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(54) Title: PUMP AND INJECTOR FOR LIQUID CHROMATOGRAPHY

(57) **Abstract:** A combined pump-injector valve utilizing a single piece as the barrel of the pump and as the stator of the valve, thus eliminating any need for connections between a pump and a valve, and therefore the potential for high-pressure leaks or pressure reductions. The combined pump-injector valve permits injection of nano liter-sized samples into a chromatographic column, which is sealed during loading of the sample and filling of the pump, such that complete analyses can be completed with microliters of mobile phase with nanoliters of a sample.

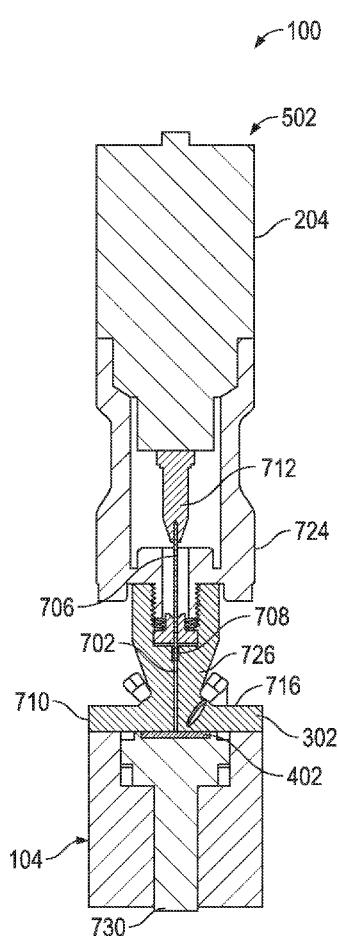


FIG. 7



KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

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TITLE OF THE INVENTION

[0001] Pump and injection valve for liquid chromatography

CROSS-REFERENCE TO RELATED APPLICATIONS

[0002] This application claims the benefit of U.S. Provisional Patent Application

5 Number 61/753,299 entitled "Integral nano-scale pump and injector for high performance liquid chromatography" filed on January 16, 2013 in the United States Patent and Trademark Office and which is incorporated herein by reference.

BACKGROUND OF THE INVENTION

1. Field of Invention

0 [0003] The present invention pertains to pump and injection valve systems for use with liquid chromatography. More particularly, the present invention pertains to a combined pump/injection valve for injection of a nanoliter-sized sample into a chromatography column utilizing a single piece as the barrel of the pump and as the stator of the valve, thus eliminating any need for connections between the pump and valve.

5 2. Description of the related art

[0004] Any discussion of the prior art throughout the specification should in no way be considered as an admission that such prior art is widely known or forms part of common general knowledge in the field.

20 [0005] High performance liquid chromatography (HPLC) is generally performed using pumps, columns and injection valves scaled to deliver fluids at flow rates measured in cubic centimeters of fluid per minute. These components are typically separate and joined together to provide a system for HPLC. Unfortunately, these systems require relatively large sample volumes, large mobile phases, and large flow rates for analysis.

[0006] Additionally, these relatively large systems frustrate generate of field portable HPLC units, where there is a need for a lightweight robust flow system which uses a minimum of mobile phase during an analysis.

[0007] It would therefore be desirable to provide an integrated nano-scale pump and
5 injection valve for high performance liquid chromatography.

SUMMARY OF THE INVENTION

[0008] It is an object of the preferred embodiments of the present invention to overcome or ameliorate at least one of the disadvantages of the prior art, or to provide a useful alternative.

0 [0009] According to a first aspect of the invention there is provided an integral nano-scale pump and injection valve for high performance liquid chromatography comprising:

an integrated barrel-stator, said integrated barrel-stator having an elongate barrel and a stator, said integrated barrel-stator integrally-formed of a single piece of monolithic material,

5 said elongate barrel having a first open end at a first end of said integrated barrel-stator and a second open end at a second end of said integrated barrel-stator and a sidewall defining an interior chamber adapted to receive a supply of fluid,

said stator being circular, said stator having a first side, said elongate barrel second end terminating at a centerpoint of said stator at said stator first side and providing an orifice, said stator first side being coplanar with said second end of said integrated barrel-stator, said stator having a first stator port for communication with a mobile phase supply, said stator in communication with a rotor at said orifice, said stator at said second end of said integrated barrel-stator,

a longitudinal plunger slidably extending into said interior chamber at said first end of said integrated barrel-stator, said plunger being of substantially uniform cross-section; and

5 said rotor being circular, said rotor having a surface adjacent said stator, said rotor having a first channel in said surface, said rotor rotatable with respect to said stator about said centerpoint of said stator between a load position and an injection position,

0 said load position defined by said first stator port and said orifice communicating with said first channel, and

0 said injection position defined by said orifice and a second stator port communicating with said first channel.

[0010] In an embodiment the integral nano-scale pump and injection valve further comprises:

a first hard plastic seal about the plunger sized to fit within said barrel and to fit about said plunger;

5 a flexible seal about the plunger sized to fit within said barrel and to fit about said plunger adjacent the first hard plastic seal;

a second hard plastic seal about the plunger sized to fit within said barrel and to fit about said plunger adjacent the flexible seal;

20 a driving disk having a bore therethrough sized to fit about said plunger without interference, said driving disk having a driving disk first end and a driving disk second end, said driving disk sized to freely fit within said integrated barrel-stator adjacent said barrel, said driving disk having a shoulder near said driving disk first end and a neck at

5 said driving disk second end, said neck sized to fit within said barrel and to contact said first hard plastic seal,

10 a threaded male sleeve having a bore therethrough sized to permit movement of said plunger without interference, said threaded male sleeve sized to a threaded female section within said integrated barrel-stator adjacent said barrel; and

15 a spring contacting said shoulder of said driving disk and an end of said threaded male sleeve.

[0011] In an embodiment the integral nano-scale pump and injection valve further comprises a pump actuator associated with a plunger-driving piston attached to said plunger.

0 [0012] In an embodiment the integral nano-scale pump and injection valve further comprising a valve actuator associated with a driveshaft attached to said rotor.

[0013] In an embodiment the integral nano-scale pump and injection valve further comprises:

5 said stator having the second stator port in communication with a fifth stator port, a third stator port for communication with a sample reservoir, a fourth stator port for outflow, a sixth stator port for communication with a chromatography column, a seventh stator port for return from said chromatography column, and an eighth stator port for outflow from said valve,

said rotor having a second channel in said surface, and a third channel in said surface,

20 said load position further defined by said third stator port and said fourth stator port communicating with said second channel; and

said injection position further defined by said fifth stator port and said sixth stator port communicating with said second channel, and by said seventh stator port and said eighth stator port communicating with said third channel.

[0014] In an embodiment the integral nano-scale pump and injection valve further

5 comprises a pump actuator associated with a plunger-driving piston attached to said plunger.

[0015] In an embodiment the integral nano-scale pump and injection valve further comprises a valve actuator associated with a driveshaft attached to said rotor.

[0016] In an embodiment the integral nano-scale pump and injection valve further comprises:

0 said stator having the second stator port in communication with a fifth stator port via loop, a third stator port for communication with a sample reservoir, a fourth stator port for outflow, a sixth stator port for communication with a chromatography column, a seventh stator port for return from said chromatography column, and an eighth stator port for outflow from said valve,

5 said rotor having a second channel in said surface, a third channel in said surface, and a fourth channel in said surface;

said load position further defined by said second stator port and said third stator port communicating with said second channel, and said fourth stator port and said fifth stator port communicating with said third channel; and

20 said injection position further defined by said fifth stator port and said sixth stator port communicating with said third channel, and by said seventh stator port and said eighth stator port communicating with said fourth channel.

[0017] In an embodiment the integral nano-scale pump and injection valve further comprises a pump actuator associated with a plunger-driving piston attached to said plunger.

[0018] In an embodiment the integral nano-scale pump and injection valve further comprises a valve actuator associated with a driveshaft attached to said rotor.

5 [0019] In an embodiment the integral nano-scale pump and injection valve further comprises:

 said stator having the second stator port in communication with a fifth stator port via loop, a third stator port for communication with a sample reservoir, a fourth stator port for outflow, a sixth stator port for communication with a chromatography column, said 0 rotor having a second channel in said surface, and a third channel in said surface, said rotor rotatable with respect to said stator about said centerpoint of said stator between a load position and an injection position,

 said load position further defined by said second stator port and said third stator port communicating with said second channel, and said fourth stator port and said fifth stator 5 port communicating with said third channel; and

 said injection position further defined by said fifth stator port and said sixth stator port communicating with said third channel.

[0020] In an embodiment the integral nano-scale pump and injection valve further comprises a pump actuator associated with a plunger-driving piston attached to said plunger.

20 [0021] In an embodiment the integral nano-scale pump and injection valve further comprises a valve actuator associated with said rotor.

[0022] According to a second aspect of the invention there is provided an integral nano-scale pump and injection valve for high performance liquid chromatography comprising:

an integrated barrel-stator, said integrated barrel-stator having an elongate barrel and a stator, said integrated barrel-stator integrally-formed of a single piece of monolithic material,

5 said elongate barrel having a first open end at a first end of said integrated barrel-stator and a second open end at a second end of said integrated barrel-stator and a sidewall defining an interior chamber adapted to receive a supply of fluid,

0 said stator being circular, said stator having a first side, said elongate barrel second end terminating at a centerpoint of said stator at said stator first side at an orifice, said stator first side being coplanar with said second end of said integrated barrel-stator, said stator at said second end of said integrated barrel-stator,

5 said elongate barrel in communication with a rotor at said orifice, said stator having a first stator port for communication with a mobile phase supply,

a longitudinal plunger slidably extending into said interior chamber at said first end of said integrated barrel-stator, said plunger being of substantially uniform cross-section; and

5

said rotor being circular, said rotor having a surface adjacent said stator, said rotor having a first channel in said surface, said rotor rotatable with respect to said stator about said centerpoint of said stator between a load position and an injection position,

20 said load position defined by said first stator port and said orifice communicating with said first channel, and

said injection position defined by said orifice and a second stator port communicating with said first channel.

[0023] In an embodiment the integral nano-scale pump and injection valve further comprises:

5 said stator having the second stator port in communication with a fifth stator port, a third stator port for communication with a sample reservoir, a fourth stator port for outflow, and a sixth stator port for communication with a chromatography column;

0 said rotor having a second channel in said surface;

0 said load position further defined by said third stator port and said fourth stator port communicating with said second channel; and

0 said injection position further defined by said fifth stator port and said sixth stator port communicating with said second channel.

[0024] In an embodiment the integral nano-scale pump and injection valve further comprises a pump actuator associated with a plunger-driving piston attached to said plunger.

[0025] In an embodiment the integral nano-scale pump and injection valve further comprises a valve actuator associated with a driveshaft attached to said rotor.

5 [0026] The preferred embodiments of the present invention meet the above stated needs and overcome one or more deficiencies in the prior art by providing a combined pump/injector valve which injects nanoliter samples into a chromatographic column, which is sealed during loading of the sample and filling of the pump, such that complete analyses can be completed with microliters of mobile phase, ranging from as small as about 5-10 nanoliters, to
20 60 nanoliters, and larger. The preferred embodiments of the present invention therefore provide a lightweight robust flow system which uses a minimum of mobile phase during an analysis and is appropriate for use as a field portable HPLC unit.

[0027] The preferred embodiments of the present invention provide an integral nano-scale pump and injection valve for high performance liquid chromatography which includes an integrated barrel-stator, which has an elongate barrel in a first end and a stator at a second end, a plunger slidably disposed within an interior chamber of the barrel of substantially uniform cross-section, and a rotor, wherein the pump and injection valve is switchable between a load position and a injection position. In one embodiment, the circular rotor has a surface adjacent the stator and has a plurality of channels in its surface and is with respect to the stator about a centerpoint between the load position and the injection position. The elongate barrel portion of the integrated barrel-stator includes an open ends, a length, and a sidewall defining the interior chamber adapted to receive a supply of fluid, an outer diameter, and a wall thickness. The circular stator has an orifice therethrough at its centerpoint and a first side and a second side such that the elongate barrel open distal end is aligned with the second side of the stator at the centerpoint and the interior chamber includes the orifice. The pump is therefore in communication with the valve at the orifice.

[0028] In a first embodiment, the rotor includes three channels and the stator has a first stator port for communication with a mobile phase supply, a second stator port in communication with a fifth stator port, a third stator port for communication with a sample reservoir, a fourth stator port for sample outflow, a sixth stator port for communication with a chromatography column, a seventh stator port for return from the chromatography column, and an eighth stator port for outflow from the valve. In the first embodiment, the load position is defined by the first port and the orifice communicating with a first channel and by the third port and the fourth port communicating with a second channel. In the first embodiment, the injection position is defined by the orifice and the second port communicating with the first channel, by

the fifth port and the sixth port communicating with the second channel, and by the seventh port and the eighth port communicating with the third channel.

[0029] In the alternative embodiment, the rotor includes four channels and the stator has a first stator port for communication with a mobile phase supply, a second stator port in communication with a fifth stator port via an external loop, a third stator port for communication with a sample reservoir, a fourth stator port for sample outflow, a sixth stator port for communication with a chromatography column, a seventh stator port for return from the chromatography column, and an eighth stator port for outflow from the valve. In the alternative embodiment, the load position is defined by the first port and the orifice communicating with a first channel, by the second port and the third port communicating with the second channel, and the fourth port and the fifth port communicating with the third channel. In the alternative embodiment, the injection position is defined by the orifice and the second port communicating with the first channel, by the fifth port and the sixth port communicating with the third channel, and by the seventh port and the eighth port communicating with the fourth channel.

[0030] In a further alternative embodiment, where the embodiment is used as a pump without regard to the equipment connected thereto, the rotor has only one channel and the stator has a first stator port for communication with a mobile phase supply and a second stator port for communication with an external device. In the further alternative embodiment, the load position is defined by the first port and the orifice communicating with a first channel and the injection position is defined by the orifice and the second port communicating with the first channel.

[0031] In an additional alternative embodiment, wherein the embodiment is used to push sample through a column, but wherein the output of the column is provided to other equipment rather than through the valve, the embodiment includes channels and the stator has a

first stator port for communication with a mobile phase supply, a second stator port in communication with a fifth stator port via an external loop, a third stator port for communication with a sample reservoir, a fourth stator port for sample outflow, and a sixth stator port for communication with a chromatography column. In the additional alternative embodiment, the 5 load position is defined by the first port and the orifice communicating with a first channel, by the second port and the third port communicating with the second channel, and the fourth port and the fifth port communicating with the third channel. In the alternative embodiment, the injection position is defined by the orifice and the second port communicating with the first channel, and by the fifth port and the sixth port communicating with the third channel.

0 [0032] Unless the context clearly requires otherwise, throughout the description and the claims, the words “comprise”, “comprising”, and the like are to be construed in an inclusive sense as opposed to an exclusive or exhaustive sense; that is to say, in the sense of “including, but not limited to”.

[0033] Additional aspects, advantages, and embodiments of the invention will 5 become apparent to those skilled in the art from the following description of the various embodiments and related drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

[0034] So that the manner in which the described features, advantages, and objects of the invention, as well as others which will become apparent, are attained and can be understood 20 in detail; more particular description of the invention briefly summarized above may be had by referring to the embodiments thereof that are illustrated in the drawings, which drawings form a part of this specification. It is to be noted, however, that the appended drawings illustrate only

typical preferred embodiments of the invention and are therefore not to be considered limiting of its scope as the invention may admit to other equally effective embodiments.

[0035] In the drawings:

[0036] **FIG. 1** is an illustration of a top view of one embodiment of the present invention as assembled.

[0037] **FIG. 2** is an illustration of a side view of one embodiment of the present invention as assembled.

[0038] **FIG. 3** is an illustration of the face of the stator of the integrated barrel-stator of the first embodiment of the present invention.

[0039] **FIG. 4** is an illustration of the face of the rotor of the first embodiment of the present invention.

[0040] **FIG. 5** is an illustration of the relative positions of the face of the stator and the face of the rotor of the first embodiment of the present invention in the load position.

[0041] **FIG. 6** is an illustration of the relative positions of the face of the stator and the face of the rotor of the first embodiment of the present invention in the injection position.

[0042] **FIG. 7** is a cross-section illustration of the present invention along line Z-Z of **FIG. 1** for the maximum position of the pump associated with the load position in connection with a linear actuator.

[0043] **FIG. 8** is a cross-section illustration of the present invention along line Z-Z of **FIG. 1** for the maximum position of the pump in the injection position in connection with a linear actuator.

[0044] **FIG. 9** is a close-up of the pump plunger driven forward for delivery for the maximum position of the pump in the injection position.

[0045] **FIG. 10** is an illustration of isometric view of the embodiment of the present invention with the pump and valve actuators illustrating the first valve position illustrated in **FIGS. 5** and **7** at the maximum position of the pump in the load position.

[0046] **FIG. 11** is an illustration of isometric view of the embodiment of the present invention with the pump and valve actuators illustrating the second valve position illustrated in **FIGS. 6** and **8** at the maximum position of the pump in the injection position.

[0047] **FIG. 12A** is an enlargement of Section A of **FIG. 10**.

[0048] **FIG. 12B** is an enlargement of Section B of **FIG. 11**.

[0049] **FIG. 13** is an illustration of the face of the stator of the integrated barrel-stator in the alternative embodiment of the present invention.

[0050] **FIG. 14** is an illustration of the face of the rotor of the alternative embodiment of the present invention.

[0051] **FIG. 15** is an illustration of the relative positions of the face of the stator and the face of the rotor of the alternative embodiment of the present invention in the load position.

[0052] **FIG. 16** is an illustration of the relative positions of the face of the rotor and the face of the rotor of the alternative embodiment of the present invention in the injection position.

[0053] **FIG. 17** is an illustration of the relative positions of the face of the stator and the face of the rotor of the further alternative embodiment of the present invention in the load position.

[0054] **FIG. 18** is an illustration of the relative positions of the face of the rotor and the face of the rotor of the further alternative embodiment of the present invention in the injection position.

[0055] **FIG. 19** is an illustration of the relative positions of the face of the stator and the face of the rotor of the additional alternative embodiment of the present invention in the load position.

[0056] **FIG. 20** is an illustration of the relative positions of the face of the rotor and 5 the face of the rotor of the additional alternative embodiment of the present invention in the injection position.

[0057] **FIG. 21** is a close-up of the pump plunger driven forward for delivery for the maximum position of the pump in the injection position depicting a seal of the present disclosure.

0 [0058] **FIG. 22** is an illustration of the relative positions of the face of the stator and the face of the rotor of the additional alternative embodiment of the present invention in the load position.

[0059] **FIG. 23** is an illustration of the relative positions of the face of the rotor and 5 the face of the rotor of the additional alternative embodiment of the present invention in the injection position.

DESCRIPTION OF THE PREFERRED EMBODIMENT

[0060] Referring to **FIGS. 1** and **2**, a two-position embodiment of the integrated nano-scale pump and injection valve **100** is provided. A top view of one embodiment of the integrated nano-scale pump and injection valve **100** as assembled is provided in **FIG. 1** while a 20 side view is provided **FIG. 2**. As illustrated in **FIGS. 1B** and **2**, the integrated nano-scale pump and injection valve **100** includes an integrated barrel-stator **716** which provides the interface between the pump section **102** and valve section **104**.

[0061] Referring to **FIGS. 3** and **4**, constructions of the face of the stator **302** and the face of the rotor **402** of the integrated barrel-stator **716** are illustrated for a first embodiment. Referring to **FIGS. 13** and **14**, constructions of the face of the stator **302** of the integrated barrel-stator **716** and the face of the rotor **1402** of the valve section **104** are illustrated for an alternative embodiment.

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[0062] Referring to **FIGS. 1-22**, by forming the elongate barrel **726** of the pump **708** and the stator **302, 1302, 1712, 1932** of the valve **710** of a single part as integrated barrel-stator **716**, the integrated nano-scale pump and injection valve **100** may operate at high pressures without degradation incident to intervening parts and fittings.

0 [0063] Unlike the prior art where a valve and pump were separate bodies simply joined together, in the integrated nano-scale pump and injection valve **100**, as illustrated in **FIGS. 7-12B**, the elongate barrel **726** of the pump **708** and the stator **302, 1302, 1712, 1932** of the valve **710** are integrally formed of a single piece to provide direct communication between the pump **708** and the valve **710** without introducing any fittings or connectors which may swell 5 or leak during high pressure operation.

[0064] By switching between the maximum extent of the load position **502, 1502, 1710, 1928** and the maximum extent of the injection position **602, 1602, 1802, 2002**, the integrated nano-scale pump and injection valve **100** provides a pump **708**, which may be sized to hold microliters for use with nano-scale columns for quick separation.

20 [0065] Upon initiation of loading, the pump **708** and valve **710** are positioned in the load position **502** and the plunger **706** begins being retracted by the piston **712** and draws a solvent from a reservoir, such as through a 15 cm × 200 μm steel tube into the barrel **726**. At the same time and independent of pump filling, a sample is introduced into the sample loop through

a 5.08 cm × 75 μm inner diameter capillary, which is connected to the port **308** on the pump and to a sample supply, preferably using a zero-dead volume connector.

[0066] After completion of loading, the integrated nano-scale pump and injection valve **100** may be switched for injection, changing the direction of operation of the pump **708** and changing the position of the valve **710**. During injection, the plunger **706** is driven by the piston **712** into the barrel **726**. The rate of advance, and therefore the dispensing flow rate, may be controlled by power supply and/or by computer software. As the plunger **706** is driven forward by the piston **712**, the sample is driven from the sample passage of second channel **406** into the column **504** while the mobile phase flows from the barrel **726** through the loop **506**, through the column **504** and to the detector.

[0067] In all embodiments, in the load position **502**, **1502**, **1710**, **1928**, the pump plunger **706** is retracted for filling the interior chamber **702** as illustrated in FIGS. 7, 10 and 12A. The plunger may have a diameter of 0.03 inches, or slightly smaller, or of 0.93 inches, or slightly larger, or may be between, such as 0.62 inches. The pump **708** thus includes a pump plunger **706**, an interior chamber **702** defined by an elongate barrel **726** and the plunger **706**. Referring to FIGS. 5, 7, 10, 12A and 15, the arrangement and nano-scale operation of integrated nano-scale pump and injection valve **100** is illustrated in at the maximum position of the pump **708** in the load position **502**. The load position **502** of integrated nano-scale pump and injection valve **100**, showing the positions of the stator **302** and the rotor **402** in the first embodiment, is depicted in FIG. 5. The load position **1502** of integrated nano-scale pump and injection valve **100**, showing the positions of the stator **1302** and the rotor **1402** for the alternative embodiment is depicted in FIG. 15. As can be appreciated either the stator **302**, **1302**, **1712**, **1932** or the rotor **402**, **1402**, **1702**, **1902** will include a seal surface to contact the other. A cross-section

illustration of the present invention along line Z-Z of **FIG. 1** for the maximum position of the pump **708** in the load position **502, 1502, 1710, 1928** is illustrated in **FIG. 7**. An illustration of isometric view of the embodiment of the present invention with the valve actuator illustrating the first valve position is illustrated in **FIG 10**. An enlargement of Section A of **FIG. 10** is provided 5 in **FIG. 12A**.

[0068] Referring to **FIG. 21**, for operation at high pressure, such as above 10000 psi, it is essential that a strong seal **2150** be positioned about the plunger **706** within the barrel **726** of the integrated barrel-stator **716**, at least a stroke-length **1202** above or beyond the first end **750** of the plunger **706** when in the maximum injection position so as to contact the plunger **706** and to 0 form a seal thereabout. Positioning the seal **2150** less than a stroke-length **1202** from the first end **750** of the plunger **706** would cause the seal **2150** to fail when the plunger **706** was fully retracted to reach the maximum load position. While a single seal across the barrel **726**, through which the plunger **706** would move, may be used, a composite seal is preferable. As depicted in **FIG. 21**, the seal **2150** about the plunger **706** within the barrel **726** may be formed of a 5 compressed sequence of a first hard seal **2100**, a flexible seal **2108**, and a second hard seal **2112**, placed under compression by a driving disk **2106** maintained within the integrated barrel-stator **716**. The diameter of the barrel **726** of the integrated barrel-stator **716** is enlarged for that section more than a stroke-length **1202** above or beyond the first end **750** of the plunger **706** when in the maximum injection position to accept a first hard plastic seal **2100**. The first hard 20 plastic seal **2100** may be composed of a material such as polyether ether ketone (PEEK) or another material, and is sized to fit within the barrel **726** and about the plunger **706** without precluding movement of the plunger **706**. Atop the first hard plastic seal **2100** is positioned a flexible seal **2108**. The flexible seal **2108** is composed of a compressible sealing material, such

as polytetrafluoroethylene (PTFE). The flexible seal **2108** is sized to fit within the barrel **726** and about the plunger **706** without precluding movement of the plunger **706**. Atop the flexible seal **2108** is positioned a second hard plastic seal **2112**, which may also be composed of a material such as polyether ether ketone (PEEK) or another material, and is sized to fit within the barrel **726** and about the plunger **706** without precluding movement of the plunger **706**.
5 Compression of the flexible seal **2108** results in lateral expansion of the flexible seal **2108** and thereby causes the flexible seal **2108** to provide a seal against the plunger **706** which does not preclude movement of the plunger **706**, between the first hard seal **2100** and the second hard seal **2112**. This may be accomplished by application of force against the second hard seal **2112** and a
0 shoulder **2114** in the barrel **726** to maintain the position of the first hard seal **2100**. The application of force against the second hard seal **2112** may be obtained by joining a threaded male sleeve or nut **2102**, having a bore therethrough to freely accommodate the plunger **706** and piston **712** without interference, to the integrated barrel-stator **716**, above or beyond the seal
5 **2150**, which threaded male sleeve **2102** would apply force to one or more springs **2122**, particularly a Belleville spring also known as a coned disc spring, positioned within the integrated barrel-stator **716** above or adjacent the barrel **726**, to force a driving disk **2106** to compress the second hard seal **2112**. The threaded male sleeve **2102** is sized to a threaded female section of the integrated barrel-stator **716** above or adjacent the barrel **726**. The driving disk **2106** includes a bore **2124** sized to permit the plunger **706** to pass therethrough without
20 interference, a shoulder **2116** to permit the application of force against the driving disk **2106** from the springs **2122** smaller in diameter than the threaded male sleeve or nut **2102** so as not to contact the inner walls of the integrated barrel-stator **716**, and a neck **2120** at its end **2126** proximate the barrel **726** sized to enter the barrel **726** without interference and having sufficient

height to contact and apply force against the second hard seal **2112**. As a result, the neck **2120** is driven against the second hard seal **2112**, which is in turn driven into the flexible seal **2108** to compress it and form a seal about the plunger **706**. The plunger **706** is therefore able to move through the seal **2150** without fluid seeping past, even as the flexible seal **2108** may become pliable during repeated movement of the plunger **706**. Because only the seals **2112**, **2108**, **2100** laterally contact the plunger **706**, and because the balance of the components, including the integrated barrel-stator **716**, the threaded male nut or sleeve **2102**, and the driving disk **2106**, include sufficient clearance for the plunger **706** to move without interference, the plunger **706** can move within the barrel **726** and can operate to draw or eject fluid into the barrel **726** and through the stator **302**, particularly at high pressure.

[0069] Thus, the seal **2150** includes a first hard plastic seal **2100**, a flexible seal **2108**, a second hard plastic seal **2112** and is compressed to seal about the plunger **706** by a driving disk **2106**, a threaded male sleeve **2102**, and one or more springs **2122**. The first hard plastic seal **2100** is sized to fit within the barrel **726** and to fit about the plunger **706**. The flexible seal **2108** is sized to fit within the barrel **726** and to fit about the plunger **706** adjacent the first hard plastic seal **2100**. The second hard plastic seal **2112** is sized to fit within the barrel **726** and to fit about the plunger **706** adjacent the flexible seal **2108**. The driving disk **2106** has a bore **2124** therethrough sized to fit about the plunger **706** without interference, a first end **2118** and a second end **2126**. The driving disk **2106** is sized to freely fit within said integrated barrel-stator **716** adjacent the barrel **726**, and includes a shoulder **2116** near the first end **2118**, and a neck **2120** at the second end **2126**, which neck **2120** is sized to fit within the barrel **726** and to contact the first hard plastic seal **2100**. The threaded male sleeve **2102** has a bore therethrough sized to permit movement of the plunger **706** without interference and is sized to a threaded female

section within the integrated barrel-stator **716** above, or adjacent, the barrel **726**. The spring **2122** contacts the shoulder **2116** of the driving disk **2106** and an end of said threaded male sleeve **2102** and is compressed as the threaded male sleeve **2102** is driven into the integrated barrel-stator **716**.

5 [0070] Referring to **FIG. 5**, in the first embodiment, the valve **710** thus has a circular stator **302**, formed integrally with the elongate barrel **726** to form integrated barrel-stator **716**, and a circular rotor **402** where the two components cooperate to permit or preclude fluid communication among various parts of the valve **710**. The stator **302** has an orifice **320** at its centerpoint, as well as a first stator port **304** for communication with a mobile phase supply, a 0 second stator port **306** in communication with a fifth stator port **312**, a third stator port **308** for communication with a sample reservoir, a fourth stator port **310** for outflow of sample waste, a sixth stator port **314** for communication with a chromatography column **504**, a seventh stator port **316** for return from the chromatography column **504**, and an eighth stator port **318** for outflow from the valve **710** such as to a detector. As both ends of the column **504** can be 5 connected to the integrated nano-scale pump and injection valve **100** to maintain pressure during filling of the integrated nano-scale pump and injection valve **100** when the flow through the column **504** is stopped, if desired. This would eliminate a delay period for column re-pressurization. The rotor **402** therefore has a surface adjacent the stator **302** and three channels, or slots, **404**, **406**, **408** in its surface. The rotor **402** is rotatable with respect to the stator **302** about 20 the centerpoint between the load position **502** and the injection position **602**. Rotation between the two positions may be 45 degrees about the centerpoint, or more or less. In the load position **502**, components are isolated while the mobile phase is delivered to the internal chamber **702** of the pump **708**, so that the first port **304** communicates with the orifice **320**, and thereby to the

internal chamber **702** of the pump **708**, via the first channel **404**, to provide filling, while all other ports are individually or paired in isolation, include the third port **308** and the fourth port **310**, while communicating via the second channel **406** not otherwise communicating with any other components. The column **504** may therefore maintained at pressure and isolated while the interior chamber **702** of the pump **708** located in the pump section **102**, as illustrated in **FIG. 7**, is filled by a mobile phase by drawing mobile phase through orifice **320**, introduced via first channel **404** which is connected to port **304**. For initial charging of the column **504**, the operator can run the mobile phase through the second channel **406**, the sample channel, switching between the load position **502** and the injection position **602** to fill the column **504** and to ensure no bubbles are present in the system. In the load position **502**, the port **318**, which may be connected to a detector, is likewise isolated. Referring to **FIGS. 3** and **4**, and more particularly to **FIG. 5**, in this load position **502**, with reference to stator **302** and rotor **402**, ports **306** and **312** are in communication to form a loop **506**, to provide an internal sample, but are otherwise isolated. This loop **506** may be of 5.08 cm × 75 or 150 µm inner diameter stainless steel tubing to carry the mobile phase to the column during injection (dispensing). A sample is introduced to and flows through the integrated nano-scale pump and injection valve **100** at port **308**, the sample inlet port, which is connected via second channel **406** to port **310**, the waste outlet port. As can be appreciated each port is associated with a connector **206** on the intersection of the pump section **102** and the valve section **104**. During the introduction of the sample, second channel **406** therefore contains the sample to be tested. Thus, in this load position **502**, a sample, which may originate from an external reservoir, may be flowed through an internal passage. In the injection position **602**, mobile phase is delivered from the pump **708** and directed through the valve **710** to the column **504** and potentially to a downstream detector by connecting the orifice

320, which is in communication with the pump **708**, and the second port **306** via the first channel **404**, by connecting the fifth port **312** and the sixth port **314** via the second channel **406**, which thereby provides a complete flow path to the chromatography column **504**, and by connecting the seventh port **316**, which is in communication with the outflow of the column **504**, with the eighth port **318** via the third channel **408** so that the sample separated by the column **504** may be processed by a detector. As can be appreciated, in a secondary embodiment, the seventh port **316**, the eighth port **318** and the third channel **408** could be omitted and the outflow from the column **504** provided directly to a detector or other equipment.

[0071] Due to the volumes involved, refilling of the integrated nano-scale pump and injection valve **100** may be accomplished in less than 2 minutes. Since typical flow rates used in capillary columns (100–150 μm i.d.) range from 100 to 500 nL/min, an isocratic separation can be easily completed without the need to refill the integrated nano-scale pump and injection valve **100**.

[0072] In the alternative embodiment, such as depicted in FIGS. **13**, **14**, **15**, and **16**, the valve **710** has a circular stator **302**, again formed integrally with the elongate barrel **726**, and a circular rotor **402** where the two components cooperate to permit or preclude fluid communication among various parts of the valve. As with the stator of the first embodiment, the stator **1302** has an orifice **1320** at its centerpoint with the pump **708** in communication with the valve **710** at the orifice **1320**, a first stator port **1304** for communication with a mobile phase supply, a second stator port **1306** in communication with a fifth stator port **1312** via a loop **1506**, a third stator port **1308** for communication with a sample reservoir, a fourth stator port **1310** for outflow, a sixth stator port **1314** for communication with a chromatography column **1504**, a seventh stator port **1316** for return from the chromatography column **1504**, and an eighth stator

port **1318** for outflow from the valve **710** such as to a detector. The rotor in the alternative embodiment includes the four channels **1404**, **1406**, **1408**, **1410** in its surface. In the alternative embodiment, the load position **1502** is defined by the first port **1304** and the orifice **1320** communicating with the first channel **1404**, by the second port **1306** and the third port **1308** 5 communicating with the second channel **1406**, and the fourth port **1310** and the fifth port **1312** communicating with the third channel **1408**. In the alternative embodiment, as illustrated in **FIG. 15**, the column **504** is attached to port **1314**, column inflow, and port **1316**, column outflow, which are otherwise isolated. The column **1504** is therefore maintained at pressure and isolated while the interior chamber **702** of the pump **708** located in the pump section **102**, as 0 illustrated in **FIG. 7**, is filled by a mobile phase by drawing mobile phase through orifice **1320**, introduced via the first channel **1404**, the fill/dispense channel, which is connected to port **1304**. In the load position **502**, the port **318**, which may be connected to a detector, is likewise isolated. Referring to **FIGS. 13** and **14**, and more particularly to **FIG. 15**, in this load position **502**, with reference to stator **1302** and rotor **1402**, ports **1306** and **1312** are in communication to form a 5 loop **1506** but are otherwise isolated. A sample is introduced to and flows through the integrated nano-scale pump and injection valve **100** at port **1308**, the sample inlet port, which is connected via second channel **1406** to port **1306** and then, via a loop **1506** to port **1312**, which is then in communication with port **1310** via third channel **1408**, the waste outlet port. As can be appreciated each port is associated with a connector **206**. During the introduction of the sample, 20 the sample to be tested is contained with the channel **1406** and the loop **506**, providing for an increased sample size. Thus, in this load position **502**, a sample, which may originate from an external reservoir, may be flowed through an internal passage. In the alternative embodiment, the injection position **1602** is defined by the orifice **1320** and the second port **1306**

communicating with the first channel **1404**, by the fifth port **1312** and the sixth port **1314** communicating with the third channel **1408**, and by the seventh port **1316** and the eighth port **1318** communicating with the fourth channel **1410**.

[0073] In the first embodiment, the second channel **406** defines the nano-scale sample size while the interior chamber **702** contains the volume from which mobile phase is pumped. In the alternative embodiment, the third channel **1408** and the loop **1506** define the nano-scale sample size.

[0074] Referring to **FIGS. 6, 8, 9, 11, and 12B**, the nano-scale operation of the pump section **102** is illustrated in the injection position **602** for the first embodiment. The injection position **602** of the nano-scale operation of the pump section **102**, showing the positions of the stator **302** and the rotor **402**, is depicted in **FIG. 6**. As illustrated in **FIG. 6**, the rotor is rotated 45 degrees, preferably by a mechanical valve actuator **202** coupled to act in concert with the action of the linear pump actuator **204**, generating a new flow path within the valve **710**. The relative position between the stator **302** and the rotor **402** may be set to provide for a greater or lesser rotation. Referring to **FIG. 6**, the first channel **404**, the fill/dispense channel, connects the internal pump **708**, via orifice **320**, to the loop **506** at port **312**. The loop **506** now connects to second channel **406** containing the sample. Ports **308** and **310** are now isolated, preventing further inflow of any sample. Similarly, port **304** is isolated, preventing further inflow of mobile phase. As second channel **406** containing the sample now connects to the inlet of the column **504** via port **314** and as channel **408** now connects the outlet of the column **504**, at port **316**, to the port **318**, the outlet to the detector, a complete flow path is established and the mobile phase pushes the sample through the column **504** and to any connected detector. This is accomplished by the pump plunger **706** being driven toward the valve **710** as illustrated in **FIGS. 8, 10** and

12B, displacing fluid from the interior chamber **702** into the valve **710**. Thus, the pump **708** delivers fluid through the sample passage of second channel **406** into the column **504**. When the drive shaft **730** of the valve **710** is rotated by a valve actuator **202**, the pump **708** is started, which results in the pump **708** starting the moment the endpoint is reached and thus avoids the column bed becoming unstable. As can be appreciated, upon completion of the analysis, the integrated nano-scale pump and injection valve **100** is returned to the load position **502**, the filling position.

[0075] Referring to **FIGS. 8, 9, 11, 12B**, and **16**, the nano-scale operation of the pump section **102** is illustrated in the injection position **1602** for the second embodiment. The injection position **1602** of the nano-scale operation of the pump section **102**, showing the positions of the stator **1302** and the rotor **1402**, is depicted in **FIG. 16**. As illustrated in **FIG. 16**, the rotor is rotated 45 degrees, preferably by a mechanical valve actuator **202** coupled to act in concert with the action of the linear pump actuator **204**, generating a new flow path within the valve **710**. The relative position between the stator **1302** and the rotor **1402** may be set to provide for a greater or lesser rotation. Referring to **FIG. 16**, first channel **1404**, the fill/dispense channel, connects the internal pump **708**, via orifice **1320**, to the loop **1506** at port **1312**. The loop **1506**, containing some sample, connected to third channel **1408** also containing some sample, now connects to the inlet of the column **1504** via port **1314** and as third channel **1408** now connects the outlet of the column **1504**, at port **1316**, to the port **1318**, the outlet to the detector, a complete flow path is established and the mobile phase pushes the sample through the column **1504** and to any connected detector. This is accomplished by the pump plunger **706** being driven toward the valve **710** as illustrated in **FIGS. 8, 10** and **12B**, displacing fluid from the interior chamber **702** into the valve **710**. Thus, the pump **708** delivers fluid into the column

504. Ports **1308** and **1310** are isolated, preventing further inflow of any sample. Similarly, port **1304** is isolated, preventing further inflow of mobile phase. When the drive shaft **730** of the valve **710** is rotated by a valve actuator **202**, the pump **708** is started, which results in the pump **708** starting the moment the endpoint is reached and thus avoids the column bed becoming 5 unstable. As can be appreciated, upon completion of the analysis, the integrated nano-scale pump and injection valve **100** is returned to the load position **502**, the filling position.

[0076] Referring to **FIGS. 17** and **18**, the present disclosure may alternatively be used as a pump without regard to the equipment connected thereto. In the further alternative embodiment, the rotor **1702** has a channel **1704** and the stator **1712** has a first stator port **1706** 0 for communication with a mobile phase supply, an orifice **1714** in communication with the elongate barrel **726** and a second stator port **1708** for communication with an external device. In the further alternative embodiment, the load position **1710**, as illustrated in **FIG. 17**, is defined by the first port **1706** and the orifice **1714** communicating with the channel **1704** and the injection position **1802** is defined by the orifice **1714** and the second port **1708** communicating 5 with the channel **1704**. As can be appreciated, any number of additional ports may be positioned on the stator **1712** to permit the pump to draw fluid through the first port **1706** to be pumped to any one of a plurality of ports, providing a multiple position valve.

[0077] Referring to **FIGS. 19** and **20**, the present disclosure may be used to push a sample through a column, wherein the output of the column is provided to other equipment 20 rather than through the valve. In the additional alternative embodiment, the rotor **1902** has a first channel **1904**, a second channel **1906**, and a third channel **1926**, and the stator **1932** has the orifice **1924** in communication with the elongate barrel **726**, a first stator port **1908** for communication with a mobile phase supply, a second stator port **1910** in communication with a

fifth stator port **1912** via an external loop **1914**, a third stator port **1916** for communication with a sample reservoir, a fourth stator port **1918** for sample outflow, and a sixth stator port **1920** for communication with a chromatography column **1922**. In the additional alternative embodiment, the load position **1928** is defined by the first port **1908** and the orifice **1924** communicating with a first channel **1904**, by the second port **1910** and the third port **1916** communicating with the second channel **1906**, and the fourth port **1918** and the fifth port **1912** communicating with the third channel **1926**. In the alternative embodiment, the injection position **2002** is defined by the orifice **1924** and the second port **1910** communicating with the first channel **1904**, and by the fifth port **1912** and the sixth port **1920** communicating with the third channel **1926**, which is connected to a column **1922** connected to the sixth port **1920**.

[0078] Referring to **FIGS. 22** and **23**, the present disclosure may be used to push an internal sample through a column, wherein the output of the column is provided to other equipment rather than through the valve, incorporating the structure and flow paths of the first embodiment depicted in **FIGS. 3-6** except for the third channel **408**, and the seventh port **316** and the eighth port **318**, which are omitted. **FIG. 22** is an illustration of the relative positions of the face of the stator and the face of the rotor of the additional alternative embodiment of the present invention in the load position. **FIG. 23** is an illustration of the relative positions of the face of the rotor and the face of the rotor of the additional alternative embodiment of the present invention in the injection position. Referring to **FIG. 22**, the valve **710** has a circular stator **2202**, formed integrally with the elongate barrel **726** to form integrated barrel-stator **716**, and a circular rotor **2250** where the two components cooperate to permit or preclude fluid communication among various parts of the valve **710**. The stator **2202** has an orifice **2220** at its centerpoint, as well as a first stator port **2204** for communication with a mobile phase supply, a

second stator port **2206** in communication with a fifth stator port **2212** via a loop **2260**, a third stator port **2208** for communication with a sample reservoir, a fourth stator port **2210** for outflow of sample waste, and a sixth stator port **2214** for communication with a chromatography column **2280**. The rotor **2250** therefore has a surface adjacent the stator **2202** and two channels, or slots, 5 **2254**, **2256** in its surface. The rotor **2250** is rotatable with respect to the stator **2202** about the centerpoint between the load position **2222** and the injection position **2232**. The injection position **2232** of the nano-scale operation of the pump section **102**, showing the positions of the stator **2202** and the rotor **2250**, is depicted in **FIG. 23**. The first channel **2254**, the fill/dispense channel, connects the internal pump **708**, via orifice **2220**, to the loop **2260** at port **2212**. The 0 loop **2260** now connects to second channel **2256** containing the sample. Ports **2208** and **2210** are now isolated, preventing further inflow of any sample. Similarly, port **2204** is isolated, preventing further inflow of mobile phase. As second channel **2256** containing the sample now connects to the inlet of the column **2280** via port **2214**, providing a complete flow path so the mobile phase pushes the sample through the column **2280** and to any connected detector.

5 [0079] The stroke of the pump section **102**, as illustrated in general in **FIGS. 7** and **8**, is particularly illustrated in **FIGS. 12A** and **12B**, wherein the stroke **1202** of the pump section **102** is illustrated between the maximum load position **502**, **1502**, **1710**, **1928** and the maximum injection position **602**, **1602**, **1802**, **2002**. The stroke **1202** may be 0.25 inches, or slightly smaller, or 0.75 inches, or slightly larger, or may be between, such as at 0.50 inches. As can be 20 appreciated, the stroke **1202** and the diameter of the barrel **726** determine the volume of fluid transmitted during each load and injection cycle, which, by virtue of their values, are measured in microliters. Operation of the invention and the associated low flow rates are made possible by

use of the integration of the pump section **102** and the valve section **104**, unlike conventional products.

[0080] Referring to FIGS. **7, 8, 9, 10, 11, 12A** and **12B**, operation of the integrated nano-scale pump and injection valve **100** is provided by the body **724**, the linear pump actuator **204**, and the integrated barrel-stator **716**. The linear pump actuator **204** includes a plunger-driving piston **712** connected to the plunger **706**. A plunger **706**, at least equal in length to the stroke **1202** and nearly-equivalent to the diameter of the interior chamber **702**, is attached to the end of the plunger-driving piston **712**. In the load position **502, 1502, 1710, 1928**, the plunger **706** is at its maximum retraction within the elongate barrel **726** and defines the maximum volume which may be moved during the stroke **1202**. In the injection position **602, 1602, 1802, 2002**, the plunger **706** is at its maximum displacement into the elongate barrel **726**. The volume displaced during the stroke **1202** between the maximum position associated with the loading **502, 1502, 1710, 1928** and the maximum position associated with the injection **602, 1602, 1802, 2002** is equal to the volume of the plunger **706** introduced into the elongate barrel **726**. The position of the plunger **706** in the barrel **726** and its extent during the stroke be determined with mechanical systems such as optical encoders, or others known in the art, and the maximum extent may be defined and operation limited by mechanical stops or limit switches.

[0081] Thus, the integral nano-scale pump and injection valve **100** includes a body having a pump section **102** and a valve section **104** where the body has a pump **708** in the pump section **102** and a valve **710** in the valve section **104**. The pump **708** functions linearly by using an elongate barrel **726** and a plunger **706**. As the barrel provides an internal chamber in which the plunger **706** moves, drawing or ejecting fluid from one end while the plunger **706** is moved from the opposing end, the elongate barrel **726** is characterized by an open proximal end, an

open distal end, a length, and a sidewall, which define the interior chamber **702**. As detailed, the internal chamber **702** is adapted to receive a supply of mobile phase, and provides operation in connection with the plunger **706** by having an inner diameter sized to the plunger, an outer diameter sized to fit within the pump section and a wall thickness therebetween to provide sufficient strength. The plunger **706**, which has a substantially uniform cross-section, is slidably disposed within the interior chamber **702** and is sized to ensure effective operation during the load position **502, 1502, 1710, 1928** and the injection position **602, 1602, 1802, 2002**.

[0082] The present invention provides an integral nano-scale pump and injection valve **100** for high performance liquid chromatography which includes an integrated barrel-stator **716**, which has an elongate barrel **726** at a first end and a stator **302, 1302, 1712, 1932** at a second end, a plunger **706** slidably disposed within an interior chamber **702** of the barrel **726** of substantially uniform cross-section, and a rotor **402**, wherein the pump **708** and valve **710** are switchable between a load position **502, 1502, 1710, 1928** and a injection position **602, 1602, 1802, 2002**. The circular rotor **402** has a surface adjacent the stator **302** and has a plurality of channels **404, 406, 408, 1404, 1406, 1408, 1410** in its surface and is rotatable with respect to the stator **302, 1302** about a centerpoint between the load position **502, 1502, 1710, 1928** and the injection position **602, 1602, 1802, 2002**. The elongate barrel **726** portion of the integrated barrel-stator **716** includes an open proximal end, an open distal end, a length, and a sidewall defining the interior chamber **702** adapted to receive a supply of fluid and which has an inner diameter, an outer diameter, and a wall thickness. The circular stator **302** has an orifice **320** at its centerpoint and a first side and a second side such that the elongate barrel open distal end is aligned with the second side of the stator **302** at the centerpoint and the interior chamber **702**

includes the orifice **320**. The pump **708** is therefore in communication with the valve **710** at the orifice **320**.

[0083] The nano-scale operation of the integrated nano-scale pump and injection valve **100** is made possible by integration of parts may be further augmented by sufficient and operable 360 zero-dead volume micrometer fittings, and by material selection. Diamond-coated surfaces may be utilized where beneficial. The plunger **706** may be constructed of a work hardened super alloy, such as MP35N, a nickel-chromium-molybdenum-cobalt alloy providing ultra-high strength, toughness, ductility and high corrosion resistance – particularly from contact with hydrogen sulfide, chlorine solutions and mineral acids (nitric, hydrochloric, and sulfuric).

0 Moreover, the nano-scale operation of the integrated nano-scale pump and injection valve **100** permits portability, such as being battery-operated, while being light weight, having low mobile phase consumption and generating low waste. Additionally, this system, designed particularly for capillary column use, does not employ a splitter, provides a substantial in operation. The integrated nano-scale pump and injection valve **100** can generate up to 110.32 MPa (16,000 psi) 5 pressure, with a pump volume capacity of 24 μ L, and a sample volume as low as 10 nL, or higher, such as 60 nL, can be injected. As a result of the structures provided herein, the maximum and minimum dispensing volumetric flow rates of the integrated nano-scale pump and injection valve **100** are 74.2 μ L/min and 60 nL/min, respectively. This may further be accomplished by providing the loop 506 of 5.08 cm \times 75 or 150 μ m inner diameter stainless steel 10 tubing to carry the mobile phase to the column during injection (dispensing).

[0084] The terms and expressions which have been employed in the foregoing specification are used therein as terms of description and not of limitation, and there is no

intention, in the use of such terms and expressions, of excluding equivalents of the features shown and described or portions thereof.

CLAIMS

Claims:

1. An integral nano-scale pump and injection valve for high performance liquid chromatography comprising:

5 an integrated barrel-stator, said integrated barrel-stator having an elongate barrel and a stator, said integrated barrel-stator integrally-formed of a single piece of monolithic material,

said elongate barrel having a first open end at a first end of said integrated barrel-stator and a second open end at a second end of said integrated barrel-stator and a sidewall defining an interior chamber adapted to receive a supply of fluid, said stator being circular, said stator having a first side, said elongate barrel second end terminating at a centerpoint of said stator at said stator first side and providing an orifice, said stator first side being coplanar with said second end of said integrated barrel-stator, said stator having a first stator port for

5 communication with a mobile phase supply, said stator in communication with a rotor at said orifice, said stator at said second end of said integrated barrel-stator,

a longitudinal plunger slidably extending into said interior chamber at said first end of said integrated barrel-stator, said plunger being of substantially uniform cross-section; and

20 said rotor being circular, said rotor having a surface adjacent said stator, said rotor having a first channel in said surface, said rotor rotatable with respect to said stator about said centerpoint of said stator between a load position and an injection position,

said load position defined by said first stator port and said orifice communicating with said first channel, and

 said injection position defined by said orifice and a second stator port communicating with said first channel.

5 2. The integral nano-scale pump and injection valve of claim 1 further comprising:

 a first hard plastic seal about the plunger sized to fit within said barrel and to fit about said plunger;

 a flexible seal about the plunger sized to fit within said barrel and to fit about said plunger adjacent the first hard plastic seal;

0 a second hard plastic seal about the plunger sized to fit within said barrel and to fit about said plunger adjacent the flexible seal;

 a driving disk having a bore therethrough sized to fit about said plunger without interference, said driving disk having a driving disk first end and a driving disk second end, said driving disk sized to freely fit within said integrated barrel-stator adjacent said barrel, said driving disk having a shoulder near said driving disk first end and a neck at said driving disk second end, said neck sized to fit within said barrel and to contact said first hard plastic seal,

5 a threaded male sleeve having a bore therethrough sized to permit movement of said plunger without interference, said threaded male sleeve sized to a threaded female section within said integrated barrel-stator adjacent said barrel; and

 a spring contacting said shoulder of said driving disk and an end of said threaded male sleeve.

3. The integral nano-scale pump and injection valve of claim 1 or claim 2, further comprising a pump actuator associated with a plunger-driving piston attached to said plunger.
4. The integral nano-scale pump and injection valve of claim 3, further comprising a valve actuator associated with a driveshaft attached to said rotor.
5. 5. The integral nano-scale pump and injection valve of claim 2 further comprising:
 - 0 said stator having the second stator port in communication with a fifth stator port, a third stator port for communication with a sample reservoir, a fourth stator port for outflow, a sixth stator port for communication with a chromatography column, a seventh stator port for return from said chromatography column, and an eighth stator port for outflow from said valve,
 - 0 said rotor having a second channel in said surface, and a third channel in said surface, said load position further defined by said third stator port and said fourth stator port communicating with said second channel; and
 - 5 said injection position further defined by said fifth stator port and said sixth stator port communicating with said second channel, and by said seventh stator port and said eighth stator port communicating with said third channel.
6. The integral nano-scale pump and injection valve of claim 5, further comprising a pump actuator associated with a plunger-driving piston attached to said plunger.
7. The integral nano-scale pump and injection valve of claim 5 or claim 6, further comprising a valve actuator associated with a driveshaft attached to said rotor.
- 20 8. The integral nano-scale pump and injection valve of claim 2 further comprising:
 - 0 said stator having the second stator port in communication with a fifth stator port via loop, a third stator port for communication with a sample reservoir, a fourth stator port

for outflow, a sixth stator port for communication with a chromatography column, a seventh stator port for return from said chromatography column, and an eighth stator port for outflow from said valve,

5 said rotor having a second channel in said surface, a third channel in said surface, and a fourth channel in said surface;

said load position further defined by said second stator port and said third stator port communicating with said second channel, and said fourth stator port and said fifth stator port communicating with said third channel; and

0 said injection position further defined by said fifth stator port and said sixth stator port communicating with said third channel, and by said seventh stator port and said eighth stator port communicating with said fourth channel.

9. The integral nano-scale pump and injection valve of claim 8, further comprising a pump actuator associated with a plunger-driving piston attached to said plunger.

10. The integral nano-scale pump and injection valve of claim 8 or claim 9, further 5 comprising a valve actuator associated with a driveshaft attached to said rotor.

11. The integral nano-scale pump and injection valve of claim 2 further comprising:
said stator having the second stator port in communication with a fifth stator port via loop, a third stator port for communication with a sample reservoir, a fourth stator port for outflow, a sixth stator port for communication with a chromatography column, said 20 rotor having a second channel in said surface, and a third channel in said surface, said rotor rotatable with respect to said stator about said centerpoint of said stator between a load position and an injection position,

5 said load position further defined by said second stator port and said third stator port communicating with said second channel, and said fourth stator port and said fifth stator port communicating with said third channel; and
said injection position further defined by said fifth stator port and said sixth stator port
5 communicating with said third channel.

12. The integral nano-scale pump and injection valve of claim 11, further comprising a pump actuator associated with a plunger-driving piston attached to said plunger.

13. The integral nano-scale pump and injection valve of claim 11 or claim 12, further comprising a valve actuator associated with said rotor.

0 14. An integral nano-scale pump and injection valve for high performance liquid chromatography comprising:

an integrated barrel-stator, said integrated barrel-stator having an elongate barrel and a stator, said integrated barrel-stator integrally-formed of a single piece of monolithic material,

5 said elongate barrel having a first open end at a first end of said integrated barrel-stator and a second open end at a second end of said integrated barrel-stator and a sidewall defining an interior chamber adapted to receive a supply of fluid, said stator being circular, said stator having a first side, said elongate barrel second end terminating at a centerpoint of said stator at said stator first side at an orifice, said stator first side being coplanar with said second end of said integrated barrel-stator, said stator at said second end of said integrated barrel-stator, said elongate barrel in communication with a rotor at said orifice, said stator 20 having a first stator port for communication with a mobile phase supply,

a longitudinal plunger slidably extending into said interior chamber at said first end of said integrated barrel-stator, said plunger being of substantially uniform cross-section; and

5 said rotor being circular, said rotor having a surface adjacent said stator, said rotor having a first channel in said surface, said rotor rotatable with respect to said stator about said centerpoint of said stator between a load position and an injection position,

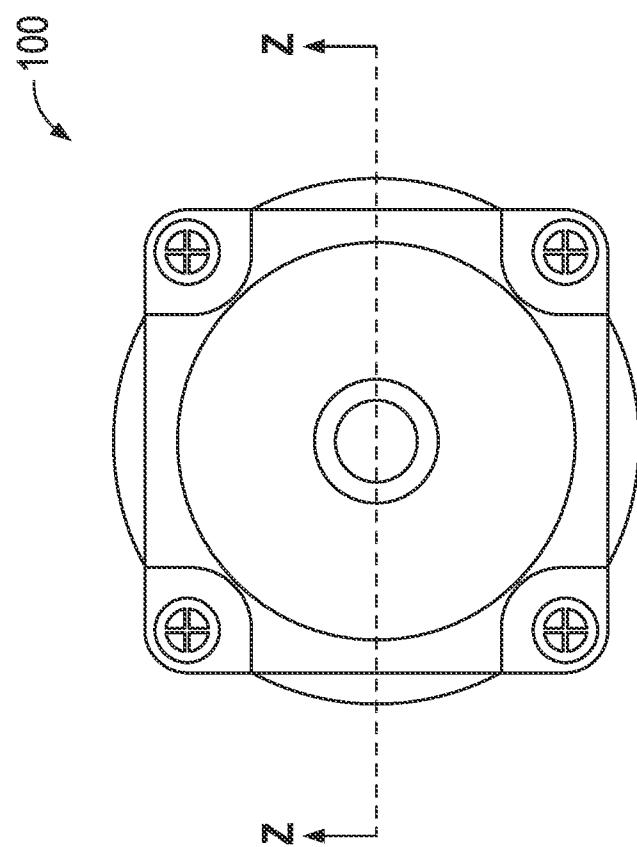
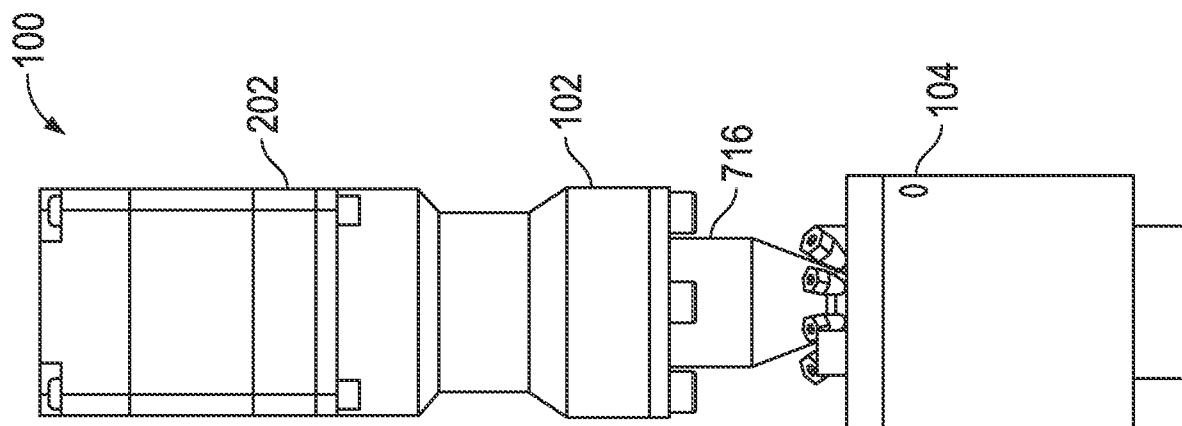
0 said load position defined by said first stator port and said orifice communicating with said first channel, and

0 said injection position defined by said orifice and a second stator port communicating with said first channel.

15. The integral nano-scale pump and injection valve of claim 2 further comprising:
said stator having the second stator port in communication with a fifth stator port, a third stator port for communication with a sample reservoir, a fourth stator port for outflow, and a sixth stator port for communication with a chromatography column;
5 said rotor having a second channel in said surface;
said load position further defined by said third stator port and said fourth stator port communicating with said second channel; and
said injection position further defined by said fifth stator port and said sixth stator port communicating with said second channel.

20 16. The integral nano-scale pump and injection valve of claim 15, further comprising a pump actuator associated with a plunger-driving piston attached to said plunger.
17. The integral nano-scale pump and injection valve of claim 15 or claim 16, further comprising a valve actuator associated with a driveshaft attached to said rotor.

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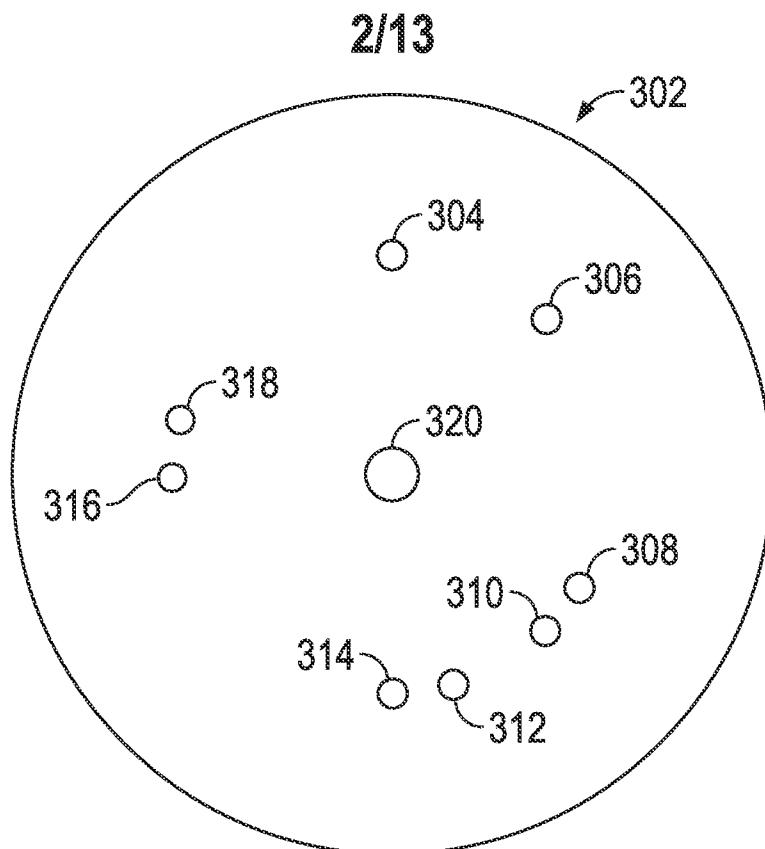


FIG. 3

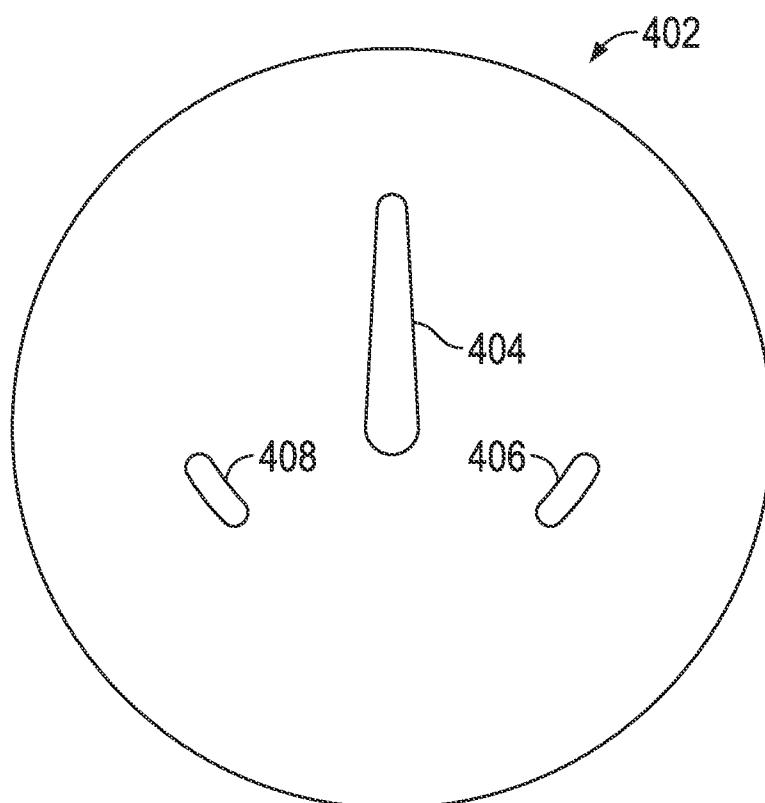


FIG. 4

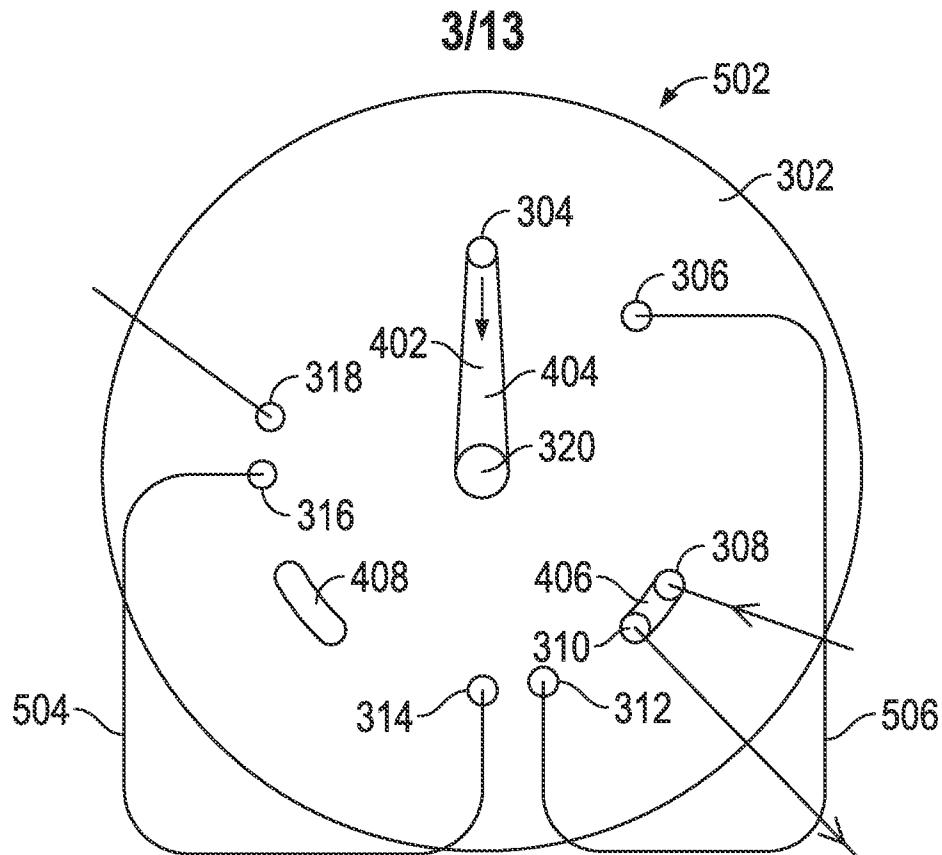


FIG. 5

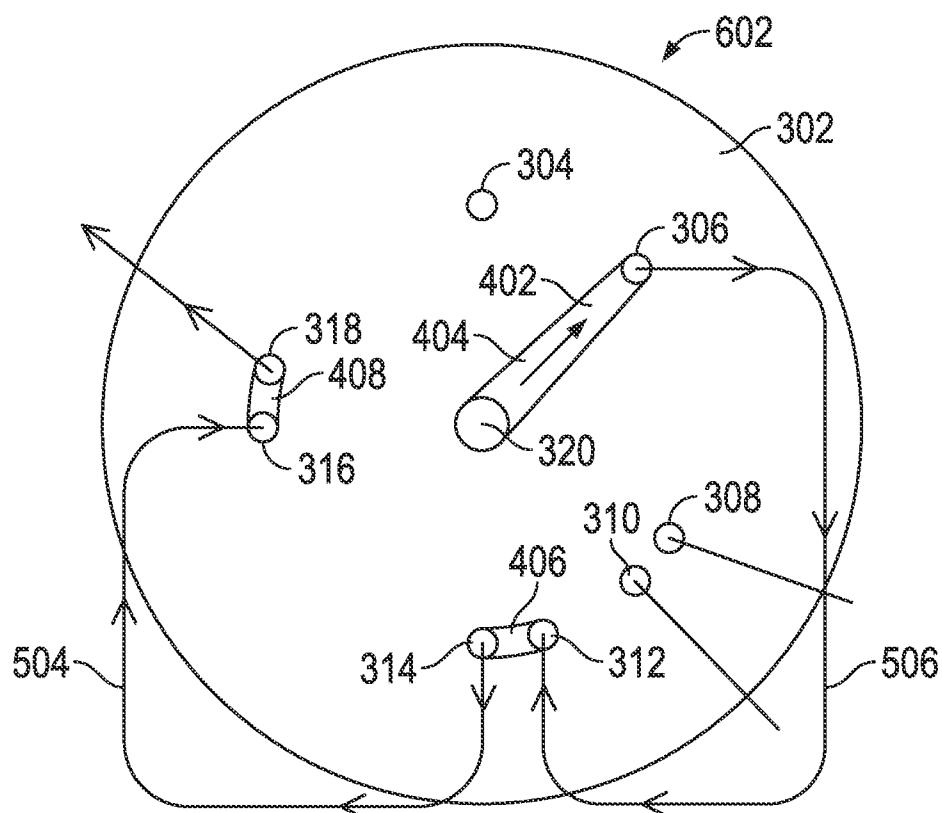


FIG. 6

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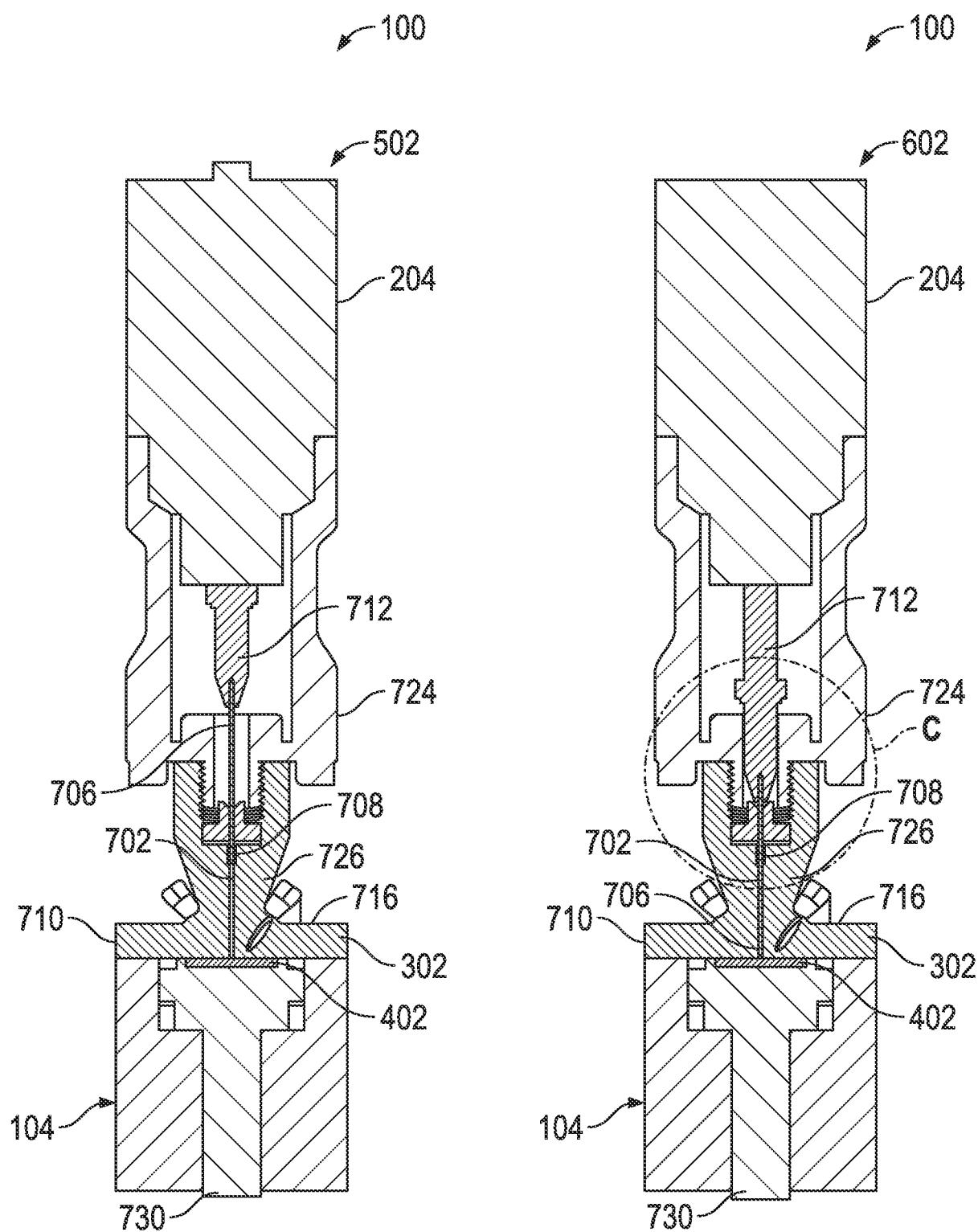


FIG. 7

FIG. 8

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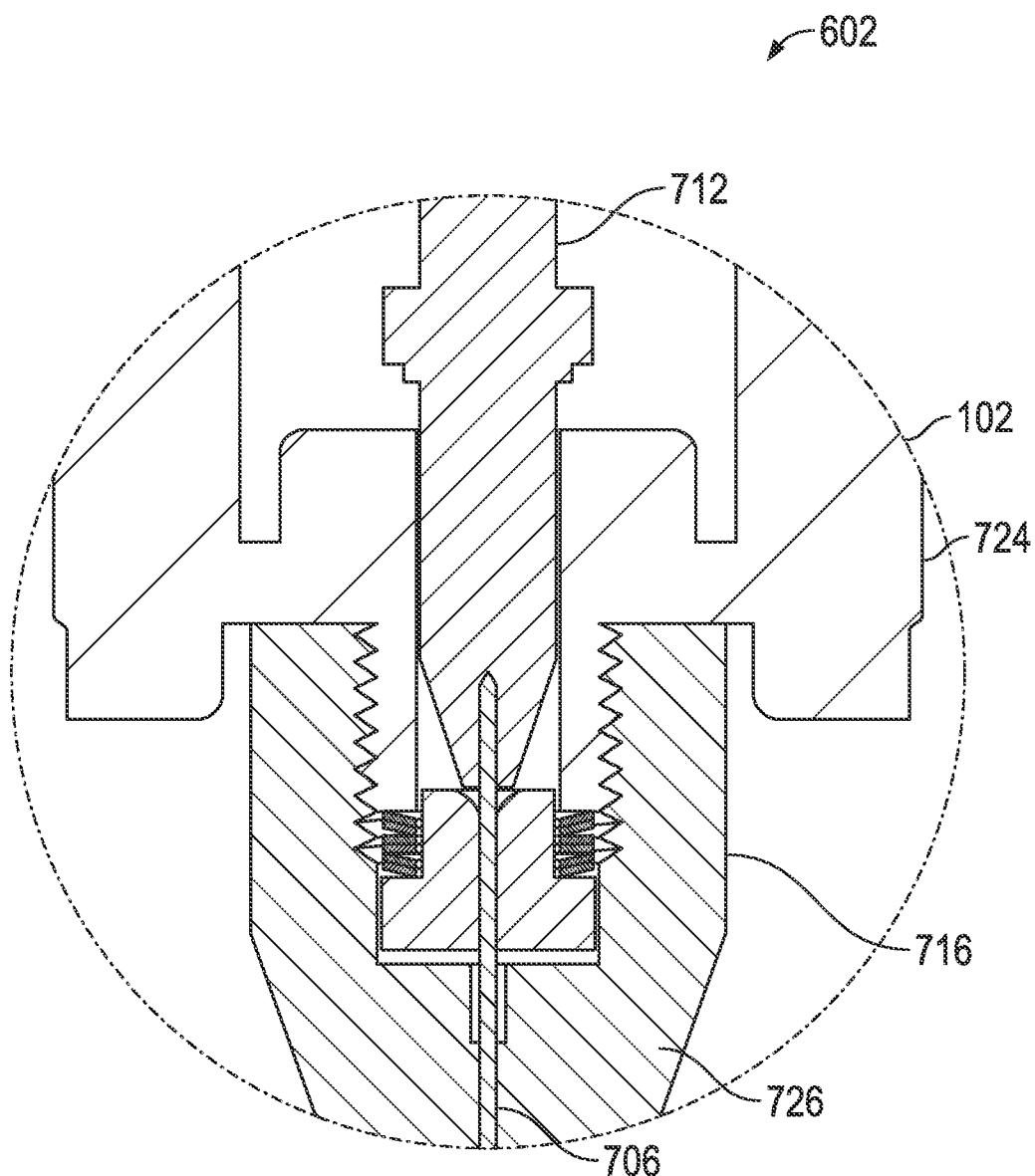


FIG. 9

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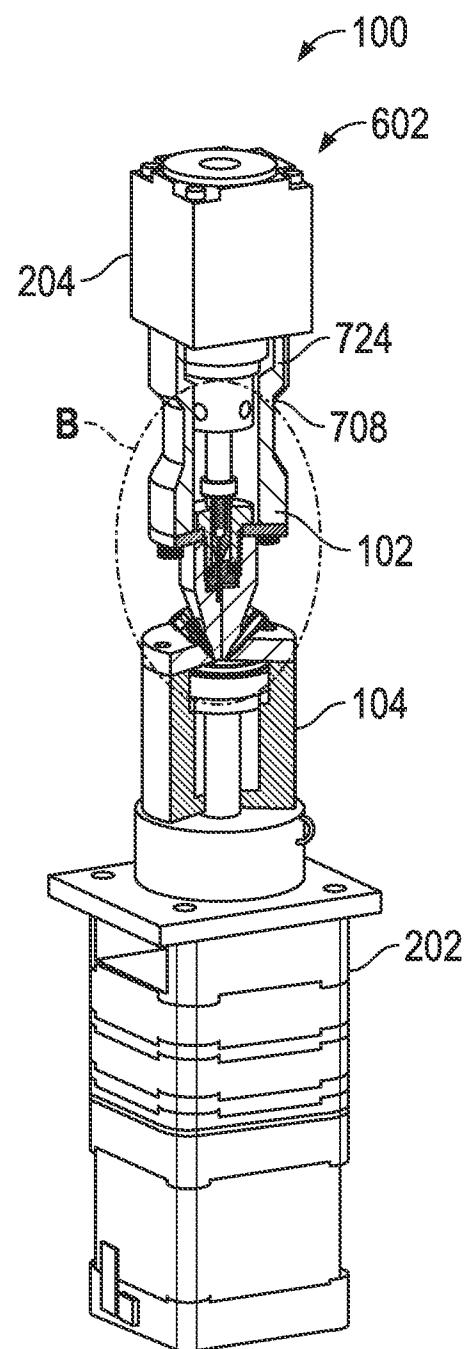
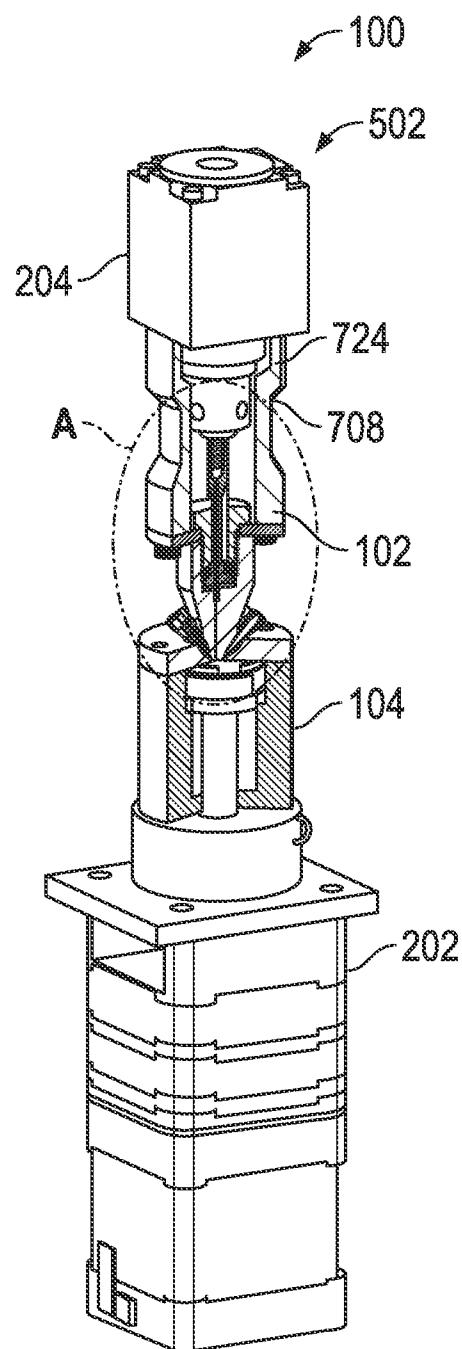
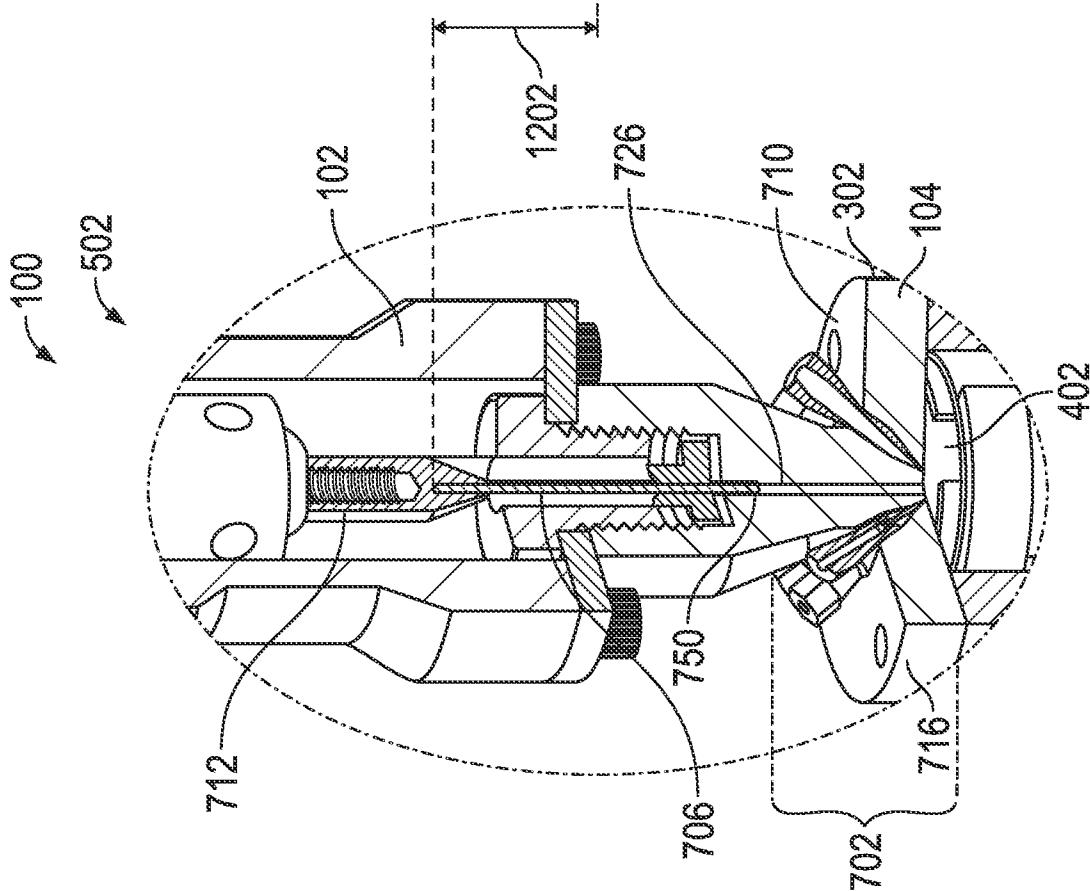
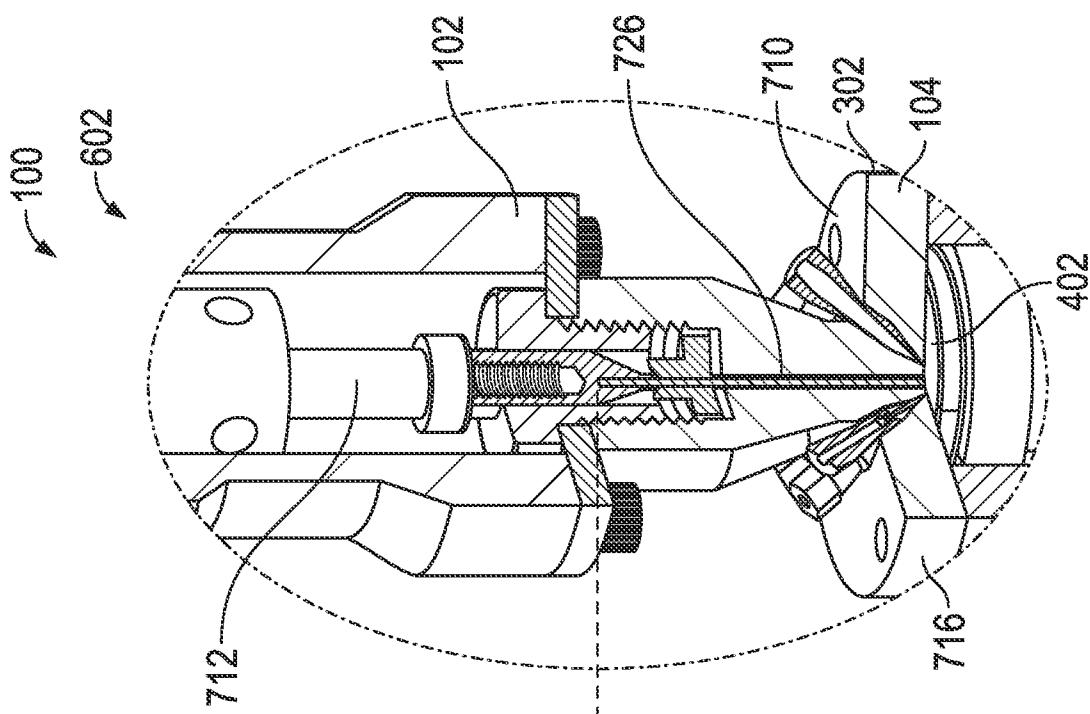


FIG. 10

FIG. 11

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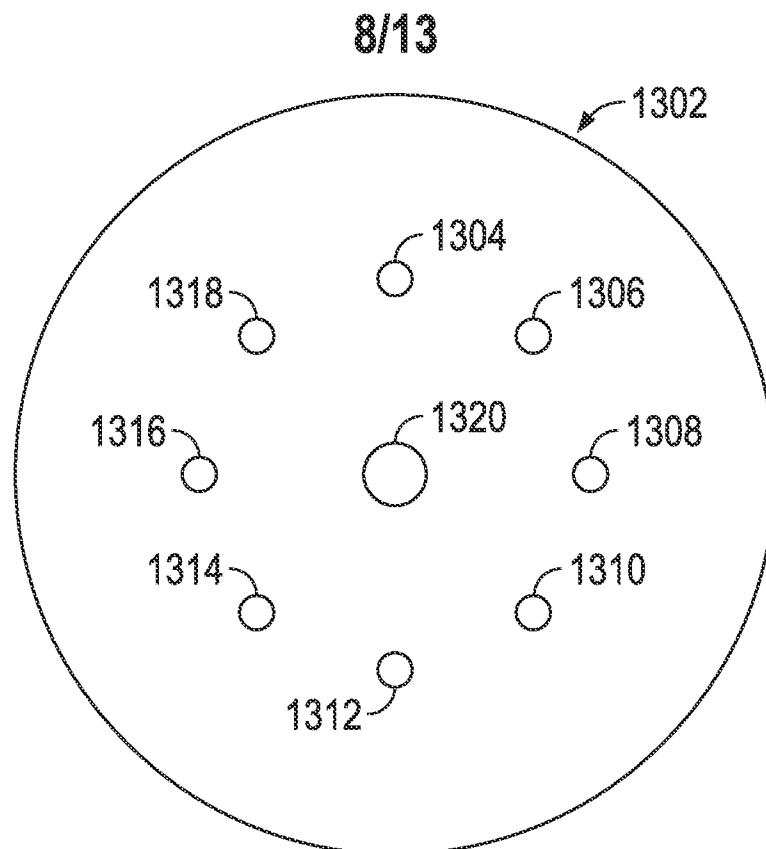


FIG. 13

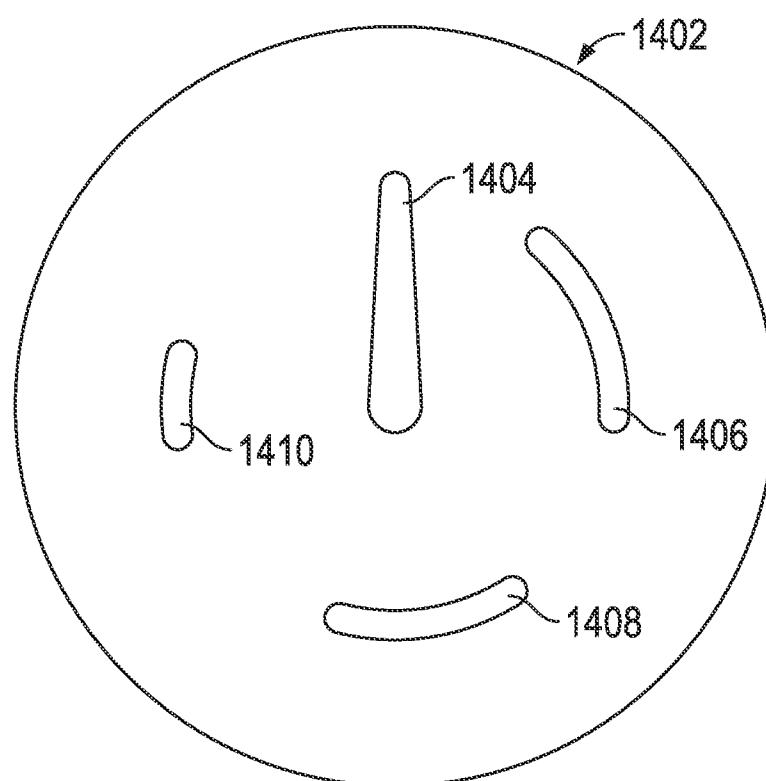


FIG. 14

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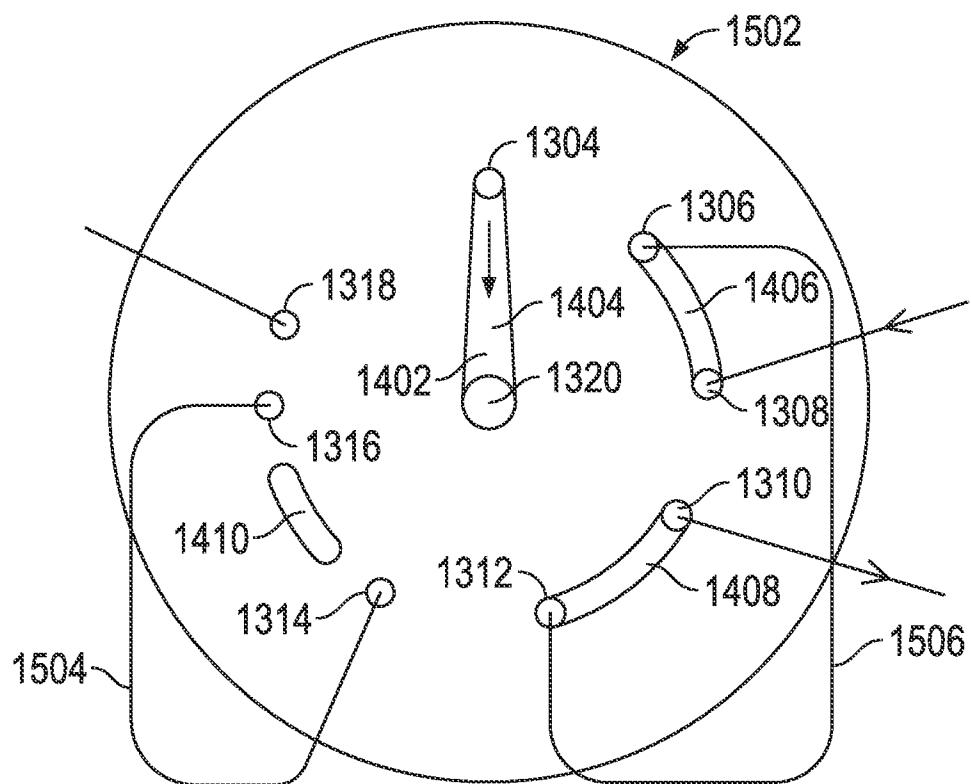


FIG. 15

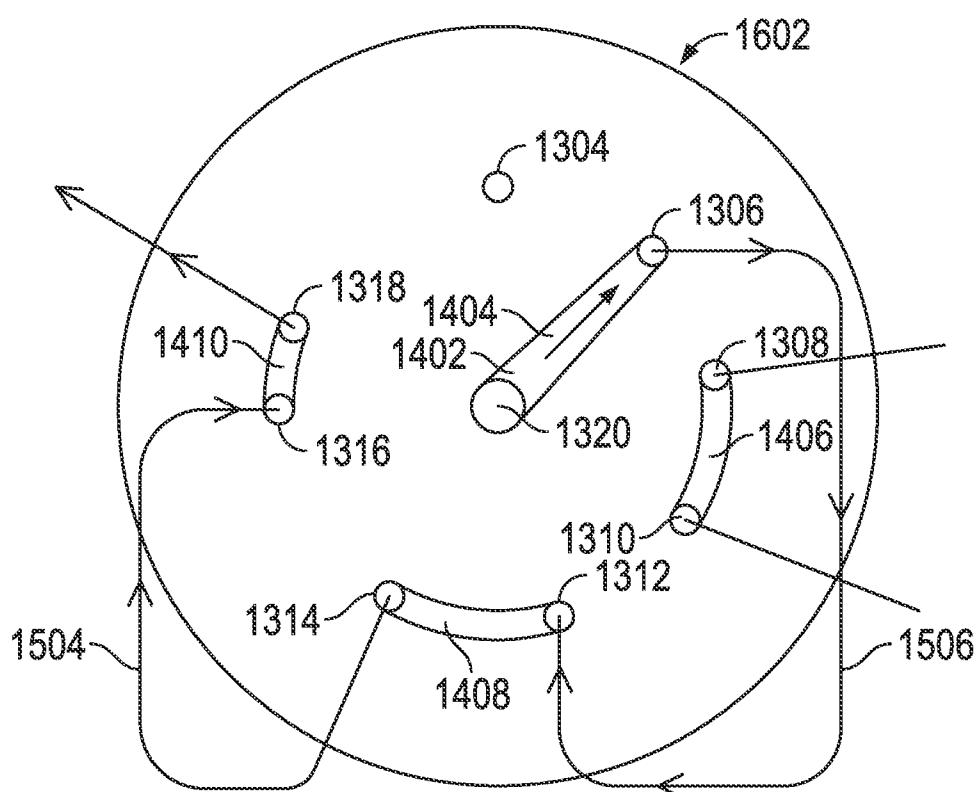


FIG. 16

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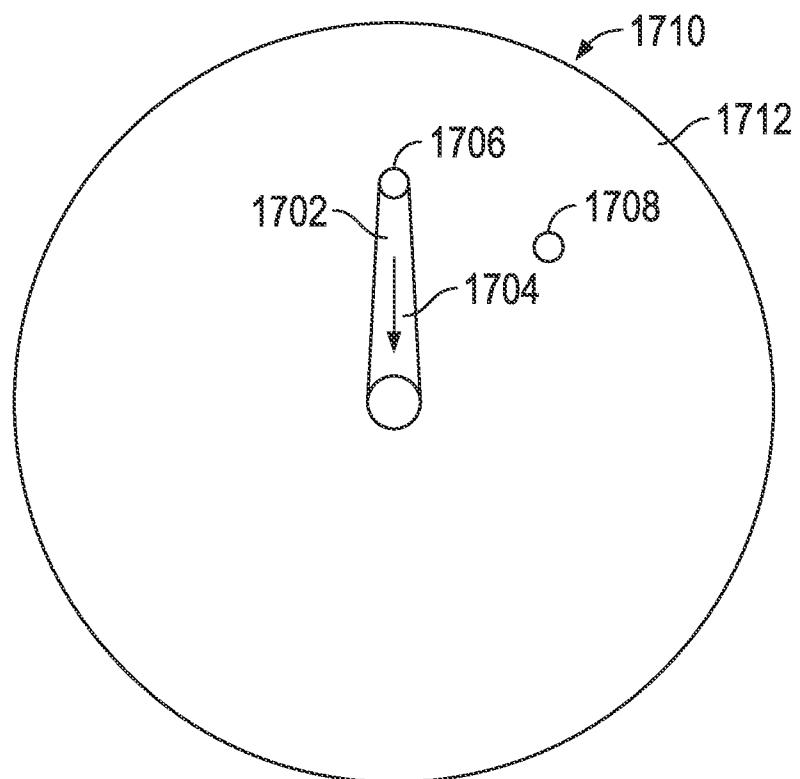


FIG. 17

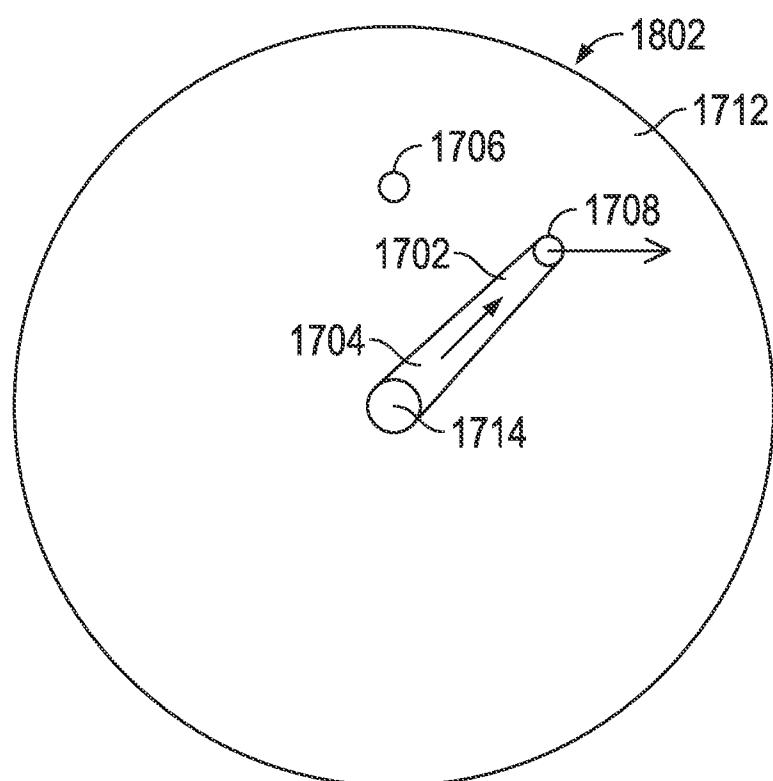


FIG. 18

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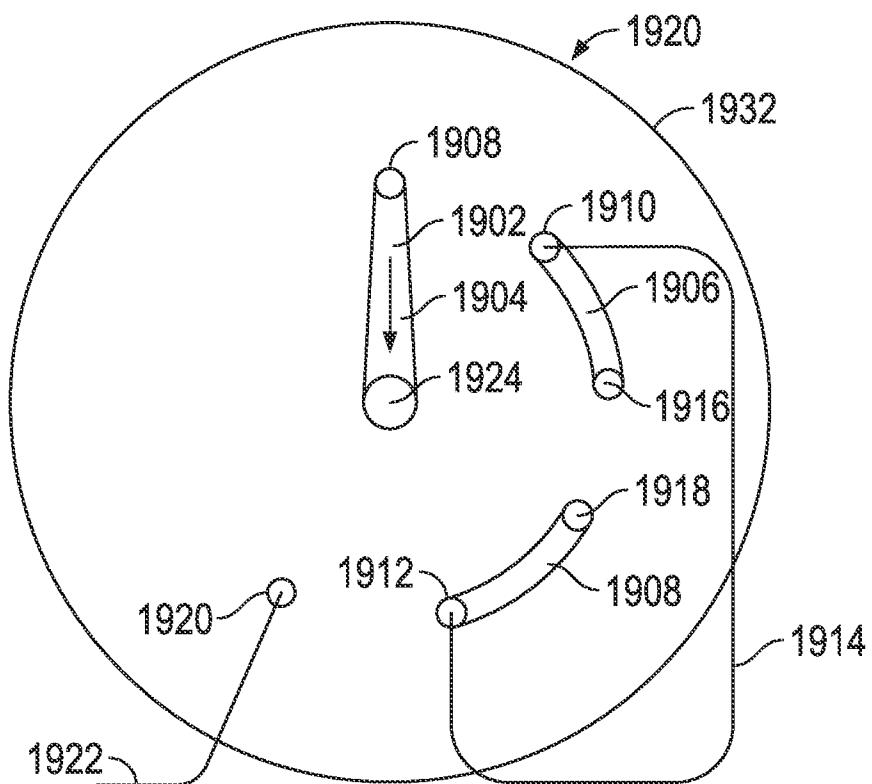


FIG. 19

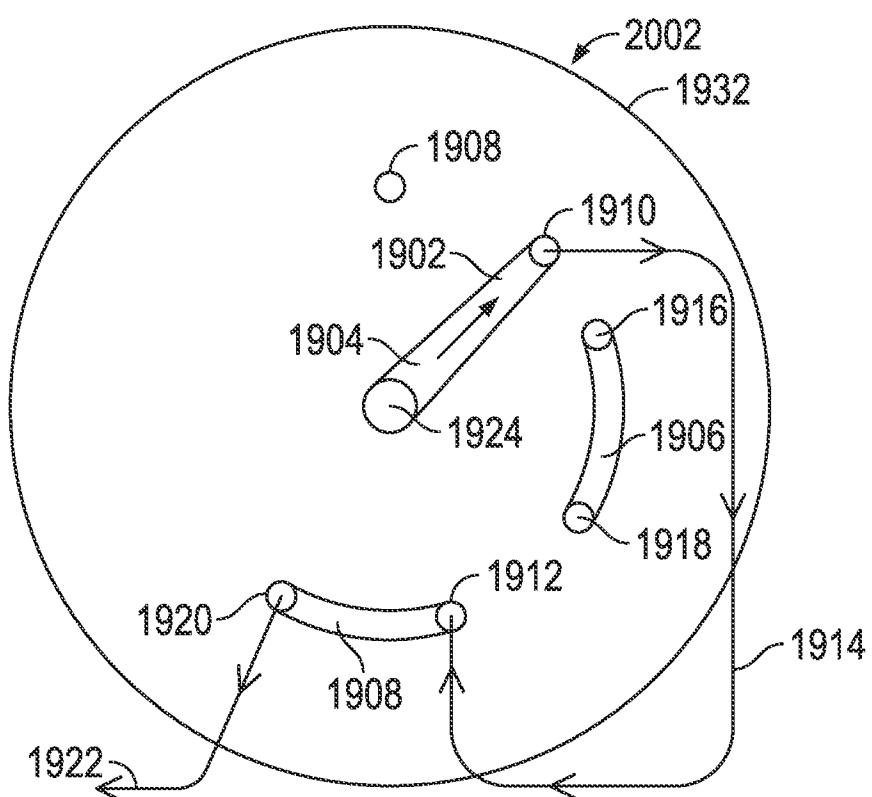


FIG. 20

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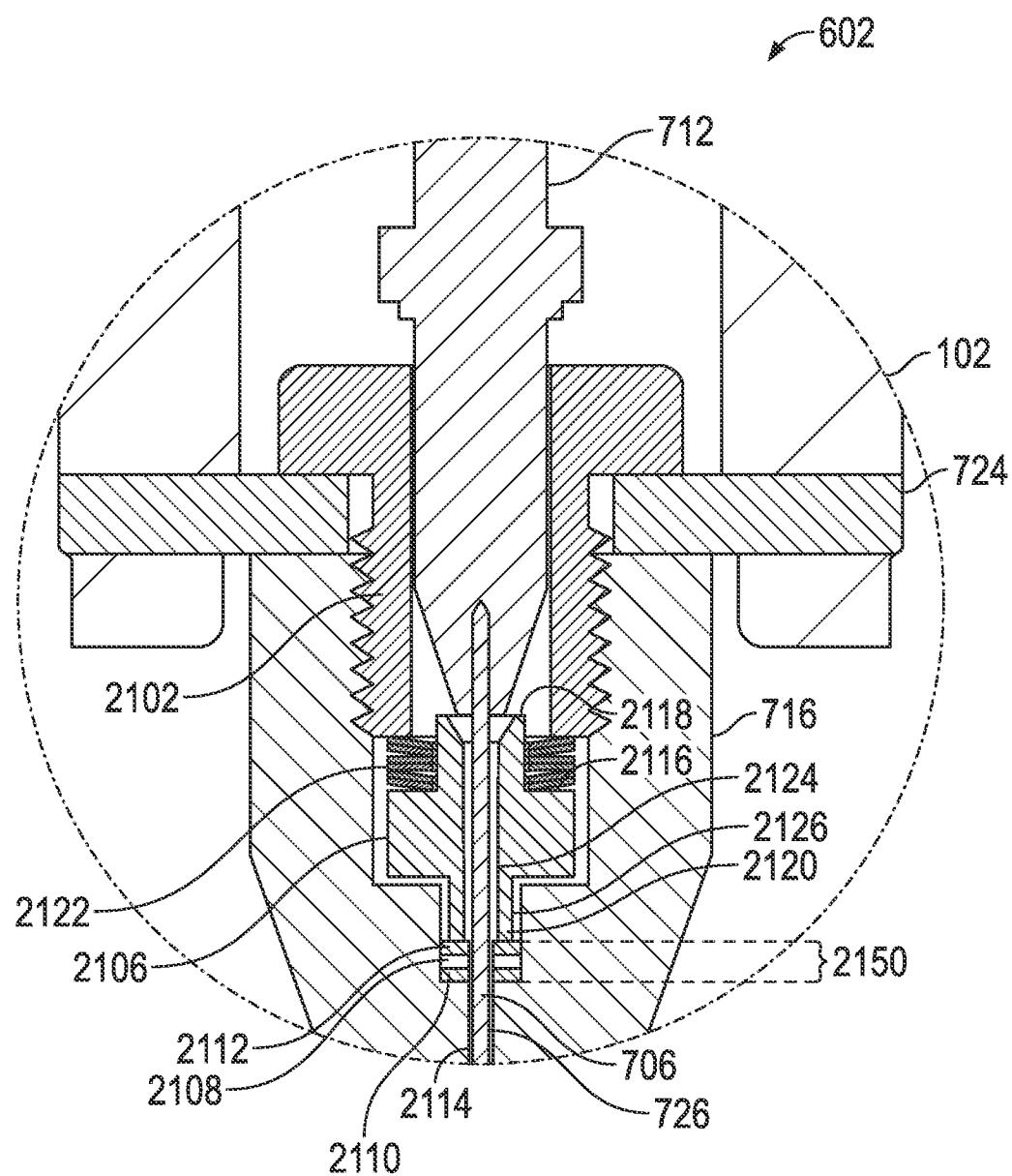


FIG. 21

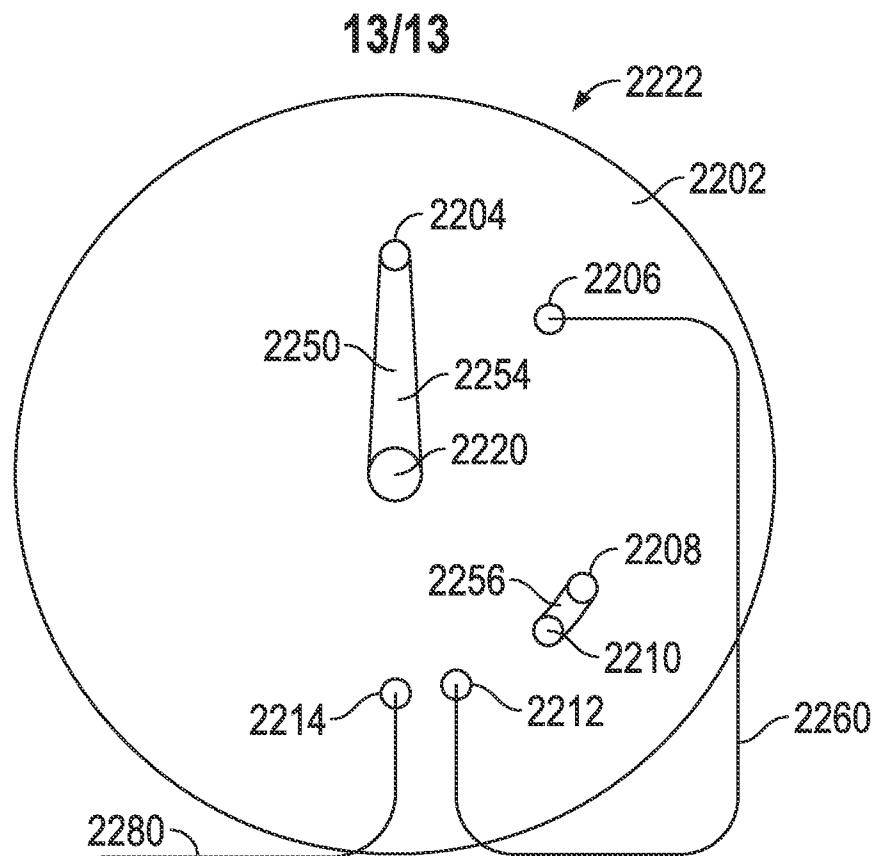


FIG. 22

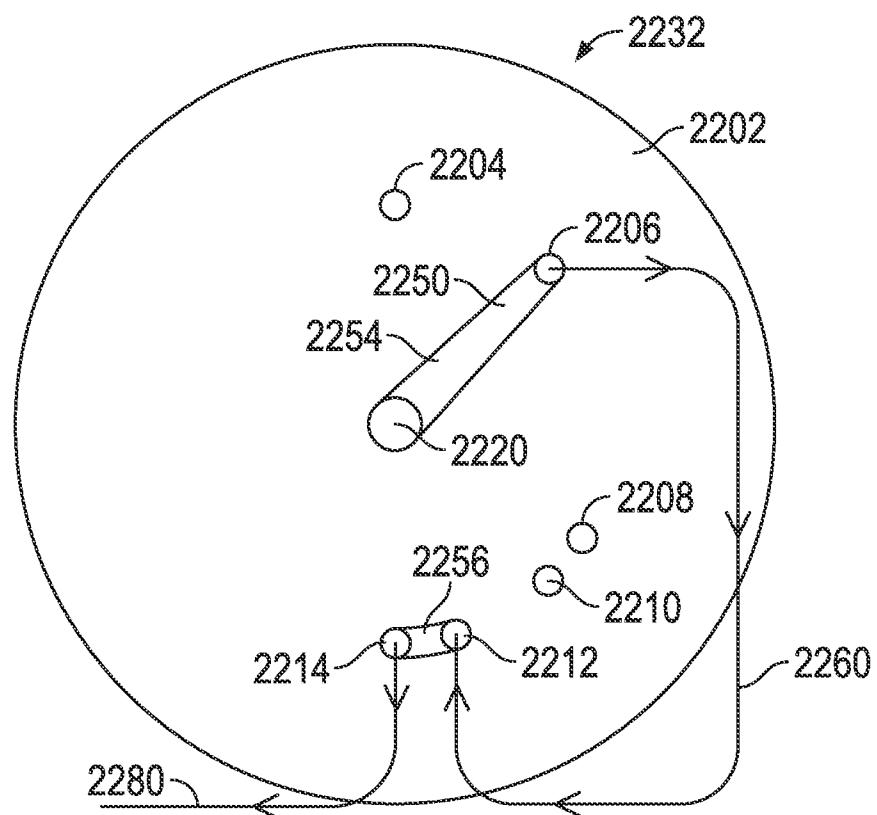


FIG. 23