



Designation: F 624 – 98a (Reapproved 2003)

Standard Guide for Evaluation of Thermoplastic Polyurethane Solids and Solutions for Biomedical Applications¹

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1. Scope

1.1 This guide covers the evaluation of thermoplastic polyurethanes in both solid and solution form for biomedical applications. The polymers have been reacted to completion and require no further chemical processing.

1.2 The tests and methods listed in this guide may be referenced in specification containing minimum required values and tolerances for specific end use products.

1.3 Test values shall be stated in SI units with inch-pound units in parentheses.

1.4 Standard tests for biocompatibility are included to aid in the assessment of safe utilization in biomedical applications. Compliance with these criteria shall not be constructed as an endorsement of implantability. Since many compositions, formulations, and forms of thermoplastic polyurethanes in solid and solution forms are within this material class, the formulator or fabricator must evaluate the biocompatibility of the specific composition or form in the intended use and after completion of all manufacturing processes including sterilization.

1.5 Purchase specifications may be prepared by agreement between the buyer and seller by selection of appropriate tests and methods from those listed applicable to the specific biomedical end use.

1.6 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

D 149 Test Method for Dielectric Breakdown Voltage and Dielectric Strength of Solid Electrical Insulating Materials at Commercial Power Frequencies²

D 150 Test Methods for ac Loss Characteristics and Permittivity (Dielectric Constant) of Solid Electrical Insulating Materials²

D 257 Test Methods for dc Resistance or Conductance of Insulating Materials²

D 395 Test Methods for Rubber Property—Compression Set³

D 412 Test Methods for Vulcanized Rubber and Thermoplastic Rubbers and Thermoplastic Elastomers—Tension³

D 570 Test Method for Water Absorption of Plastics⁴

D 575 Test Methods for Rubber Properties in Compression³

D 671 Test Method for Flexural Fatigue of Plastics by Constant-Amplitude-of-Force⁵

D 790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials⁴

D 792 Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement⁴

D 1238 Test Method for Flow Rates of Thermoplastics by Extrusion Plastometer⁴

D 1242 Test Methods for Resistance of Plastic Materials to Abrasion⁴

D 1434 Test Method for Determining Gas Permeability Characteristics of Plastic Film and Sheeting⁶

D 1544 Test Method for Color of Transparent Liquids (Gardner Color Scale)⁷

D 1638 Methods of Testing Urethane Foam Isocyanate Raw Materials⁸

D 2124 Test Method for Analysis of Components in Poly-(Vinyl Chloride) Compounds Using an Infrared Spectrophotometric Technique⁴

D 2240 Test Method for Rubber Property—Durometer Hardness³

D 2857 Test Method for Dilute Solution Viscosity of Polymers⁹

D 2990 Test Methods for Tensile, Compressive, and Flexural Creep and Creep-Rupture of Plastics⁹

D 3137 Test Method for Rubber Property—Hydrolytic Stability³

¹ This guide is under the jurisdiction of ASTM Committee F04 on Medical and Surgical Materials and Devices and is the direct responsibility of Subcommittee F04.11 on Polymeric Materials.

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² Annual Book of ASTM Standards, Vol 10.01.

³ Annual Book of ASTM Standards, Vol 09.01.

⁴ Annual Book of ASTM Standards, Vol 08.01.

⁵ Discontinued; See 2001 Annual Book of ASTM Standards, Vol 08.01.

⁶ Annual Book of ASTM Standards, Vol 15.09.

⁷ Annual Book of ASTM Standards, Vol 06.01.

⁸ Discontinued; See 1998 Annual Book of ASTM Standards, Vol 08.01.

⁹ Annual Book of ASTM Standards, Vol 08.02.

D 3418 Test Method for Transition Temperatures of Polymers by Thermal Analysis³

E 96 Test Methods for Water Vapor Transmission of Materials¹⁰

F 619 Practice for Extraction of Medical Plastics¹¹

F 748 Practice for Selecting Generic Biological Test Methods for Materials and Devices¹¹

3. Terminology

3.1 Definitions:

3.1.1 *chain extender*—(1) an active hydrogen containing compound such as a diol or diamine used to increase the molecular weight of an isocyanate-terminated prepolymer by chemical reaction; (2) a diisocyanate used to extend a polyol-terminated polyurethane by chemical reaction.

3.1.2 *chain terminating agent*—an active hydrogen containing a compound such as a monofunctional alcohol, amine, or acid that reacts with the isocyanate group of a prepolymer to prevent further chain growth.

3.1.3 *linear polyurethane*—a polymer whose backbone consists of urethane groups joined by hydrocarbon chains with little or no cross linking.

3.1.4 *segmented polyurethane*—A family of polymers in which ester or ether groups, connected by hydrocarbon chains, occur as blocks that are coupled by urethane and urea groups.

3.1.5 *thermoplastic polyurethane*—linear or segmented polyurethanes that can be melted for processing without significant crosslinking or degradation. They are most frequently synthesized by reacting diols with diisocyanates.

4. Significance and Use

4.1 This guide is intended to aid device fabricators in the selection of proper commercially available polyurethane solids and solutions for their application.

4.2 The polyurethanes covered by this guide may be thermoformed or solution cast into biomedical devices for use as surgical aids or for implantation as determined to be appropriate, based on supporting biocompatibility and physical test data.

5. Descriptive Chemical Information

5.1 *Diols*—Diols that can be used for biomedical applications are as follows:

5.1.1 Poly(oxypropylene).

5.1.2 Poly(oxytetramethylene).

5.1.3 Poly(caprolactone).

5.1.4 Poly(ethylene adipate).

5.1.5 1,4-dihydroxybutane.

5.1.6 Mixture of the above diols.

5.2 *Difunctional Diisocyanates*—Difunctional diisocyanates that can be used are:

5.2.1 Diphenylmethane 4,4-diisocyanate (MDI).

5.2.2 2,4-tolylene diisocyanate (TDI).

5.2.3 1,5-naphthalene diisocyanate.

5.2.4 1,6-hexamethylene diisocyanate (HMDI).

5.3 *Chain Extenders*—Chain extenders that can be used are:

5.3.1 Water.

5.3.2 Glycols.

5.3.3 Aliphatic and aromatic diamines.

5.4 *Chain-Terminating Agents*—Chain-terminating agents suitable for use are:

5.4.1 Monofunctional alcohols, such as methanol or ethanol.

5.4.2 Monofunctional amines, such as dibutylamine or diethylamine.

5.5 *Catalysts*—Stannous octoate is suitable for prepolymer preparation.

5.6 *Optional Additives*:

5.6.1 Pigments and dyes, such as titanium dioxide and copper phthalocyanine blue.

5.6.2 Radiopaque materials, such as barium sulfate.

5.6.3 Antiblocking agents and lubricants, such as natural and synthetic waxes.

5.6.4 Optical brighteners, antioxidants, and light and heat stabilizers.

5.6.5 The basic polymer bought may contain, as agreed upon between the purchaser and supplier, optional adjunct substances required in the production of the polymer or intended end use product, provided these substances are in minor amounts and are biocompatible in the recommended concentrations.

5.7 *Descriptive Information on Polyurethane Solutions*:

5.7.1 Solvent or solvents.

5.7.2 Percent solids.¹²

5.7.3 Solution viscosity—Test Method D 2857.

5.7.4 Infrared identity test—Test Method D 2124.

5.7.5 Recommended diluents.

5.7.6 Gardner color test—Test Method D 1544.

6. Processing Recommendations for Fabrication (by Supplier)

6.1 Drying conditions before fabrication.

6.2 Suggested optimum time, temperature, and pressure for injection molding, extrusion, or thermoforming to desired shapes.

6.3 Polymer stability at elevated temperatures of dry polymer in air or under an inert atmosphere.

6.4 Recommended storage conditions.

7. Suggested Physical Tests on a Solid Specimen or Film

7.1 *Tensile Strength*—Test Methods D 412.

7.2 *Ultimate Elongation*—Test Methods D 412.

7.3 *Compression Deflection Characteristics*—Test Methods D 575.

7.4 *Tensile Stress at 100, 200, and 300 % Strain*—Test Methods D 412.

7.5 *Flexural Strength*—Test Methods D 790.

7.6 *Indentation Hardness (Durometer)*—Test Method D 2240.

¹⁰ Annual Book of ASTM Standards, Vol 04.06.

¹¹ Annual Book of ASTM Standards, Vol 13.01.

¹² David and Staley, *Analytical Chemistry of the Polyurethanes*, Wiley Interscience Publishers, 1969, p. 359.