

Claims

1. Method for manufacturing a cannula system with a body unit and a compressing unit, the method comprising the steps:
- Providing a body unit comprising a mounting structure, the body being
5 mounted onto a molding core pin, wherein the body unit is optionally provided by injection molding onto the molding core pin;
 - Threading a soft cannula on the mounting structure of the body unit;
 - Injection molding of the compressing unit on the soft cannula and at least parts of the body unit, wherein the compressing unit circumferentially surrounds the
10 mounting structure, at least parts of the soft cannula and at least parts of the body unit;
 - Cooling of the compressing unit, thereby providing an internal material tension of the compressing unit;
 - Removing the molding core pin.
- 15 2. The method according to claim 1, wherein only a distal end area of the soft cannula is threaded on the mounting structure of the body unit and wherein the compressing unit preferably circumferentially surrounds only the distal end area of the soft cannula.
3. The method according to claim 2, wherein the distal end area is provided with a locking structure for establishing a form lock and/or an adhesive bond between the soft cannula
20 and the compressing unit.
4. The method according to claim 3, wherein prior to threading the soft cannula on the mounting structure of the body unit, a locking structure is generated at the distal end area of the soft cannula.

5. The method according to any of claims 3 or 4, wherein the locking structure includes at least one protrusion, preferably a collar arranged at the most distal part of the distal end area, protruding from the distal end area and/or at least one hole, preferably a through bore or a blind hole.
- 5 6. The method according to any of claims 2 to 5, wherein the distal end area of the soft cannula has a larger diameter than the rest of the cannula before the cannula is threaded on the mounting structure.
7. The method according to any of the previous claims, wherein the internal material tension of the compressing unit exerts a compression force which is directed radially inwards and/or wherein the internal material tension of the compressing unit compresses the soft cannula.
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8. The method according to any of the previous claims, wherein the body unit and the compressing unit and/or wherein the compressing unit and the soft cannula form a bonded connection during injection molding of the compressing unit.
- 15 9. Cannula system (1) comprising a soft cannula (10) and a cannula unit for holding the soft cannula (10), wherein the cannula unit comprises a compressing unit (20) and a body unit (30), wherein the body unit (30) contains a mounting structure (31) and a cavity (32) for holding a septum, wherein the soft cannula (10) is threaded on the mounting structure (31), wherein the compressing unit (20) circumferentially surrounds the mounting structure (31) and at least parts of the body unit (30) and wherein the compressing unit (20) contains an internal material tension for exerting a compression force on the soft cannula (10) and the mounting structure (31).
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- 10.** Cannula system (1) according to claim 9, wherein only a distal end area (11) of the soft cannula (10) is threaded on the mounting structure (31) and wherein the compressing unit (20) circumferentially surrounds the distal end area (11) of the soft cannula (10).
- 11.** Cannula system (1) according to claim 10, wherein the distal end area (11) of the soft
5 cannula comprises a locking structure providing a form lock and/or an adhesive bond between the soft cannula (10) and the compressing unit (20).
- 12.** Cannula system according to claim 10 or 11, wherein the locking structure includes at least one protrusion, preferably a collar (12b) arranged at the most distal part of the distal end area (11), protruding from the distal end area (11) and/or at least one hole (12a), preferably
10 a through bore or a blind hole.
- 13.** Cannula system (1) according to any of claims 10 to 12, wherein distal end area (11) of the soft cannula (10) has a larger diameter than the rest of the soft cannula (10).
- 14.** Cannula system (1) according to any of claims 10 or 13, wherein the compressing unit (20) compresses at least the distal end area (11) of the soft cannula (10) and/or wherein the body
15 unit (30) and the compressing unit (20) are connected by a bonded connection and/or wherein the soft cannula (10) and the compressing unit (20) are connected by a bonded connection.
- 15.** Use of a cannula system according to any of claims 9 to 14 in an infusion set.