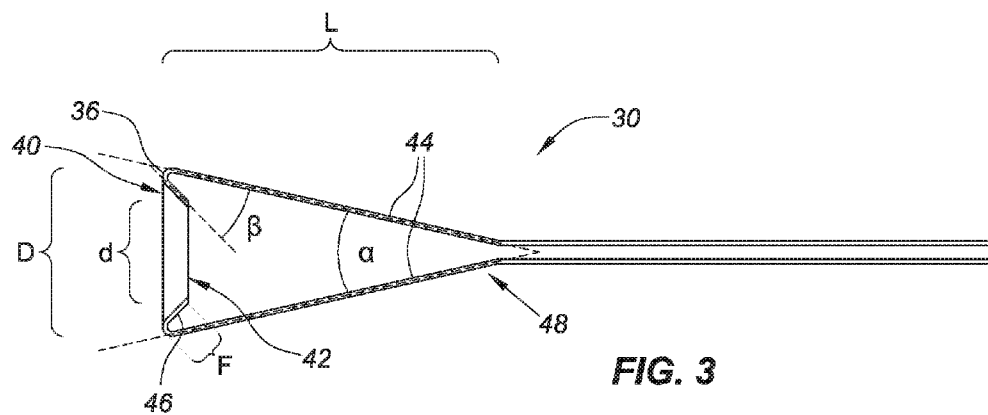
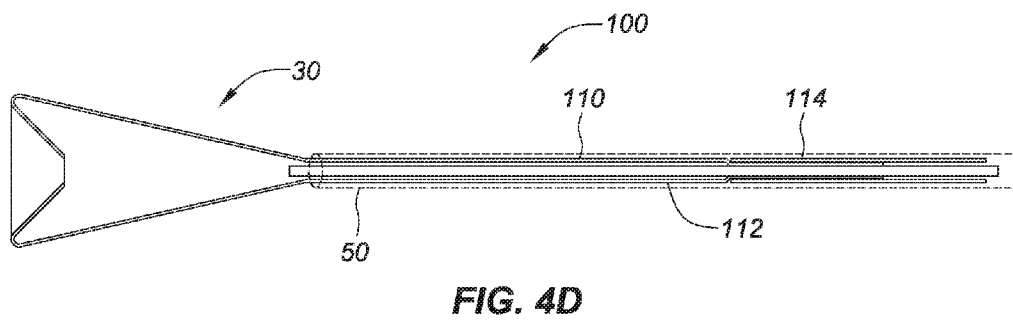
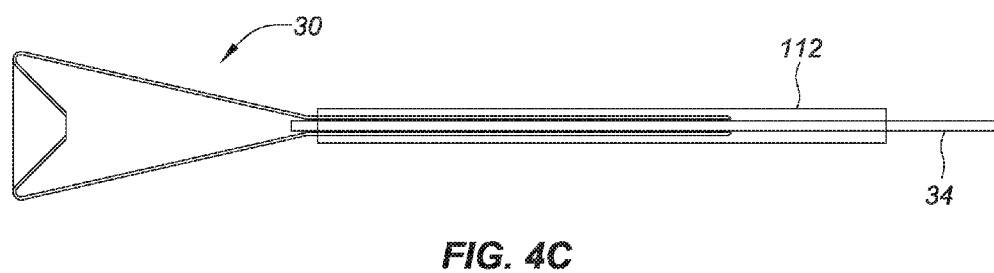
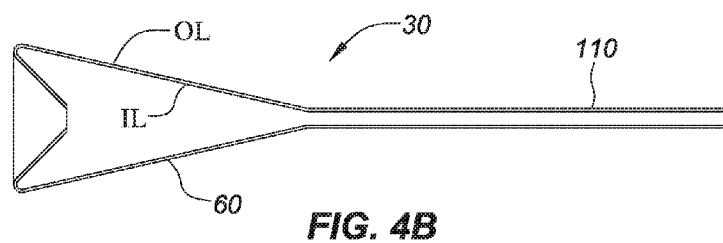
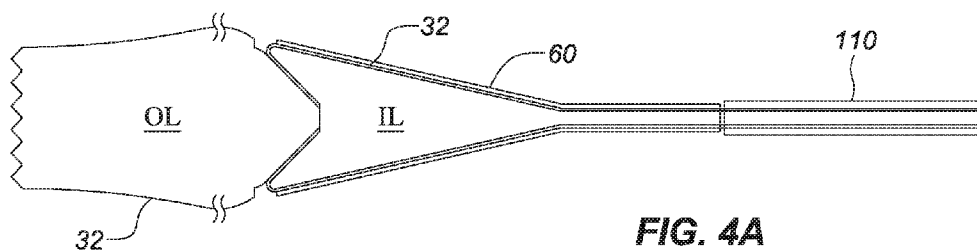


FIG. 3



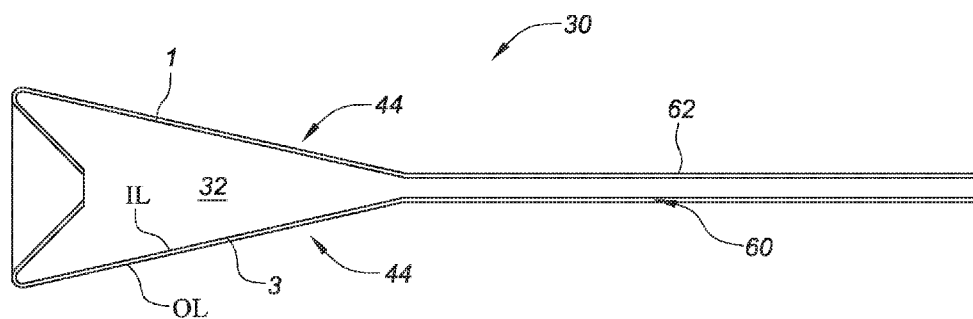


FIG. 5A

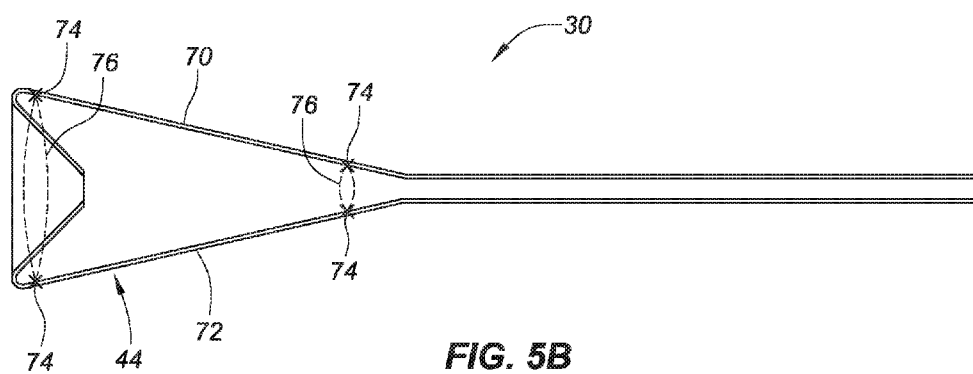
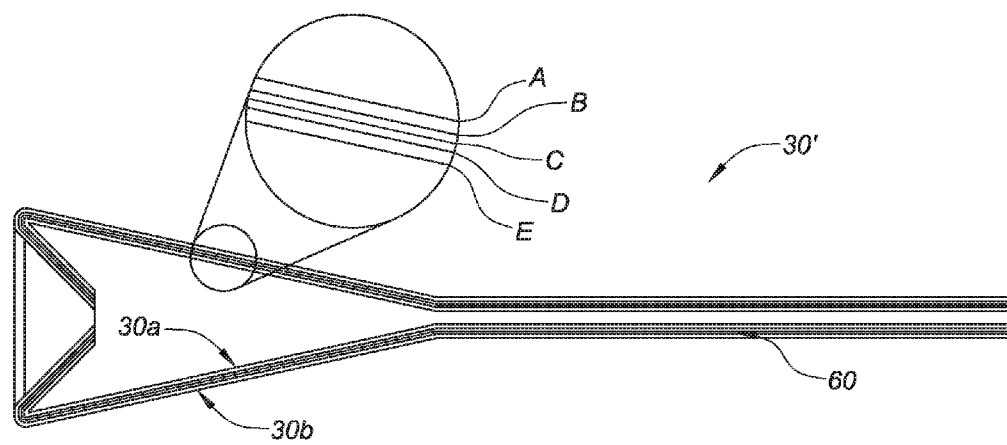
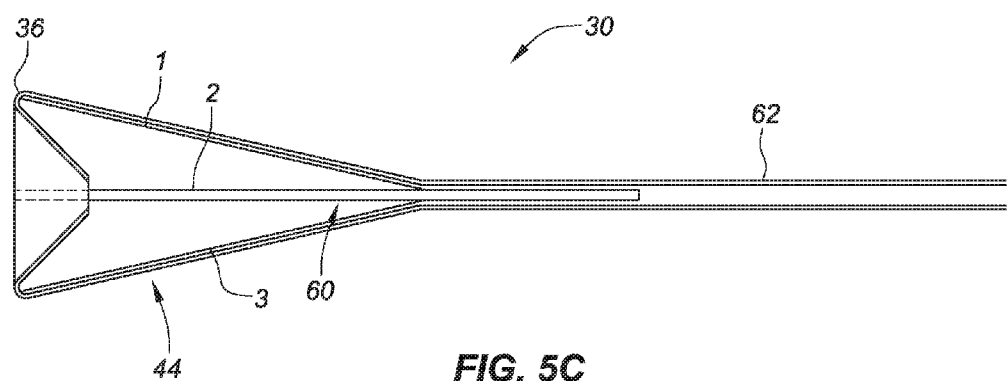


FIG. 5B



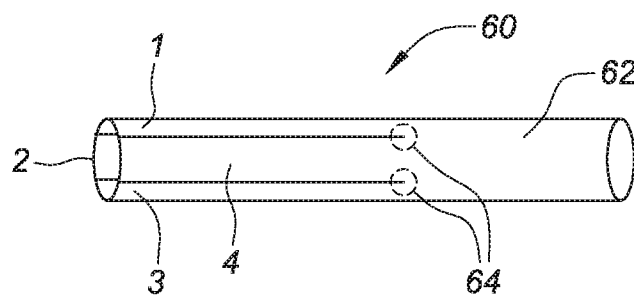


FIG. 6A

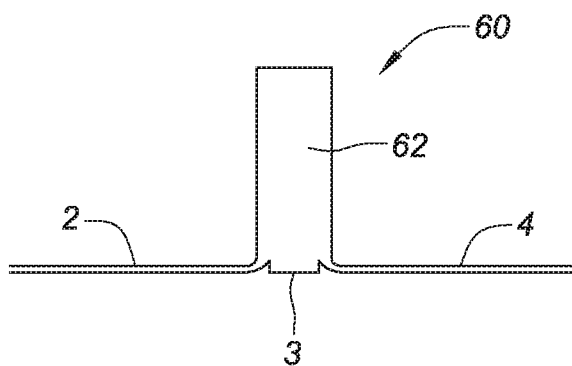


FIG. 6B

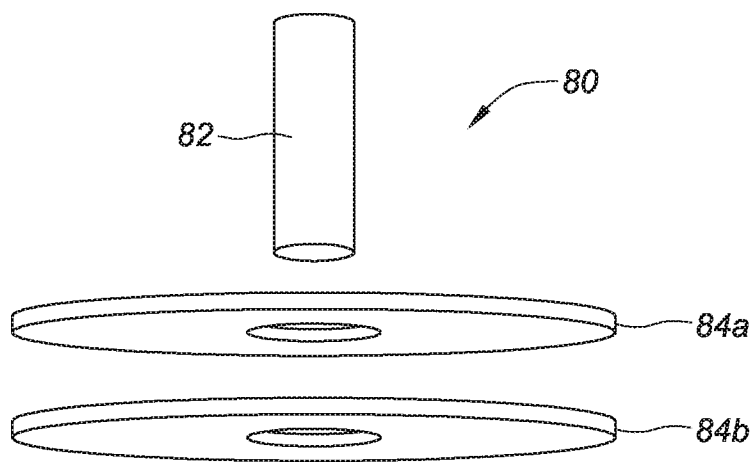


FIG. 7

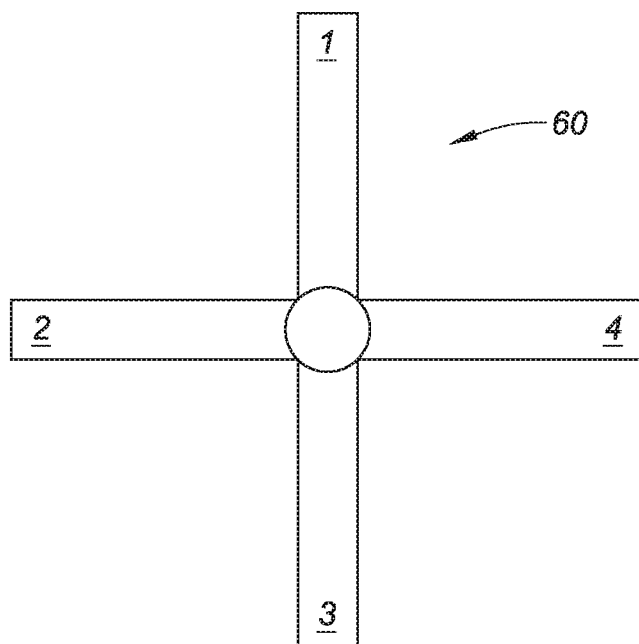


FIG. 8A

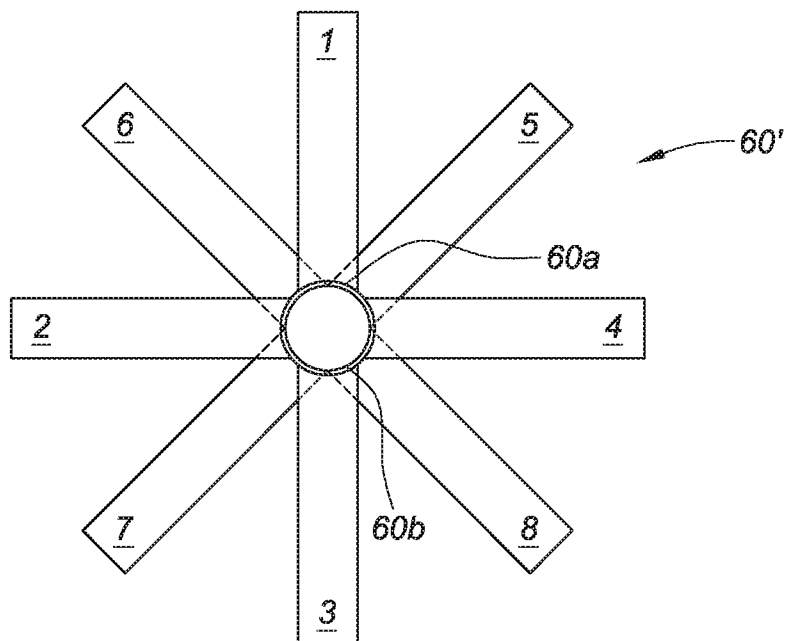


FIG. 8B

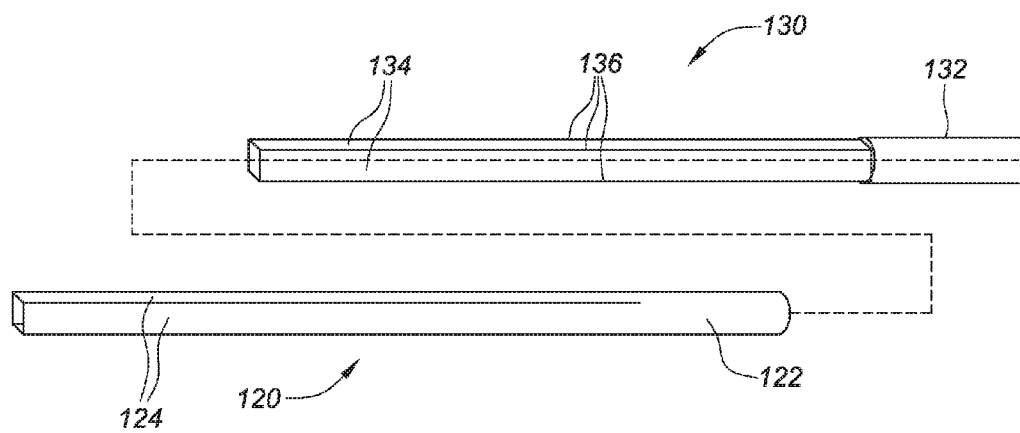


FIG. 9

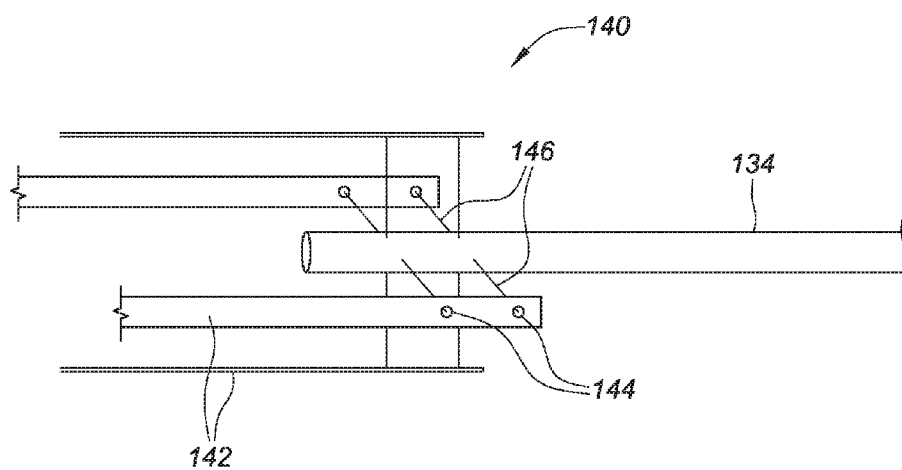


FIG. 10

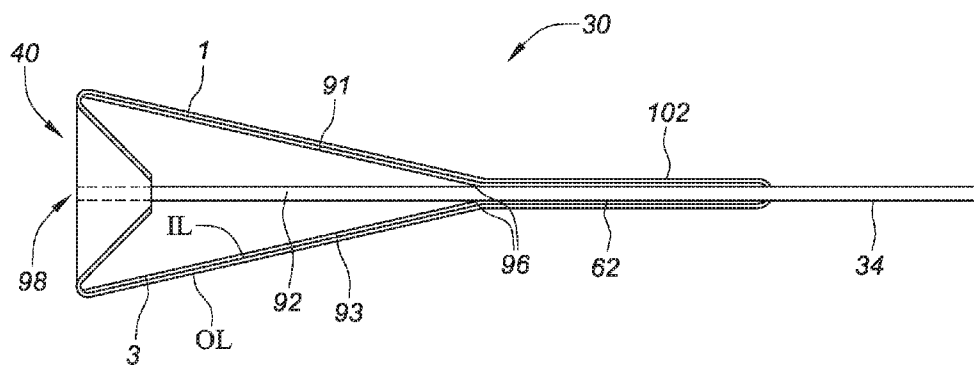


FIG. 11

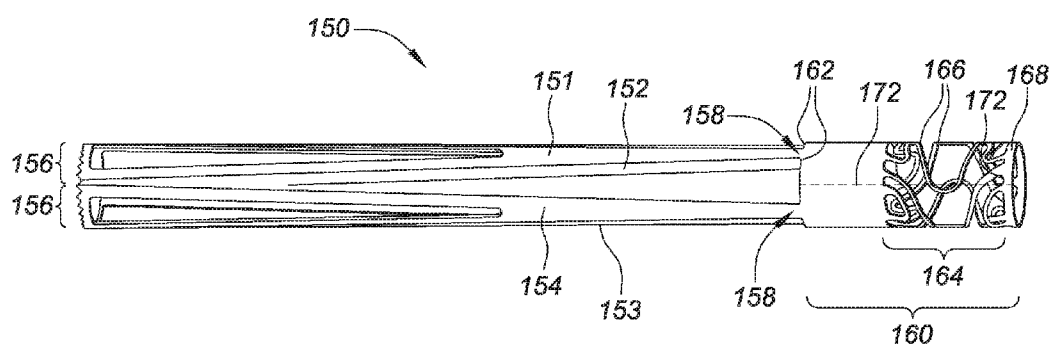


FIG. 12A

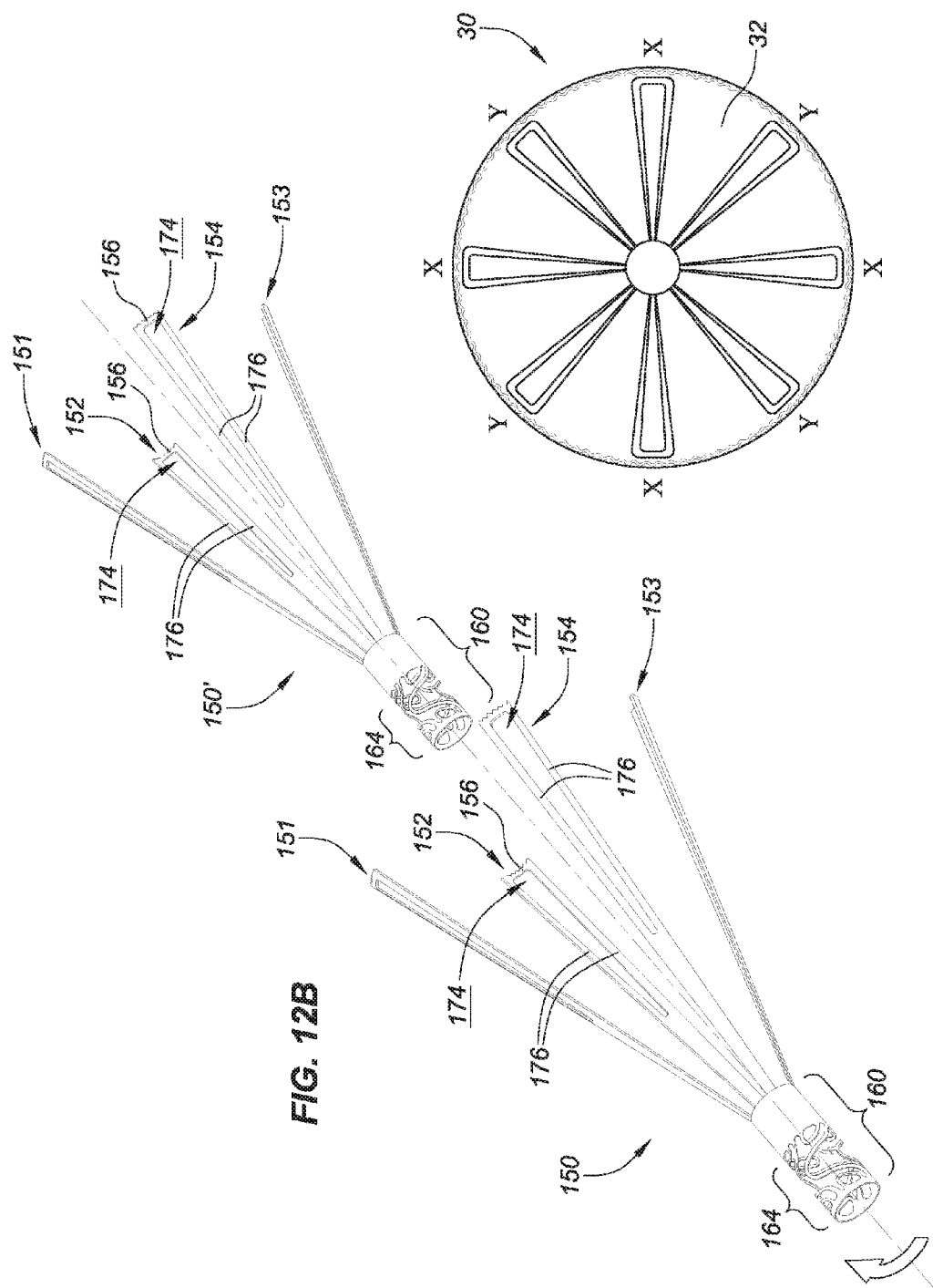


FIG. 12B

FIG. 13

IVC FILTER RETRIEVAL SYSTEMS WITH INTERPOSED SUPPORT MEMBERS

RELATED APPLICATION

[0001] This application claims the benefit of and priority to U.S. Provisional Patent Application Ser. No. 62/091,433 filed Dec. 12, 2014, which is incorporated by reference herein in its entirety and for all purposes.

FIELD

[0002] The embodiments described herein relate to endovascular temporary Inferior Vena Cava (IVC) filter, other implant or other foreign body retrieval devices or system and methods.

BACKGROUND

[0003] Temporary IVC filters are placed much like permanent filters, but are designed so that they may be retrieved in a separate endovascular procedure, generally from a femoral vein or internal jugular vein approach. Most of the currently available temporary filters include a hook-like feature with which they can be captured and received within a catheter or sheath for removal by employing a gooseneck snare or a multi-loop snare.

[0004] While retrieval is a simple procedure in principle, difficulty is often encountered capturing a filter's hook with the snare loop(s). Such difficulty is compounded when the filter is tilted or off-kilter in placement. Several filters are designed to avoid such orientation. However, the problem remains common because the device is not anchored into the IVC in a stable fashion. Constant blood flow in addition to blood clots can disorient the filter within the IVC making recapture difficult.

[0005] Accordingly, there exists a need for a filter retrieval system with improved ease of use and/or less susceptibility to problems of filter orientation.

SUMMARY

[0006] Embodiments hereof meet this need and others as applied to other medical device applications. For IVC filters, the subject systems may be used with a wide variety of filter architectures—existing or otherwise. Accordingly, new filters may be designed for use with the subject retrievers in which fewer design constraints and/or compromises may be required of the filter design. Features of the subject system may be used in connection with existing and/or modified versions of the filters described in any of U.S. Pat. Nos. 3,952,747; 5,601,595; 6,443,972; 7,338,512 and 7,625,390 (all of which patents are incorporated herein by reference in their entireties for any purpose), with commercially available devices including the OPTEASE, GÜNTHER TULIP, CELECT and OPTION or others.

[0007] In the subject embodiments, one or more members are interposed between braid layers defining a funnel trap in the subject device. In one embodiment, the support member may resemble a flower. The support member may comprise a polymer, Nitinol (superelastic at body temperature or below) or other metal or alloy. Especially when the “flower” comprises a thermoplastic material or Nitinol, the “petals” of the so-called flower may be heatset flat at appropriate temperatures as understood by those with skill in the art. In another embodiment, the support members are independent and stabilized between layers of braid as having a hook or “J” shape.

These may be originally cut from flat stock or a tube of polymer or metallic material. Such member may be further stabilized by suture loop(s) through or around each such member or body. Advantageously, any knot securing the suture can be positioned within the interior of the funnel trap section of the device. This can be accomplished by tying the knot(s) on the outside and then pivoting the trimmed structure through the braid from which the device is constructed.

[0008] In the so-called flower embodiment, a single such member may be used. It may be advantageously cut with four strips, slats, leaflets or petals—collectively, “support elements.” More cuts may be made (e.g., with a blade or laser) to define a greater number of elements. However, since it is advantageous for these members to have a large width-to-thickness ratio to avoid lateral displacement when cycling the funnel trap between open and closed (or vice-versa) it may instead be desirable to double-up one flower member with another in a slip or press fit or other telescoping fashion. So paired (or tripled), leaflet or petal width can be maintained while their number is increased.

[0009] With this embodiment, the flower also has a shaft. This is typically received over an inner layer of the funnel trap braid. But it can also be positioned inside the inner layer and abut the distal fold of the funnel trap extension. A proximal end of the shaft may be abutted by a heat shrink, glued or fused-on tube to maintain stability without increasing proximal profile. With the flower overlaid by a/the outer braid layer of the funnel trap structure, the entire assembly may be secured by an outer jacket of heat shrink or fused-on polymer layer. Suitable shrink and/or fusing materials include PTFE, FEP, PEBAX, PEEK or others. Adhesive bonding may alternatively be employed.

[0010] In the so-called J or hook-shaped embodiment, for proper recapture, it is important that the proximal end of the support members are able to float between the layers. This is so because of the way in which the angles of the braid change during compression. Accordingly, any suture securing the members in position relative to the braid that pass through the members should be located distally. Any proximal stabilization features should be looped around the members to allow translation or slipping.

[0011] The former embodiment (i.e., with the flower) may also use lateral stabilization features. However, in this embodiment, the proximal “shaft” of the flower is fixed or pinned with the braid and the braid should slide or translate past the distal end of the leafs or petals. As such, any distal petal stabilization features should be of the loop-type described above in this region.

[0012] Other approaches as further shown and described may be employed in support member construction. Examples include laser-cut tubular bodies. Generally, these will be elastic (e.g., as produced in polymer) or superelastic (e.g., as cut from Nitinol hypotube). Such members may be cut in a compressed or collapsed configuration and then plastically or thermally (i.e., as in heatsetting) formed to an expanded shape and then so-assembled with the device embodiment braid. Various optional constructions and construction techniques are detailed below. So-too are different braid layer assembly options.

[0013] The subject delivery and/or retrieval devices, kits in which they are included (with and without assembly), methods of use and manufacture (including assembly of the constituent components in vivo or ex vivo) are all included within the scope of the present disclosure. Some aspects of the same

are described above, more detailed discussion is presented in connection with the figures below.

[0014] Other systems, devices, methods, features and advantages of the subject matter described herein will be or will become apparent to one with skill in the art upon examination of the following figures and detailed description. It is intended that all such additional systems, devices, methods, features and advantages be included within this description, be within the scope of the subject matter described herein, and be protected by the accompanying claims. In no way should the features of the example embodiments be construed as limiting the appended claims, absent express recitation of those features in the claims.

BRIEF DESCRIPTION OF THE DRAWINGS

[0015] The details of the subject matter set forth herein, both as to its structure and operation, may be apparent by study of the accompanying figures, in which like reference numerals refer to like parts. The components in the figures are not necessarily to scale, emphasis instead being placed upon illustrating the principles of the subject matter. Moreover, all illustrations are intended to convey concepts, where relative sizes, shapes and other detailed attributes may be illustrated schematically rather than literally or precisely.

[0016] FIGS. 1A and 1B picture IVC filter variations as may be used in the present system.

[0017] FIG. 2 is a side view of a delivery and/or retrieval system with an end of any type of implantable medical device or foreign body.

[0018] FIG. 3 is a side-sectional view of a converted pre-form (i.e., a finally shaped funnel section of the subject device) after heatsetting.

[0019] FIGS. 4A-4D are side sectional views illustrating an assembly approach with the subject interposed support member(s).

[0020] FIGS. 5A-5D are side-sectional views illustrating interposed support member assembly options and features.

[0021] FIG. 6A is a perspective side view one support member in an as-cut or compressed configuration; FIG. 6B is a side view of a/the support member heatset in a splayed and flattened configuration. FIG. 7 is a perspective view of tooling for heatsetting a support member as shown in FIG. 6B.

[0022] FIG. 8A is a top view of an open support member; FIG. 8B is a top view of paired support members.

[0023] FIG. 9 is an assembly view illustrating support member construction according to heat-shrink material based approach.

[0024] FIG. 10 is another assembly view illustrating support member construction with separate elements.

[0025] FIG. 11 is a side-sectional view a system including a shaft-based support member.

[0026] FIG. 12A is a side view of another support member embodiment; FIG. 12B is an assembly view of elements as shown in FIG. 12A.

[0027] FIG. 13 is an end view of an embodiment constructed with the assembly in FIG. 12B.

DETAILED DESCRIPTION

[0028] Various exemplary embodiments are described below. Reference is made to these examples in a non-limiting sense, as it should be noted that they are provided to illustrate more broadly applicable aspects of the devices, systems and methods. Various changes may be made to these embodi-

ments and equivalents may be substituted without departing from the true spirit and scope of the various embodiments. In addition, many modifications may be made to adapt a particular situation, material, composition of matter, process, process act(s) or step(s) to the objective(s), spirit or scope of the present invention. All such modifications are intended to be within the scope of the claims made herein.

[0029] Before the present subject matter is described in detail, it is to be understood that this disclosure is not limited to the particular example embodiments described, as such may, of course, vary. It is also to be understood that the terminology used herein is for the purpose of describing particular embodiments only, and is not intended to be limiting, since the scope of the present disclosure will be limited only by the appended claims.

[0030] All features, elements, components, functions, and steps described with respect to any embodiment provided herein are intended to be freely combinable and substitutable with those from any other embodiment. If a certain feature, element, component, function, or step is described with respect to only one embodiment, then it should be understood that that feature, element, component, function, or step can be used with every other embodiment described herein unless explicitly stated otherwise. This paragraph therefore serves as antecedent basis and written support for the introduction of claims, at any time, that combine features, elements, components, functions, and steps from different embodiments, or that substitute features, elements, components, functions, and steps from one embodiment with those of another, even if the following description does not explicitly state, in a particular instance, that such combinations or substitutions are possible. Express recitation of every possible combination and substitution is overly burdensome, especially given that the permissibility of each and every such combination and substitution will be readily recognized by those of ordinary skill in the art upon reading this description.

[0031] FIG. 1A shows a GÜNTHER TULIP (Cook Medical, Inc.) temporary IVC filter 10 with a hook 12 end interface for retrieval. As shown in FIG. 1B for an IVC filter 20, the hook may be modified or substituted for a nubbin-type interface 22. The nubbin (itself) may comprise a laser-formed or solder-formed protuberance or bump 24 on an extension 26 from a hub 28. Alternatively, as shown in FIG. 2, a/the filter retrieval interface 22 may comprise a band 24' (e.g., a Pt marker band) mounted (e.g., by swaging, welding, gluing, etc.) on a/the extension 26. However the enlargement is created, the funnel-trap structures described below are adapted to secure that feature for IVC filter retrieval.

[0032] FIG. 2 provides an overview of the subject system 100. A funnel-trap structure 30 is shown made of heatset braid material 32. The construction provides a flexible distal extension to an elongate shaft 34. The shaft is received within an elongate sleeve 50 (that may be a commercially available catheter or a custom part of the overall system 100) and may include a distal radiopaque marker band 52.

[0033] The braid may comprise Nitinol (preferably that is superelastic at body temperature), CoCr, Stainless Steel or another biocompatible material. It is advantageously braided material incorporating between 72 and 288, or between about 144 and 192 filament “ends” in a 1-over-1, 1-over-2, 2-over-2 or other pattern. With (superelastic) Nitinol, the wire is advantageously between about 0.001 and about 0.003 inches in diameter. In which case, a supple and relatively “smooth” matrix surface is provided from which to construct the flex-

ible funnel-trap architecture shown and described. The value of such a surface is in its atraumatic aspect and/or ability to help guide in IVC filter interface into position for capture even if it is oriented off-angle. Still, other wire size and/or end count in a braid or other construction options are possible as well.

[0034] To further assist with recapture, the funnel trap structure **30** may be selectively directable. As indicated by the arrows in FIG. 2, the material from which it is made can be heatset or otherwise configured to provide a bias in an angular direction. The angle of deployment may be selectable or fully straightened by relative position of a core member or obturator (not shown) or by a sleeve or catheter sheath as further described. Further positioning may be achieved by rotating the device as further illustrated. Alternatively, a curved, “L” or “J” shaped wire may be received within a lumen of shaft **34** that can be passed up to and/or through to the inside of the funnel trap structure. Made of superelastic Nitinol (or other) wire, this member can be used to selectively shape or direct the device end.

[0035] Other device articulation options for selecting the angular orientation of the funnel-trap portion of the device are possible as well. Any of a variety of steerable or directable catheter-type technologies (reliant on pull-wires or otherwise) can be incorporated in shaft **34** for such purposes. Examples include the mechanisms described in U.S. Pat. Nos. 4,723,936; 4,960,411; 6,251,092 and 8,273,073, each incorporated herein by reference in its entirety, for such description.

[0036] The subject “funnel trap” may be generally frusto-conical in shape as shown or otherwise configured. With an outer conical shape (i.e., a triangular shape in cross section as shown) the structure is highly supportive for any necessary or desirable tissue discretion that might need to occur to free an emplaced filter. Moreover, such a shape provides a flexible “waist” section **48** for the directable feature(s) noted above. Still, the device may be bowed outward along its sides or otherwise configured without departing from claimed inventive aspects or variations.

[0037] Importantly, the distal rim opening **40** of the structure is larger than the more proximal rim opening **42** to operate in guiding filter engagement feature(s) or enlargement **24/24'** into a pocket (P) where it is captured and subsequently locked upon advancing sleeve **50**.

[0038] Such a pocket is formed between braid walls **44** and bend **38**, optionally serving as an abutment feature with an edge or shoulder of nubbin/bump **24/24'**. To ensure capture, the sleeve **50** may be advanced fully over trap **30** before withdrawal into a separate catheter. In other words, advancing sleeve **50** over funnel section **30** “closes the trap” and securely captures the implant to be retrieved. Otherwise, the sleeve may be a catheter.

[0039] Notably, system **100** may be used identically when capturing a filter **10** with a typical hook end **12**. However, the additional bulk/lateral extension of the hook may necessitate use of a relatively larger sleeve or catheter **50**. In any case, system use may be visualized fluoroscopically by a physician by way of marker features **24/24'** and **52** and/or others as may be conveniently provided.

[0040] In the various system architectures, the catheter/pusher shaft and/or sleeve may comprise a simple extrusion (e.g., PTFE, FEP, PEEK, PI, etc.) or may be constructed using conventional catheter construction techniques and include a liner, braid support and outer jacket (not shown), metal hypo-

tube, etc. Further, the filter frame may be constructed using conventional laser cutting and electropolishing techniques and/or be otherwise constructed. In embodiments intended for tracking through a guide/delivery catheter without an incorporated sheath, a loading sheath may be employed. Advantageously, any such loading sheath is splittable. Other typical percutaneous access instruments (such as wires, etc.), valves and other hardware may also be employed in connection with the invention embodiments.

[0041] The funnel-trap structure **30** may be made as a sub-assembly and attached to the catheter/pusher shaft. PCT publication PCT/US2014/042343 (WO2014201380) and U.S. patent application Ser. No. 14/569,500, each incorporated by reference in its entirety, detail optional steps in the manufacture of a pre-form for constructing the funnel-trap portion of the final device as shown in FIG. 3.

[0042] For IVC filter retrieval, the funnel-trap portion **30** shown may have a diameter (D) from about 5 mm to about 20 mm, or more preferably about 10 to about 15 mm (i.e., size in a range to work within average size human IVCs where such vessels are reported as having a mean diameter of 20 mm within a range of 13 to 30 mm). A length (L) may range from about 10 mm to about 30 mm. An overall cone angle (α) between braid walls **44** may be between about 30 and about 90 degrees. An angle (β) of bend **36** between braid wall **44** and flap **46** may be between about 0 and about 60 degrees and flap length (F) may be between about 1 and about 10 mm in length. Overall, a funnel trap opening diameter (d) may be between about 5 and about 95 percent of diameter (D) depending on the selected combination of the noted variables (i.e., d, D, L, F, α and β). At the lower end of this range, the inner “opening” may be substantially closed such that it must be pushed-open to receive the proximal engagement feature(s) of the implant during retrieval. At the higher end of the range, the flap may lie completely along or in-line with the outer layer(s) of the device. The opening **40** of the funnel trap may be set at 90 degrees relative to a device axis as shown. Otherwise, it may be angled or have a more complex shape as described in connection with FIGS. 9-13 in the above-referenced U.S. patent application Ser. No. 14/569,500, incorporated herein by reference.

[0043] Embodiments hereof include a support member or support members set within the funnel trap section or portion of the device. The support member(s) may be interposed between braid layers or set inside the braid layers but interposed between heatset features. FIGS. 4A-4D illustrate an approach to producing the former construction and a method of manufacture.

[0044] Here, braid **32** is manipulated (in FIG. 4A) flipping an outer layer (OL) over and then back (in FIG. 4B) upon an inner layer (IL) with support member **60** placement and abutment by a locating feature **110** in the form of shrink tubing. The braid layers are re-aligned and shrink tubing **110** reduced in diameter by applying hot air in FIG. 4B. In FIG. 4C, funnel trap structure **30** is mounting on pusher member **34** using another jacketing shrink sleeve **112**. In FIG. 4D, a final system assembly is shown with an outer sleeve **50** and optional proximal catheter jacket **114** comprising PTFE shrink or other material.

[0045] FIG. 5A provides an enlarged view of the funnel trap **30** plus support structure **60** shown in FIGS. 4A-4D. Here, the two-layer (IL and OL) construction of the trap **30** formed by heatsetting braid **32** is more apparent. In this cross-section view, two “petals” 1, 3 of the support structure **60** “flower” are

shown as well. In this example of a four-petal support member embodiment, petals (which would otherwise be numbered 2 and 4) into an out of the plane of the figure are not shown. A section of a cylindrical base or shaft 62 of support structure 30 is, however, shown in cross-section.

[0046] FIG. 5B illustrates another support structure embodiment. Here separate support member 70, 72 “fingers” that are curled or hooked over into “J” shapes are independent of one another and stabilized between layers of braid. (As per the convention in FIG. 5B, the fingers into and out of of the page of the cross-section view are not shown.) Such member (s) may be further stabilized by suture loop(s) passing through and/or around each such member or body with knot (s) 74 securing the suture positioned within the interior of the outer walls 44 of the device.

[0047] The sutures may be looped around a single member and interwoven through the braid to form a guide or way. In another approach, the suture is formed in a ring around the circumference of the braid between its layers (an option indicated by the dashed-line loops 76 in the figure) and tied to each member. Such a tie or knotting approach may be facilitated by forming various locator-type through holes in the member 72, 74, etc. as by laser cutting, hypotube drilling or otherwise. An example of such an approach is shown in FIG. 11 (although in different context).

[0048] In FIG. 5C, a support member 60 as described in FIG. 5A is placed within the funnel trap structure 30 inside its wall(s) 44. As such, petal number 2 is visible in the figures and extends like the others to adjacent fold 36 to support opening rim 40 (as indicated by dashed line).

[0049] In some ways, the support member placement in FIG. 5D resembles that in FIG. 5A; in other ways it is like that in FIG. 5C. The distinction between the embodiments lies in that FIG. 5D shows a funnel trap construction 30' incorporating two funnel trap preforms 30a and 30b. Thus, it may be said that the FIG. 5D construction takes the approach in FIG. 5C and adds a second, inner funnel trap to the construction. Alternatively, the FIG. 5D construction may be viewed as a doubling-up of layers relative to the FIG. 5A approach.

[0050] Regardless, the detail view in FIG. 5D includes five layers (A-D) of material. As shown, layer “C” identifies a/the support member 60 layer. However, other layers combinations are possible, as in an A-C-B-DE combination (i.e., moving the support member 60 or members 72, 74, etc. outward one layer), A-B-D-C-E (i.e., moving the support layer inward one layer) or A-B-D-E-C (i.e., moving the support layer inward two layers). However the support is received, the doubled-up funnel 30' approach (i.e., with subassemblies 30a plus 30b) may offer benefits when lower braid end counts or smaller diameter wires are desired in a given layer while maintaining overall braid density.

[0051] FIGS. 6A and 6B and FIGS. 8A and 8B detail methods of manufacture for certain support member embodiments. FIG. 6A is a perspective side view one support member in an as-cut or compressed configuration. In FIG. 6A, a tube (e.g., PET, PTFE or PEEK) is cut with four slits or slots to define a support member 60 four petals 1, 2, 3, 4 leaving an interconnected support base or sleeve 62. The cutting may be done with a blade or laser cutter. Use of a laser will facilitate the addition of optional stress-relief features 64 (dotted line) at the petal junctions as well.

[0052] When cut in metal such as Nitinol, the relief features 64 may be necessary. In plastic, they are not. In either case, the body shown in FIG. 6A is advantageously heatset in a

splayed-out form as shown in FIG. 6B. This can be accomplished in connection with tooling 80 as illustrated in FIG. 7 and a heatsetting or annealing oven. The tooling may comprise a shaft or rod 82 to center the support member shaft or sleeve 62 and washers 84a, 84b for compressing petals 1-4 flat.

[0053] FIG. 8A provides a top view of a support member 60 so-set. With the material heatset open and flat (or set in an approximately conical shape), the structure assists the resiliency of the braid 32 in opening the funnel trap structure 30 upon deployment. FIG. 8B illustrates how a first support member 60a can be nested with a second support member 60b to form a combined support member 60'.

[0054] In this case, the nesting doubles the number of support petals. The approach (i.e., nesting of at least two support member sub-assemblies) offers a maximum number of petals, with maximum possible pedal width each (as compared to cutting more petals out of a single tube). The maximized width may be particularly useful in providing lateral stability for the elements when constructed of thin material (e.g., on the order of 0.002 to about 0.005 inches thick) and/or avoiding pushing or poking through the braid the members are intended to support.

[0055] FIG. 9 illustrates still another approach to support member construction. Here, a support 120 is constructed using tubing (e.g., PET or PEEK heat shrink) that is heat shrunk or formed onto a mandrel 130. A cylindrical portion 132 of the mandrel provides a round interface portion 122 of the support for mounting to the device shaft 34. Flats 134 on the mandrel result in flat portions or petals 124 in the support. When originally formed by heat shrinking on the mandrel, the petals are connected. However, they are cut with shears, a razor blade or otherwise along squared edges (dashed lines) formed by edges 136 of the mandrel.

[0056] One such support may be used in a construct as described above. Otherwise a pair (or more) may be nested concentrically. When stacked or nested, as before, the petals are advantageously offset from one another. A symmetrical offset of 45 degrees is advantageous for support members each including four petals, thus providing a combined structure with eight symmetrically arranged support petals. With a support member formed with three petals to be nested with another to form a final construct with six petals, the offset between each petal is advantageously 60 degrees.

[0057] Also, it is possible to plastically deform and set the petals splayed outwards. In a heat-shrink embodiment, it should be done mechanically (i.e., without significant heating), in order to avoid inadvertent (mis)shaping by unintended recovery of the heat shrink tubing. Nevertheless, when two support bodies are employed in a concentric arrangement, they may heat-staked together using a soldering iron tip by cross-wise penetration (or otherwise joined, e.g., by adhesive wicked between the bodies) in order to maintained the desired spacing of petals or for any other reason. The same approach (i.e., heat staking, etc.) may be employed in connection with the FIG. 8B embodiment as well.

[0058] FIG. 10 illustrates yet another approach to support member construction. Here, a support 140 is constructed either on the end of a shaft 34 (as shown) or as a separate subassembly to be used like other examples above. Either way, the support comprises a plurality of independent extension members 142. These may be formed by die cutting or laser cutting PET, PEEK or another sheet material. And then located as shown onto a support body via guide or eye holes

144. The eye holes may be aligned along axes **146** with wires (wire axes shown) that are removed after affixing the complementary features (e.g., by gluing, laser welding or fusing by typical catheter constructions techniques or otherwise).

[0059] The construct in FIG. **10** may be employed in the support member nesting approach shown in FIG. **11**. Alternatively, a tubular shaft **34** can be processed such that its distal end is cut into a support member section **90** with finger or petal extensions **91, 92, 93**, etc. therefrom. These extensions can be heatset as described in connection with FIG. **7** or into a conical shape using a matching tool or form. For shape or heatsetting purposes, the shaft advantageously comprises PET or PEEK (as such a selection provides a good compromise in strength, machinability and formability) or Nitinol. The cutting may be performed with a laser and include stress relief features **96** at a junction of the shaft body **34** and extensions. Optional zig-zag end features **98** may also be included in the construction. These zig-zag, square-wave or other such engaging features can assist in maintaining stable position of the support member fingers when the braid of rim opening **40** is compressed and contacting the same. Notably, the same such features may be included in the FIG. **10** and/or FIGS. **12A** and **12B** embodiment as shown or others as provided herein.

[0060] In FIG. **11**, the funnel trap embodiment **30** also includes an optional second support member **60** interposed between its braid layers (IL and OL). Notably, the support member **60** fingers **1, 2**, etc. are advantageously staggered or interdigitated (as in the manner shown in FIG. **8B**) with extensions **81, 82**, etc. coordinated to maximize the number of non-overlapping elements and provide uniform spacing of radial support points for opening rim **40**.

[0061] In such a system **100**, the extension section **30** may be located as shown and bonded with one or more PEBAX (or other thermoplastic material) layers **102** to shaft **34**. A laser welding approach is also possible—particularly for embodiments in which all elements are made Nitinol although other materials might be employed to the same effect.

[0062] FIG. **12A** illustrates a laser cut pattern that may be used for the extension sections of a shaft-cum-support as discussed above. Alternatively, the pattern may define the geometry of a separate support **150** as shown.

[0063] In either case, the shape includes a plurality of extensions **151, 152, 153** and **154** in the form of substantially triangular petals, fingers or leaflets. So-configured, the available distal interface area **156** of each member to support the funnel trap braid **32** is maximized in size, while minimizing a waist or flexure section **158** for each petal. The minimized waist provides space for (optionally) radiused stress relief features **160** from a base or stem section **160**.

[0064] Support member **150** may be so-cut from Nitinol tubing or other material. The cut pattern may include an open stress-relief area **164** comprising a plurality of curved or otherwise configured beams **166** within stem section **160**. Such a section will serve as one or more windows for flow-through of bonding material (e.g., thermoplastic PEBAX—or other material—as noted above) without significant increase in stiffness across the entire base **160** of the structure. Alternatively, square or rectangular shaped windows may be provided for bonding. In either case (i.e., with complex, curved windows or rectilinear forms), the windows in each base are advantageously set or “clocked” such that the extensions **151**, etc. are spaced apart as desired when the windows are aligned for bonding material flow-through. A proximal rim or band

168 of each support member **150, 150'** will prevent pull-out from flow-through bonding approach.

[0065] A wide proximal or distal rim or band **170** (i.e., as shown) can—in effect—serve as an integrated radiopaque marker to a/the built-up system. As another option, an inner extent or “frame” portion of one or more aligned windows can be laser welded together to stabilize overall support member **150, 150'** position for further assembly processing. Yet another option is to laser or resistance weld proximal or distal rim or band **168, 170** for such purpose(s).

[0066] Still further, each rim (or an integrated rim without an intermediate stress-relief section or area **164**) may be split as shown, even if cut from cylindrical tubing. A split line **172** may be used for nesting one such tube with another. If the kerf or separation of the split line is wide enough, the base **160** may be compressed and fit inside another tube originally of the same size. Alternatively, a split pair may be employed where one contracts and the other expands.

[0067] FIG. **12B** illustrates assembly of a pair of support members **150** and **150'**. In this example, neither base is split. Rather, the tubes from which the patterns are cut are sized to nest with each other. The base **160** of each body may include a relief pattern **164** configured to match-up when they are set concentrically with each other and offset (e.g., as suggested by the curved arrow so the so-called fingers or petals do not overlap. Alternatively (as shown), the relief patterns may be configured so that they are non-aligned with the petals offset. Such an approach may provide more uniform flexibility.

[0068] For use, petal extensions **151, 152**, etc. are typically heatset outwardly (as shown) and end interface sections **156** may retain the curvature native to the tube from which they are cut. In which case, any included zig-zag end pattern along with interior relief **174** may provide flexibility when opening or deploying the funnel trap device. Otherwise, the interface sections may be heatset flat (or at least partially flat) for one or both of the support members **150, 150'**. In which case, the aforementioned flexibility will assist in fully compressing the device for tracking and/or retrieval. Without such a pattern provided, associated part width or thickness may be altered if so-desired.

[0069] With a relief section **174**, distal interface **156** (whether zig-zagged, flat or otherwise configured) portions are shown supported by struts **176**. Alternatively, relief space **174** may be omitted. Such an embodiment (not shown) may employ a single central strut as part of an overall “T” shaped body.

[0070] In any case, FIG. **13** is an end view of a device **100** funnel section **30** with support members **150/150'** set within braid material **32**. It can be observed through the braid that alternating petals X, Y are wider and narrower, respectively. This is a result of cutting maximum width interface sections **156** from larger and smaller tubing, respectively, for nesting.

[0071] With the split-tube approach, the same size interface sections **156** may be provided. However, upon compression, narrower “Y-type” members may compress better (i.e., to their native tube size) offering a reduced device crossing profile. Stated otherwise, excessive dimensional stack-up can be avoided if a mix of X- and Y-type or sized members are provided. Such a consideration may be of use in minimizing locking sleeve **50** size, if used.

[0072] Variations

[0073] The subject methods, including methods of use and/or manufacture, may be carried out in any order of the events which is logically possible, as well as any recited order of

events. Medical methods may include any of a hospital staffs activities associated with device provision, implant positioning, re-positioning, retrieval and/or release.

[0074] Furthermore, where a range of values is provided, it is understood that every intervening value, between the upper and lower limit of that range and any other stated or intervening value in the stated range is encompassed within the invention. Also, it is contemplated that any optional feature of the inventive variations described may be set forth and claimed independently, or in combination with any one or more of the features described herein.

[0075] Though the invention has been described in reference to several examples, optionally incorporating various features, the invention is not to be limited to that which is described or indicated as contemplated with respect to each variation of the invention. Various changes may be made to the invention described and equivalents (whether recited herein or not included for the sake of some brevity) may be substituted without departing from the true spirit and scope of the invention.

[0076] Reference to a singular item includes the possibility that there are a plurality of the same items present. More specifically, as used herein and in the appended claims, the singular forms “a,” “an,” “said,” and “the” include plural referents unless specifically stated otherwise. In other words, use of the articles allow for “at least one” of the subject item in the description above as well as the claims below. It is further noted that the claims may be drafted to exclude any optional element. As such, this statement is intended to serve as antecedent basis for use of such exclusive terminology as “solely,” “only” and the like in connection with the recitation of claim elements, or use of a “negative” limitation.

[0077] Without the use of such exclusive terminology, the term “comprising” in the claims shall allow for the inclusion of any additional element—irrespective of whether a given number of elements are enumerated in the claim, or the addition of a feature could be regarded as transforming the nature of an element set forth in the claims. Except as specifically defined herein, all technical and scientific terms used herein are to be given as broad a commonly understood meaning as possible while maintaining claim validity. Accordingly, the breadth of the different inventive embodiments or aspects described herein is not to be limited to the examples provided and/or the subject specification, but rather only by the scope of the issued claim language.

1. An apparatus for delivery or retrieval of a vascular medical device, the apparatus comprising:

an elongate shaft having an axis having a flexible distal extension comprising braid, the extension folded-back inwardly at a distal opening and forming a more proximal opening, and

a support member comprising a plurality of elongate support elements secured to or within the extension for supporting the extension along the axis,

wherein the proximal opening is sized to receive and pass a proximal end of the medical device therethrough for capture.

2. The apparatus of claim 1, further comprising an elongate sleeve receiving the elongate shaft and distal extension to secure the proximal end of the medical device.

3. The apparatus of claim 1, further comprising the medical device.

4. The apparatus of claim 3, where the medical device is an inferior vena cava filter.

5. The apparatus of claim 1, wherein the support member is secured by being interposed between layers of the extension.

6. The apparatus of claim 1, wherein the support member is secured without being interposed between layers of the extension.

7. The apparatus of claim 1, wherein walls of the extension comprise two layers of braid.

8. The apparatus of claim 7, wherein the walls consist of four layers of braid.

9. The apparatus of claim 1, wherein the plurality of elongate support member elements comprise a zig-zag distal interface.

10. The apparatus of claim 1, wherein the support member comprises two concentric bodies.

11. The apparatus of claim 10, wherein the two concentric bodies are offset from one another in angular relation.

12. The apparatus of claim 10, wherein one of the two concentric bodies is formed as an extension of the shaft.

13. The apparatus of claim 1, wherein the support member is formed in the shaft.

14. The apparatus of claim 1, wherein the plurality of elongate support member elements are headset flat.

15. The apparatus of claim 1, wherein the support member is not connected to the shaft.

16. The apparatus of claim 15, wherein the plurality of elongate support members are J shaped and folded inwardly with the extension.

17. A method of manufacturing a medical device, the method comprising:

forming a section of tubular braid with a first fold;

forming the braid with a second fold adjacent to the first fold to provide an interior flap between the first and second fold; and

inserting an axial support member within the braid layers.

18. The method of claim 17, wherein the support member is inserted between the braid layer.

19. The method of claim 17, wherein the support member is inserted inside the braid layer and not in-between the braid layer.

20. The method of claim 17, further comprising bonding the support member and braid to the shaft with thermoplastic flow through a base of the support member.

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