

CLIP SYRINGE

TECHNICAL FIELD

[0001] An aspect of the invention relates generally to a single use pre-filled delivery
5 device having a deformable container including a side wall having an inside surface defining
a chamber for retaining fluid, a closed proximal end and an open distal end including a male
luer tip having a passageway therethrough providing fluid communication with said chamber;
said male luer tip removably connectable to a female luer connection of a vascular access
device; and a clip element for collapsing the deformable container having a distal end and
10 proximal end comprising a pivot located between the distal end and the proximal end for
driving fluid out of said chamber by movement of the proximal end towards the distal end,
the clip element comprising a distal portion and a proximal portion, said deformable
container being attached to the clip element; and a locking element disposed on the clip
element. Another aspect of the invention relates generally to a method of flushing or
15 administering a fluid using the single use pre-filled delivery device described herein.

BACKGROUND

[0002] Vascular access devices (VAD) used to access a patient's vascular space
without puncture using a hypodermic needle. Vascular Access Devices (VADs) include
20 intravenous catheters, syringes, extension sets, stop cocks, tubing, high pressure extension
tubing, and needleless access devices. These devices are used in patients where frequent
access is required to the vascular space for delivery of treatment and withdraw of fluids.
Indwelling vascular access devices are susceptible to infection and occlusion, requiring
continued preventive maintenance. To ensure VADs are used properly and do not become
25 occluded, standards of practice have been developed to maintain the indwelling VAD. These
standards include a cleaning procedure, which is commonly referred to as a flush procedure.
One form of VAD maintenance is a continuous saline drip where which a saline bag is
connected to the VAD and provides continuous flow of saline solution to the patient through
the VAD. This approach may put the patient at risk by delivering excess fluid to the vascular
30 space.

[0003] An alternative method for vascular device maintenance, known as flushing,
involves intermittent delivery of saline thru the VAD using a hypodermic syringe. One way
to deliver intermittent saline to the VAD is to fill a hypodermic syringe fitted with a needle
from a saline vial or ampoule. The filled syringe is then connected to the VAD and the saline

is then flushed thru the VAD into the patient. Use of pre-filled saline flush syringes to deliver saline flush to VAD's offers improved safety and efficiency over manually filled hypodermic syringes.

[0004] It is important in the flush procedure not to draw blood back into the catheter where it can clot and seal the catheter, commonly referred to as "reflux". In order to prevent blood reflux into the catheter the user is encouraged to maintain a positive pressure in the line during the flush procedure. This may involve clamping the IV line and withdrawing the syringe and cannula from the LV. port while still applying pressure to the syringe plunger rod during the flush procedure. When using a conventional syringe with an elastomeric stopper, the stopper is often compressed when it contacts the distal end of the syringe barrel at the completion of the flush procedure. When a user relieves the pressure to the plunger after the flush procedure is completed, the stopper will expand back to its normal size thereby withdrawing liquid from the catheter into the syringe barrel. This is undesirable, since it can cause blood to enter the catheter at the catheter distal end (reflux) where it will remain stationary until the next time the VAD is used.

[0005] Although a wide variety of catheters and I.V. ports can be adequately flushed using currently available syringe assemblies, as flushing practices change from continuous IV drip to intermittent flushing, there is a need for a new sterile, single use, pre-filled delivery device for maintenance of VAD's.

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SUMMARY

[0006] Embodiments of the present invention are directed to a single use pre-filled delivery device having a deformable container, including a side wall having an inside surface defining a chamber for retaining fluid; a clip element; and a locking element. The deformable container further includes a closed proximal end and an open distal end including a male luer tip having a passageway therethrough providing fluid communication with the chamber. The deformable container may be made of thermoplastic elastomers, polyolefin, polyester or other injection moldable or formable resin. Thermoplastic elastomers include, but are not limited to, polypropylene, polyethylene and the like. The male luer tip may be removably connectable to a female luer connection of a vascular access device. The clip element includes a distal end, proximal end, and a pivot located between the distal end and the proximal end of the clip element for collapsing the deformable container to drive fluid out of the chamber by movement of the proximal end towards the distal end. In one or more embodiments, the pivot may be a hinge, which may be in the form of a living hinge. The

deformable container may be attached to the clip element. The locking element may be disposed on the clip element.

5 [0007] In one or more embodiments, the single use pre-filled delivery device further includes a tip cap that is releasably connected to the male luer tip of the deformable container for sealing the passageway.

[0008] In one or more embodiments, the vascular access device is a syringe, extension set, intravenous set, stop cock, tubing, high pressure extension tubing, or needleless connector.

10 [0009] In one or more embodiments, the single use pre-filled delivery device further includes a pre-selected amount of fluid in the chamber. The pre-selected amount of fluid in the chamber may be from 0.5ml to 10 ml. In one or more embodiments, the fluid may include a medicament, drug or flush solution, such as saline solution.

15 [0010] The locking element of the present invention minimizes, limits or prevents reflux of solution in the passageway. The locking element also provides confirmation to the user of solution delivery by providing feedback to the user to confirm delivery of a desired volume of fluid from the chamber. The feedback may be tactile, visual or audible. In one or more embodiments, the locking element includes at least one protrusion and at least one corresponding cavity. In one or more embodiments, the at least one protrusion is disposed on the proximal end of the clip element and the corresponding cavity is disposed on the distal end of the clip element. In another embodiment, the at least one protrusion is disposed on the distal end of the clip element and the at least one corresponding cavity is disposed on the proximal end of the clip element. The locking element is arranged to be manually activated by a user after the protrusion engages to the corresponding cavity after the fluid has been expelled from the deformable container. In an alternate embodiment of the present invention, the locking element includes detents. In yet another alternate embodiment of the present invention, the locking element includes a ratcheting mechanism having a plurality of teeth and a catch. In one embodiment, the catch is disposed on the proximal end of the clip element and the plurality of teeth is disposed on the distal end of the clip element. In another embodiment, the catch is disposed on the distal end of the clip element and the plurality of teeth is disposed on the proximal end of the clip element. The locking element is arranged to be manually activated by a user after the catch engages to one or more of the plurality of teeth.

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[0011] In yet another alternate embodiment of the present invention, the locking element includes a snap fit element to connect the distal end of the clip element to the proximal end of the clip element upon the release.

[0012] In one embodiment, the pivot is positioned on the proximal end of the deformable container. In another embodiment, the pivot is positioned on the distal end of the deformable container. The pivot may be oriented in a perpendicular position with respect to the distal end of the deformable container.

[0013] In one or more embodiments, the clip element further includes at least one protrusion for removing one or more air bubbles from the delivery device and controlling the delivery of fluid from the delivery device.

[0014] In an alternate embodiment of the present invention, a single use pre-filled delivery device having a deformable container includes a side wall having an inside surface defining a chamber for retaining fluid, a closed proximal end and an open distal end including a male luer tip having a passageway therethrough providing fluid communication with said chamber, a three-fold clip element and a locking element. The male luer tip is removably connectable to a female luer connection of a vascular access device. The three-fold clip element includes a first portion, a second portion and third portion. The deformable container may be attached to the first portion of the clip element. The second portion of the clip element may be attached to the first portion by a first pivot. The second portion of the clip element is foldable over the first portion of the clip element for removing one or more air bubbles from the deformable container. The third portion is attached to the second portion by a second pivot, and the third portion of the clip element is foldable over the first portion of the clip element for driving fluid out of said chamber. The locking element may be disposed on the first and third portion of the clip element.

[0015] Another aspect of the present invention pertains to a method of flushing or administering a fluid to a vascular access device comprising providing a single use pre-filled delivery device as described herein; providing a vascular access device having a proximal end, a distal end and a passageway therethrough, said proximal end having a female luer tip in fluid communication with said passageway; placing said distal end of said vascular access device in a blood vessel of a patient; engaging said male luer tip of said deformable container with said female luer tip of said vascular access device; applying force to said clip element to deform the collapsible container so that said flush solution in said chamber flows through said passageway into said vascular access device; continuing to apply force to the clip element until said distal end of the locking element engages the said proximal end of the

locking element; and disengaging said male luer tip of said deformable container from said female luer tip of said vascular access device.

BRIEF DESCRIPTION OF THE DRAWINGS

- 5 [0016] FIG. 1 is a perspective view illustrating one embodiment of the single use pre-filled delivery device of the present invention.
- [0017] FIG. 2 is a perspective view illustrating a second embodiment of the single use pre-filled delivery device of the present invention.
- [0018] FIG. 3 is a perspective view illustrating a third embodiment of the single use pre-filled delivery device of the present invention.
- 10 [0019] FIG. 4 is a perspective view illustrating a fourth embodiment of the single use pre-filled delivery device of the present invention.
- [0020] FIG. 5 is a perspective view illustrating a fifth embodiment of the single use pre-filled delivery device of the present invention.
- [0021] FIG. 6 is a perspective view illustrating a sixth embodiment of the single use pre-filled delivery device of the present invention.
- 15 [0022] FIG. 7 is a perspective view illustrating a seventh embodiment of the single use pre-filled delivery device of the present invention.
- [0023] FIG. 8 is a perspective view illustrating an eighth embodiment of the single use pre-filled delivery device of the present invention having a tip cap.
- 20 [0024] FIG. 9 is a top view illustrating an eighth embodiment of the single use pre-filled delivery device of the present invention having a tip cap.
- [0025] FIG. 10 is a right side view illustrating an eighth embodiment of the single use pre-filled delivery device of the present invention having a tip cap.
- [0026] FIG. 11 is a bottom view illustrating an eighth embodiment of the single use pre-filled delivery device of the present invention having a tip cap.
- 25 [0027] FIG. 12 is a side view illustrating an eighth embodiment of the single use pre-filled delivery device of the present invention having a tip cap.
- [0028] FIG. 13 is a back view illustrating an eighth embodiment of the single use pre-filled delivery device of the present invention having a tip cap.
- 30 [0029] FIG. 14 is a front view illustrating an eighth embodiment of the single use pre-filled delivery device of the present invention having a tip cap.

[0030] FIG. 15 is a side view illustrating an eighth embodiment of the single use pre-filled delivery device of the present invention having a tip cap.

[0031] FIG. 16 is a side view illustrating an eighth embodiment of the single use pre-filled delivery device of the present invention having a tip cap.

5 [0032] FIG. 17 is a side view illustrating an eighth embodiment of the single use pre-filled delivery device of the present invention having a tip cap.

DETAILED DESCRIPTION OF THE INVENTION

[0033] Before describing several exemplary embodiments of the invention, it is to be understood that the invention is not limited to the details of construction or process steps set forth in the following description. The invention is capable of other embodiments and of being practiced or being carried out in various ways.

[0034] In this disclosure, a convention is followed wherein the distal end of the device is the end closest to a patient and the proximal end of the device is the end away from the patient and closest to a practitioner.

15 [0035] The term “deformable” refers to a wall or container that is structured to be flexible enough to collapse at least partially into the inner chamber under manual depression. The shape and extent of the deformation will vary with the various configurations of the inner chamber and deformable container.

[0036] As used herein, the term “luer” with respect to a connector, connection or tip refers to a connection collar that is the standard way of attaching syringes, catheters, hubbed needles, IV tubes, etc. to each other. The luer connection consists of male and female interlocking tubes, slightly tapered to hold together better with even just a simple pressure/twist fit. Luer connectors can optionally include an additional outer rim of threading, allowing them to be more secure. The luer connector male end is generally associated with a delivery device and can interlock and connect to the female end located on a vascular access device (VAD). A luer connector comprises a distal end, a proximal end, an irregularly shaped outer wall, a profiled center passageway for fluid communication from the chamber of the barrel of a syringe to the hub of a VAD. A luer connector also has a distal end channel that releasably attaches the luer connector to the hub of a VAD, and a proximal end channel that releasably attaches the luer connector to the barrel of a syringe.

30 [0037] The single use pre-filled delivery device of the present invention is shown in Figures 1-7. A single use sterile delivery device of the present invention reduces the risk

associated with contamination due to manual filling a syringe with flush solution or medicament from a vial. Generally speaking, the single use device of the present invention capable of delivering sterile solution to the female luer connection of a VAD. In general, the device comprises a deformable container with a male luer connector capable of holding
5 between 0.5mL and 10mL of sterile solution and a clip element that collapses the deformable container to expel the solution within. The deformable container includes a male luer connector that enables secure connection to the female luer connector within a VAD. The clip element contains a pivot which is activated by pressing the moveable sides together to expel the solution from the deformable container.

10 [0038] Referring to Figure 1, a single use pre-filled delivery device 10 according to the present invention generally comprises a deformable container 20 including a side wall 21 having an inside surface 22 defining a chamber 23 for retaining fluid, a clip element 30, and a locking element 40. In operation, delivery device 10 is attached to a patient's catheter via a patient's vascular access device (VAD). The deformable container 20 further comprises a
15 closed proximal end 24 and an open distal end 25 including a male luer tip 26 having a passageway 27 therethrough providing fluid communication with the chamber 23. The male luer tip 26 may be removably connectable to a female luer connection of a vascular access device. Thus, the delivery device of the present invention is capable of a generating a secure connection with a receiving needleless female vascular access connector. The clip element
20 30 comprises a distal end 31, proximal end 32, and a pivot 33 located between the distal end 31 and the proximal end 32 of the clip element 30 for collapsing the deformable container 20 to drive fluid out of the chamber 23 by movement of the proximal end 32 towards the distal end 31. In one or more embodiments, the pivot 33 may be a hinge, which may be in the form of a living hinge. The deformable container 20 may be attached to the clip element 30. The
25 locking element 40 may be disposed on the clip element 30.

[0039] One advantage of the present invention over prior is that the clip element 30 of the present invention improves control of fluid delivery from the deformable container 20.

[0040] In one or more embodiments, the single use pre-filled delivery device 10 further includes a tip cap 45 that is releasably connected to the male luer tip 26 of the
30 deformable container 20 for sealing the passageway 27. Figures 8-17 show an embodiment of the single use pre-filled delivery device 10 of the present invention having a tip cap 45.

[0041] In one or more embodiments, the vascular access device is a syringe, extension set, intravenous set, stop cock, tubing, high pressure extension tubing, or needleless connector.

[0042] In one or more embodiments, the single use pre-filled delivery device **10** further includes a pre-selected amount of fluid in the chamber **23**. The pre-selected amount of fluid in the chamber **23** may be from 0.5ml to 10 ml. In one or more embodiments, the fluid may include a flush solution or a medicament. The flush solution may be any solution intended for flushing or maintaining performance of VAD's. The flush solution may be selected from the group consisting of saline flush solution, water, heparin flush solution or a combination thereof. These solutions are known in the art and are readily available. The single-use delivery device **10** is pre-filled with flush solution during or after the assembly of the syringe using sterile filling methods. Such prefilled assemblies may be supplied with a tip cap **45** that seals the passageway **27** of the deformable container **20** and male luer tip **26**. The tip cap may be is formed of material selected from a group of thermoplastic materials and elastomeric materials such as natural and synthetic rubber, thermoplastic elastomers, polyolefin, polyester or other injection moldable or formable resin, combinations thereof, or other easily disposable and/or recyclable material. Thermoplastic elastomers include, but are not limited to, polypropylene, polyethylene and the like. Once assembled, the syringe assembly may be used in flushing or administering a fluid to a VAD such as a catheter of an I.V. set.

[0043] The locking element **40** of the present invention minimizes, limits or prevents reflux of solution in the passageway **27**. The locking element **40** also provides confirmation to the user of solution delivery. In one or more embodiments, the locking element **40** includes at least one protrusion and at least one corresponding cavity. In one or more embodiments, the at least one protrusion is disposed on the proximal end **32** of the clip element **30** and the corresponding cavity is disposed on the distal end **31** of the clip element **30**. In another embodiment, the at least one protrusion is disposed on the distal end **31** of the clip element **30** and the at least one corresponding cavity is disposed on the proximal end **32** of the clip element **30**. The locking element **40** is arranged to be manually activated by a user after the protrusion engages to the corresponding cavity after the fluid has been expelled from the deformable container **20**. When the entire contents of the inner chamber **23** are expelled and the protrusion is in contact and engages with the cavity to locks the proximal end **32** of the clip element **30** to the distal end **31** of the clip element **30**.

[0044] In one or more alternative embodiments, detents or tabs on the locking element **40** may be used to retain the proximal end **32** of the clip element **30** to the distal end **31** of the clip element **30**.

[0045] In an alternate embodiment of the present invention, the locking element 40 includes a ratcheting mechanism having a plurality of teeth and a catch. In one embodiment, the catch is disposed on the proximal end 32 of the clip element 30 and the plurality of teeth is disposed on the distal end 31 of the clip element 30. In another embodiment, the catch is disposed on the distal end 31 of the clip element 30 and the plurality of teeth is disposed on the proximal end 32 of the clip element 30. The locking element 40 is arranged to be manually activated by a user after the catch engages to one or more of the plurality of teeth.

[0046] In an alternate embodiment of the present invention, the locking element 40 includes a snap fit element to connect the distal end 31 of the clip element 30 to the proximal end 32 of the clip element 30 upon the release.

[0047] In one embodiment, the pivot 33 is positioned on the proximal end 24 of the deformable container 20. In another embodiment, the pivot 33 is positioned on the distal end 25 of the deformable container 20. The pivot 33 may be oriented in a perpendicular position with respect to the distal end 25 of the deformable container 20.

[0048] The locking element 40 enables the clip element 30 to be secured in place after the solution has been expelled. The locking element 40 also limits reflux of solution in the fluid path of the vascular access. The locking element 40 provides feedback to the user to confirm delivery of a desired volume of fluid from the chamber 23. The feedback may be tactile, visual or audible.

[0049] The materials for the deformable container 20 will have to be chosen based not only on performance but on compatibility with the injectable liquid. In a preferred embodiment the single use pre-filled delivery device 10 is prefilled with injectable liquid. There may be a substantial amount of time between when the delivery device 10 is filled and when the contents of the delivery device 10 are delivered. Accordingly, materials chosen for delivery device 10 may have to be stable under long term storage.

[0050] The deformable container 20, clip element 30 and locking element 40 may be made of thermoplastic elastomers, polyolefin, polyester or other injection moldable or formable resin, natural rubber, synthetic rubber, thermoplastic materials, or other easily disposable and/or recyclable material and combinations thereof. Thermoplastic elastomers include, but are not limited to, polypropylene, polyethylene and the like. Materials should be chosen to be compatible with the solution, medicament and manufacturing process being used. It is envisioned that in one or more embodiments, the delivery device of the present invention may be made of a single material to facilitate recycling of the device.

[0051] In one or more embodiments, the clip element 30 further includes at least one protrusion for removing one or more air bubbles from the delivery device 10 and controlling the delivery of fluid from the delivery device 10.

[0052] There are several embodiments of the orientation of the clip element 30. As shown in Figure 1, the delivery device 10 comprises one pivot 33 positioned opposite of the male luer tip of the deformable container 20 between the proximal end and distal end of the clip element 30. As shown in Figure 2, the delivery device 10 comprises a locking element 60 having a forked tip on the proximal end of the clip element which engages the distal end of the clip element near the male luer tip upon activation. As shown in Figure 2, the delivery device 10 comprises a V-shaped clip element having one pivot 33 positioned mid-way along the clip element near of the male luer tip of the deformable container 20. The delivery device 10 may include a frangible seal 51 to close the passageway of the chamber 23. As shown in Figure 2, the delivery device 10 comprises a locking element 40 having a protrusion on the distal end of the clip element which engages a cavity on the proximal end of the clip element. As shown in Figures 3-5, the delivery device comprises a deformable container positioned in between a V-shaped clip element, said V-shaped clip element comprising two flat longitudinal surfaces 70 connected by pivot 33 positioned perpendicular to the male luer tip located on the distal end of the deformable container. As shown in Figure 3, in one embodiment, the locking element includes a protrusion 80 on one longitudinal end of the clip element which engages a corresponding cavity 90 located on the opposite end of the clip element. As shown in Figure 4, in one embodiment, the locking element includes a plurality of teeth 92 on one longitudinal end of the clip element which engages a corresponding catch 94 located on the opposite end of the clip element. As shown in Figure 5, in one embodiment, the locking element includes detents or a tab 98 on one longitudinal end of the clip element which engages a corresponding slot or cavity 99 located on the opposite end of the clip element. The embodiments of Figures 1-5 are activated by pressing the moveable distal and proximal ends of the clip element together to activate the device and deliver the contents.

[0053] As shown in Figure 6, the delivery device 10 comprises two pivots 33 and 34 to create a three-fold clip element comprising portions A, B and C. Pivot 33 connects portions A and B. Pivot 34 connects portions B and C. Deformable container 20 is attached to portion A. Upon activation, portion B folds upon the proximal end of portion A via pivot 33 to serve a priming function for the removal of air bubbles from deformable container 20. Portion C folds upon portion A via pivot 34 for the expulsion of fluid from deformable container 20.

[0054] As shown in Figure 7, the delivery device 10 comprises one pivot 33 to create a two-fold clip element comprising portions A and B. Pivot 33 allows movement in an axial direction in a clockwise or counter-clockwise direction. When portion A moves along pivot 33 in a counter-clockwise direction, portion A serves a priming function for the removal of air bubbles from deformable container 20. When portion A moves along pivot 33 in a clockwise direction, portion A of clip element serves to expel fluid from deformable container 20. As shown in Figure 7, locking element 40 is in the form of a detent or tab which engages a recess 41.

[0055] Additional embodiments are possible in which the clip element 30 of the device includes features which allow for additional control of the volume and rate of fluid expelled from the device. In one embodiment, the moveable clip element contains protrusions, which control the delivery of solution volume for priming the syringe for use and delivery of the remaining solution. The term "priming" is defined as the removal of the air bubble. Two additional embodiments include an embodiment with the protrusion on one side of the clip, as shown in Figure 6, and on both sides of the clip elements, as shown in Figure 7.

[0056] In an alternate embodiment, single use pre-filled delivery device 10 comprises a deformable container including a side wall having an inside surface defining a chamber for retaining fluid, a closed proximal end and an open distal end including a male luer tip having a passageway therethrough providing fluid communication with said chamber, a three-fold clip element and a locking element. The male luer tip is removably connectable to a female luer connection of a vascular access device. The three-fold clip element includes a first portion, a second portion and third portion. The deformable container may be attached to the first portion of the clip element. The second portion of the clip element may be attached to the first portion by a first pivot. The second portion of the clip element is foldable over the first portion of the clip element for removing one or more air bubbles from the deformable container. The third portion is attached to the second portion by a second pivot, and the third portion of the clip element is foldable over the first portion of the clip element for driving fluid out of said chamber. The locking element may be disposed on the first and third portion of the clip element.

[0057] The delivery device 10 of the present invention may be used in conjunction with a vascular access device having a proximal end, a distal end and a passageway 27 therethrough, said proximal end having a female luer tip in fluid communication with said passageway 27. To use the delivery device 10 in a flushing procedure or to administering a fluid, the user engages the male luer tip 26 of the deformable container 20 of the delivery

device **10** with the female luer tip of a vascular access device, after the distal end of said vascular access device has been placed in a blood vessel of a patient. The user then applies force to the clip element **30** to deform the collapsible container **20** so that said flush solution in said chamber **23** flows through said passageway **27** into said vascular access device. The user continues to apply force to the clip element **30** until said distal end **41** of the locking element **40** engages the said proximal end **42** of the locking element **40**. After the expulsion of the desired amount of fluid from the chamber **23**, the user disengages said male luer tip **26** of said deformable container **20** from said female luer tip of said vascular access device. One advantage of the present invention is that the delivery device of the present invention collapses to a configuration with minimal dead space and secures using the locking element **40**. Another advantage of the present invention is that the moveable clip element **30** allows the user to sense the resistance in the fluid path, wherein increased resistance could allow the operator to detect resistance within the components of the delivery device or vascular access device.

[0058] The device of the present invention may be produced as a single component or as multiple parts assembled in a second step. As a single component, the clip element **30**, deformable container **20** and locking element **40** are incorporated into a single part. In the multiple component configuration, the clip element **30**, deformable container **20** and locking element **40** may be formed from any number of individual parts and assembled together.

[0059] The single use pre-filled delivery device **10** of the present invention may be manufactured in accordance with a blow-fill-seal technique of a character well understood by those skilled in the art.

[0060] The concept of a blow-fill-seal process is that a container is formed, filled, and sealed as a unitary container in a continuous manner without human intervention in a sterile, enclosed area inside a machine. Blow-fill-seal manufacturing forms a closed container by extruding and forming a parison within a mold, filling the container and sealing the container in a single step. This manufacturing process enables the device to be produced in a single process. For example, pharmaceutical grade resin is extruded into a tube, which is then formed into a container. A mandrel is inserted into the newly formed container and filled. The container is then sealed, all inside a sterile, shrouded chamber. The product is then discharged to a non-sterile area for packaging and distribution. This blow-fill-seal technique comprises the continuous extrusion through an extruder head of a length of a parison in the form of a hollow tube between and through two co-acting first or main mold halves. The method includes the step of cutting off the parison below the extruder head and above the

main mold halves to create an opening which allows a blowing and filling nozzle assembly to be moved downwardly into the opening in the parison for molding and thereafter filling a molded container. When the container portion of the container assembly is filled with the desired amount of liquid, the blowing and filling nozzle assembly is retracted from the opening in the parison. A separate pair of co-acting second or upper sealing mold halves are then moved together around the exposed length of parison to form and seal the container upper portion. The finished container assembly, completely formed, filled, and sealed as a unitary structure is then conveyed out of the molding apparatus.

[0061] A single use, pre-filled, sterile delivery device of the present invention reduces the risk associated with contamination due to manual filling a syringe with flush solution or medicament from a vial.

[0062] Reference throughout this specification to "one embodiment," "certain embodiments," "one or more embodiments" or "an embodiment" means that a particular feature, structure, material, or characteristic described in connection with the embodiment is included in at least one embodiment of the invention. Thus, the appearances of the phrases such as "in one or more embodiments," "in certain embodiments," "in one embodiment" or "in an embodiment" in various places throughout this specification are not necessarily referring to the same embodiment of the invention. Furthermore, the particular features, structures, materials, or characteristics may be combined in any suitable manner in one or more embodiments.

[0063] Although the invention herein has been described with reference to particular embodiments, it is to be understood that these embodiments are merely illustrative of the principles and applications of the present invention. It will be apparent to those skilled in the art that various modifications and variations can be made to the method and apparatus of the present invention without departing from the spirit and scope of the invention. Thus, it is intended that the present invention include modifications and variations that are within the scope of the appended claims and their equivalents.

Claims

1. A single use pre-filled delivery device comprising:
 - a deformable container including a side wall having an inside surface defining a chamber for retaining fluid, a closed proximal end and an open distal end including a male luer tip having a passageway therethrough providing fluid communication with said chamber; said male luer tip removably connectable to a female luer connection of a vascular access device; and
 - a two-fold clip element for collapsing the deformable container having a distal end and proximal end comprising a pivot located between the distal end and the proximal end for driving fluid out of said chamber by movement of the proximal end towards the distal end, the clip element comprising a distal first portion and a proximal second portion, said deformable container being attached to the clip element, wherein the clip element further includes at least one protrusion for removing one or more air bubbles from the delivery device and controlling the delivery of fluid from the deformable container, wherein the first portion moves along the pivot in a counterclockwise direction to remove one or more air bubbles and the first portion moves along the pivot in a clockwise direction to expel a fluid from the chamber; and
 - a locking element disposed on the clip element wherein the locking element comprises at least one protrusion and at least one corresponding cavity, the at least one protrusion and the at least one corresponding cavity being on opposite ends of the clip element.
2. The single use pre-filled delivery device of claim 1, wherein the pivot is a hinge.
3. The single use pre-filled delivery device of claim 2, wherein the hinge is a living hinge.
4. The single use pre-filled delivery device of claim 1, further including a tip cap releasably connected to said male luer tip of said deformable container for sealing said passageway.

5. The single use pre-filled delivery device of claim 1, wherein the vascular access device is a syringe, extension set, intravenous set, stop cock, tubing, high pressure extension tubing, or needleless connector.
6. The single use pre-filled delivery device of claim 1, further comprising a pre-selected amount of sterile fluid in the chamber.
7. The single use pre-filled delivery device of claim 6, wherein the pre-selected amount of fluid in the chamber is from 0.5ml to 10 ml.
8. The single use pre-filled delivery device of claim 6, wherein the fluid comprises a sterile flush solution.
9. The single use pre-filled delivery device of claim 8, wherein the flush solution is saline, heparin, water or a combination thereof.
10. The single use pre-filled delivery device of claim 6, wherein the fluid comprises a medicament or drug.
11. The single use pre-filled delivery device of claim 1, wherein the locking element minimizes reflux of solution in the passageway.
12. The single use pre-filled delivery device of claim 1, wherein the locking element provides confirmation to the user of solution delivery.
13. The single use pre-filled delivery device of claim 12, wherein the at least one protrusion is disposed on the proximal end of the clip element and the at least one corresponding cavity is disposed on the distal end of the clip element.
14. The single use pre-filled delivery device of claim 12, wherein the at least one protrusion is disposed on the distal end of the clip element and the at least one corresponding cavity is disposed on the proximal end of the clip element.

15. The single use pre-filled delivery device of claim 12, wherein the locking element is arranged to be manually activated by a user after the protrusion engages to the corresponding slot after the fluid has been expelled from the deformable container.

16. The single use pre-filled delivery device of claim 1, wherein the locking element comprises detents.

17. The single use pre-filled delivery device of claim 1, wherein the locking element comprises a ratcheting mechanism having a plurality of teeth and a catch.

18. The single use pre-filled delivery device of claim 17, wherein the catch is disposed on the proximal end of the clip element and the plurality of teeth is disposed on the distal end of the clip element.

19. The single use pre-filled delivery device of claim 17, wherein the catch is disposed on the distal end of the clip element and the plurality of teeth is disposed on the proximal end of the clip element.

20. The single use pre-filled delivery device of claim 17, wherein the locking element is arranged to be manually activated by a user after the catch engages to one or more of the plurality of teeth.

21. The single use pre-filled delivery device of claim 1, wherein the locking element comprises a snap fit element to connect the distal end of the clip element to the proximal end of the clip element upon the release.

22. The single use pre-filled delivery device of claim 1, wherein the pivot is positioned on the proximal end of the deformable container.

23. The single use pre-filled delivery device of claim 1, wherein the pivot is positioned on the distal end of the deformable container.

24. The single use pre-filled delivery device of claim 1, wherein the pivot is oriented in a perpendicular position with respect to the distal end of the deformable container pivot.

25. The single use pre-filled delivery device of claim 1, wherein the locking element provides feedback to the user to confirm delivery of a desired volume of fluid from the chamber.
26. The single use pre-filled delivery device of claim 25, wherein the feedback is tactile, visual or audible.
27. The single use pre-filled delivery device of claim 1, wherein the deformable container is made of thermoplastic elastomers, polyolefin, polyester or other injection moldable or formable resin.
28. A single use pre-filled delivery device comprising:
- a deformable container including a side wall having an inside surface defining a chamber for retaining fluid, a closed proximal end and an open distal end including a male luer tip having a passageway therethrough providing fluid communication with said chamber; said male luer tip removably connectable to a female luer connection of a vascular access device; and
 - a three-fold clip element having a first portion, a second portion and third portion, said deformable container being attached to said first portion of the clip element, said second portion being attached to the first portion by a first pivot, said second portion of the clip element being foldable over the first portion of the clip element for removing one or more air bubbles from the deformable container wherein the second portion further includes at least one protrusion for removing one or more air bubbles from the delivery device and controlling the delivery of fluid from the deformable container;
 - said third portion being attached to the second portion by a second pivot, said third portion of the clip element being foldable over the first portion of the clip element for driving fluid out of said chamber; and
 - a locking element disposed on the first and third portion of the clip element.