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**POLY(ARYL ETHER SULFONES) WITH IMPROVED
ENVIRONMENTAL STRESS-CRACK RESISTANCE
AND MEDICAL DEVICES MADE THEREFROM**

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Field of Invention

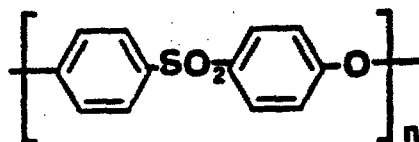
This invention is directed to the use of certain well-defined poly(aryl ether sulfones) in medical devices where transparency and excellent environmental stress-crack resistance are required. These poly(aryl ether sulfones) are based on 4,4'-dichlorodiphenyl sulfone and an aromatic dihydroxy compound which is a mixture of either:

- (a) 4,4'-dihydroxydiphenyl sulfone and hydroquinone;
- (b) 4,4'-dihydroxydiphenyl sulfone and 4,4'-biphenol;
- (c) 2,2-bis(4-hydroxyphenyl)propane (bisphenol-A) and 4,4'-biphenol; or
- (d) 2,2-bis(4-hydroxyphenyl)propane and hydroquinone.

Articles made from these poly(aryl ether sulfones) can be steam-sterilized while under stresses of 500 psi or greater; moreover they are not affected by corrosion-reducing additives such as morpholine, for example. Also, the above materials demonstrate good chemical resistance in contact with commonly used hospital cleaners and detergents.

Background of the Invention

Poly(aryl ether sulfones) have been known for about two decades. They are tough linear polymers that possess a number of attractive features such as excellent high temperature resistance, good electrical properties, and very good hydrolytic stability. Two poly(aryl ether sulfones) are commercially available. A poly(aryl ether sulfone) is available from Imperial Chemical Industries, Ltd. It has the formula (1)



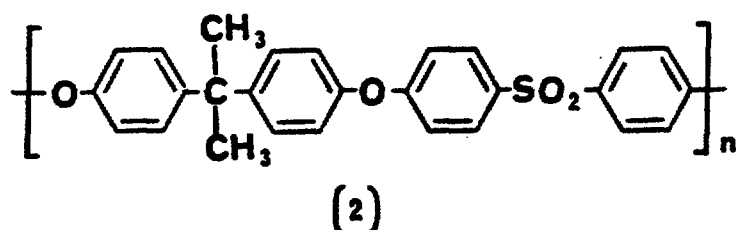
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☒	Description : paged 1 to paged 13	
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and is produced by the polycondensation of 4,4'-dihydroxy-diphenyl sulfone with 4,4'-dichlorodiphenyl sulfone as described in, for example, Canadian Patent No. 847,963. The polymer contains no aliphatic moieties and has a heat deflection temperature of approximately 210°C. Another commercial poly(aryl ether sulfone) is available from Amoco Performance Products, Inc., under the trademark of UDEL®. It corresponds to formula (2),



has a heat deflection temperature of about 180°C, and is made via the nucleophilic polycondensation of bisphenol-A di-sodium salt with 4,4'-dichlorodiphenyl sulfone, as described in U.S. Patent No. 4,108,837.

Over the years, there has developed a substantial body of patent and other literature directed to the formation and properties of poly(aryl ether sulfones) and other poly(aryl ethers) (all hereinafter called "PAE"). A broad range of PAE's was achieved by Johnson et al., J. of Polymer Science, A-1, Vol. 5, 1967, pp. 2415-2427; Johnson et al., U.S. Patent Nos. 4,108,837 and 4,175,175. Johnson et al. show that a very broad range of PAE's can be formed by the nucleophilic aromatic substitution (condensation) reaction of an activated aromatic dihalide and an aromatic diol. By this method, Johnson et al. created a host of new PAE's.

Because of their excellent mechanical and thermal properties, coupled with outstanding hydrolytic stability, the poly(aryl ether sulfones) have been utilized in the medical market for a variety of purposes for at least ten years. These medical devices constitute a wide variety of

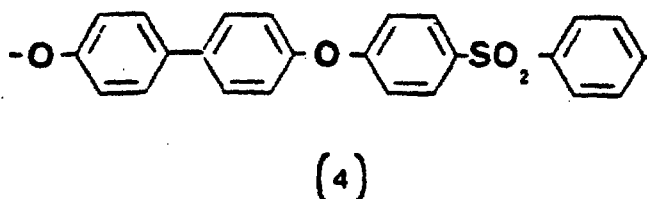
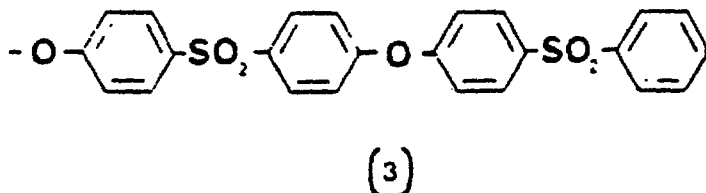




articles. Obviously, one of the major attributes of the poly(aryl ether sulfones) is their ability to be steam autoclaved repeatedly without loss of properties. Steam autoclaving is a very severe test, requiring both high temperature and hydrolytic stability, and involving cyclical effects - wet/dry, hot/cold.

The poly(aryl ether sulfones) (1) and (2) show some important deficiencies, however. Indeed, parts molded from these materials, stress-crack when steam sterilized under stresses of say 500 psi or greater; especially when boiler additives, such as morpholine are employed to reduce corrosion in the steam generating system; or, when in contact with commonly used hospital cleaners and detergents. A way, whereby these deficiencies can be circumvented is described in the present invention.

British Patent Application No. 2,088,396 describes copolymers containing units (3) and (4):



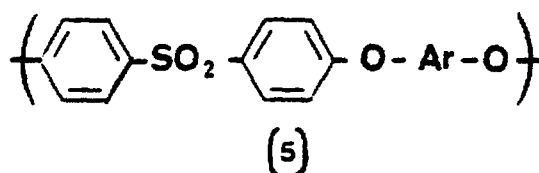
The claimed copolymers comprise about 80 to 10 mole percent of repeat units (3), and correspondingly about 20 to 90 mole percent of repeat units (4). The application states that the incorporation of (4) into the poly(aryl ether sulfone) (1) yields materials with improved resistance to hot water crazing. The application does not mention steam-sterilizability under load; nor does it teach that the copolymers show resistance to stress-cracking in the pres-

ence of boiler additives such as morpholine, or when in contact with typical hospital cleaners and detergents.

The Invention

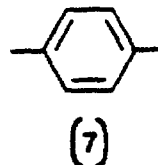
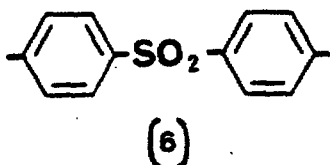
It was now unexpectedly discovered that certain poly-(aryl ether sulfones) closely related to the materials (1), and (2), display superior stress-crack resistance when steam-sterilized under stresses of 500 psi or greater. These materials are unaffected by corrosion-reducing additives in the steam generating system (e.g., by morpholine or similar substances); or when in contact with commonly used hospital cleaners and detergents.

The poly(aryl ether sulfones) of the instant invention are of formula (5)

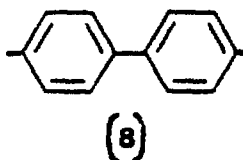


wherein Ar is either

- (a) a mixture of (6) and (7), containing from about 20 to about 100 mole percent of (7); or



- (b) a mixture of (6) and (8), containing from about 60 to about 100, preferably from about 75 to

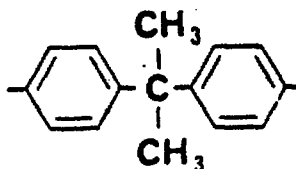


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about 100, and most preferably from about 85 to about 100 mole percent of (8); or

- (c) a mixture of (8) and (9), containing from about 60 to about 100, preferably from about 75 to about 100,



(9)

and most preferably from about 85 to about 100 mole percent of (8); or

- (d) a mixture of (9) and (7) containing from about 20 to about 100 mole percent of (7).

In addition, blends of (5) with either (1) or, with (2), wherein the weight proportion of (1) or of (2) is 50 percent or less, were also found to be satisfactory for applications herein before described.

The poly(aryl ether sulfones) (5) may be prepared by either of two methods, i.e., the carbonate method or the alkali metal hydroxide method.

In the carbonate method, the polymers are prepared by contacting substantially equimolar amounts of the hydroxy-containing compounds and dihalodiarylsulfones, e.g., 4,4'-dichlorodiphenyl sulfone or 4,4'-difluorodiphenyl sulfone, with from about 0.5 to about 1.0 mole of an alkali metal carbonate per mole of hydroxyl group in a solvent mixture comprising a solvent which forms an azeotrope with water in order to maintain the reaction medium at substantially anhydrous conditions during the polymerization.

The temperature of the reaction mixture is kept at about 170°C to about 250°C, preferably from about 210°C to about 235°C for about one to 15 hours.

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In a modification which is particularly suitable for making copolymers from bisphenol A and one or more additional dihydroxy compounds, the reactants other than said additional dihydroxy compounds are charged and heated at from about 120°C to about 180°C for about one to about 5 hours, said additional dihydroxy compounds are added, the temperature is raised and the mixture is heated at from about 200°C to about 250°C, preferably from about 210°C to about 240°C, for about one to 10 hours. This modification is further described in the copending U.S. Patent application of Donald R. Kelsey, et al., Serial No. 068,973, filed July 1, 1987, commonly assigned.

The reaction is carried out in an inert atmosphere, e.g., nitrogen, at atmospheric pressure, although higher or lower pressures may also be used.

The polyarylethersulfone is then recovered by conventional techniques such as coagulation, solvent evaporation, and the like.

The solvent mixture comprises a solvent which forms an azeotrope with water and a polar aprotic solvent. The solvent which forms an azeotrope with water includes an aromatic hydrocarbon such as benzene, toluene, xylene, ethylbenzene, chlorobenzene, and the like.

The polar aprotic solvents employed in this invention are those generally known in the art for the manufacture of polyarylether sulfones and include sulfur containing solvents such as those of the formula:



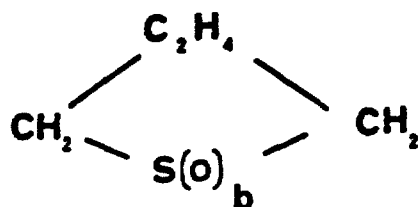
in which each R_1 represents a monovalent lower hydrocarbon group free of aliphatic unsaturation, which preferably contains less than about 8 carbon atoms or when connected together represents a divalent alkylene group with b being an integer from 1 to 2 inclusive. Thus, in all of these



solvents, all oxygens and two carbon atoms are bonded to the sulfur atom. Contemplated for use in this invention are such solvents as those having the formula:



where the R_2 groups are independently lower alkyl, such as methyl, ethyl, propyl, butyl, and like groups, and aryl groups such as phenyl and alkylphenyl groups such as the tolyl group, as well as those where the R_2 groups are interconnected as in a divalent alkylene bridge such as



in tetrahydrothiophene oxides and dioxides. Specifically, these solvents include dimethylsulfoxide, dimethylsulfone, diphenylsulfone, diethylsulfoxide, diethylsulfone, diisopropylsulfone, tetrahydrothiophene 1,1-dioxide (commonly called tetramethylene sulfone or sulfolane) and tetrahydrothiophene-1 monoxide.

Additionally, nitrogen containing solvents may be used. These include dimethylacetamide, dimethylformamide and N-methylpyrrolidone.

The azeotrope forming solvent and polar aprotic solvent are used in a weight ratio of from about 1:10 to about 1:1, preferably from about 1:5 to about 1:3.

In the reaction, the hydroxy containing compound is slowly converted, in situ, to the alkali salt thereof by reacting with the alkali metal carbonate. The alkali metal

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carbonate is preferably potassium carbonate. As indicated before, mixtures of carbonates such as potassium and sodium carbonate may also be used.

Water is continuously removed from the reaction mass as an azeotrope with the azeotrope forming solvent so that substantially anhydrous conditions are maintained during the polymerization.

It is essential that the reaction medium be maintained substantially anhydrous during the polycondensation. While amounts of water up to about one percent can be tolerated, and are somewhat beneficial when employed with fluorinated dihalobenzenoid compounds, amounts of water substantially greater than this are desirably avoided as the reaction of water with the halo and/or nitro compound leads to formation of phenolic species and only low molecular weight products are secured. Consequently, in order to secure the high polymers, the system should be substantially anhydrous, and preferably contain less than 0.5 percent by weight water during the reaction.

Preferably, after the desired molecular weight has been attained, the polymer is treated with an activated aromatic halide or an aliphatic halide such as methyl chloride or benzyl chloride, and the like. Such treatment of the polymer converts the terminal hydroxyl groups into ether groups which stabilize the polymer. The polymer so treated has good melt and oxidative stability.

While the carbonate method for preparing the polymer of this invention is simple and convenient, in some cases products of higher molecular weight can be made by the alkali metal hydroxide method. In the alkali metal hydroxide method, described by Johnson et al., U. S. Patent Nos. 4,108,837 and 4,175,175, a double alkali metal salt of a dihydric phenol is contacted with a dihalobenzenoid compound in the presence of a sulfur containing solvent as herein above defined under substantially anhydrous conditions.

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Additionally, the polymers of this invention may be prepared by other methods known in the prior art, in which at least one dihydric phenol and at least one dihalobenzoid compound are heated, for example, with a mixture of sodium carbonate or bicarbonate and a second alkali metal carbonate or bicarbonate having a higher atomic number than that of sodium, as described in U. S. Patent No. 4,176,222.

The molecular weight of the poly(aryl ethers) utilized for manufacturing the devices of the instant invention is indicated by reduced viscosity data in an appropriate solvent such as methylene chloride, chloroform, N-methylpyrrolidone, and the like. The reduced viscosities of the materials, as measured at concentrations of 0.2g per 100 ml. at 25°C, are at least 0.3 dl/g, preferably at least 0.4 dl/g and, typically, not exceeding about 1.5 dl/g.

The poly(aryl ether sulfones) of the instant invention allow for the fabrication of medical devices having excellent transparency as well as outstanding stress-crack resistance. These devices can be steam-sterilized under stresses of 500 psi or greater and in the presence of a variety of steam boiler additives. Typical boiler additives designed to reduce corrosion in steam generating systems are amino compounds such as morpholine, hydrazine, N,N-diethylaminoethanol ("NALCO 359" or "BETZ NA-9"), and octadecylamine. Steam sterilization is also possible in the presence of various hospital cleaners and detergents, such as those sold under the tradenames of "Castle 7900" (a sonic cleaner), "Chem Crest 14" (an ultrasonic cleaner), "Tergitol Min Foam 2X" (a non ionic surfactant), and the like.

The materials of the instant invention may include pigments, thermal stabilizers, ultraviolet light stabilizers, and other additives.

The instant poly(aryl ether sulfones) are useful for the fabrication of a wide variety of medical devices. They are of particular interest for autoclavable storage trays such as the systems for storage and delivery of sterile



surgical instruments (thus eliminating the costs associated with wrapping); in the medical supply industry for shipment and storage of implants, prostheses and other medical devices under sterile conditions; and in many other similar applications.

EXAMPLES

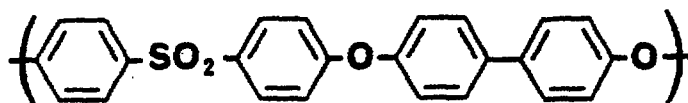
The following examples serve to give specific illustration of the practice of this invention but they are not intended in any way to act to limit the scope of this invention.

Materials

Polysulfone UDEL P-1700 - a poly(aryl ether sulfone) of formula (2), melt-flow at 650°F and 44 psi of 6.5 g/10 minutes. Sold by Amoco Performance Products, Inc.

Polysulfone I - a poly(aryl ether sulfone) of formula (5), wherein Ar is a mixture of (6) and (7) in a mole ratio 25:75. and having a reduced viscosity from 0.5 to 0.55 as measured in N-methylpyrrolidone, at 25°C, at a concentration of 0.2 g/100 ml.

Polysulfone II - a poly(aryl ether sulfone) of the formula:



having a reduced viscosity from 0.5 to 0.55 as measured in N-methylpyrrolidone, at 25°C, at a concentration of 0.2 g/100 ml.

A blend (60:40 by weight) of polysulfones I/UDEL P-1700 was also prepared and used in the steam sterilization experiments.



Comparative Example A and Examples 1-3Procedure

The materials to be tested were molded into 0.125 inch flex bars (5 inch by 0.5 inch). These bars were autoclaved under constant stress applied via the weighted cantilever beam method. The experiments were performed in a Pelton and Crane tabletop autoclave with a 50 ppm aqueous morpholine solution. Each cycle comprised a steam cycle of 30 minutes at 270°F under 27 psi, followed by a cooling cycle of a minimum of 10 minutes at room temperature. The cooling samples were examined for the presence of any defects, cracks, breakages, etc.

The results, summarized in Table I, clearly show that the poly(aryl ether sulfones) of the instant invention display steam sterilizability under stresses of 500 psi or greater, in the presence of morpholine. It is noteworthy that even the Polysulfone I/UDEL P-1700 60:40 (by weight) blend is significantly better than UDEL P-1700 under a 1000 psi stress; and is far superior to UDEL P-1700 under a stress of 500 psi. The discrepancies noted in Table I are probably due to variations in blending efficiency and, hence, quality of the resulting materials.

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TABLE I
Steam Sterilization Using a
50 ppm Aqueous Morpholine Solution

<u>Example</u>	<u>Poly(Aryl Ether Sulfone)</u>	<u>Stress(psi)</u>	<u>Number of Cycles</u>
Comparative A	UDEL P-1700	1000	79 (fail)
		500	148 (fail)
		0	400
1	Blend Polysulfone I/ UDEL P-1700 (60:40, by weight)	1000	107 (fail)
		500	476 (fail)
		0	1012
		1000	185 (fail)
		500	1005 (fail)
		0	1012
2	Polysulfone I	1000	272 (fail)
		500	1048
		0	1048
3	Polysulfone II	1000	1320
		500	1320
		0	1320

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Comparative Example B and Example 4

To determine the effect of cleaners and detergents, a test was run at 180°F for 24 hours using 1/8 inch bars made from UDEL P-1700 (Comparative Example B) and from the other poly(aryl ether sulfones). Aqueous solutions of various cleaners and detergents were utilized. The stress was applied by bending the bar (constant strain). Note that the stress values were calculated for room temperature; therefore, their actual values may be lower at 180°F. The data are summarized in Table II. The data of Table II clearly show that Polysulfone I and Polysulfone II performed much better than UDEL P-1700.

TABLE IIEffect of Various Cleaners and Detergents

<u>Reagent</u>	<u>Stress Level</u>	<u>UDEL P-1700</u>	<u>Polysulfone I</u>	<u>Polysulfone II</u>
Castle 7900	0	Surface Cracks	OK	OK
Sonic Cleaner	1000	TD*Cracks	OK	OK
(2 oz/gal)	2000	Rupture	OK	OK
	4000	Rupture	OK	OK
Chem Crest 14	0	OK	OK	OK
Ultrasonic	1000	TD*Cracks	OK	OK
Cleaner	2000	Rupture	OK	OK
(2 oz/gal)	4000	Rupture	OK	OK
Tergitol Nin	0	OK	OK	OK
Foam 2X	1000	Rupture	OK	OK
Nonionic	2000	Rupture	OK	OK
Surfactant**	4000	Rupture	Rupture	OK
(5 ml/liter)				

* TD = transverse direction

** Produced by Union Carbide Corporation. The formula is:

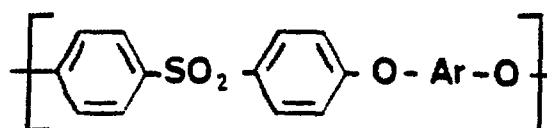
$C_{12-14}H_{25-29}O(CH_2CH_2O)_x[CH_2CH_2O/CH_2CH(CH_3)O]_yCH_2CH(CH_3)OH$;
Molecular weight is about 640; and x and y are 1 or greater.

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WHAT IS CLAIMED IS:

1. A stress-crack resistant medical device, steam sterilizable under stresses of 500 psi or greater, made from a poly(aryl ether sulfone) of the formula



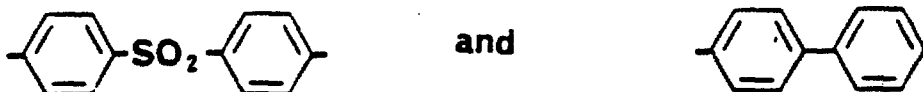
wherein Ar is selected from the group of

(a) a mixture of the diradicals



containing from about 20 to about 100 mole percent of p-phenylene; or

(b) a mixture of the diradicals



containing from about 60 to about 100 mole percent of 4,4'-biphenylene; or

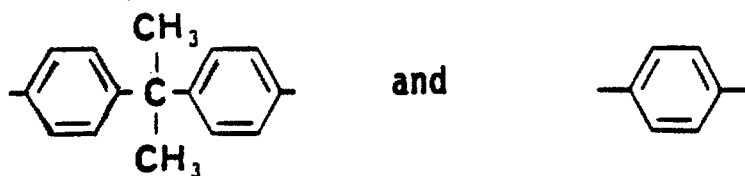
(c) a mixture of the diradicals



containing from about 60 to about 100 mole percent of 4,4'-biphenylene; or

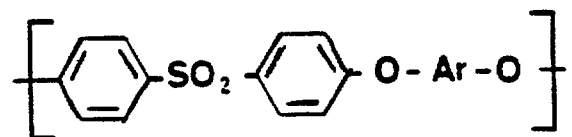


(d) a mixture of the diradicals

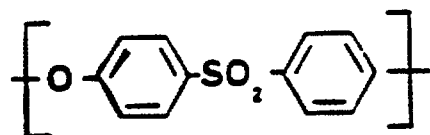


containing from about 20 to about 100 mole percent of p-phenylene.

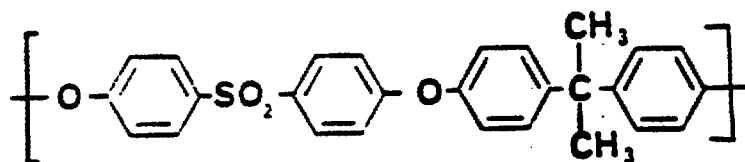
2. A stress-crack resistant medical device, steam sterilizable under stresses of 500 psi or greater, made from a blend of the poly(aryl ether sulfone) of the formula



with the poly(aryl ether sulfone)



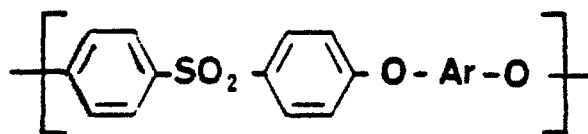
or with the poly(aryl ether sulfone)



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where Ar is a previously defined; and wherein the amount of



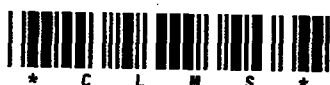
in the blend is at least 50 percent by weight.

3. A medical device as defined in claims 1 or 2 which is unaffected by corrosion-reducing additives in the steam generating system.

4. A medical device as defined in claim 3, where the corrosion-reducing additive is one or more of morpholine, hydrazine, N,N-diethylaminoethanol or octadecylamine.

5. A medical device as defined in claim 3 which is resistant to hospital cleaners and detergents.

6. A medical device as defined in claim 5 where the cleaner or detergent is selected from the group of sonic cleaners, ultrasonic cleaners and/or non ionic surfactants.



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7. A medical device as defined in claim 6 where the non ionic surfactant is of the formula



where x and y are one or greater and where the surfactant has a molecular weight of about 640.

8. A medical device as defined in claims 1 or 2 where the poly(aryl ether sulfone) has a reduced viscosity of from about 0.3 to about 1.5 dl/g as measured in methylene chloride or in chloroform, at a concentration of 0.2 g per 100 ml., at 25°C.



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