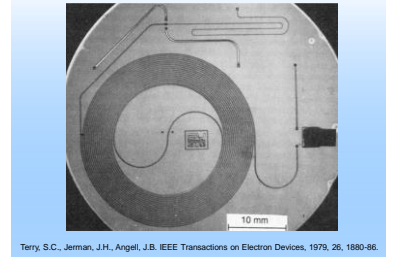


A Gas Chromatographic Air Analyzer Fabricated on a Silicon Wafer



### Microfabrication at subdiffraction-limit resolution

780 nm, 150 fsec, Ti-sapphire laser.  
Raster scanning with two photon absorption - polymerization of SCR500 resin.  
Spatial resolution 120 nm.

Kawata, S., Sun, H.-B., Tanaka, T. & Takada, K. Finer features for functional microdevices. Nature 412, 697 - 698 (2001).

### Basic Microfabrication Techniques

- Micromachining/Precision Machining**
  - High-precision Micromilling  $\Rightarrow$  10's  $\mu$ m
  - Laser Ablation  $\Rightarrow$  10's  $\mu$ m
- Lithography**
  - Optical Lithography  $\Rightarrow$  250 nm
  - X-ray Lithography  $\Rightarrow$  5-10 nm
  - E-beam Lithography  $\Rightarrow$  5-10 nm
  - Ion Beam Lithography  $\Rightarrow$  5-10 nm
- Etching Techniques**
  - Dry and Wet Etching  $\Rightarrow$  10's nm
- Replication Techniques**
  - Hot Embossing  $\Rightarrow$  10's nm
  - Injection Molding  $\Rightarrow$  10's nm
  - Casting  $\Rightarrow$  10's nm

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### What Can Microfluidics Provide?

- Reduced processing time
- Process automation
- Point-of-Care (POC) operation
- Assay reproducibility
- New processing capabilities
- Reduction in reagent/sample consumption
- But, be careful:
  - Scaling issues
  - Fabrication difficulties
  - Surface chemistry (high surface-to-volume ratio)
  - Sampling statistics

Steven A. Soper, Univ. North Carolina, Chapel Hill

### Ultra-high-speed DNA fragment separations using microfabricated capillary array electrophoresis chips

Adam T. Woolley and Richard A. Mathes. Proc. Natl. Acad. Sci. USA, vol. 91, pp. 11348-11352, 1994

### Radial Capillary Array Electrophoresis Microplate and Scanner for High-Performance Nucleic Acid Analysis.

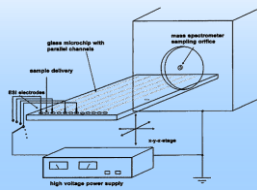
Yaling Shi, Peter C. Simpson, James R. Scheer, David Weiden, Christine Shibata, Marilyn T. Smith, and Richard A. Mathes. Anal. Chem. 1999, 71, 3354-3361

### Microscale Fluid Handling System

What is claimed is: 1. A liquid handling system comprising a microscale liquid handling substrate having one or more channels integrally formed therein, for conducting a liquid sample in said substrate, said one or more channels extending in one or more axial planes in a plane surface of said substrate for transfer of a microscale quantity of a liquid sample of said substrate by droplet, spray or stream.

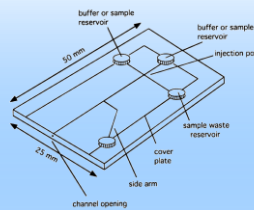
Karger, B.L., Foret, F., Ofeng, X., Durayevski, Y., Zavracki, P., McGuer, N. U.S. Patent # 5,872,010, 1999.

### Multichannel Microchip Electro spray Mass Spectrometry



Xia, Q., Foret, F., Dorayevsky, Y.M., Zarecky, P.M., McQuar, N.E., Karger, B.L. Anal. Chem., 69, 1997, 426-430.

### Generating Electro spray from Microchip Devices Using Electroosmotic Pumping



J. M. Ramsey, R. Ramsey Anal. Chem., 1997, 69, 1174-1178.

### ESI tip (micro)fabrication ?



### Electrospray tip preparation

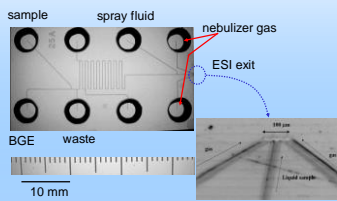
- grinding
- pulling
- etching



Figure 3. A series of photographs showing the steps in the preparation of a tip for electro spray. The general procedure for the grinding, pulling, etching, and the application of the tip.

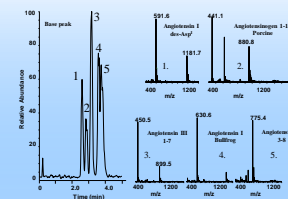
Yves E. Frenay, Jean-Louis Gauduin, Anal. Chem., 2001, 73, 222, 7786-7801

### CE Microdevice with a Pneumatic Nebulizer



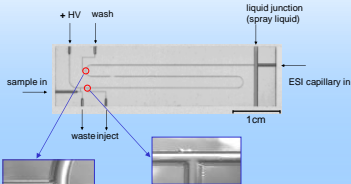
Zhang, B. Liu, H. Karger, B. L. Foret, F. Anal. Chem., 1999, 71, 3258-3264.

### CE Microdevice with a Pneumatic Nebulizer

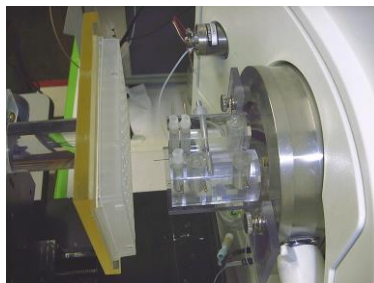


Zhang, B. Liu, H. Karger, B. L. Foret, F. Anal. Chem., 1999, 71, 3258-3264.

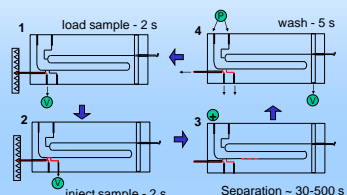
### Liquid junction with an external ESI tip



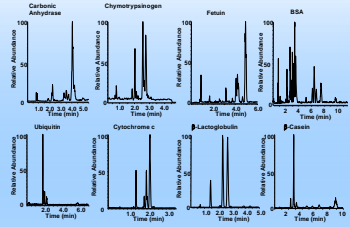
B. Zhang, F. Foret, B. L. Karger, High-Throughput Microfabricated CE/ESI-MS Automated Sampling from a Microchip Plate Anal. Chem., 2001, 73, 2075-2081



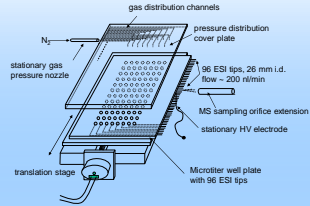
### Scheme of the Operation



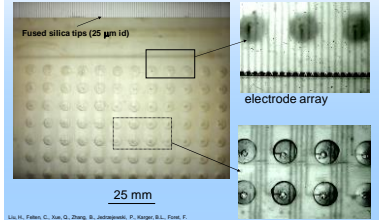
### Protein Tryptic Digests



### High Throughput ESI/MS Analysis

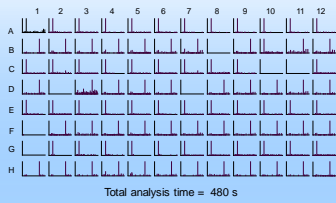


### 96 Tip Plastic Microdevice

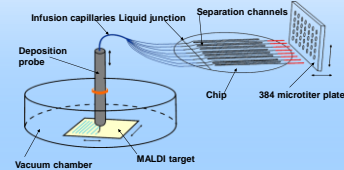


Lin H, Feller C, Liu Q, Zhang B, Johnson V, Karger B.L., Fowl F. Anal Chem. 2005, 77, 2552-2555.

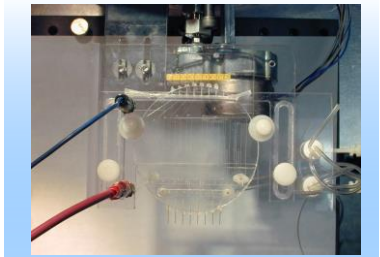
### High Throughput Analysis with 96 ESI Tips Microdevice



### Vacuum Deposition MALDI With Multichannel CE Chip

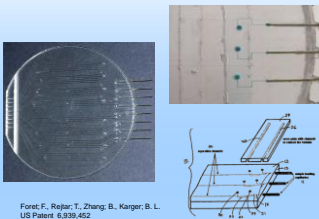


Rejzlar, T., et al., unpublished



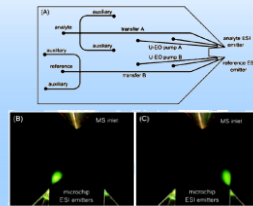
Rejzlar, T., et al., unpublished

### Parallel sample loading and injection device for multichannel microfluidic devices



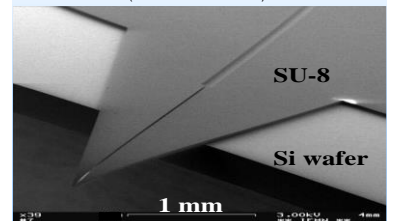
Foster F., Rejzlar T., Zhang B., Karger, B. L. US Patent 6,939,452

### Microfluidic dual emitter electrospray ionization source for accurate mass measurements



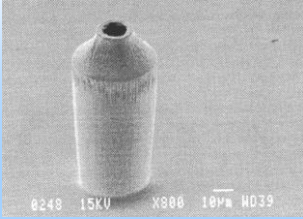
A. G. Chambers and J. M. Ramsey. Anal. Chem., 2012, 84, 1446

### Micro-nib electrospray source (SU-8 on a silicon wafer)



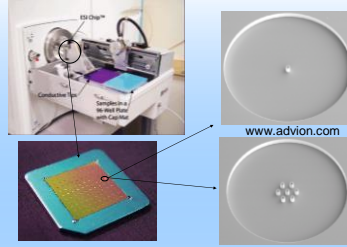
Le Duc S., Anouf S., Follwo C. ELECTROPHORESIS 2009, 30, 3640-3647.

**ESI tips produced by DRIE in silicon**

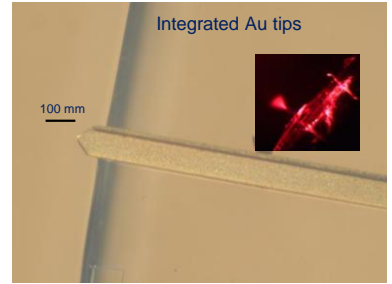
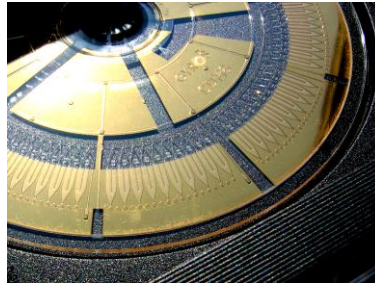
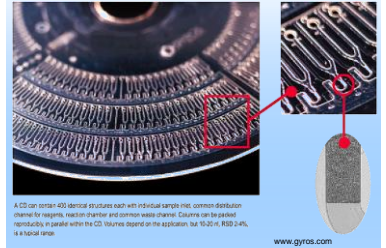


Splahn, J., Mann, J., Graf, F., Emmet, A., Demina, G., Rasmussen, J. Rapid Commun. Mass Spectrom. 2003, 17, 327-341.

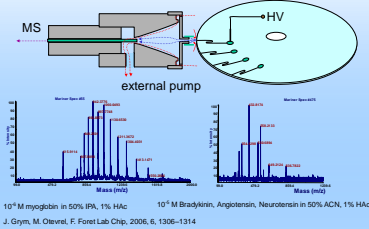
**Infusion ESI Tip Array**



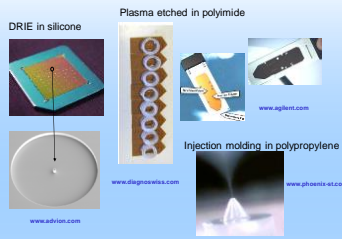
**The CD microdevice concept**



**Aerodynamic mass spectrometry interfacing of microdevices without electrospray tips**

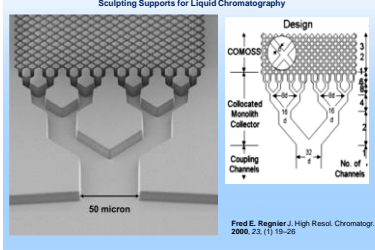


**ESI tip fabrication**

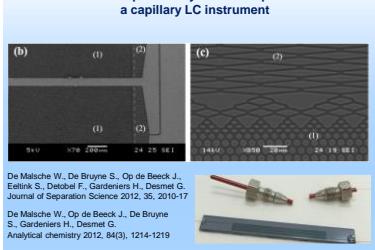


**Applications**

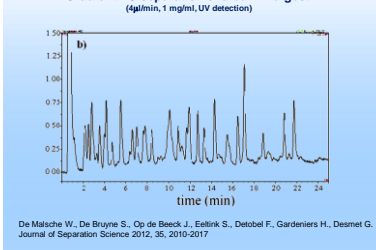
### Microfabricated Monolith Columns for Liquid Chromatography



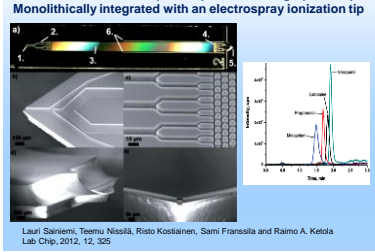
### Porous-shell pillar array column separations on a capillary LC instrument



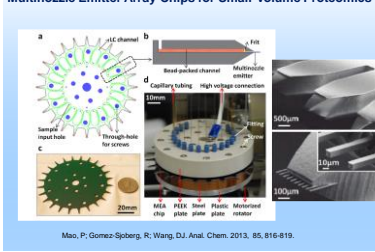
### Gradient LC separation of albumin digest



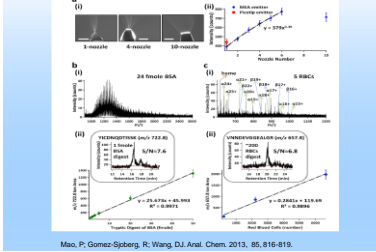
### A microfabricated micropillar liquid chromatographic chip



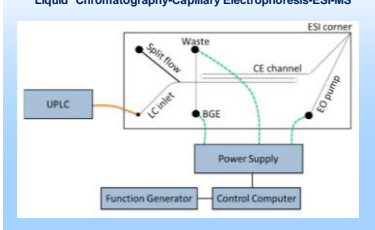
### Multinozzle Emitter Array Chips for Small-Volume Proteomics



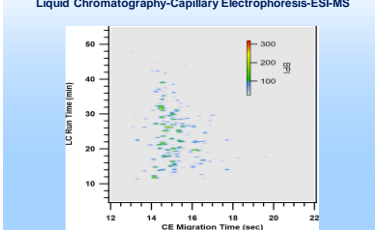
### Multinozzle Emitter Array Chips for Small-Volume Proteomics



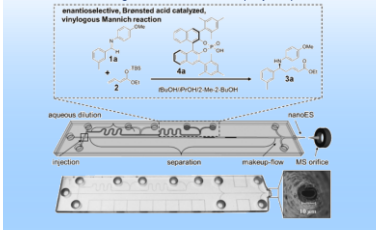
### Hybrid Capillary/Microfluidic System for Comprehensive Online Liquid Chromatography-Capillary Electrophoresis-ESI-MS



### Hybrid Capillary/Microfluidic System for Comprehensive Online Liquid Chromatography-Capillary Electrophoresis-ESI-MS



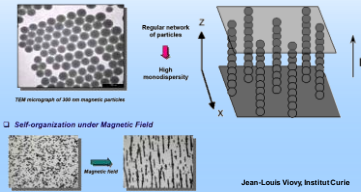
### Asymmetric Organocatalysis and Analysis on a Single Microfluidic Nanospray Chip



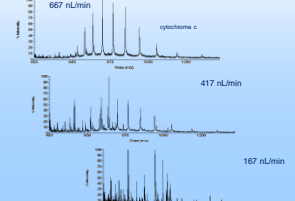
### Enzymatic microreactor with magnetic nanoparticles



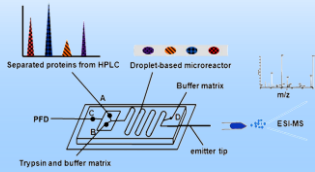
### Self assembly of magnetic nanoparticles



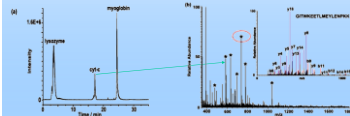
### On-chip tryptic digest with direct coupling to ESI-MS using magnetic particles



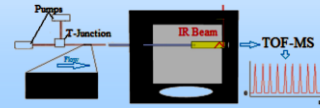
### Proteolysis in microfluidic droplets: an approach to interface protein separation and peptide mass spectrometry



### Proteolysis in microfluidic droplets: an approach to interface protein separation and peptide mass spectrometry

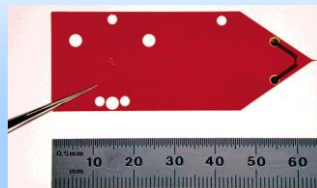


### Nanoliter Segmented-Flow Sampling Mass Spectrometry with On-Line Compartmentalization

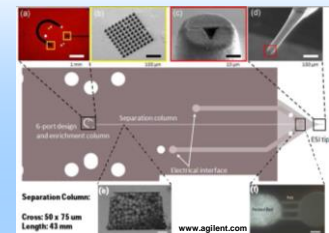


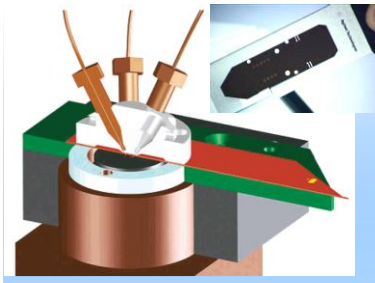
## Commercialization

### Microfluidic Chip for Peptide Analysis with an Integrated HPLC Column, Sample Enrichment Column, and Nanoelectrospray Tip



### Polyimide HPLC-chip, integrating an enrichment column, frits, a laser ablated ESI tip and trapezoidal separation column





### Segmented column HPLC/chip

(A) Standard one segment LC column with sample loop bypassing the enrichment column.

(B) Two segment LC column with sample loop. Note transfer channels.

(C) Three segment LC column with sample loop. Note transfer channel in blue. Full column layout is below.

www.agilent.com

### Segmented column HPLC/chip

Three LC columns – length 130 mm  
Each segment individually packed.

Multi-segment three chip stack in enclosure.

BSA digest separated with a 30min gradient on a 2 column segmented chip, packed with 3.5µm particles

www.agilent.com

### TRIZAIC nanoTile - Waters

- UPLC Performance
- All fluidic connections are pre-made & factory tested
- Integrated ESI Emitter
- Low System Volumes
- Decreased Band Broadening
- Higher Sensitivity
- Incorporates:
  - Heater & Sensor
  - EPROM
- Increased Reproducibility

1.7µm BEH TRIZAIC nanoTile

Built-in Heater, Sensors, EPROM

ESI Emitter

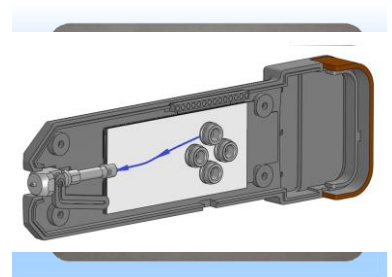
UPLC 'Column'

### Enolase digest

70 fmol, 2 µm particles

TRIZAIC nanoTile

nanoACQUITY



### Green tape

$Al_2O_3$ -MgO-SiO<sub>2</sub> glass particles mixed with organic binders and solvents to form glass ceramic

**Product Description**  
951 Green Tape is a low-temperature fired ceramic tape. The 951 system comprises a complete cofirable family of Au and Ag metallizations, buried passives, and encapsulants. 951 is available in multiple thicknesses for use as an insulating layer in:

- Multichip modules
- Single chip packages
- Ceramic printed wiring boards
- RF modules

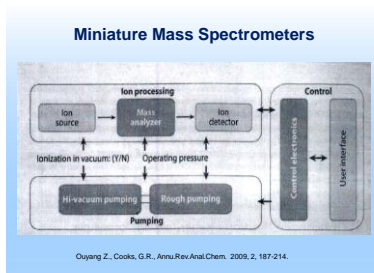
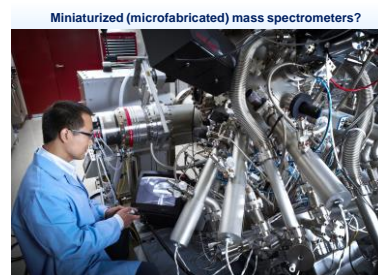
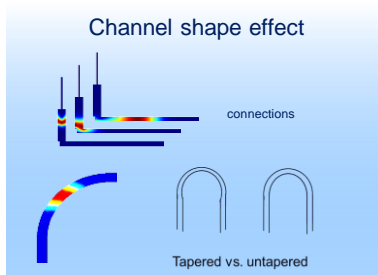
<http://www.dupont.com/mcm>

### Ceramic Microfluidic Fabrication

Cast Ceramic Material    Fired Wafer    Final Circuit Part

### Channel Geometries and Packing

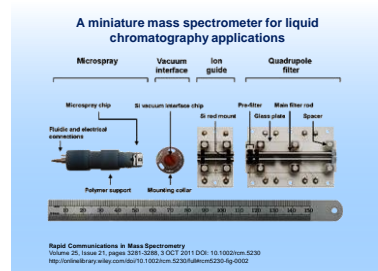
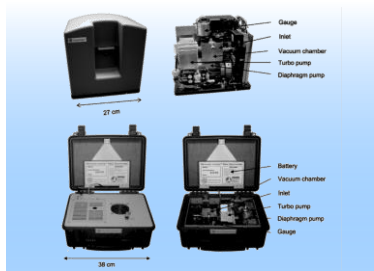
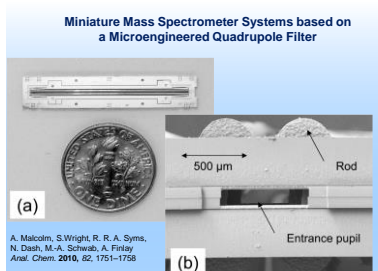
1.7µm particles



### Table 1. Portable mass spectrometry analytical systems

System	Ion-molecule parallel systems					Portable system without ion-pairing	
	Filter (d/f)	Chemical ionization (CI)	Quadrupole (Q)	Ion mobility (IM)	Gridless (G)	Ion current (IC)	Mass resolution (M/R)
Developer	SI	SI	SI	SI	SI	SI	SI
Function	SI	SI	SI	SI	SI	SI	SI
Company	SI	SI	SI	SI	SI	SI	SI
Weight (kg)	1.5	1.5	1.5	1.5	1.5	1.5	1.5
Power (W)	10	10	10	10	10	10	10
Mass resolution	1000	1000	1000	1000	1000	1000	1000
Mass range (amu)	10-1000	10-1000	10-1000	10-1000	10-1000	10-1000	10-1000
Mass range resolution	1000	1000	1000	1000	1000	1000	1000


SI: SI-MS; CI: Chemical Ionization; Q: Quadrupole; IM: Ion Mobility; G: Gridless; IC: Ion Current; M/R: Mass Resolution; M: Mass; R: Range.



A. Malcolm, S. Wright, R. A. Syme, N. Dash, M.-A. Schwab, A. Finlay *Anal. Chem.* **2010**, *82*, 1751–1758

Rapid Communications in Mass Spectrometry  
Volume 25, Issue 21, pages 2351–2358, 9 OCT 2011 DOI: 10.1002/rcm.5239  
http://dx.doi.org/10.1002/rcm.5239





Mass Analyzer ionchip® quadrupole mass spectrometer  
 Mass Range m/z 50-800 with ionchip®150  
 Mass Accuracy  $\pm$  m/z 0.3 in full scan  
 Mass Resolution m/z 0.7 $\pm$ 0.1 FWHM  
 Sensitivity 10pg of reserpine in SIM mode S/N ratio of 10:1 (RMS)



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4000 MiD Bringing mass spectrometry down to size

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Advion expression Compact Mass Spectrometer

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