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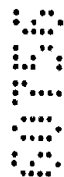
(12) PATENT ABSTRACT (11) Document No. AU-A-60756/96
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APPARATUS AND METHOD FOR COATING OF OBJECTS USING A POROUS RESILIENT MATRIX
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An apparatus for applying a coating to an object includes a pair of reciprocating members which each include a porous resilient pad mounted for movement toward and away from each other. The apparatus includes a coating supply system for supplying coating to the resilient pads. The pads have a movement sequence from an initial rest position where the pads are spaced apart from one another to a coating loading position where the pads are in physical contact and have a degree of compression with each other to load the coating onto the pads, then the pads are moved to an intermediate rest position with the pads spaced apart and the object to be coated is moved between the pads. The sequence then includes a coating delivery position where the pads are in physical contact with each other and the object so that the pads have a degree of compression with each other and the object thereby applying the coating to the object.

Abstract of the Disclosure

An apparatus for applying a coating to an object includes a pair of reciprocating members which each include a porous resilient pad mounted for movement toward and away from each other. The apparatus includes a coating supply system for supplying coating to the resilient pads. The pads have a movement sequence from an initial rest position where the pads are spaced apart from one another to a coating loading position where the pads are in physical contact and have a degree of compression with each other to load the coating onto the pads, then the pads are moved to an intermediate rest position with the pads spaced apart and the object to be coated is moved between the pads. The sequence then includes a coating delivery position where the pads are in physical contact with each other and the object so that the pads have a degree of compression with each other and the object thereby applying the coating to the object.



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COMPLETE SPECIFICATION
STANDARD PATENT

Invention Title:

Apparatus and method for coating of objects using a porous resilient matrix

The following statement is a full description of this invention including the best method of performing it known to us:-

Field of Invention

This invention relates to the coating of objects and more particularly relates to methods
5 and apparatus for applying lubricants to medical devices such as over-the-needle peripheral
venous catheters, hypodermic needles, blades and the like.

Background of the Invention

Medical devices are often assembled from components formed from many different
10 materials. It often is necessary to apply a coating of a lubricant to one or more of the
components so that a component of one material will readily slide against a component of
another material. Examples of this type of application are catheters with guidewires, over-
needle catheters, syringe plunger stopper within a syringe barrel, needles for penetration of
blood collection tube stoppers and the like. In other medical device applications, a lubricant is
15 applied to a device to ease its penetration into the body. Examples of these applications are
surgical blades, hypodermic needles, peripheral venous catheters and the like.

In all of these medical device lubrication applications, there are strict requirements on
the amounts of lubricant, the uniformity of the application and a need to avoid contamination
20 of the device with foreign material other than the lubricant. A further requirement on
application of lubricant results from the high volume production requirements often resulting in
the use of high speed assembly equipment. Thus, any lubricant application must be precise and
compatible with high volume production.

25 Currently, a commonly used lubricant for medical devices is "silicone," i.e.,
polydimethyl siloxane having a Brookfield viscosity between about 1,000 and 20,000
centistokes (cs). For some applications, the silicone is applied "neat", i.e., without solvent. An

example of neat application of silicone to syringe plunger stoppers is disclosed in United States Patent 5,207,293 to Eden et al. This patent discloses a method and apparatus for lubricating syringe stoppers by moving the stoppers between a pair of wheels which are positioned partially in a reservoir containing lubricant so that with rotation of the wheels, lubricant is transferred to the stoppers.

Another commonly used neat application method is tumbling a measured quantity of small parts, such as stoppers, with a measured quantity of lubricant so that the parts acquire a coating of the lubricant.

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Silicone lubricant also may be sprayed onto the parts either neat or in a carrier solvent. Neat spraying has been found to work well for interior surfaces such as inside syringe barrels. Solvent based dipping or spraying is commonly used for coating hypodermic needles and catheters. Chlorofluorocarbon solvents have proven to be very satisfactory for the delivery of silicone onto medical devices because they are non-toxic, non-flammable, inert, evaporate rapidly without leaving residue and are available in very high purity. Unfortunately, because of the belief that chlorofluorocarbon solvents are responsible for destruction of ozone in the upper atmosphere, most commonly used chlorofluorocarbon solvents will no longer be available. Alternate solvents such as hydrocarbons are flammable, and aqueous based systems generally are not practical for silicones.

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Thus, there is a need for an apparatus that is compatible with high production volume and capable of uniformly delivering precise quantities of lubricant to medical devices.

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Summary of the Invention

An apparatus for applying a coating to an object includes a pair of reciprocating members each having a porous resilient pad. The members are mounted for movement toward

and away from each other. The apparatus further includes a coating supply system for supplying the coating to the resilient pads. The members have sequential movement positions starting from an initial rest position with the resilient pads spaced apart from each other. The movement sequence then includes a coating loading position where the resilient pads are in
5 physical contact and have a degree of compression with each other loading the coating into the pads. There is an intermediate rest position where the pads are spaced apart and the object to be coated is placed between the resilient pads. The movement sequence includes a coating delivery position with the resilient pads in physical contact with each other and the object being coated, the resilient pads additionally having a degree of compression with each other and the
10 object, thereby applying the coating to the object.

A method for applying a coating to an object includes placing an object to be coated between two reciprocating members each including a resilient pad mounted for motion toward and away from each other. The object is placed between the pads when the pads are spaced
15 apart from each other and are loaded with the coating to be applied to the object. The method then includes moving the pads from the pads spaced apart position to a position where the pads are in physical contact with each other and the object to be coated so that the pads have a degree of compression with each other and the object to be coated thereby applying the coating to the object.

20 The apparatus and method of the present invention provide a precise coating of neat lubricant to objects such as hypodermic needles, catheters, guidewires and the like. The invention is compatible with high volume assembly and can be built into a compact station to be fit into existing assembly machinery. The method of the present invention leaves no residual
25 solvent and is simple to practice and maintain.

Brief Description of the Drawings

Fig. 1 is a partially sectioned perspective view of the preferred apparatus of the present invention for applying a coating to an object;

5 Figs. 2A to 2E are partial cross-section schematic views of the apparatus of Fig. 1 along the line 2-2 showing the reciprocating members in the several positions of a movement sequence;

Fig. 3 is a flow chart for a method of applying coating to an object with the apparatus illustrated in Fig. 1;

10 Fig. 4 is a perspective partially sectioned view of another embodiment of the apparatus of the present invention;

Figs. 5A to 5E are partial cross-sectional schematic views of the apparatus of Fig. 4 along the line 5-5 showing the reciprocating member in the several positions of a movement sequence;

15 Fig. 6 is a flow chart for a method of applying coating to an object with the apparatus of Fig. 4;

Fig. 7 is a perspective view of another embodiment of the apparatus of the present invention;

Fig. 8 is a partial cross-sectional schematic view of the apparatus of Fig. 7 along the line 8-8;

20 Fig. 9 is a flow chart for a method of applying coating to an object with the apparatus of Fig. 7;

Fig. 10 is a perspective view of a further embodiment of the apparatus of the present invention;

Fig. 11 is a partial schematic view of the apparatus of Fig. 10 along the line 11-11; and

25 Fig. 12 is a flow chart for a method of applying coating to an object with the apparatus of Fig. 10.

Detailed Description

While this invention is satisfied by embodiments in many different forms, there are shown in the drawings and herein described in detail preferred embodiments of the invention with the understanding that the present disclosure is to be considered exemplary of the principles of the invention and is not considered to limit the invention to the embodiments illustrated. The scope of the invention is to be measured by the appended claims and their equivalents.

Referring to Figs. 1 and 2A to 2E, an apparatus 10 for coating an object 12 of the present invention includes a pair of reciprocating members 14A and 14B.

In order to facilitate and simplify the present description, the reciprocating members and other parts of apparatus 10 which are present in pairs are described as symmetrical or identical and are identified with suffixes "A" and "B." For particular applications, such as when object 12 is not symmetrical, the present invention is intended to encompass embodiments where parts of the apparatus, herein described in pairs to simplify the description, are not symmetrical or identical.

Reciprocating members 14A and 14B each further include porous resilient pads 16A and 16B. Members 14A and 14B are preferably mounted on a base 20 and include drive mechanisms 30A, 30B, and supports 31A, 31B. Pads 16A, 16B are mounted for movement toward and away from each other.

Apparatus 10 includes a coating supply system 24 for supplying a coating to resilient pads 16A, 16B. Preferably resilient pads 16A, 16B each include backing plates 40A, 40B each having a first side 42A, 42B and a second side 44A, 44B and having a plurality of holes 46A, 46B therethrough. Pads 16A, 16B each further preferably include reticulated elastomeric foam

layers 48A, 48B having front sides 52A, 52B and back sides 56A, 56B. Back sides 56A, 56B of preferred foam layer 48A, 48B preferably are fixedly attached to first sides 42A, 42B of the backing plates.

5 Members 14A, 14B have a movement sequence schematically illustrated in Figs. 2A to 2E including an initial rest position with resilient pads 16A, 16B spaced apart a distance "m" from each other. The movement sequence then includes a coating loading position where resilient pads 16A, 16B are in physical contact and have a degree of compression with each other. The degree of compression is determined by comparing the thickness t_1 of pads 16A,
10 16B in the initial rest position as shown in Fig 2B to thickness t_2 of pads 16A, 16B in Fig. 2B showing the coating loading position. The compression of the pads serves to spread the coating onto pads 16A, 16B. The compression of the pads in the coating loading step followed by the release of the compression in the intermediate rest position serves to load the coating onto the pads and also to distribute it. The movement sequence then includes
15 movement to an intermediate rest position where resilient pads are again spaced apart distance "m" as shown in Fig. 2C, allowing placement of the object to be coated between the pads. The movement sequence then includes a coating delivery position where pads 16A, 16B are in physical contact with each other and the object being coated. In the coating delivery position, the pads have a thickness t_3 and a degree of compression with each other and the object being
20 coated as represented in Fig. 2D. The degree of compression is determined by comparing the ratio of pad thickness t_3 with thickness t_1 of the initial rest position. In the coating delivery position the coating is transferred from pads 16A, 16B to the object.

25 Preferably, the degree of compression of pads 16A, 16B in the coating loading position (t_2/t_1) is greater than the degree of compression in the coating delivery position (t_3/t_1). When the degree of compression for coating delivery is less than the degree of compression for

coating loading, results show more uniform and precise transfer of the coating to the objects being coated.

Preferably, coating supply system 24 includes a reservoir 26 for holding a coating 27
5 and a transport system 28A, 28B transporting the coating to the pads through holes 46A, 46B. Each of the preferred reciprocating members 14A, 14B include drive mechanisms 30A, 30B for reciprocal movement of the pads through the movement sequence. Preferably apparatus 10 includes an object placement system 34 for placing objects 12 between the pads and then removing the objects. Preferred apparatus 10 includes a control system 32 for controlling the
10 coating supply system, the reciprocating member drive system and the object placing system.

The preferred coating supply system includes having coating transport system 28A, 28B in fluid communication with second sides 44A, 44B of the backing plates 40A, 40B so that a relatively constant supply of coating is maintained at holes 46A, 46B at back sides 56A,
15 56B of the foam layers 48A, 48B to load the resilient foam layers.

Control system 32 preferably adjusts coating supply system 28A, 28B so that there is a sufficient amount of coating available for delivery to the object. The control system may be mechanical, electromechanical, digital and the like to control the coating delivery, the
20 movement of the reciprocating members and the object placement and removal.

A suitable material for the porous foam layer is a reticulated polyurethane foam with between about 300 to about 1250 pores per square centimeter. In applications where the object to be coated is a medical device such a catheter or a hypodermic needle, a preferred
25 foam is a reticulated polyurethane foam which has been permanently thermally sintered from an as-blown height of between about 5cm to 25cm to a height of about 2.5cm. One skilled in the art of polymeric foams recognizes that the thermal sintering is also described as "felting," and

further described as "firmness" or "firmness ratio" of between 2 and 10. Thermal sintering involves compressing the foam from the as-blown thickness to a desired thickness, then heating. When the compression then is released, the foam retains the compressed thickness. This sintering has the effect of increasing the density of the foam by reducing the void volume
5 of the pores in the foam.

In the preferred present apparatus, where the object being coated is a medical device such as a catheter, hypodermic needle, a catheter mounted over a hypodermic needle and the like, preferred resilient foam pads 16A, 16B have a thickness t_1 between about 0.25cm to
10 about 2.5cm and most preferably between about 0.4cm to about 0.8cm. Preferably the object being coated is placed substantially centrally between the resilient foam pads so that when the pads are in the coating delivery position, the object is not substantially deflected. The positioning of the object is particularly important when the object being coated is pointed, e.g., a hypodermic needle or a catheter mounted over a needle. If a pointed object is deflected
15 during the coating delivery compression, there may be a tendency to cause the point to partially imbed in one pad or the other, potentially damaging the point, reducing the service life of the pad and generating undesirable particles.

Preferably the foam has about 10 to about 100 pores per linear cm with a firmness
20 about 4. This preferred foam will have about 85% to about 90% void volume or open pore space. Suitable reticulated polyurethane foams, which are available in a range of firmness between 2 and 10, are available as "Foamex SIF felt" from Speciality Polyurethane, 1500 E. Second Street, Eddystone, PA 19013 and from E. E. Murray Co., 707 Umatilla Street, Denver, CO 80204. Other foams having similar properties are expected to perform
25 satisfactorily. In cases where the objects to be coated are not medical devices such as needles, blades, catheters and the like, foams having different properties may be desired. In the preferred coating system, the coating is a lubricant. The apparatus of the invention is suitable

for application of other coatings including, but not limited to, colorants, pesticides and the like. For these other applications, foams having different composition and properties may be selected and are included in the scope of the invention.

5 In the preferred application, the degree of compression between resilient pads 16A, 16B in the coating loading position is greater than the degree of compression in the coating delivery position. These compression positions have the effect of reducing the void volume or open space within the foam. When the compression is released from the coating loading position, the foam returns to the original uncompressed volume, and at least a portion of the
10 void volume is occupied by the coating charge. When the foam having a charge of coating is compressed into the coating delivery position, the foam preferably substantially engulfs the object being coated, the coating in the portion of the void volume is displaced and transferred to the object being coated.

15 One skilled in the art of lubricating medical devices recognizes that a coating of polydimethyl siloxane is often used as a lubricant on medical devices such as hypodermic needles, scalpels and guidewires made from metal and on medical devices formed from polymeric materials such as catheters and probes. The purpose of the lubricant coating is to reduce the sliding friction between the device and tissue or the sliding friction between one
20 component of the device and another. In almost all applications of silicone lubricant to medical devices there are two conflicting requirements governing the amount applied; there should be some uniform minimum amount applied over the entire surface where the sliding friction is to be reduced; and there should not be excess or visible silicone present on the device. These requirements are often in conflict with each other since polydimethyl siloxane with viscosity
25 above about 500cs applied by direct dipping into the neat material, while providing complete coverage, generally results in an undesirable excess that leads to visible droplet formation. Currently, many silicone lubricant applications rely on use of a volatile solvent carrier to dilute

the silicone, insure complete coverage of the object and avoid deposition of excess lubricant. Since polydimethyl siloxane is non-polar, many solvents otherwise suitable for its delivery are quite flammable and the medical device industry evolved toward non-flammable chlorofluorocarbon solvents. With the recent recognition of the ozone depletion problem and its attribution to chlorofluorocarbons, many of these solvent based dilution systems for application of silicone are no longer practical.

As an example, data is presented related to coating four 14 gauge catheters at a time with 12,500cs. polydimethyl siloxane (silicone) using the preferred embodiment of the present invention illustrated in Figs. 1-3. The control used in this study was standard commercial product having identical components. The control product was lubricated with identical silicone applied using a chlorofluorocarbon solvent based application system. While the preferred embodiment of the present invention is well suited for the lubrication of cylindrical objects with a length at least three times longer than their diameter such as needles and catheters, this example is not to be considered limitative of the invention to 14g catheters, rather it is intended to show the utility and repeatability of the apparatus and method in use over a 24 hour period. In this example, the foam used was firmness 4 polyurethane Foamex. Preferably, pads 16A, 16B are each divided into four sections 17A, 17B, the sections being mounted on each reciprocating member to facilitate easy replacement. Each section 17A, 17B is about 0.635 cm thick (t_1) by 1.27 cm wide by 6.35 cm long giving an uncompressed 16A, 16B volume of 41 cm³. The preferred apparatus was set up so that in the coating loading position pads 16A, 16B were compressed to a thickness of 0.158 cm (t_2), a 75% compression ($t_2/t_1 = 0.25$). In the coating delivery position, the pads 16A, 16B were compressed to a thickness of 0.312 cm (t_3), a 50% compression ($t_3/t_1 = 0.5$). The void volume, i.e., the pores, in the uncompressed state of the foam is about 88% of 41 cm³. When the foam is under 75% compression, the void volume decreases from 88% to a value of 76%. When the foam returns to the uncompressed state the increase in void volume is 12% of 41 cm³ or 4.92 cm³ at least a portion of the void volume then is filled by the preferred coating material, polydimethyl

siloxane having a viscosity of 12,500cs. While the preferred polydimethyl siloxane has a viscosity about 12,500cs, the present invention is suitable for application of polydimethyl siloxanes or other coatings with Brookfield viscosities at 25°C. between about 10cs to about 1,000,000cs.

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The 24 hour trial run of the apparatus of the present invention was conducted to apply 12,500cs polydimethyl siloxane for lubrication to the 14g peripheral venous catheters mounted over needles. Samples of the coated catheters were taken at regular intervals and the amount of silicone lubricant present on their surface was determined by extraction. In the preferred configuration used in the trial, the reciprocating members are mounted so that the pads are vertical with the motion toward and away from each other being horizontal. Preferably, top surfaces 19A, 19B of the resilient pads are sealed so that when the pads are in the compressed state the coating cannot pass through the top surface of the pad and pool on surfaces 19A, 19B of the pads. The top surface may be sealed by adhesive, fusing by heat, ultrasound and the like. Preferably top surfaces 19A, 19B are fused by pressing against a smooth surfaced heated above the melting point of the polyurethane foam forming a skin. When the apparatus is operating in a steady state, control system 32 is preferably adjusted so that the amount of coating material delivered to the foam pads is only a slight excess to the desired amount being applied to the catheters. The slight excess cannot pool on the top surface because of the sealed surfaces 19A, 19B and migrates to the bottom of the pads where it may be collected without effecting the amount present on the catheters. The slight excess delivery to the pads ensures that the distribution into the pads during the coating loading cycle is sufficient to provide substantially uniform coverage of the object being coated.

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The results show that the preferred apparatus of the present invention was able to reliably and repeatedly apply 0.30 ± 0.075 mg polydimethyl siloxane to more than 20,000 catheters over a 24 hour period. Comparisons in standard laboratory performance testing for

penetration force and drag force show generally similar behavior between these experimental catheters lubricated by the preferred apparatus of the present invention and standard commercial product lubricated by application of the same silicone in chlorofluorocarbon solvent.

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A constant concern in manufacture of over needle catheters is damage to the point of the needle during lubrication of the catheter and introduction of foreign matter onto the catheter or needle point during lubrication. In the trial, there was overall comparable performance of the catheters lubricated by the preferred present invention to standard commercial product indicating that the lubrication levels were comparable and that there was no detectable degradation in needle point quality. Careful microscopic examination showed that there was little evidence of introduction of particulates resulting from the contact between the resilient foam and the catheter. Further, there was no additional microbial background contamination or bioburden on catheters lubricated in the trial of the preferred apparatus when compared to the standard commercial product.

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Referring now to Figs. 4-12, alternative embodiments of the coating apparatus of the present invention are illustrated. In these embodiments the coating loading and the coating delivery include compression and release of a porous resilient member being loaded with and delivering coating to an object. Accordingly, substantially similar components performing substantially similar functions are numbered identically to those components of the embodiment of Figs. 1-3 except that the reference characters include hundreds digits to identify those components in Figs. 4-12.

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In the embodiment illustrated in Figs. 4-6, apparatus 110 includes a reciprocating member 114 with a coating supply system 124 for supplying a coating to a resilient pad 116. Preferably resilient pad 116 includes a backing plate 140 having a first side 142 and a second

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side 144 and having a plurality of holes 146 therethrough. Pad 116 further preferably includes a reticulated resilient foam layer 148 having a front side 152 and a back side 156. Back side 156 is preferably fixedly attached to first side 142 of the backing plate.

5 Member 114 has sequential movement positions, illustrated in Figs. 5A to 5E, similar to that described for the embodiment of Figs. 1-3. In the embodiment of Figs. 4-6, coating 127 is supplied to resilient pad 116 by a coating supply system 124 from a coating reservoir 126 through a coating transport system 128. In the movement sequence, member 114 includes an initial rest position with resilient pad 116 spaced a distance "m" from a fixed member 117
10 having a resilient surface 119. The movement sequence then includes a coating loading position with resilient pad 116 in physical contact with and has a degree of compression with the fixed member as shown by comparing the thickness t_1 of pad 116 in the initial rest position shown in Fig. 5B to thickness t_2 of pad 116 in Fig. 5B which shows the coating loading position. The compression serves to load and spread the coating into pad 116. The sequential
15 movement then includes movement to an intermediate rest position shown in Fig. 5C, where resilient pad 116 is again spaced a distance "m" away from fixed member 117. The intermediate rest position allows placement of object 112 to be coated between resilient pad 116 and fixed member 117. The movement sequence then includes a coating delivery position shown in Fig. 5D where pad 116 is in physical contact with and has a degree of compression
20 with surface 119 of the fixed member and the object to be coated. The coating delivery position serves to transfer the coating from pad 116 to the object. Preferably, object 112 is placed closely adjacent to surface 119 of the fixed member so that object 112 is not substantially deflected by the physical contact of pad 116 in the coating delivery position.

25 Preferably, the degree of compression of pad 116 in the coating loading position (t_2/t_1) is greater than the degree of compression in the coating delivery position (t_3/t_1). In this embodiment, coating supply system 124 having coating reservoir 126 and a coating transport

system 128 perform similar functions as in the embodiment of Figs. 1-3 as does object delivery system 134. Reciprocating member 114 preferably is mounted on a base 120 and includes a drive mechanism 130. Apparatus 110 preferably includes a control system 132 to synchronize movement of reciprocating member 114, movement of objects 112 and delivery of the coating
5 so that the amount of coating delivered to the object is precisely controlled.

A preferred method for applying a coating to an object using apparatus 110 is outlined in Fig. 6. The method includes having pad 116 away from fixed member 117 in an initial rest position, moving the pad to a coating loading position against fixed member 117 and moving
10 the pad away from the fixed member so that an object to be coated may be moved to a position intermediate to the pad and the fixed member. The preferred method then includes moving the pad to a coating delivery position where the pad is in physical contact and in a degree of compression with the object and the fixed member applying the coating to the object. The pad is then moved away from the fixed member and the coated object removed.

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Other embodiments illustrated in Figs. 7-12, are within the scope of the present invention. As shown in Figs. 7-9, an apparatus 210 is used for coating an object 212. Apparatus 210 includes a rotating member 250 with a porous resilient roll 216. Rotating member 250 rotates about a shaft 251. Rotating member 250 has a rotary movement sequence schematically illustrated in Fig. 8. The movement sequence includes a coating loading segment where resilient roll 216 is in physical contact with and has a degree of compression with a coating loading member 260. The coating loading member 260 preferably is supplied with coating by a coating supply system 224 which includes a coating reservoir 226 with a coating 227 and a coating transport system 228. The coating loading member may rotate counter to the rotation of rotating member 250 or it may be fixed, but preferably, coating loading member 260 rotates counter to member 250. Member 260 preferably is porous with the coating being supplied to a contact surface 262 of member 260 through a plurality passageways 264 supplied

by transport system 228. As resilient roll 216 passes surface 262, the degree of compression may be determined by comparing uncompressed thickness t_1 with thickness t_2 where roll 216 contacts coating member 260. The t_2/t_1 compression serves to transfer the coating to the resilient roll and spread it uniformly.

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Apparatus 210 preferably further includes a base 220 and a rotating support member 270 having a resilient surface 272. As resilient roll 216 rotates past coating loading member 260 the compression is released and roll 216 returns to uncompressed thickness t_1 . Apparatus 210 preferably includes an object handling system 234 for moving objects 212 to be coated
10 between resilient roll 216 and rotating support member 270 at the coating loading segment so that resilient roll 216 is in physical contact and has a degree of compression with object 212 and surface 272 of the rotating support member in an area 213. The compression between roll 216 and object 212 transfers the coating to the object. The degree of compression between resilient roll 216 and surface 272 is shown by thickness (t_3/t_1). Preferably the degree of
15 compression in the coating loading segment is greater than the degree of compression in the coating delivery segment.

A method for applying a coating to an object using the apparatus 210 of the present invention includes moving objects 212 between rotating member 250 which has porous
20 resilient roll 216 with a loading of a coating mounted for rotatory motion about shaft 251 in a coating delivery segment so that the roll contacts resilient surface 272 on rotating support member 270 and object 212 with a degree of compression.

As shown in Figs. 10-11, an apparatus 310 for applying a coating to an object 312
25 includes a pair of rotating members 350A, 350B mounted for counter-rotatory movement so that the members contact each other during one segment of the movement in an area of contact 313 and do not contact each other at other segments of the movement. Rotating members

350A, 350B rotate respectively about shafts 351A, 351B. Rotating members 350A, 350B have a rotary movement sequence schematically illustrated in Fig. 11. The movement sequence includes a coating loading segment where each resilient roll 316A, 316B is respectively in physical contact and has a degree of compression with coating loading members 5 360A, 360B. Coating loading members 360A, 360B may rotate counter to the rotation of rotating member 350A, 350B or the coating loading members may be fixed, but preferably, coating loading members 360A, 360B rotate counter to members 350A, 350B. Members 360A, 360B preferably are porous with the coating being supplied to contact surfaces 362A, 362B through a plurality of passageways 364A, 364B supplied by transport system 328A, 10 328B. As resilient rolls 316A, 316B, respectively, pass surfaces 362A, 362B, the degree of compression may be determined by comparing uncompressed thickness t_1 with thickness t_2 where rolls 316A, 316B contact coating members 360A, 360B. The compression t_2/t_1 serves to transfer the coating to the resilient rolls and spread it uniformly into the rolls.

15 Apparatus 310 preferably further includes a base 320 for mounting the rotating members and the coating loading members. As resilient rolls 316A, 316B rotate past coating loading members 360A, 360B, the compression is released and rolls 316A, 316B return to the uncompressed thickness t_1 . Apparatus 310 preferably includes an object handling system 334 for moving objects 312 to be coated between the resilient rolls 316A, 316B in the direction of 20 rotation of the rolls at the position where the rolls are in physical contact with each other and have a degree of compression. This movement of the objects between the rolls causes the rolls to have a degree of compression with object 312 being coated transferring coating from the rolls to the object. Preferably, the movement of objects 312 between resilient rolls 316A, 316B is a continuous motion into and out of area of contact 313 of the rolls. The degree of 25 compression between the resilient rolls is determined by thickness t_3/t_1 . Preferably the degree of compression in the coating loading (t_2/t_1) segment is greater than the degree of compression (t_3/t_1) in the coating delivery segment.

A method for applying a coating to an object using the apparatus 310 of the present invention includes moving objects 312 between rotating members 350A, 350B which has porous resilient rolls 316A, 316B with a loading of a coating. The rolls are mounted for
5 counter rotatory motion about shafts 351A, 351B in a coating delivery segment so that the rolls contact each other and the object being coated with a degree of compression.

The coating apparatus of the present invention may be compactly built to fit on assembly machines into space currently used for solvent based coating apparatus. The
10 apparatus and method for its use demonstrate a capability to produce product having similar quality and performance properties to standard commercial product produced with solvent based coating. The apparatus of the present invention is also compatible with the assembly rate requirements and efficiency of current assembly machines using solvent based coating systems. The present invention provides a simple and reliable coating station for medical
15 device assembly machines allowing manufacturers to eliminate the use of solvent based coating systems in many applications.

THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS: -

1. An apparatus for applying a coating to an object comprising:

a pair of reciprocating members each comprising a porous resilient pad mounted for movement toward and away from each other;

5 a coating supply system for supplying a coating to said resilient pads; and

said members having sequential movement positions comprising an initial rest position wherein said resilient pads are spaced apart from each other, a coating loading position wherein said resilient pads are in physical contact and have a degree of compression with each other thereby loading the coating into the pads, an intermediate rest position wherein
10 said resilient pads are spaced apart from each other so that an object to be coated is placeable between said resilient pads, a coating delivery position wherein said resilient pads are in physical contact with each other and with the object to be coated, said pads having a degree of compression with each other and the object to be coated in order to apply the coating to the object.

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2. The apparatus of claim 1 wherein said degree of compression in said coating loading position is greater than said degree of compression in said coating delivery position.

3. The apparatus of claim 1 wherein said coating supply system comprises a
20 reservoir and a transport system for supplying the coating to the resilient pads.

4. The apparatus of claim 1 wherein each of said reciprocating members further includes a drive mechanism and a backing plate for mounting said resilient pads.

25 5. The apparatus of claim 4 wherein said backing plates have a first side and a second side and further include a plurality of openings therethrough, said first side having said

resilient pads mounted thereon and said openings being in fluid communication with said second side to said coating supply system for supplying said coating to said resilient pads.

6. The apparatus of claim 1 wherein said resilient pads are foam and have a sealed top edge surface, said sealed top edge surface serving substantially to prevent said coating from pooling on said top edge surface of said pad when said pads are compressed in said coating loading position.

7. The apparatus of claim 1 wherein said coating is a lubricant comprising polydimethyl siloxane having a Brookfield viscosity between about 100 centistokes to about 1,000,000 centistokes.

8. A method for applying a coating to an object comprising:

placing an object to be coated between two reciprocating members each comprising a porous resilient pad mounted for motion toward and away from each other, said placing occurring when said pads are in a position having said pads spaced a distance apart from each other and having a loading of a coating to be applied to the object; and

moving said pads from said position having said pads spaced apart to a position having said pads in physical contact with each other and the object to be coated, so that said pads have a degree of compression with each other and the object to be coated, thereby applying the coating to the object.

9. The method of claim 8 wherein the object is a cylinder having a ratio of length to diameter greater than three to one and said placing step comprises placing the object intermediate said pads when said pads are spaced apart so that when said pads are moved to said position having said pads in physical contact with each other and the object, said degree of

compression between said pads and the object being similar from each pad so that said object is not substantially deflected.

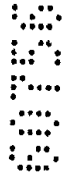
- 5 10. The method of claim 9 wherein said reciprocating members further include a coating supply system and said loading of said coating of said resilient pads further comprises moving said pads from a position having said pads spaced apart to a coating loading position having said pads in physical contact with each other and having a degree of compression with each other, the coating thereby being loaded into said pads, said coating loading step occurring
10 before said object placing step.

DATED THIS 26 day of July 1996

BECTON DICKINSON AND COMPANY

Patent Attorneys for the
Applicant:-

F B RICE & CO



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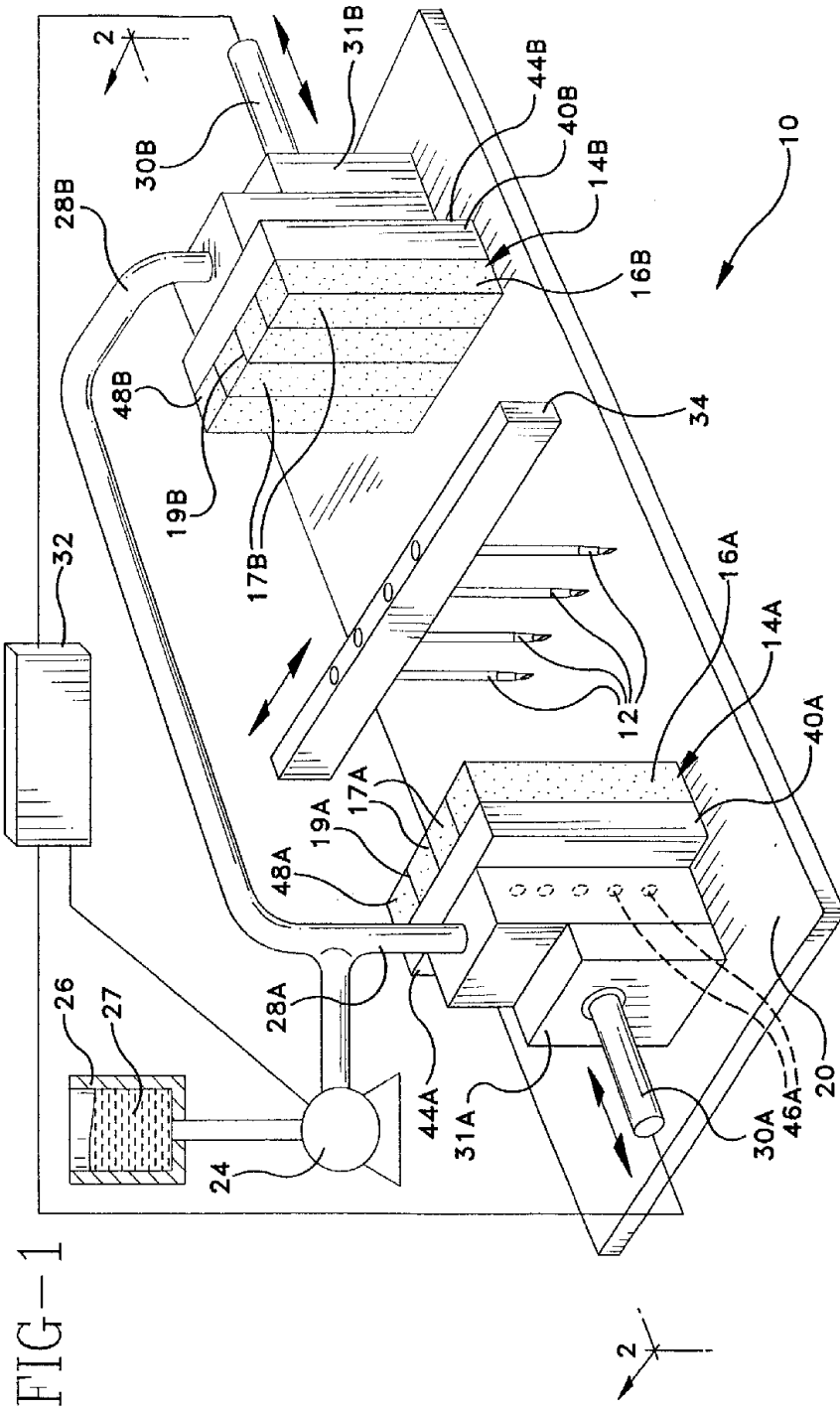


FIG-2A

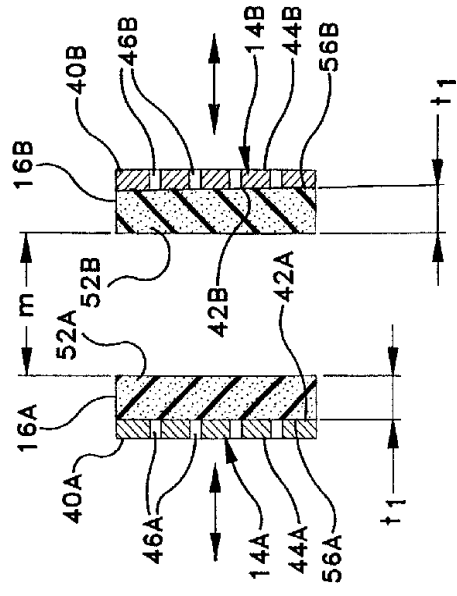


FIG-2B

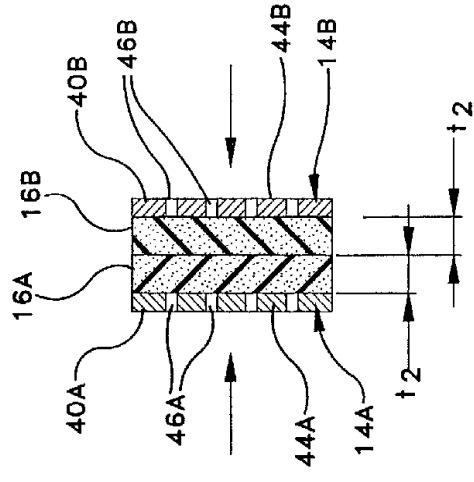


FIG-2C

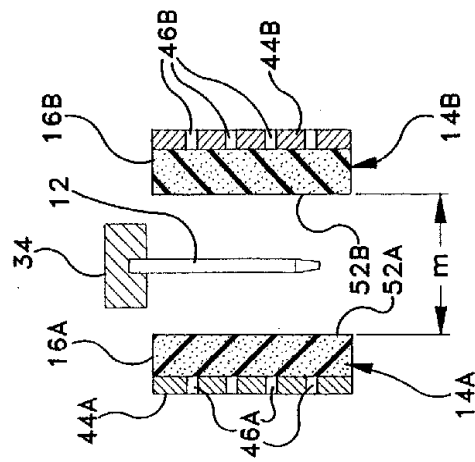


FIG-2D

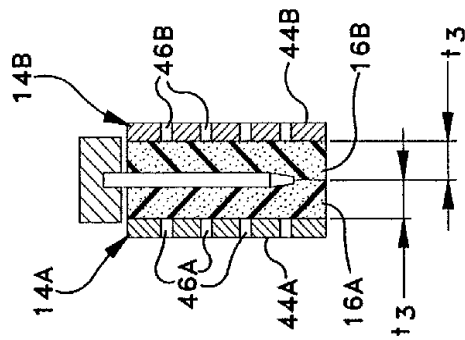


FIG-2E

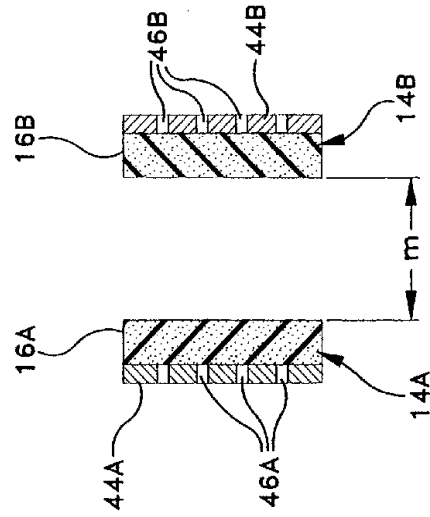
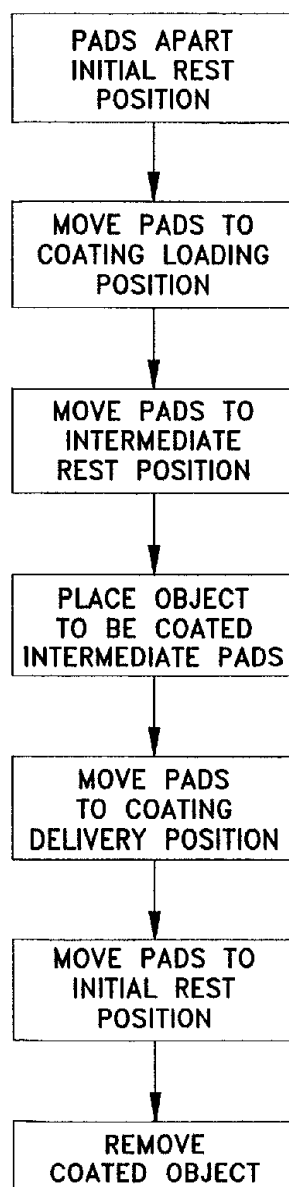


FIG-3



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FIG-4

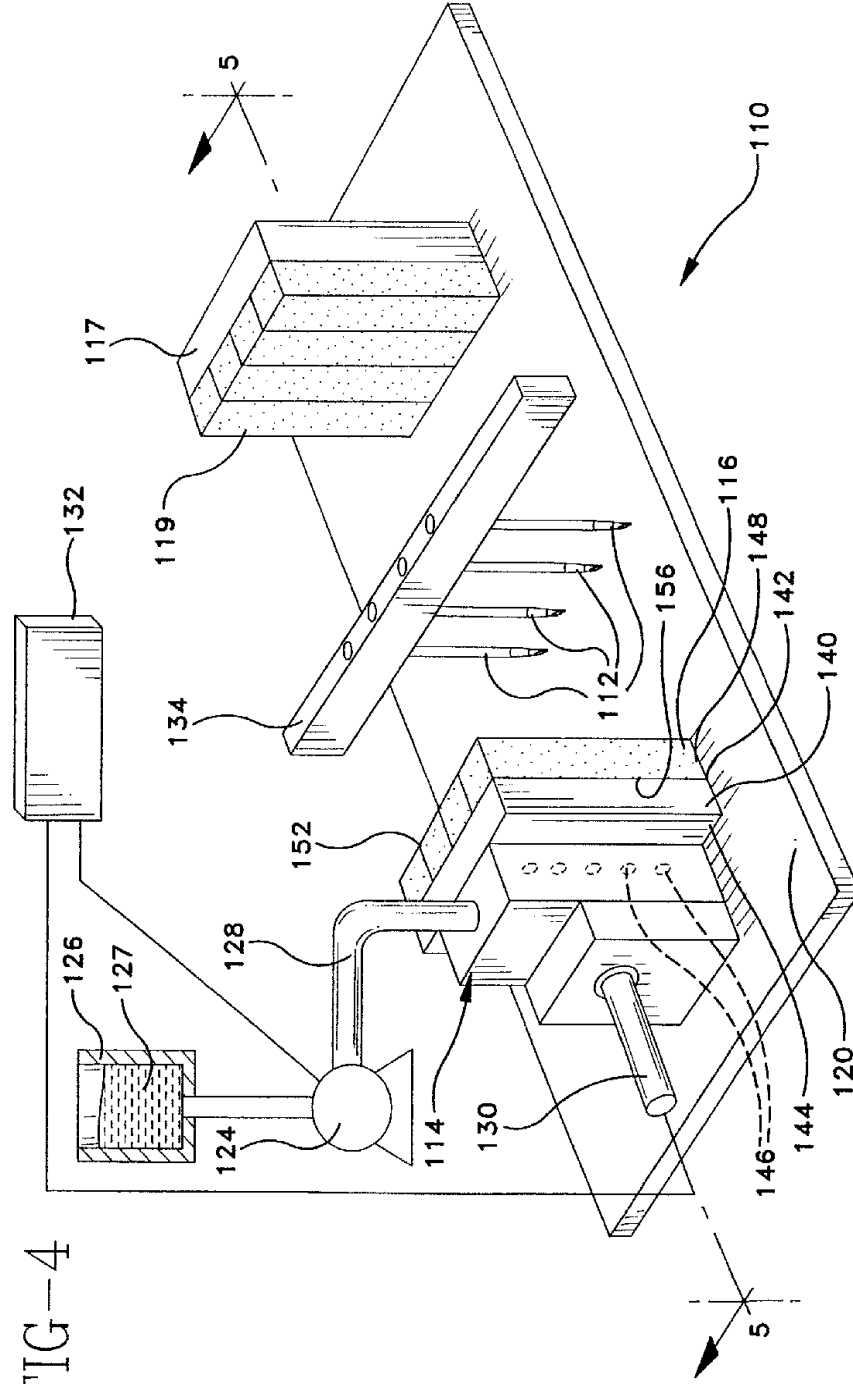


FIG-5A

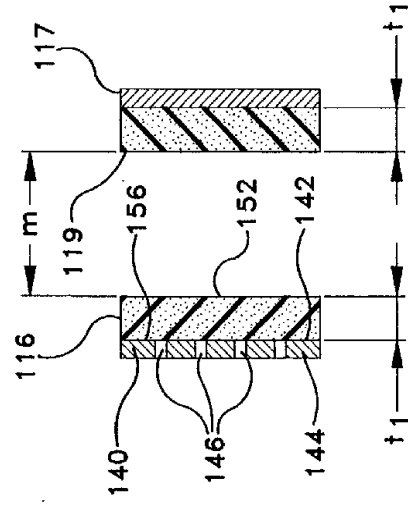


FIG-5B

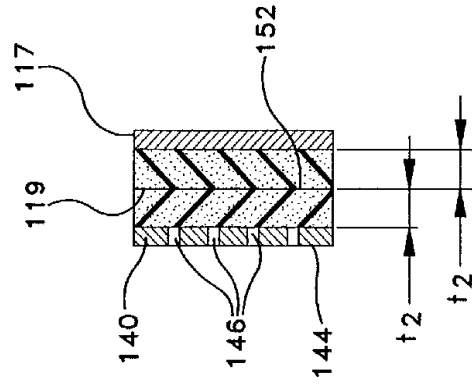


FIG-5C

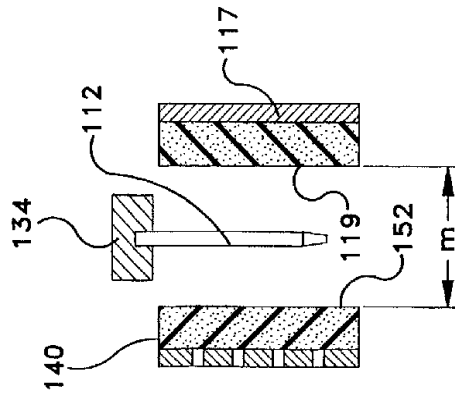


FIG-5D

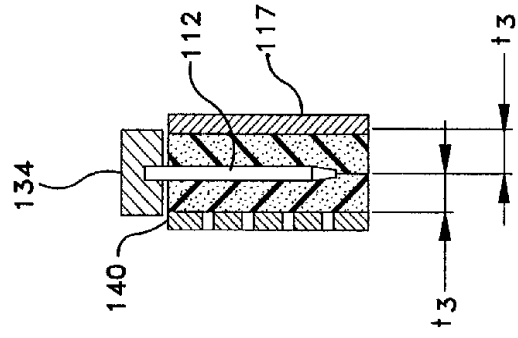


FIG-5E

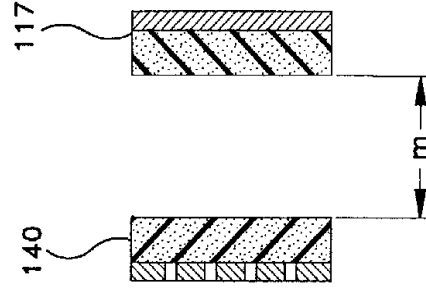


FIG-6

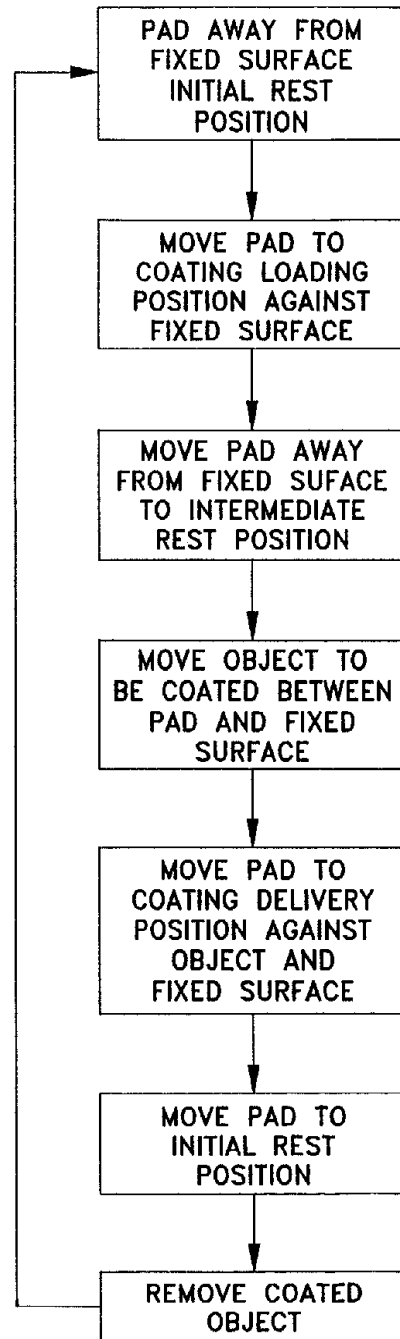


FIG-7

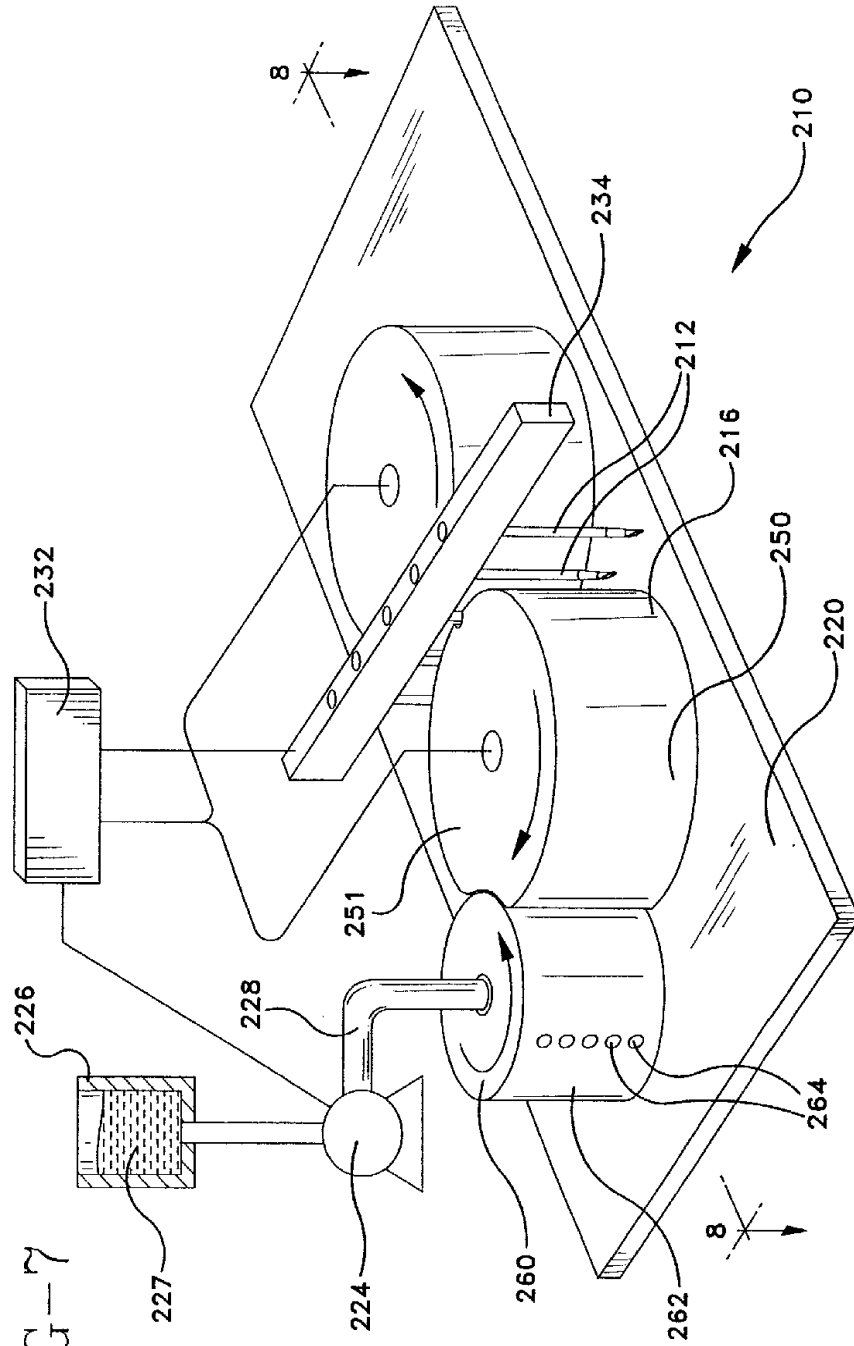


FIG-8

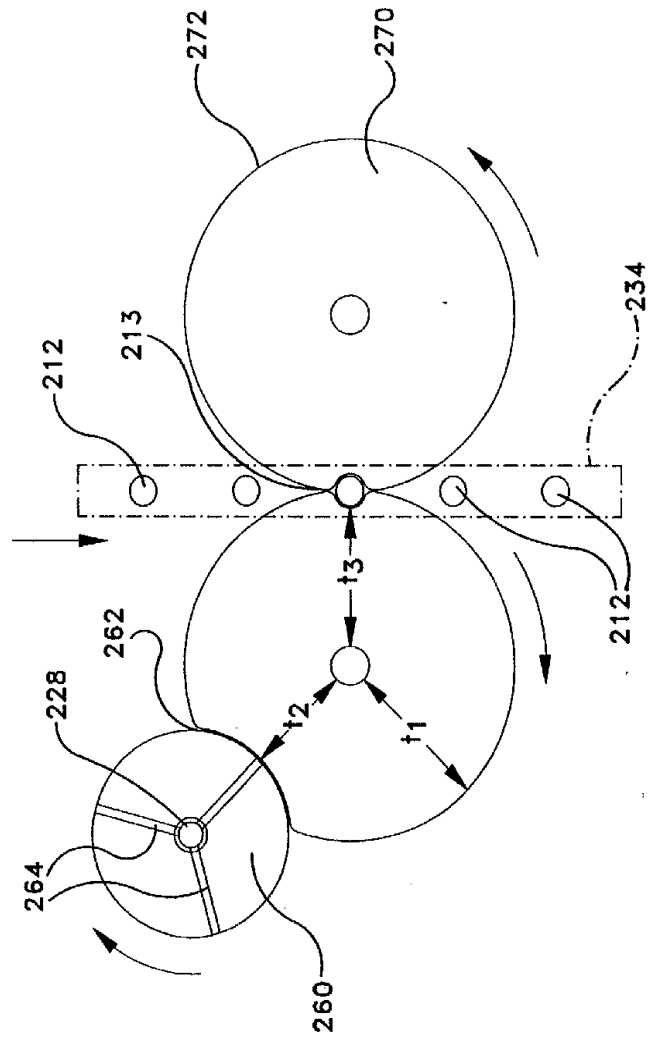
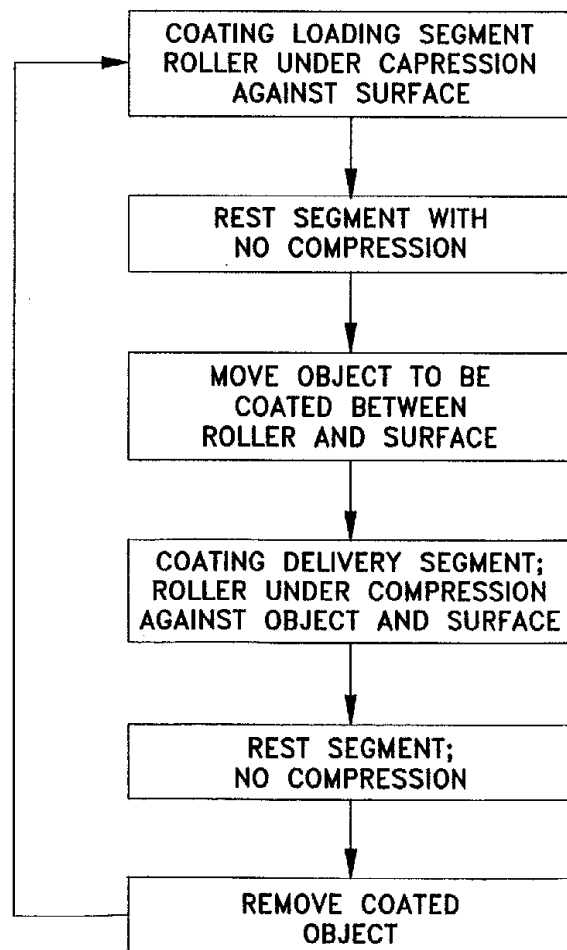


FIG-9



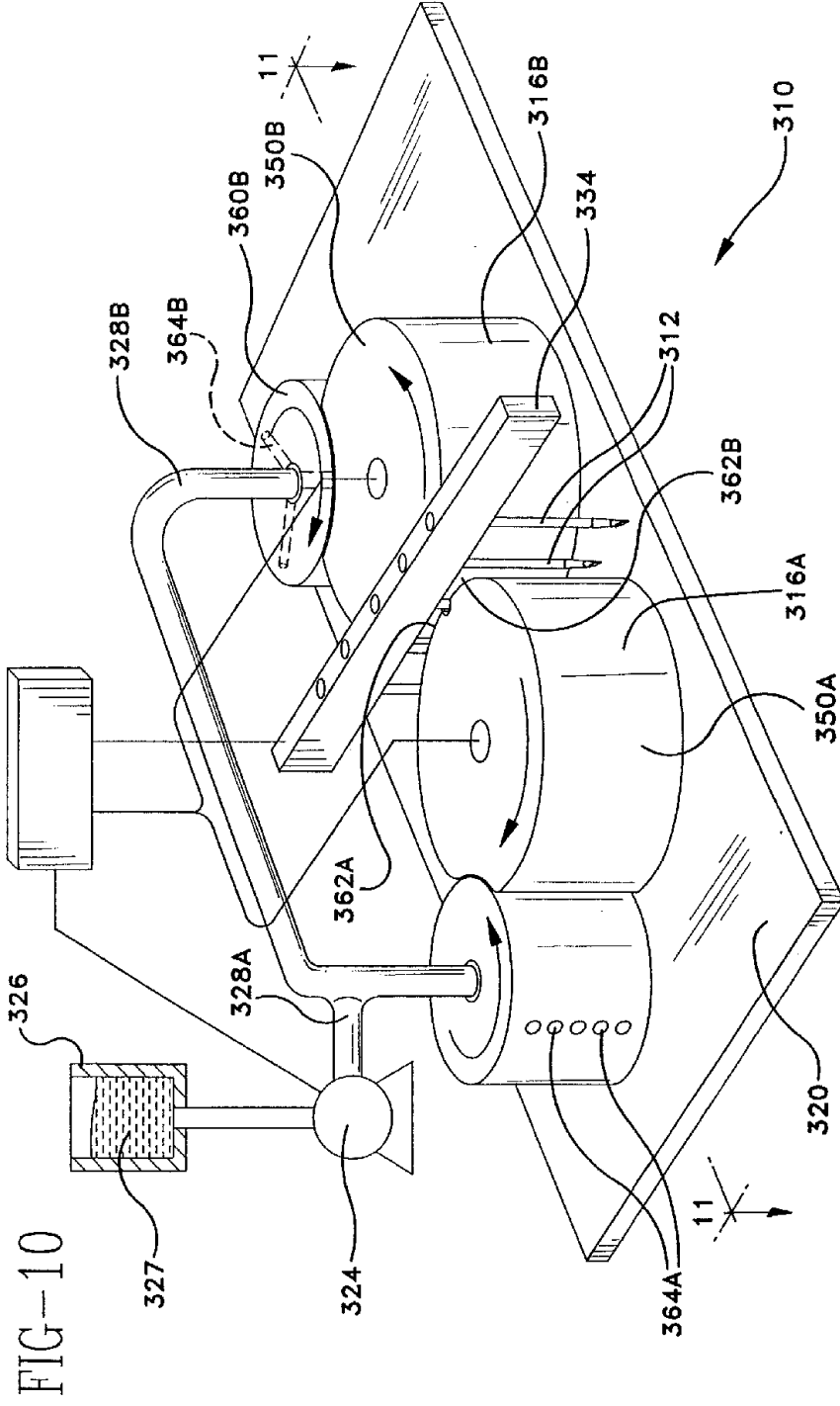


FIG-11

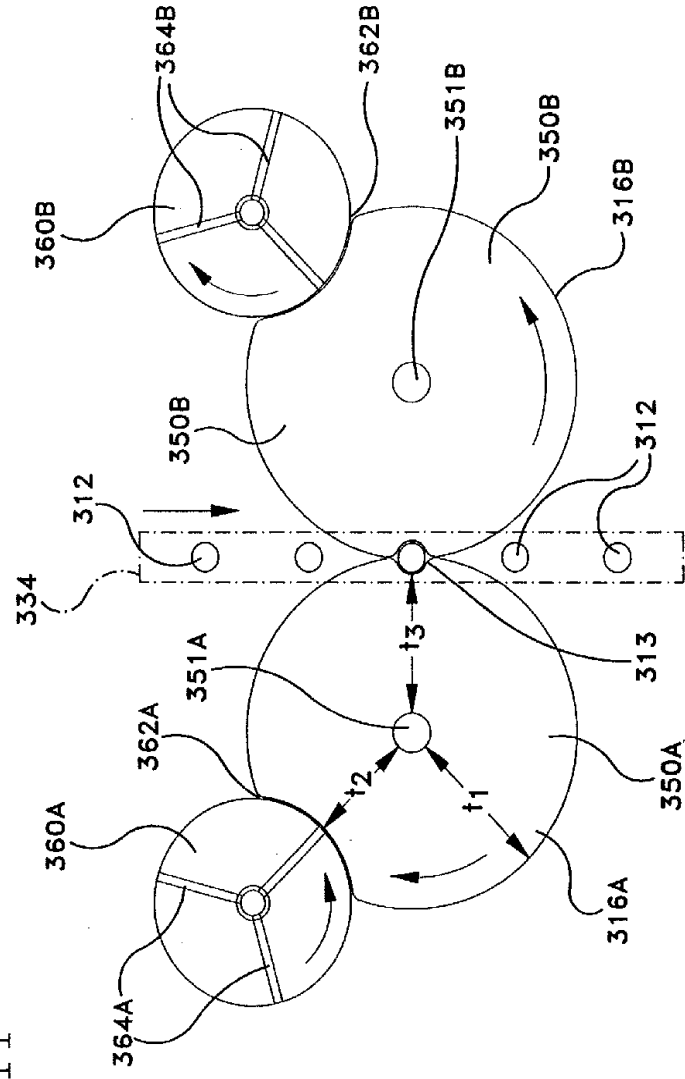


FIG-12

