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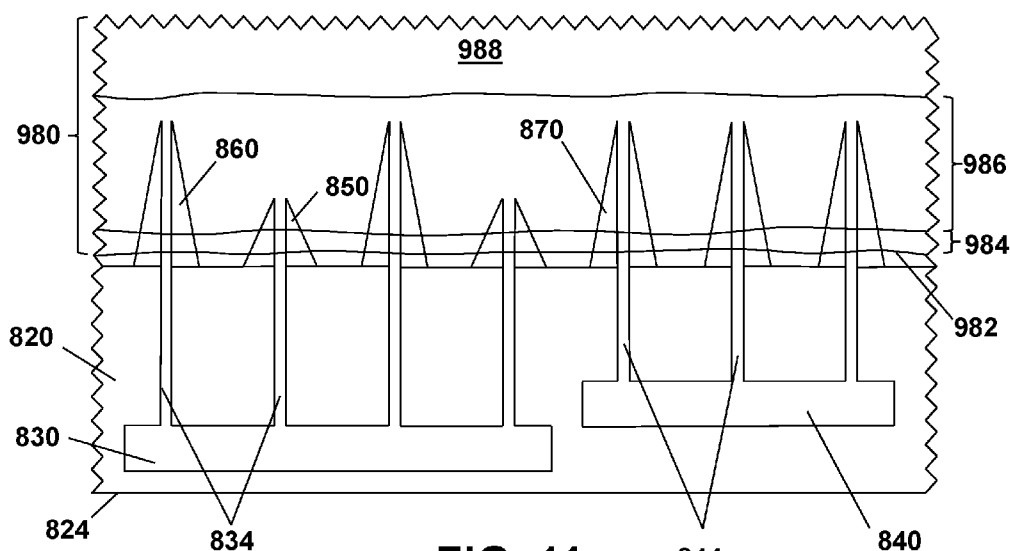


FIG. 11

(57) Abstract: A transdermal delivery device includes a film having first and second outwardly facing major surfaces; at least one liquid reservoir contained within the film; at least one microfluidic channel having a transverse dimension between about 100 nm and 0.5 mm disposed within the film and in fluid communication with the at least one liquid reservoir; and at least one outlet port associated with at least one microneedle operatively connected to the first outwardly facing major surface of the film in fluid communication with the at least one microfluidic channel.



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Three-Dimensional Microfluidics Devices for the Delivery of Actives

FIELD OF THE INVENTION

The present invention relates to devices for the administration of benefit agents to patients at surface of the skin. More particularly, this invention relates to microfluidic devices comprising one or more benefit agents, and methods for making and using these devices.

BACKGROUND OF THE INVENTION

Dermal delivery refers to the process of mass transport of benefit agents applied on the skin to various skin strata. The application of benefit agents to the skin has a long history. Numerous carriers, including conventional semisolid bases (creams, gels, ointments), matrix systems (clays, polymers), and liquid systems (solutions, emulsions, suspensions), are being used for cutaneous application of benefit agents.

The human skin functions as the primary barrier to the transdermal penetration of materials into the body. Transdermal delivery refers to the process of mass transport of substances applied on the skin surface and includes their absorption by each layer of the skin, their uptake by microcirculation of the skin, and distribution in the systemic circulation. Transdermal delivery of benefit agents to patients through the skin provides many advantages over other means of delivery. Primarily, transdermal delivery is a comfortable, convenient and noninvasive way of administering benefit agents.

Transdermal delivery also provides other advantages over other routes for administering a benefit agent formulation to a patient. For example, oral administration of some benefit agents may be ineffective because the benefit agent is destroyed in the gastrointestinal tract or eliminated by the liver, both of which are avoided by transdermal drug delivery. Parenteral injection with a conventional hypodermic needle also has drawbacks, as it is often painful and inconvenient. Transdermal benefit agent delivery also makes possible a high degree of control over blood concentrations of any agent.

Dermal and transdermal delivery may be accomplished by rubbing benefit agents onto the skin surface. But control of the amount and location of the benefit agent is an issue. Dermal and transdermal devices, also known as patches, are known for use in dermal and transdermal delivery of benefit agents. A delivery patch is a medicated

adhesive patch that is placed on the skin to deliver a specific dose of medication to the surface of the skin. These patches are typically constructed of a backing layer and an adhesive layer. Often, the benefit agents (drugs, medications) are located in the adhesive layer, but may be located on the surface of the adhesive, or in a separate layer or reservoir. Benefit agents are released from the patch through the adhesive, or through porous membrane covering a reservoir.

Recently developed are patches which use microfluidic delivery to the skin surface. Microfluidics is the science dealing with the behavior, precise control, and manipulation of fluids that are geometrically constrained to a small, typically sub-millimeter, scale, and with very small volumes (such as nanoliters or picoliters).

Microfluidic devices move, mix, separate or otherwise process fluid. Numerous applications employ passive fluid control techniques like capillary forces. In some applications, external actuation means are used for a directed transport of the fluid. These include components such as micropumps or microvalves. Micropumps supply fluids in a continuous manner or are used for dosing. Microvalves determine the flow direction or the mode of movement of pumped liquids.

The main disadvantage to transdermal delivery systems stems from the fact that the skin is a very effective barrier; as a result, only medications whose molecules are small enough to penetrate the skin can be delivered by this method. A wide variety of benefit agents are now available in transdermal patch form.

To address the challenge of intact skin, a variety of microneedle-array based drug delivery devices have been developed. These known microneedle (or microprotrusions) arrays generally fall into one of two design categories: (1) solid microneedles arrays with no active component, and (2) microneedles with a central hollow bore, which are like conventional hypodermic needle.

Solid delivery devices can pre-condition the skin by piercing the stratum corneum and the upper layer of epidermis to enhance percutaneous drug penetration prior to topical application of a biologic-carrier or a traditional patch. If solid delivery devices are kept in the skin, then the drug cannot readily flow into and through the holes in the skin because the holes remain plugged by the microneedles. This method has been shown to significantly increase the skin's permeability; however, this method provides only limited ability to control the dosage and quantity of delivered drugs or vaccine.

To increase the dosage control some methods uses solid microneedles that are surface-coated with a drug, or solid microneedles that are biodegradable, bioabsorbable, or dissolvable. Although these methods provide a somewhat better dosage control, they greatly limit the quantity of drug delivered. Also, the drug formulation could be easily chipped off the microneedle during storage, transport, or administration (insertion) of the microneedles. The application of a thicker and stronger layer of drug formulation can be undesirable because it reduced the sharpness of the microneedles and therefore made insertion more difficult and painful. This shortcoming has limited the widespread application of these approaches and precludes, for example, the simultaneous delivery of optimal quantities of combinations of antigens and/or adjuvant in vaccine applications.

Microneedles with hollow bore attached to a reservoir of benefit agents are also known. The syringe needle-type characteristics of these arrays can significantly increase the speed and precision of delivery, as well as the quantity of the delivered agent. However, reservoir-based delivery devices are expensive to make and require complex and expensive micromachining procedures. It is difficult to make sharp tips on hollow microneedles with machining techniques. Consequently, insertion of the microneedles into a patient's skin can be difficult and often painful.

Dermal or transdermal delivery of benefit agents using patch devices offer attractive theoretical advantages over other delivery methods. However, considerable practical limitations exist in the design, fabrication, and testing associated with patches constructed using conventional processes. Also, there is a need for a simple, effective, and economically desirable device for dermal or transdermal administration of using patches simultaneously delivering more than one benefit agent.

SUMMARY OF THE INVENTION

One aspect of the invention relates to a dermal delivery device comprising:

- (a) film having first and second outwardly facing major surfaces;
- (b) at least one liquid reservoir contained within the film;
- (c) at least one microfluidic channel having a transverse dimension between about 100 nm and 0.5 mm disposed within the film and in fluid communication with the at least one liquid reservoir;

(d) at least one outlet port operatively connected to the first outwardly facing major surface of the film in fluid communication with the at least one microfluidic channel.

5 Another aspect of the invention relates to a dermal delivery device comprising:

- (a) film having first and second outwardly facing major surfaces;
- (b) a plurality of liquid reservoirs contained within the film;
- (c) each liquid reservoir being in fluid communication with at least one microfluidic channel having a major transverse dimension between
- 10 about 100 nm and 0.5 mm disposed within the film;
- (d) at least one outlet port operatively connected to the first outwardly facing major surface of the film in fluid communication with at least one microfluidic channel.

15 A third aspect of the invention relates to a transdermal delivery device comprising:

- (a) film having first and second outwardly facing major surfaces;
- (b) at least one liquid reservoir contained within the film;
- (c) at least one microfluidic channel (having a major transverse dimension
- 20 between about 100 nm and 0.5 mm) disposed within the film and in fluid communication with the at least one liquid reservoir;
- (d) at least one outlet port operatively connected to the first outwardly facing major surface of the film in fluid communication with the at least one microfluidic channel;
- 25 (e) at least one microneedle in fluid communication with the at least one outlet port.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a perspective view of a first embodiment microfluidic delivery device

30 of the present invention;

FIG. 2 is a cross-sectional view of a section of the microfluidic delivery device of FIG. 1 along the 2-2 plane;

FIG. 3 is a cross-sectional view of a second embodiment of the microfluidic delivery device of FIG. 1 along the 2-2 plane;

FIG. 4 is a cross-sectional view of a third embodiment of the microfluidic delivery device of FIG. 1 along the 2-2 plane;

5 FIG. 5 is a cross-sectional view of a fourth embodiment of the microfluidic delivery device of FIG. 1 along the 5-5 plane;

FIG. 6 is a perspective view of a fifth embodiment microfluidic delivery device of the present invention;

FIG. 7 is a top view of a section of the microfluidic delivery device of FIG. 6;

10 FIG. 8 is a cross-sectional view of a section of the microfluidic delivery device of FIG. 6 along the 8-8 plane;

FIG. 9 is a cross-sectional view of a section of a sixth embodiment microfluidic delivery device;

15 FIG. 10 is a cross-sectional view of a section of a seventh embodiment microfluidic delivery device;

FIG. 11 is a cross-sectional view of a section of the microfluidic delivery device of FIG. 10 after the microneedles have penetrated the patient's skin;

FIG. 12 is a perspective view of an eighth embodiment microfluidic delivery device of the present invention; and

20 FIG. 13 cross-sectional view of a section of the microfluidic delivery device of FIG. 12 along the 12-12 plane.

DETAILED DESCRIPTION OF THE INVENTION

25 The present invention relates to devices for the dermal or transdermal administration of a plurality of benefit agents to patients using microfluidic delivery devices, and methods for making and employing these devices.

30 The presently disclosed subject matter will now be described more fully hereinafter with reference to the accompanying drawings and examples, in which representative embodiments are shown. The presently disclosed subject matter can, however, be embodied in different forms and should not be construed as limited to the embodiments set forth herein, but is to be accorded the widest scope consistent with the features described herein. Rather, these embodiments are provided so that this disclosure will be thorough and complete, and will fully convey the scope of the

embodiments to those skilled in the art. Unless otherwise defined, all technical and scientific terms used herein have the same meaning as commonly understood by one of ordinary skill in the art to which this presently described subject matter belongs. All publications, patent applications, patents, and other references mentioned herein are
5 incorporated by reference in their entirety.

As used herein the specification and the claims, the term “topical” and variants thereof mean “of or applied to an isolated part of the body”. This includes, without limitation skin, mucosa, and enamel, either directly or through an intermediate such as a biofilm.

10 As used herein, “benefit agent” means an ingredient or material that provides a benefit, e.g., improves, relieves, reduces, or treats symptoms or conditions of the skin or body, either cosmetic or therapeutic. Other terms of use for “benefit agent” include “biologic,” “active component,” “active formulation,” or “bioactive material”. These terms all refer to pharmaceutically active agents, such as analgesic agents, anesthetic
15 agents, anti-asthmatic agents, antibiotics, anti-depressant agents, anti-diabetic agents, anti-fungal agents, anti-hypertensive agents, anti-inflammatory agents, anti-neoplastic agents, anxiolytic agents, enzymatically active agents, nucleic acid constructs, immunostimulating agents, immunosuppressive agents, vaccines, and the like. The benefit agent material can comprise dissoluble materials, insoluble but dispersible
20 materials, natural or formulated macro, micro and nano particulates, and/or mixtures of two or more of dissoluble, dispersible insoluble materials and natural and/or formulated macro, micro and nano particulates.

As used herein, the term “microfluidic delivery device” generally refers to a device through which materials, particularly fluid borne materials, such as liquids, can
25 be transported, in some embodiments on a micro-scale, and in some embodiments on a nano-scale. Thus, the microfluidic devices described by the presently disclosed subject matter can include microscale features, nanoscale features, and/or combinations thereof.

Accordingly, a microfluidic device typically includes structural or functional
30 features dimensioned on the order of a millimeter-scale or less, which are capable of manipulating a fluid at a flow rate on the order of a microliter/min or less. Typically, such features include, but are not limited to channels, fluid reservoirs, reaction chambers, mixing chambers, and separation regions. In some examples, the channels

having at least one transverse dimension between about 100 nanometers and about 0.5 millimeter (about 500 micrometers). The use of dimensions on this order allows the incorporation of a greater number of channels in a smaller area, and utilizes smaller volumes of fluids.

5 A microfluidic device can exist alone or can be a part of a microfluidic system which, for example and without limitation, can include: pumps for introducing fluids, e.g., reagents, buffers and the like, into the system and/or through the system; detection equipment or systems; reagent, product or data storage systems; and control systems for controlling fluid transport and/or direction within the device, monitoring and
10 controlling environmental conditions to which fluids in the device are subjected, e.g., temperature, current, and the like.

 As used herein, the terms “channel,” “microscale channel,” and “microfluidic channel” are used interchangeably and can mean a recess or cavity formed in a material, or can mean a recess or cavity in combination with any suitable fluid-
15 conducting structure mounted in the recess or cavity, such as a tube, capillary, or the like. The terms “flow channel” and “control channel” are used interchangeably and can mean a channel in a microfluidic device in which a material, such as a fluid, e.g., a liquid, can flow through. More particularly, the term “flow channel” refers to a channel in which a material of interest can flow through. More particularly, such a channel is
20 filled with a fluid that does not permeate the material of the microfluidic device

 As used herein, the term “valve” unless otherwise indicated refers to a configuration in which two channels are separated by an elastomeric segment that can be deflected into or retracted from one of the channels, e.g., a flow channel, in response to an actuation force applied to the other channel, e.g., a control channel. The term
25 “valve” also includes one-way valves, which include channels separated by a bead.

 As used herein, the term “pattern” can mean a channel or a microfluidic channel or an integrated network of microfluidic channels, which, in some embodiments, can intersect at predetermined points. A pattern also can include one or more of a fluid reservoir, or micro- or nano-scale fluid reservoir, a micro- or nano-scale reaction
30 chamber, a micro- or nano-scale mixing chamber, a micro- or nano-scale separation region, a surface texture, a pattern on a surface that can include micro and/or nano recesses and/or projections. The surface pattern can be regular or irregular.

As used herein, the term "intersect" can mean to meet at a point, to meet at a point and cut through or across, or to meet at a point and overlap. More particularly, as used herein, the term "intersect" describes an embodiment wherein two or more channels meet at a point, meet at a point and cut through or across one another, or meet at a point and overlap one another. Accordingly, in some embodiments, two channels can intersect, i.e., meet at a point or meet at a point and cut through one another, and be in fluid communication with one another. In some embodiments, two channels can intersect, i.e., meet at a point and overlap one another, and not be in fluid communication with one another, as is the case when a flow channel and a control channel intersect.

As used herein, the term "communicate" (e.g., a first component "communicates with" or "is in communication with" a second component) and grammatical variations thereof are used to indicate a structural, functional, mechanical, electrical, optical, or fluidic relationship, or any combination thereof, between two or more components or elements. As such, the fact that one component is said to communicate with a second component is not intended to exclude the possibility that additional components can be present between, and/or operatively associated or engaged with, the first and second components.

In referring to the use of a microfluidic device for handling the containment or movement of fluid, the terms "in", "on", "into", "onto", "through", and "across" the device generally have equivalent meanings. As used herein, the term "monolithic" refers to a structure having or acting as a single, uniform structure.

In some embodiments, the microfluidic delivery device may be more rigid; built as the described three-dimensional shape to match the topical contour. The delivery device may have varying personalized area-specific treatment zones to enable the treatment application more effectively. With a design matched to the individual user's body part profile as physical guides, the application becomes easier and more effective, and can help in locating specific target zones to the precise area for applications.

Referring to the drawings, FIG. 1 is a perspective view of a first embodiment of a microfluidic delivery device **10** which may be used in the present invention. Delivery device **10** includes a film **20** having first outwardly facing major surface **22** and second outwardly facing major surface **24**. First outwardly facing major surface **22** has a plurality of outlet ports **32** disposed thereon.

In FIG. 1, delivery device **10** is shown to have a rectangular footprint. Film **20** of delivery device **10** may also have a variety of shapes, depending on the location of skin treatment. Possible shapes of the footprint left by film **20** include, but are not limited to, squares, rectangles, triangles, circles, ovals, kidneys, stars, crosses, characters, etc. The corners of such shapes, if any, may be angular or curved to reduce potential lift/removal points. The zone of the treatment could be greater than about 1,000 cm², about 1,000 cm², or about 100 cm², or about 10 cm², or about 1 cm², or less than 1 cm².

Delivery device **10** of FIG. 1 is shown to be planar. In some embodiments, the array may be curvilinear. The curvilinear delivery devices shaped to the body surface may provide superior retention of the array to the isolated body part under treatment.

Outlet ports **32** disposed on film **20** are shown to have circular cross-sections in FIG. 1, but may also have a variety of cross-sectional shapes. Possible shapes for outlet ports **32** include, but are not limited to, square, rectangular, triangular, circular, oval, kidney-shapes, stars, crosses, characters, etc.

Film **20** element of delivery device **10** preferably is relatively thin and flexible, so that it preferably readily conforms to the user's skin and is comfortable to wear, both because of the flexibility and conformability, as well as from the thinness. Delivery device **10** of the present invention may be intended for extended wear preferably are also formed to be aesthetically elegant without either peeling, wrinkling, cracking, or appearing greasy or tacky, or otherwise unpleasant or unsightly in nature. Delivery device **10** preferably is formed with sufficient rigidity and integrity to be able to withstand normal use when on the skin. In some embodiments, delivery device **10** of the invention preferably is formed with sufficient strength to stay intact on the skin when exposed to normal external forces that the skin may experience, such as rubbing of clothing.

In some embodiments, first outwardly facing major surface **22** of film **20** has disposed thereon an adhesive layer. The adhesive layer may be used to give delivery device **10** the sufficient strength to stay intact on the skin when exposed to normal external forces. Other means of creating sufficient strength to delivery device **10** so that the array stays intact on the skin will be discussed below.

FIG. 2 is a cross-sectional view of a section of delivery device **10** along the 2-2 plane of FIG. 1. The figure shows a liquid reservoir **30** contained within film **20**, as

well as a plurality of outlet ports **32** disposed on first outwardly facing major surface **22** of film **20**. Benefit agent is disposed in liquid reservoir **30**. Microfluidic channels **34** (having a transverse dimension between about 100 nanometers and about 0.5 millimeter) are disposed within film **20** and in fluid communication with reservoir **30**.

5 Outlet ports **32** are operatively connected to first outwardly facing major surface **22** of film **20** in fluid communication with at least one microfluidic channel **34**.

The figure also shows microfluidic channels **34** as being of constant width from liquid reservoir **30** to outlet ports **32**. In other embodiments, microfluidic channels **34** may be tapered from one end to the other. If they are tapered from wider at liquid
10 reservoir **30** to thinner at outlet ports **32**, capillary flow may aid in the movement of the liquid to outwardly facing major surface **22** of film **20**.

Benefit agent is disposed in liquid reservoir **30**. In some embodiments, the benefit agent is disposed in liquid reservoir **30** during the manufacturing process. In other embodiments, the benefit agent is disposed in liquid reservoir **30** after
15 microfluidic delivery device **10** has been made (post manufacturing).

In some embodiments, benefit agent is disposed in liquid reservoir **30** post manufacturing by filling liquid reservoir **30** via one or more of microfluidic channels **34**. In other embodiments, microfluidic delivery device **10** can be manufactured with fill channels (not shown) operatively connected to first outwardly facing major surface
20 **22** or second outwardly facing major surface **24** of film **20** which are in fluid communication with liquid reservoir **30**.

In the embodiment shown in FIG. 2, there is one liquid reservoir **30** contained within film **20**. Liquid reservoir **30** is disposed closer to second outwardly facing major surface **24** than to first outwardly facing major surface **22**. In other embodiments, there
25 may be multiple liquid reservoirs, and they may be in different locations within the film comprising the delivery device. FIG. 3 is a cross-sectional view of a second embodiment of a microfluidic delivery device **100** along a similar 2-2 plane. Delivery device **100** includes a film **120** having first outwardly facing major surface **122** and second outwardly facing major surface **124**. First outwardly facing major surface **122**
30 has a plurality of first outlet ports **132** and second outlet ports **142** disposed thereon.

First liquid reservoir **130** and second liquid reservoir **140** are contained within film **120**. The same, or different, benefit agents may be disposed in liquid reservoirs **130** and **140**. First microfluidic channels **134** disposed within film **120** are in fluid

communication with first liquid reservoir **130**, with outlet ports **132** operatively connected to first outwardly facing major surface **122** of film **120** in fluid communication with at least one first microfluidic channel **134**. Second microfluidic channels **144** disposed within film **120** are in fluid communication with second liquid reservoir **140**, with second outlet ports **142** operatively connected to first outwardly facing major surface **122** of film **120** in fluid communication with at least one second microfluidic channel **144**. In this embodiment, first liquid reservoir **130** is disposed closer to second outwardly facing major surface **124** than second liquid reservoir **140**.

The pattern of microfluidic channels is the integrated network of microfluidic channels, which, in some embodiments, can intersect at predetermined points. In FIGs. 2 and 3, the pattern is simple. The microfluidic channels flow in straight line paths from the liquid reservoirs to the first outwardly facing major surface of the film. In other embodiments, the pattern of microfluidic channels, or the pattern of the liquid reservoirs, may be more complex.

FIG. 4 is a cross-sectional view of a third embodiment of a microfluidic delivery device **200** along a similar 2-2 plane. Delivery device **200** includes a film **220** having first outwardly facing major surface **222** and second outwardly facing major surface **224**. First outwardly facing major surface **222** has a plurality of outlet ports disposed thereon. In this embodiment, there are four liquid reservoirs contained within film **220**: first liquid reservoir **230**, second liquid reservoir **240**, third liquid reservoir **250**, and fourth liquid reservoir **260**. The same, or different benefit agents may be disposed in liquid reservoirs **230**, **240**, **250**, and **260**.

First microfluidic channels **234a** and **234b** disposed within film **220** are in fluid communication with first liquid reservoir **230**, with outlet ports **232a** operatively connected to first outwardly facing major surface **222** of film **220** in fluid communication with at least one first microfluidic channel **234a**, and outlet ports **232b** operatively connected to first outwardly facing major surface **222** of film **220** in fluid communication with at least one first microfluidic channel **234b**. Outlet ports **232b** are significantly further from first liquid reservoir **230** than are outlet ports **232a**.

Second microfluidic channel **244** disposed within film **220** is in fluid communication with second liquid reservoir **240**, with second outlet port **245** operatively connected to first outwardly facing major surface **222** of film **220** in fluid communication with second microfluidic channel **244**. Third microfluidic channels

254a and **254b** disposed within film **220** are in fluid communication with third liquid reservoir **250**. Second outlet port **245** is also operatively connected to first outwardly facing major surface **222** of film **220** in fluid communication with third microfluidic channel **254a**. Third microfluidic channel **254a** is in fluid communication with third liquid reservoir **250**. So, in this embodiment, second microfluidic channel **244** and third microfluidic channel **254a** intersect at second outlet port **245**, thereby allowing the contents of second liquid reservoir **240** to mix with the contents of third liquid reservoir **250**.

Third outlet port **255** is operatively connected to first outwardly facing major surface **222** of film **220** in fluid communication with third microfluidic channel **254b** and with third liquid reservoir **250**. Third outlet port **255** is also operatively connected to first outwardly facing major surface **222** of film **220** in fluid communication with fourth microfluidic channel **264a**. Fourth microfluidic channel **264a** disposed within film **220** is also in fluid communication with fourth liquid reservoir **260**. So, in this embodiment, third microfluidic channel **254a** and fourth microfluidic channel **264a** intersect at third outlet port **255**, thereby allowing the contents of third liquid reservoir **250** to mix with the contents of fourth liquid reservoir **260**.

Finally, fourth outlet port **262** is operatively connected to first outwardly facing major surface **222** of film **220** in fluid communication with fourth microfluidic channel **264b**. Fourth microfluidic channel **264b** disposed within film **220** is in fluid communication with fourth liquid reservoir **260**. So, the contents of fourth liquid reservoir **260** may be delivered to the surface of the skin without being mixed with the contents of any other liquid reservoir.

The pattern of microfluidic channels in the third embodiment (shown in FIG. 4) is more complex than that shown in the first two embodiments. A more complex pattern of both of microfluidic channels and liquid reservoirs is shown in FIG. 5. The figure is a cross-sectional view of a fourth embodiment of the microfluidic delivery device of the present invention shown along the 5-5 plane of the device of FIG. 1. In this embodiment, delivery device **300** includes a film **320** having first and second outwardly facing major surfaces (not shown). There are six liquid reservoirs in delivery device **300**: first liquid reservoir **330**, second liquid reservoir **331**, third liquid reservoir **340**, fourth liquid reservoir **350**, fifth liquid reservoir **360**, and sixth liquid reservoir

370. Shown in dotted lines are outlet ports **332** which are located on first outwardly facing major surface.

All outlet ports **332** are operatively connected to first outwardly facing major surface of film **320** in fluid communication with microfluidic channels as well as liquid reservoirs in the film. Outlet ports **332** located directly above first liquid reservoir **330** and second liquid reservoir **331** yield a pattern with the flow in the microfluidic channels (not shown) being in straight line paths from liquid reservoirs **330** and **331** to the first outwardly facing major surface of the film. Outlet ports **332** located between third liquid reservoir **340** and fourth liquid reservoir **350**, or between fourth liquid reservoir **350** and fifth liquid reservoir **360** may be fed by one, or more than one, microchannel (not shown).

Liquid reservoirs **330**, **331**, **340**, **350**, and **360** disposed in film **320** are shown to have rectangular cross-sections in FIG. 5, but may also have a variety of cross-sectional shapes. Possible shapes for the liquid reservoirs include, but are not limited to, square, rectangular, triangular, circular, oval, kidney-shapes, stars, crosses, etc.

Sixth liquid reservoir **370** is shown to taper from first end **376a** to second end **376b**. Outlet ports **332** located directly above sixth liquid reservoir **370** yield a pattern with the flow in the microfluidic channels (not shown) being in straight line paths from sixth liquid reservoir **370** to the first outwardly facing major surface of the film. Microchannel **384** is shown as permitting the flow of liquid from second end **376b** of sixth liquid reservoir **370** to the far side of delivery device **300**. Microchannel **384** is tapered from first end **386a** to second end **386b**. This may be done to enhance the capillary flow of liquid from first to second end of microchannel **384**.

All the embodiments discussed thus far are used to deliver benefit agent(s) to patients at surface of the skin. To address the challenge of intact skin, a variety of microneedle-array based microfluidic delivery devices may be used.

FIG. 6 is a perspective view of a fifth embodiment microfluidic delivery device **500** which may be used in the present invention. Delivery device **500** includes a film **520** having first outwardly facing major surface **522** and second outwardly facing major surface **524**. First outwardly facing major surface **522** has a plurality of stratum corneum piercing hollow bore microneedles **610** and stratum corneum piercing solid microneedles **620** extending therefrom. Each hollow bore microneedle **610** has a proximal end **612** and a distal end **614**, where proximal end **612** is the end of hollow

bore microneedle **610** disposed on first outwardly facing major surface **522** of a delivery device **500**. Outlet ports **532** are disposed on distal end **614** of hollow bore microneedle **610**. Each solid microneedle **620** has a proximal end **622** and a distal end **624**, where proximal end **622** is the end of hollow bore microneedle **620** disposed on
 5 first outwardly facing major surface **522** of a delivery device **500**.

Delivery device **500** is shown to have a rectangular footprint. Film **520** of delivery device **500** may also have a variety of shapes including, but are not limited to, squares, rectangles, triangles, circles, ovals, kidneys, stars, crosses, characters, etc. The zone of the treatment could be greater than about 1,000 cm², about 1,000 cm², or about
 10 100 cm², or about 10 cm², or about 1 cm², or less than 1 cm².

Delivery device **500** of FIG. 6 is shown to be planar. In some embodiments, the array may be curvilinear. The curvilinear delivery devices shaped to the body surface provides microneedles **610**, **620** oriented normal to that surface. This provides better penetration of the microneedles and retention of the array for treatment.

15 Film **520** element of delivery device **500** preferably is relatively thin and flexible, so that it readily conforms to the user's skin and is comfortable to wear because of its conformability. Device **500** may be intended for extended wear, so is formed to be aesthetically elegant without either peeling, wrinkling, cracking, or appearing greasy or tacky, or otherwise unpleasant or unsightly in nature. The device
 20 preferably is formed with sufficient rigidity and integrity to be able to withstand normal use when on the skin of the user.

In some embodiments, delivery device **500** is formed with sufficient strength to stay intact on the skin when exposed to normal external forces that the skin may experience, such as rubbing of clothing. In some embodiments, hollow bore
 25 microneedles **610** and stratum corneum piercing solid microneedles **620** are sufficient to keep delivery device **500** intact on the skin. In other embodiments, first outwardly facing major surface **522** of film **520** has disposed thereon an adhesive layer. The adhesive layer may be used to give delivery device **500** the sufficient strength to stay intact on the skin when exposed to normal external forces. Alternatively, microneedles
 30 **610**, **620** may have a desired surface structure, such as slight directional ridges, to hold needle in place.

FIG. 7 is a top view of a section of the delivery device of FIG. 6. The figure shows stratum corneum piercing hollow bore microneedles **610** and stratum corneum

piercing solid microneedles **620** extending from facing major surface **522** of a delivery device **500**. Each hollow bore microneedle **610** has a proximal end **612** and a distal end **614**. Each solid microneedle **620** has a proximal end **622** and a distal end **624**.

Outlet ports **532** disposed on distal end **614** of hollow bore microneedle **610** are
 5 shown to have circular cross-sections in FIG. 7, but may also have a variety of cross-sectional shapes. Possible shapes for outlet ports **532** include, but are not limited to, square, rectangular, triangular, circular, oval, kidney-shapes, stars, crosses, etc.

As shown in the figure, hollow bore microneedles **610** and solid microneedles **620** are arranged in rows in a uniform a square pattern on first outwardly facing major
 10 surface **522** of delivery device **500**. In other embodiments, **610** and solid microneedles **620** may be arranged in other patterns.

FIG. 8 is a cross-sectional view of a section of delivery device **500** along the 8-8 plane of FIG. 6. The figure shows a liquid reservoir **530** contained within film **520**. In addition, the figure shows a plurality solid microneedle **620**, each solid microneedle
 15 having a proximal end **622** and a distal end **624**, as well as a plurality of hollow bore microneedles **610**, each hollow bore solid microneedle having a proximal end **622** and a distal end **624**. Each hollow bore microneedle **610** has an outlet port **532** disposed on its distal end **614**.

Benefit agent is disposed in liquid reservoir **530**. Microfluidic channels **534**
 20 (having a transverse dimension between about 100 nanometers and about 0.5 millimeter) are disposed within film **520** and in fluid communication with reservoir **530**. Outlet ports **532** are operatively connected to distal ends **614** of hollow bore microneedles **610** in fluid communication with at least one microfluidic channel **534**.

The figure shows microfluidic channels **534** as being of constant width from
 25 liquid reservoir **530** to outlet ports **532**. In other embodiments, microfluidic channels **534** may be tapered from one end to the other. If they are tapered from wider at liquid reservoir **530** to thinner at outlet ports **532**, capillary flow may aid in the movement of the liquid from liquid reservoir **530** to outlet ports **532**.

Solid microneedles **620** may be surface-coated with a benefit agent, or may be
 30 made of biodegradable, bioabsorbable, or dissolvable materials in which one, or several, benefit agents have been mixed.

The dimensions of microneedles **610**, **620** may vary depending on a variety of factors such as the type of benefit agent to be delivered, the dosage of the benefit agent

to be delivered, and the desired penetration depth. Generally, the stratum corneum piercing microneedles are constructed to provide skin-piercing and benefit agent delivery functions and thus will be designed to be sufficiently robust to withstand insertion into and withdrawal from the skin. Each microneedle has a length of about 1
5 micrometer (μm) to about 5000 micrometers (μm), or about 1 μm to about 500 μm , or about 100 μm to about 500 μm . The penetration length of the microneedles into the biological barrier is about 50 μm to about 200 μm . In addition, each of the microneedles has a width of about 1 μm to about 500 μm . Furthermore, each microneedle has a thickness of about 1 μm to about 200 μm . It will be understood by
10 one skilled in the art that the width and thickness of the stratum corneum piercing microneedle may vary along its length. For instance, the base portion may be wider (thicker) than the body portion, or the body portion may have a slight taper approaching the tip portion.

Generally, stratum corneum piercing microneedles **610, 620** can be in any
15 elongated shape suitable for providing the skin piercing and benefit agent delivery, with minimal pain to the patient. In various embodiments, an individual microneedle is substantially cylindrical, wedge-shaped, cone-shaped, or triangular (e.g., blade-like). The cross-sectional shape (cut along a plane approximately parallel to the planar substrate or approximately perpendicular to the longitudinal axis of the microneedle) of
20 the microneedle, or at least the portion of the microneedle that is penetrable into the skin, may take a variety of forms, including rectangular, square, oval, circular, diamond, triangular, or star-shaped.

The tip portions of stratum corneum piercing microneedles **610, 620** are designed to pierce a biological barrier, e.g., to pierce the stratum corneum of the skin of
25 a patient, to deliver benefit agents into the patient's tissue. Preferably, the tip portion of each microneedle should be sufficiently small and sharp to enable piercing and penetration of the skin with minimal pain. In a preferred embodiment, the tip end portion of the microneedle is tapered from the body portion toward the tip end, defining a point or apex at the end of the microneedle. In various embodiments, the tapered tip
30 portion may be in the form of an oblique angle at the tip, or a pyramidal or conical or triangular shape.

Microneedles in delivery devices of the invention may also be of a variety of lengths and geometries. FIG. 9 is a cross-sectional view of a section of a sixth

embodiment delivery device **700**. Delivery device **700** includes a film **720** having first outwardly facing major surface **722** and second outwardly facing major surface **724**. The figure shows a liquid reservoir **730** contained within film **720**. First outwardly facing major surface **722** has a plurality of stratum corneum piercing hollow bore microneedles **740**, **750**, **760**, and **770** extending therefrom.

In this embodiment, a variety of hollow bore microneedle stratum corneum piercing microneedle lengths and shapes are presented. Hollow bore microneedle **740** is cylindrical in shape, with no taper from proximal end **742** to distal end **744**. Outlet port **746** is disposed on distal end **744** of hollow bore microneedle **740**. Hollow bore microneedle **750** has a cylindrical proximal end **752**, which tapers to a point at distal end **754**. Outlet port **756** is disposed on distal end **754** of hollow bore microneedle **750**. Hollow bore microneedle **760** is conical in shape, with a taper from proximal end **762** to distal end **764**. Outlet port **766** is disposed on distal end **764** of hollow bore microneedle **760**. Finally, hollow bore microneedle **770** has a proximal end **772** and a distal end **774**, and has an undulating shape. Outlet port **776** is disposed on distal end **774** of hollow bore microneedle **770**.

Hollow bore microneedles **740** and **750** extend from first outwardly facing major surface **722** of film **720** to a height of h_1 , while hollow bore microneedles **760** and **770** extend from first surface **722** of film **720** to a height of h_2 .

Benefit agent is disposed in liquid reservoir **730**. Microfluidic channels **734** (transverse dimension between about 100 nanometers and about 0.5 millimeter) are disposed within film **720** and in fluid communication with reservoir **730**. Outlet ports **746**, **756**, **766**, and **776** are in fluid communication with at least microfluidic channels **734**.

In this embodiment, height h_2 is greater than height of h_1 , and there may be a desire for both a shallower and a deeper penetration into the skin of the user for the benefit agent contained in liquid reservoir **730**. Although the figure shows hollow bore microneedles **740** and **750** are of uniform height h_1 , while hollow bore microneedles **760** and **770** are of uniform height h_2 , it is to be understood that in other embodiments the microneedles may be of any number of different heights.

FIG. 10 is a cross-sectional view of a seventh embodiment of a microfluidic delivery device **800**. Delivery device **800** includes a film **820** having first outwardly facing major surface **822** and second outwardly facing major surface **824**. The figure

shows first liquid reservoir **830** and second liquid reservoir **840** contained within film **820**. Hollow bore microneedles **850**, **860**, and **870** extend from first outwardly facing major surface **822** of film **820**.

Hollow bore microneedles **850** are conical in shape, tapering from proximal end **852** to distal end **854**. Microneedles **850** extend from first outwardly facing major surface **822** of film **820** to a height of h_1 . Outlet port **856** is disposed on distal end **854** of hollow bore microneedle **850**.

Hollow bore microneedles **860** are conical in shape, tapering from proximal end **862** to distal end **864**. Microneedles **860** extend from first outwardly facing major surface **822** of film **820** to a height of h_2 . Outlet port **866** is disposed on distal end **864** of hollow bore microneedle **860**.

Hollow bore microneedles **870** are conical in shape, tapering from proximal end **872** to distal end **874**. Microneedles **870** extend from first outwardly facing major surface **822** of film **820** to a height of h_2 . Outlet port **876** is disposed on distal end **874** of hollow bore microneedle **870**.

Although FIG. 10 shows hollow bore microneedles **850**, **860**, and **870** of different heights (h_1 , h_2 , and h_2 , respectively), it is to be understood that in other embodiments the microneedles may all be of the same height, or any number of different heights.

First liquid reservoir **830** and second liquid reservoir **840** are contained within film **820**. The same, or different, benefit agents may be disposed in liquid reservoirs **830** and **840**. First microfluidic channels **834** disposed within film **820** are in fluid communication with first liquid reservoir **830**, with outlet ports **856** and **866** operatively connected to first outwardly facing major surface **822** of film **820** in fluid communication with at least one first microfluidic channel **834**. Second microfluidic channels **844** disposed within film **820** are in fluid communication with second liquid reservoir **840**, with second outlet ports **876** operatively connected to first outwardly facing major surface **822** of film **820** in fluid communication with at least one second microfluidic channel **844**. In this embodiment, first liquid reservoir **830** is disposed closer to second outwardly facing major surface **124** than second liquid reservoir **840**.

Obstructors **868** are disposed in first microfluidic channels **834** near distal end **864** of hollow bore microneedle **860**. In some embodiments, obstructors **868** act as valves which may open and close to permit the flow of benefit agents from first liquid

reservoir **830**. In other embodiments, obstructors **868** may be made of biodegradable, bioabsorbable, or dissolvable materials. In these embodiments, release of benefit agents from first liquid reservoir **830** may be initiated when biodegradable obstructors **868** break down when subjected to bodily fluids.

5 Seventh embodiment microfluidic delivery device **800** is demonstrated in a prophetic use in FIG. 10. The figure is a cross-sectional view of a section of the microfluidic delivery device **800** after the microneedles have penetrated the patient's skin. The figure shows skin tissue **980** with an outer surface **982**. Beneath outer surface **982** lies the epidermis **984**, dermis **986**, and the subcutis or hypodermis **988** layers. The
10 first outwardly facing major surface **822** of film **820** is in contact with outer surface **982** of skin tissue **980**.

Hollow bore microneedle **850**, **860**, and **870** all penetrate outer surface **982** and epidermis **944**. Microneedles **860** and **870** penetrate deeper into dermis **986** than microneedles **850**. So, if there is a desire for personalized treatment at different skin
15 depths, delivery devices **800** of the present invention allow a degree of flexibility not available to delivery devices produced using the microcasting process.

The microfluidic delivery devices presented thus far in the present invention are single use devices with single-use liquid reservoirs. In some embodiments, the reservoirs may be refillable. FIG. 12 is a perspective view of an eighth embodiment of
20 a microfluidic delivery device **1500** which may be used in the present invention. Delivery device **1500** includes a film **1520** having first outwardly facing major surface **1522** and second outwardly facing major surface **1524**. First outwardly facing major surface **1522** has a plurality of stratum corneum piercing hollow bore microneedles **1610** and stratum corneum piercing solid microneedles **1620** extending therefrom. Each
25 hollow bore microneedle **1610** has a proximal end **1612** and a distal end **1614**, where proximal end **1612** is the end of hollow bore microneedle **1610** disposed on first outwardly facing major surface **1522** of a delivery device **1500**. Outlet ports **1532** are disposed on distal end **1614** of hollow bore microneedle **1610**. Each solid microneedle **1620** has a proximal end **1622** and a distal end **1624**, where proximal end **1622** is the
30 end of hollow bore microneedle **1620** disposed on first outwardly facing major surface **1522** of a delivery device **1500**.

Delivery device **1500** is shown to have a rectangular footprint, but may also have a variety of shapes, such as squares, rectangles, triangles, circles, ovals, kidneys,

stars, crosses, characters, etc. The zone of the treatment could be greater than about 1,000 cm², about 1,000 cm², or about 100 cm², or about 10 cm², or about 1 cm², or less than 1 cm².

Delivery device **1500** of FIG. 12 is shown to be planar. In some embodiments, the array may be curvilinear. The curvilinear delivery devices shaped to the body surface provides microneedles **1610**, **1620** oriented normal to that surface. This provides better penetration of the microneedles and retention of the array for treatment.

Film **1520** element of delivery device **1500** preferably is relatively thin and flexible, so that it readily conforms to the user's skin and is comfortable to wear because of its conformability. is formed with sufficient strength to stay intact on the skin when exposed to normal external forces that the skin may experience, such as rubbing of clothing. Hollow bore microneedles **1610** and stratum corneum piercing solid microneedles **1620** may be sufficient to keep delivery device **1500** intact on the skin. However, first outwardly facing major surface **1522** of film **1520** may have an adhesive layer disposed thereon. The adhesive layer may be used to give delivery device **1500** the sufficient strength in some embodiments to stay intact on the skin when exposed to normal external forces. Alternatively, microneedles **1610**, **1620** may have a desired surface structure, such as slight directional ridges, to hold needle in place.

Outlet ports **1532** disposed on distal end **1614** of hollow bore microneedle **1610** are may have a variety of cross-sectional shapes. Possible shapes for outlet ports **1532** include, but are not limited to, square, rectangular, triangular, circular, oval, kidney-shapes, crosses, etc.

As shown in the figure, hollow bore microneedles **1610** and solid microneedles **1620** are arranged in rows in a uniform a square pattern on first outwardly facing major surface **1522** of delivery device **1500**. In other embodiments, **1610** and solid microneedles **1620** may be arranged in other patterns.

FIG. 13 is a cross-sectional view of a section of delivery device **1500** along the 12-12 plane of FIG. 12. The figure shows a liquid reservoir **1530** contained within film **1520**. In addition, the figure shows a plurality solid microneedle **1620**, each solid microneedle having a proximal end **1622** and a distal end **1624**, as well as a plurality of hollow bore microneedles **1610**, each hollow bore solid microneedle having a proximal

end **1622** and a distal end **1624**. Each hollow bore microneedle **1610** has an outlet port **1532** disposed on its distal end **1614**.

Benefit agent is disposed in liquid reservoir **1530**. Microfluidic channels **1534** (having a transverse dimension between about 100 nanometers and about 0.5 millimeter) are disposed within film **1520** and in fluid communication with reservoir **1530**. Outlet ports **1532** are operatively connected to distal ends **1614** of hollow bore microneedles **1610** in fluid communication with at least one microfluidic channel **1534**.

The figure shows microfluidic channels **1534** as being of constant width from liquid reservoir **1530** to outlet ports **1532**. In other embodiments, microfluidic channels **1534** may be tapered from one end to the other. If they are tapered from wider at liquid reservoir **1530** to thinner at outlet ports **1532**, capillary flow may aid in the movement of the liquid from liquid reservoir **1530** to outlet ports **1532**.

As mentioned earlier, in this embodiment microfluidic delivery device **1500** has a fillable or refillable liquid reservoir **1530**. FIG. 13 shows inlet port **1538** disposed on second outwardly facing major surface **1524** of film **1520**. Refill channel **1536** is disposed within film **1520** and in fluid communication with reservoir **1530**. Inlet port **1538** is in fluid communication with refill channel **1536**.

Refill channel **1536** may be microfluidic in nature, i.e. having a transverse dimension between about 100 nanometers and about 0.5 millimeter. The figure shows refill channel **1536** being tapered from wider at second outwardly facing major surface **1524** to narrower at refillable liquid reservoir **1530**. In some embodiments, refill channel **1536** may be of constant width from liquid reservoir **1530** to inlet port **1538**. In still other embodiments, refill channel **1536** may be tapered from wider at refillable liquid reservoir **1530** to narrower at second outwardly facing major surface **1524**.

Inlet port **1538** may have a variety of cross-sectional shapes. Possible shapes for inlet port **1538** include, but are not limited to, square, rectangular, triangular, circular, oval, kidney-shapes, crosses, etc. In some embodiments, inlet port **1538** may be shaped so as to adapt to the device used to refill liquid reservoir **1530**.

Solid microneedles **1620** may be surface-coated with a benefit agent, or may be made of biodegradable, bioabsorbable, or dissolvable materials in which one, or several, benefit agents have been mixed.

Similar to the dimensions of microneedles **610**, **620** discussed previously, microneedles **1610**, **1620** may have lengths of about 1 micrometer (μm) to about 5000

micrometers (μm), widths of about 1 μm to about 500 μm , and thicknesses of about 1 μm to about 200 μm . It will be understood by one skilled in the art that the width and thickness of the stratum corneum piercing microneedle may vary along its length. For instance, the base portion may be wider (thicker) than the body portion, or the body portion may have a slight taper approaching the tip portion.

Stratum corneum piercing microneedles **1610**, **1620** can be in any elongated shape suitable for providing the skin piercing and benefit agent delivery, with minimal pain to the patient, with individual microneedles being substantially cylindrical, wedge-shaped, cone-shaped, or triangular (e.g., blade-like). The cross-sectional shape (cut along a plane approximately parallel to the planar substrate or approximately perpendicular to the longitudinal axis of the microneedle) of the microneedle, or at least the portion of the microneedle that is penetrable into the skin, may take a variety of forms, including rectangular, square, oval, circular, diamond, triangular, or star-shaped.

The tip portions of stratum corneum piercing microneedles **1610**, **1620** are designed to pierce a biological barrier, e.g., to pierce the stratum corneum of the skin of a patient, to deliver benefit agents into the patient's tissue. Preferably, the tip portion of each microneedle should be sufficiently small and sharp to enable piercing and penetration of the skin with minimal pain. In a preferred embodiment, the tip end portion of the microneedle is tapered from the body portion toward the tip end, defining a point or apex at the end of the microneedle. In various embodiments, the tapered tip portion may be in the form of an oblique angle at the tip, or a pyramidal or conical or triangular shape.

In a preferred embodiment, at least two independent liquid systems each includes a fillable reservoir **1530** having an inlet port **1538** and coupled to at least one microfluidic channel **1534** associated with at least one microneedle **1610**.

In some embodiments, film **20**, **120**, **220**, **320**, are formed of, or coated with, a biocompatible material. In some embodiments, film **520**, **720**, **820**, **1520**, stratum corneum piercing microneedles **620**, **740**, **750**, **760**, **770**, **850**, **860**, **870**, **1610**, **1620**, or both, are formed of, or coated with, a biocompatible material. Microneedles **620**, **740**, **750**, **760**, **770**, **850**, **860**, **870**, **1610**, **1620**, may be formed from the same material used in film **520**, **720**, **820**, **1520**, or alternatively, the microneedles can include a material different from the film material. Representative examples of suitable materials of construction include metals and alloys such as stainless steels, palladium, titanium, and

aluminum; plastics such as polyetherimide, polycarbonate, polyetheretherketone, polyimide, polymethylpentene, polyvinylidene fluoride, polyphenylsulfone, liquid crystalline polymer, polyethylene terephthalate (PET), polyethylene terephthalate-glycol modified (PETG), and polyimide; and ceramics such as silicon and glass. The material preferably is selected such that the microneedle is strong enough at its designed dimensions for the microneedle to effectively pierce the skin without significant bending or breaking of the microneedle. The microneedle and substrate materials also should be non-reactive with the drug formulation being delivered by the delivery device.

10 In some embodiments, the films, microneedles, or both, are formed of biodegradable or bioabsorbable materials. Representative examples of suitable materials include, but are not limited to, poly(lactic acid) (PLA), poly(glycolic acid) (PGA), polydioxanone (PDO), poly(epsilon-caprolactone) (PCL), poly(lactic-co-glycolic acid) (PLGA), poly(ortho ester) (POE), copoly(ether-ester) (CEE), based
15 formulations, or combinations of such materials. Microneedles can be formed from water soluble materials that include polyvinyl alcohol (PVOH), carboxymethylcellulose (CMC) and polyethylene oxide (PEO) based formulations, or combinations of such materials.

Films, stratum corneum piercing microneedles, or both, optionally may further
20 include secondary materials of construction embedded therein or coated thereon. For example, microparticles, nanoparticles, fibers, fibrils, or other particulate materials may be included. These secondary materials may enhance one or more physical or chemical characteristics of delivery device **10, 100, 200, 300, 500, 700, 800, 1500**.

In some embodiments, stratum corneum piercing microneedles **620, 740, 750, 760, 770, 850, 860, 870, 1610, 1620**, are formed of biodegradable materials, while film **520, 720, 820, 1520**, is not biodegradable. In these embodiments the benefit agent material can comprise dissolvable materials or insoluble but dispersible materials. So, the mechanism of delivery of the benefit agent can be, for example, the simultaneous biodegradation of the microneedles with the dissolution or dispersing of the benefit
25 agent. The rate of degradation of the needles could be controlled to allow predetermined drug-delivery rates of the benefit agent. In some embodiments, the release rate of first benefit agent could differ from that of second benefit agent. At the
30

point in time when all of the stratum corneum piercing microneedles have degraded, film **520, 720, 820, 1520**, can be removed from the site of treatment.

In some embodiments, the delivery device **10, 100, 200, 300, 500, 700, 800, 1500**, may be further coated with a benefit agent, either the needles alone or in
5 combination with the substrate.

The benefit agents may include lubricants, slip agents and the like. Alternatively, the benefit agents may provide one or more benefits to the targeted topical region. Such benefit agents may be any of a variety of compositions, including, without limitation, waxes, oils, emollients, moisturizers, and the like.

10 Benefit agents may include hyaluronic acid; hydroxyl acids (e.g., glycolic acid, lactic acid, malic acid, salicylic acid, citric acid, tartaric acid); anti-acne agents (e.g., salicylic acid, retinol, retinoids, or other keratolytics, and benzoyl peroxide, or other antimicrobial agents used to treat acne); shine control agents (e.g., rice protein, cotton powder, elubiol (dichlorophenyl-imidazoltioxolan); a retinoid or its derivative such as
15 tretinoin, isotretinoin, motretinide, adapalene, tazarotene, azelaic acid, and retinol; a 5-alpha-reductase inhibitor of amino acids, e.g., glycine derivatives; hydrolyzed vegetable proteins, including soy protein and wheat protein, etc., green tea (*camellia sinensis*) extract, and cinnamon bark extract); moisturizers; anti-microbial agents (e.g., cationic antimicrobials such as benzyllkonium chloride, benzethonium chloride,
20 triclocarbon, polyhexamethylene biguanide, cetylpyridium chloride, methyl and benzothonium chloride; salts of chlorhexidine, such as lodopropynyl butylcarbamate, diazolidinyl urea, chlorhexidene digluconate, chlorhexidene acetate, chlorhexidine isethionate, and chlorhexidene hydrochloride; halogenated phenolic compounds, such as 2,4,4'-trichloro-2-hydroxy diphenyl ether (Triclosan); parachlorometa xyleneol
25 (PCMX); short chain alcohols, such as ethanol, propanol, and the like); antibiotics or antiseptics (mupirocin, neomycin sulfate bacitracin, polymyxin B, 1-ofloxacin, tetracyclines (chlortetracycline hydrochloride, oxytetracycline-10hydrochloride and tetracycline hydrochloride), clindamycin phosphate, gentamicin sulfate, metronidazole, hexylresorcinol, methylbenzethonium chloride, phenol, quaternary ammonium
30 compounds, tea tree oil, and their pharmaceutically acceptable salts and prodrugs), anti-inflammatory agents (e.g., suitable steroidal anti-inflammatory agents such as corticosteroids such as hydrocortisone, hydroxyltriamcinolone alphasethyl dexamethasone, dexamethasone-phosphate, beclomethasone dipropionate, clobetasol

valerate, desonide, desoxymethasone, desoxycorticosterone acetate, dexamethasone, dichlorisone, diflorasone diacetate, diflucortolone valerate, fluadrenolone, fluclarolone acetonide, fludrocortisone, flumethasone pivalate, fluosinol one acetonide, fluocinonide, flucortine butylester, fluocortolone, fluprednidene (fluprednylidene) acetate, flurandrenolone, halcinonide, hydrocortisone acetate, hydrocortisone butyrate, methylprednisolone, triamcinolone acetonide, cortisone, cortodoxone, flucetonide, fludrocortisone, difluorosone diacetate, fluradrenalone acetonide, medrysone, amciafel, amcinafide, betamethasone, chlorprednisone, chlorprednisone acetate, clocortelone, clescinolone, dichlorisone, difluprednate, flucloronide, flunisolide, fluoromethalone, fluperolone, fluprednisolone, hydrocortisone valerate, hydrocortisone cyclopentylpropionate, hydrocortamate, meprednisone, paramethasone, prednisolone, prednisone, beclomethasone dipropionate, betamethasone dipropionate, triamcinolone, and salts, nonsteroidal anti-inflammatory agents, feverfew (*Tanacetum parthenium*), goji berry (*Lycium barbarum*), milk thistle extract (*Silybum marianum*), amaranth oil (15 *Amaranthus cruentus*), pomegranate (*Punica granatum*), yerbe mate (*Ilex paraguariensis* leaf extract), white lily flower extract (*Lilium Candidum*), olive leaf extract (*Olea europaea*) and phloretin (apple extract)); anti-mycotic / antifungal agents (e.g., miconazole, econazole, ketoconazole, sertaconazole, itraconazole, fluconazole, voriconazole, clioquinol, bifoconazole, terconazole, butoconazole, tioconazole, oxiconazole, sulconazole, saperconazole, clotrimazole, undecylenic acid, haloprogin, 20 butenafine, tolnaftate, nystatin, ciclopirox olamine, terbinafine, amorolfine, naftifine, elubiol, griseofulvin, and their pharmaceutically acceptable salts and prodrugs; an azole, an allylamine, or a mixture thereof); external analgesics (e.g., ibuprofen- or diclofenac; capsaicin, fentanyl, and salts thereof such fentanyl citrate; paracetamol (as 25 acetaminophen); non-steroidal anti-inflammatory drugs (NSAIDs) such as salicylates; opioid drugs such as morphine and oxycodone; ibuprofen- or diclofenac-containing gel); anti-oxidants (e.g., sulfhydryl compounds and their derivatives (e.g., sodium metabisulfite and N-acetyl cysteine), lipoic acid and dihydrolipoic acid, resveratrol, lactoferrin; ascorbic acid, ascorbic acid esters, and ascorbic acid derivatives (e.g., 30 ascorbyl palmitate and ascorbyl polypeptide); butylhydroxy anisole, butylated hydroxytoluene (butylhydroxy toluene), retinoids (e.g., retinol and retinyl palmitate), tocopherols (e.g., tocopherol acetate), tocotrienols, and ubiquinone; cysteine, N-acetylcysteine, sodium bisulfite, sodium metabisulfite, sodium

formaldehydesulfoxylate, acetone sodium bisulfite, tocopherols, and nordihydroguaiaretic acid; extracts containing flavonoids and isoflavonoids and their derivatives (e.g., genistein and diadzein); extracts containing resveratrol and the like; grape seed, green tea, pine bark, and propolis; plant-derived polyphenol antioxidants

5 such as clove, cinnamon, oregano, turmeric, cumin, parsley, basil, curry powder, mustard seed, ginger, pepper, chili powder, paprika, garlic, coriander, onion and cardamom; typical herbs such as sage, thyme, marjoram, tarragon, peppermint, oregano, savory, basil and dill weed)); depilatory agents (e.g., calcium thioglycolate or potassium thioglycolate); vitamins (e.g., Vitamin A, Vitamin B, Vitamins C, Vitamin

10 E; either alpha, beta, gamma or delta tocopherols, niacin or niacinamide) and vitamin salts or derivatives such as ascorbic acid diglucoside and vitamin E acetate or palmitate; sunblock (e.g., titanium dioxide) and / or sunscreen (e.g., inorganic sunscreens such as titanium dioxide and zinc oxide; organic sunscreens such as octyl-methoxy cinnamates, octyl salicylate, homosalate, avobenzone); vasodilators (e.g.,

15 niacin); humectants (e.g., glycerin); anti-aging agents (e.g., retinoids; dimethylaminoethanol (DMAE), copper containing peptides); alpha hydroxy acids or fruit acids and their precursors such as glycolic acid, citric acid, lactic acid, malic acid, mandelic acid, ascorbic acid, alpha-hydroxybutyric acid, alpha-hydroxyisobutyric acid, alphahydroxyisocaproic acid, atrolactic acid, alpha-hydroxyisovaleric acid, ethyl

20 pyruvate, galacturonic acid, glucoheptonic acid, glucoheptono 1,4-lactone, gluconic acid, gluconolactone, glucuronic acid, glucuronolactone, isopropyl pyruvate, methyl pyruvate, mucic acid, pyruvic acid, saccharic acid, saccaric acid 1,4-lactone, tartaric acid, and tartronic acid; beta hydroxy acids such as beta-hydroxybutyric acid, beta-phenyl-lactic acid, and beta-phenylpyruvic acid; zinc and zinc containing compounds

25 such as zinc oxides; botanical extracts such as green tea, soy, milk thistle, algae, aloe, angelica, bitter orange, coffee, goldthread, grapefruit, hoellen, honeysuckle, Job's tears, lithospermum, mulberry, peony, puerarua, nice, and safflower, and salts and prodrugs thereof); carotenoids, ceramides, fatty acids, enzymes, enzyme inhibitors, minerals, steroids, peptides, amino acids, botanical extracts, colorants, allergy relief agents such

30 as Cetirizine HCl or a pharmaceutically equivalent Cetirizine compounds, analgesic compounds such as acetaminophen, ibuprofen, ketoprofen, or pharmaceutically equivalents thereof, cough/cold relief actives such as Phenylephrine HCL, Dextromethorphan Hydrobromide Hydrate, Pseudoephedrine HCl, or pharmaceutically

equivalents thereof, quit smoking medications such as Bupropion SR, Varenicline and nicotine replacement therapy agents, or pharmaceutically equivalent thereof, etc. The substances may affect the skin in any of a variety of manners, such as by moisturizing; enhancing skin tone or color (such as with pigments); treating or at least mitigating various skin conditions (such as dry or severe dry skin, eczema, psoriasis, atopic dermatitis, allergic rashes, acne, blackheads, pustules, comedones, rosacea, shingles, wrinkles, cold sores, herpes, corns, warts, sunburn, insect bites, poison ivy, etc.); applying a mechanical force (such as shrinkage) to smooth wrinkles; or, more generally, treating or mitigating the symptoms and appearance of undesired skin imperfections (such as under eye dark circle, redness of acne, fine lines and wrinkles, post inflammatory hyperpigmentation (PIH), redness, inflammation, cellulite, wrinkles, age spots, mottled pigmentation, dark spots, liver spots, under eye puffiness); removing unwanted facial or body hair; aiding in wound healing; etc.. For instance, lotions, creams, oils, and even masks may be applied to skin to treat or otherwise to affect the skin. Such personal or consumer healthcare substances are absorbed into the skin generally following the principles of diffusion, under which the rate of diffusion or transport across the skin is correlated with the difference in active concentration on both sides of the skin.

The benefit agent(s) can be introduced into the reservoir(s) as a single compound, especially those that are liquid at processing and delivery temperatures. They can also be formulated into solutions, suspensions, and the like. Those benefit agents that are for therapeutic treatment of patients must be formulated with pharmaceutically acceptable carriers, such as organic solvents such ethanol, dimethyl sulfoxide ("DMSO") or dimethylformamide ("DMF"), and can be diluted preferably in aqueous solution.

As mentioned earlier, the micromachining or microcasting process for producing delivery devices are limited to producing arrays of a single composition. In the present invention, the personalized treatment uses stratum corneum piercing stratum corneum piercing microneedles with more than one benefit agent. So, the micromachining or microcasting process cannot be used.

The delivery devices of the present invention can be produced using Additive Manufacturing technology. Additive Manufacturing is a group of techniques used to quickly fabricate a physical part or assembly using three-dimensional computer aided

design (CAD) data. Construction of the part or assembly is usually done using “additive layer manufacturing” technologies such as 3D printing. Additive manufacturing is a simple, effective, and economically method of making delivery devices which simultaneously delivering more than one benefit agent.

5 In general, the computer-aided-design - computer-aided manufacturing CAD-CAM workflow is the traditional additive manufacturing process. The process starts with the creation of geometric data, either as a 3D solid using a CAD workstation, or 2D slices using a scanning device. For Additive Manufacturing, this data must represent a valid geometric model; namely, one whose boundary surfaces enclose a
10 finite volume, contains no holes exposing the interior unless they are designed into the structure, and do not fold back on themselves. In other words, the object must have an “inside.” The model is valid if for each point in 3D space the algorithm can determine uniquely whether that point lies inside, on, or outside the boundary surface of the model. CAD post-processors will approximate the internal CAD geometric forms with
15 a simplified mathematical form, which in turn is expressed in a specified data format which is a common feature in Additive Manufacturing. To obtain the necessary motion control trajectories to drive the Additive Manufacturing mechanism, the prepared geometric model is typically sliced into layers, and the slices are scanned into lines (producing a “2D drawing” used to generate trajectory as in computer numerical
20 control toolpath), resulting in a layer-to-layer physical building process.

 The 3D printing process enables the creation of different sizes and shapes microneedles, as well as the ability to produce delivery devices with more than one benefit agent. The location, sharpness, cavitation, and material within individual microneedles can be much more easily controlled with 3D printing than
25 micromachining or microcasting. Soft materials, hard materials, and even liquids can be incorporated into individual microneedles. A change in delivery profile can be designed into the system to make a smart delivery device. Incompatible compounds may also be built into different sections of the delivery device without cross contamination fears.

 The microneedles need to deliver active/drug at least 100 microns or deeper, but
30 can be designed to have a variable penetration at or above 20 microns. Different applications and uses would need differing levels of penetration, solubility and design features (size, shape, angle, solubility, etc.). In some cases, the benefit agent may be dissolved into the needle material, whereas in others it may be stored in a reservoir and

delivered through a microfluidic channel. In some embodiments, the benefit agent may be coated onto the needle material.

The resulting delivery device comprising a benefit agent can be use by applying to the skin in any known manner. In the event that the delivery device comprises a
5 reservoir having an inlet port, the reservoir can be filled with a liquid comprising a benefit agent through the inlet port. The inlet port can then be closed for use, as above.

In embodiments in which multiple benefit agents are to be delivered, at least two independent liquid systems, each including a fillable reservoir having an inlet port and coupled to at least one microfluidic channel associated with at least one
10 microneedle, can be filled through their respective inlet ports with a desired liquid comprising a benefit agent. The inlet ports can be closed for use, as above.

In some embodiments, these dermal delivery devices, or patches, can include sensors which detect the amount of a liquid delivered over time, so that the amount of drug can be monitored using an App so that consumers (users) can track the amount
15 that is delivered over a period of time and can change the drug delivery profile as desired.

In some embodiments, a large bolus of the benefit agents can be delivered by these dermal delivery devices by preparing water soluble microneedles with high concentration of benefit agents; or by preparing coated microneedles with high
20 concentration of benefit agents. The delivery of low concentration of benefit agents from the reservoir can then provide longer term delivery of the benefit agents.

The present invention will be further understood by reference to the following specific Examples which are illustrative of the composition, form and method of
25 producing the present invention. It is to be understood that many variations of composition, form and method of producing this would be apparent to those skilled in the art. The following Examples, wherein parts and percentages are by weight unless otherwise indicated, are only illustrative.

30 Examples

Example 1: Transdermal drug delivery devices for long duration allergy relief applications.

A transdermal drug delivery devices in the form of a film having with an internal liquid reservoir(s) and microfluidic channel as well as microneedles for use in allergy relief applications can be prepared as follows.

5 Cetirizine HCl, an antihistamine used to relieve allergy symptoms such as watery eyes, runny nose, itching eyes/nose, sneezing, hives, and itching, can be dissolved in organic solvents such as DMSO and DMF and can be diluted preferably in aqueous solution. The Cetirizine HCl may be stored in the internal liquid reservoir(s) and delivered through a microfluidic channel to the hollow microneedles for transdermal delivery.

10 The amount of Cetirizine will depend on the duration for delivery of the drug. For a seven-day Cetirizine patch, for example, at least about 70 mg to about 100 mg of drug will be required to be stored in the reservoir(s) and delivered through hollow microneedles over a period of seven days. The length and thickness of the hollow microneedles can range from about 100 microns to about 0.5 mm.

15 Since Cetirizine HCl is highly water soluble, there will be some loss during the transport of drug through the skin and therefore more than 70 mg of drug could be required to compensate for drug loss.

20 Other antihistamines, such as diphenhydramine, can also be used for this application. The amount of drug will range from about 700 to about 1000 mg for a seven-day drug delivery device.

Example 2: Transdermal drug delivery devices for long duration cough/cold relief applications.

25 Transdermal drug delivery devices in the form of a film having with an internal liquid reservoir(s) and microfluidic channel as well as microneedles for use in cough/cold relief applications can be prepared as follows.

30 (a) Phenylephrine HCL, a decongestant used to relieve stuffiness from colds can be dissolved in organic solvents such ethanol, DMSO or DMF, and can be diluted preferably in aqueous solution. The Phenylephrine HCL may be stored in the internal liquid reservoir(s) and delivered through a microfluidic channel to the hollow microneedles for transdermal delivery.

The amount of Phenylephrine will depend on the duration for delivery of the active. For a seven-day patch, for example, about 160 mg to about 200 mg of

drug will be required to be stored in the reservoir(s) and delivered through hollow microneedles over a period of seven days. The length and thickness of the hollow microneedles can range from about 100 microns to about 0.5 mm.

5 (b) Dextromethorphan Hydrobromide Hydrate used for temporary relief of coughs without phlegm that are caused by certain infections of the air passages can be dissolved in organic solvents such ethanol, DMSO or DMF, and can be diluted preferably in aqueous solution. The Dextromethorphan Hydrobromide Hydrate may be stored in the internal liquid reservoir(s) and delivered through a
10 microfluidic channel to the hollow microneedles for transdermal delivery. The amount of Dextromethorphan Hydrobromide Hydrate will depend on the duration for delivery of the active. For a seven-day patch, for example, about 90 mg to about 120 mg of the drug will need to be stored in the reservoir and delivered through hollow microneedles over a period of seven days. The length
15 and thickness of the hollow microneedles can range from about 100 microns to about 0.5 mm.

(c) Pseudoephedrine HCl used for the temporary relief of stuffy nose and sinus pain/pressure caused by infection can be dissolved in organic solvents such
20 ethanol, DMSO or DMF, and can be diluted preferably in aqueous solution. The Pseudoephedrine HCl may be stored in the internal liquid reservoir(s) and delivered through a microfluidic channel to the hollow microneedles for transdermal delivery. The amount of Pseudoephedrine HCl will depend on the duration for delivery of
25 the active. For a seven-day patch, for example, about 1500 mg to about 1700 mg of the drug will need to be stored in the reservoir and delivered through hollow microneedles over a period of seven days. The length and thickness of the hollow microneedles can range from about 100 microns to about 0.5 mm.

30 **Example 3:** Transdermal drug delivery devices for long duration pain relief applications.

The most commonly used drugs for pain can include acetaminophen, ibuprofen, naproxen and ketoprofen. These actives may be stored in the internal liquid

reservoir(s) and delivered through a microfluidic channel to the hollow microneedles for transdermal delivery. For an acetaminophen patch, the drug amount will depend on the duration and will range from about 1300 to about 10,000 mg of drug for one-day to seven-day patches, respectively. The length and thickness of the hollow microneedles can range from about 250 microns to about 0.5 mm as the amount of drug required to initiate the benefits is larger.

For an ibuprofen patch, the amount of drug will range from about 600 mg to about 4000 mg for a one-day to seven-day patches, respectively. The length and thickness of the hollow microneedles can range from about 100 microns to about 0.5 mm.

The most preferred drug for pain application can be ketoprofen as the amount of drug required is lower compared to the other pain relieving actives. For a one-day patch the drug can be about 40 mg and can go as high as about 300 mg for a seven-day patch. The length and thickness of the hollow microneedles can range from about 100 microns to about 0.5 mm.

Example 4: Transdermal drug delivery devices for long duration applications for using combined drugs.

Two drugs can be combined to provide improved cough/cold relief for consumers. Solutions of Phenylephrine HCL and Dextromethorphan Hydrobromide Hydrate can be prepared and kept separate in different microchannels or reservoirs to prevent interaction between the drugs. Individual drugs can be delivered through microneedles separately and the ratio between the drugs can be altered based on the consumer needs. Other drugs can also be included for pain and cough/cold applications, and these drugs can be delivered separately to minimize interaction between drugs and the dosing can be monitored.

In some embodiments, these patches can include sensors so that the amount of drug can be monitored using an App so that consumers can track the amount that is delivered over a period of time and can change the drug delivery profile as desired.

What is claimed is:

1. A transdermal delivery device comprising:
 - (a) film having first and second outwardly facing major surfaces;
 - (b) at least one liquid reservoir disposed within the film;
 - 5 (c) at least one microfluidic channel (having a major transverse dimension between about 100 nm and 0.5 mm) disposed within the film and in fluid communication with the at least one liquid reservoir;
 - (d) at least one outlet port operatively connected to the first outwardly facing major surface of the film in fluid communication with the at least one microfluidic
 - 10 channel;
 - (e) at least one microneedle in fluid communication with the at least one outlet port.
2. The transdermal delivery device of claim 1 wherein the at least one liquid reservoir disposed within the film contains Cetirizine HCl or a pharmaceutically equivalent
- 15 Cetirizine compound in a pharmaceutically acceptable solvent.
3. The transdermal delivery device of claim 2 comprising a total amount of Cetirizine HCl or a pharmaceutically equivalent Cetirizine compound of between about 70 mg and about 100 mg.
- 20 4. The transdermal delivery device of claim 1 wherein the at least one liquid reservoir disposed within the film contains an analgesic compound in a pharmaceutically acceptable solvent.
- 25 5. The transdermal delivery device of claim 4 wherein the analgesic is selected from the group consisting of acetaminophen, ibuprofen, ketoprofen and pharmaceutical equivalents thereof.
6. The transdermal delivery device of claim 4, wherein the analgesic comprises
- 30 acetaminophen or a pharmaceutically equivalent of acetaminophen in a pharmaceutically acceptable solvent and the at least one microneedle in fluid communication with the at least one outlet port has a length of about 0.25 mm and about 0.5 mm.

7. The transdermal delivery device of claim 6 comprising a total amount of acetaminophen or a pharmaceutically equivalent of acetaminophen of between about 1300 mg and about 10000 mg.
- 5 8. The transdermal delivery device of claim 4, wherein the analgesic comprises ibuprofen or a pharmaceutically equivalent of ibuprofen in a pharmaceutically acceptable solvent and the at least one microneedle in fluid communication with the at least one outlet port has a length of about 0.1 mm and about 0.5 mm.
- 10 9. The transdermal delivery device of claim 8 comprising a total amount of ibuprofen or a pharmaceutically equivalent of ibuprofen of between about 600 mg and about 4000 mg.
10. The transdermal delivery device of claim 4, wherein the analgesic comprises
15 ketoprofen or a pharmaceutically equivalent of ketoprofen in a pharmaceutically acceptable solvent and the at least one microneedle in fluid communication with the at least one outlet port has a length of about 0.1 mm and about 0.5 mm.
11. The transdermal delivery device of claim 10 comprising a total amount of
20 ketoprofen or a pharmaceutically equivalent of ketoprofen of between about 40 mg and about 300 mg.
12. The transdermal delivery device of any preceding claim further comprising a
25 sensor.
13. The transdermal delivery device of claim 12 wherein the sensor detects an amount of a liquid delivered over time.
14. The transdermal delivery device for long duration delivery of at least two active
30 formulations comprising:
(a) film having first and second outwardly facing major surfaces;
(b) a first active formulation subsystem comprising:

- (i) at least one first active formulation liquid reservoir containing a first active formulation disposed within the film;
- (ii) at least one first active formulation microfluidic channel (having a major transverse dimension between about 100 nm and 0.5 mm) disposed within the film and in fluid communication with the at least one first active formulation liquid reservoir;
- (iii) at least one first active formulation outlet port operatively connected to the first outwardly facing major surface of the film in fluid communication with the at least one first active formulation microfluidic channel; and
- (iv) at least one first active formulation microneedle in fluid communication with the at least one first active formulation outlet port; and
- (c) a second active formulation subsystem comprising:
- (i) at least one second active formulation liquid reservoir containing a second active formulation disposed within the film;
- (ii) at least one second active formulation microfluidic channel (having a major transverse dimension between about 100 nm and 0.5 mm) disposed within the film and in fluid communication with the at least one second active formulation liquid reservoir;
- (iii) at least one second active formulation outlet port operatively connected to the second outwardly facing major surface of the film in fluid communication with the at least one second active formulation microfluidic channel; and
- (iv) at least one second active formulation microneedle in fluid communication with the at least one second active formulation outlet port.
15. The transdermal delivery device of claim 14 further comprising:
- (d) a third active formulation subsystem comprising:
- (i) at least one third active formulation liquid reservoir containing a third active formulation disposed within the film;
- (ii) at least one third active formulation microfluidic channel (having a major transverse dimension between about 100 nm and 0.5 mm) disposed within the film and in fluid communication with the at least one third active formulation liquid reservoir;

- (iii) at least one third active formulation outlet port operatively connected to the third outwardly facing major surface of the film in fluid communication with the at least one third active formulation microfluidic channel; and
- (iv) at least one third active formulation microneedle in fluid communication with the at least one third active formulation outlet port.
16. The transdermal delivery device of claim 14 or 15 wherein the first active formulation comprises a solution of Phenylephrine HCl or a pharmaceutically equivalent Phenylephrine compound in a pharmaceutically acceptable solvent.
17. The transdermal delivery device of claim 16, comprising a total amount of Phenylephrine HCl or a pharmaceutically equivalent Phenylephrine compound of between about 160 mg and about 200 mg.
18. The transdermal delivery device of claim 14 or 15 wherein the second active formulation comprises a solution of Dextromethorphan Hydrobromide Hydrate or a pharmaceutically equivalent Dextromethorphan compound in a pharmaceutically acceptable solvent.
19. The transdermal delivery device of claim 18, comprising a total amount of Dextromethorphan Hydrobromide Hydrate or a pharmaceutically equivalent Dextromethorphan compound of between about 90 mg and about 120 mg.
20. The transdermal delivery device of claim 15 wherein the third active formulation comprises a solution of Pseudoephedrine HCl or a pharmaceutically equivalent Pseudoephedrine compound in a pharmaceutically acceptable solvent.
21. The transdermal delivery device of claim 20, comprising a total amount of Pseudoephedrine HCl or a pharmaceutically equivalent Pseudoephedrine compound of between about 1500 mg and about 1700 mg.
22. The transdermal delivery device of any of claims 14-21 further comprising a sensor.

23. The transdermal delivery device of claim 22 wherein the sensor detects an amount of a liquid delivered over time.
24. A method of producing delivery devices comprising the steps of:
- 5 (a) forming a transdermal delivery device via additive manufacturing, the transdermal delivery device comprising:
- (i) film having first and second outwardly facing major surfaces;
- (ii) at least one liquid reservoir disposed within the film and having an inlet port;
- 10 (iii) at least one microfluidic channel (having a major transverse dimension between about 100 nm and 0.5 mm) disposed within the film and in fluid communication with the at least one liquid reservoir;
- (iv) at least one outlet port operatively connected to the first outwardly facing major surface of the film in fluid communication with the at least
- 15 one microfluidic channel; and
- (v) at least one microneedle in fluid communication with the at least one outlet port;
- (b) filling the at least one liquid reservoir with a liquid comprising a benefit agent through the inlet port; and
- 20 (c) closing the inlet port.
- 25 25. The method of claim 24 wherein the benefit agent comprises Cetirizine HCl or a pharmaceutically equivalent Cetirizine compound in a pharmaceutically acceptable solvent.
26. The method of claim 24 wherein the benefit agent comprises an analgesic compound in a pharmaceutically acceptable solvent.
27. The method of claim 26 wherein the analgesic is selected from the group consisting of acetaminophen, ibuprofen, ketoprofen and pharmaceutical equivalents thereof.
- 30 28. The method of any of claims 24-27 further comprising sensing an amount of liquid delivered over time.

29. A method of producing delivery devices comprising the steps of:

(a) forming a transdermal delivery device via additive manufacturing, the transdermal delivery device comprising:

- 5 (i) a film having first and second outwardly facing major surfaces
- (ii) a first active formulation subsystem comprising:
 - (A) at least one first active formulation liquid reservoir disposed within the film and having an inlet port;
 - (B) at least one first active formulation microfluidic channel (having a major transverse dimension between about 100 nm and 0.5 mm) disposed within the film and in fluid communication with the at least one first active formulation liquid reservoir;
 - 10 (C) at least one first active formulation outlet port operatively connected to the first outwardly facing major surface of the film in fluid communication with the at least one first active formulation microfluidic channel; and
 - 15 (D) at least one first active formulation microneedle in fluid communication with the at least one first active formulation outlet port; and
- (iii) a second active formulation subsystem comprising:
 - 20 (A) at least one second active formulation liquid reservoir disposed within the film and having an inlet port;
 - (B) at least one second active formulation microfluidic channel (having a major transverse dimension between about 100 nm and 0.5 mm) disposed within the film and in fluid communication with the at least one second active formulation liquid reservoir;
 - 25 (C) at least one second active formulation outlet port operatively connected to the first outwardly facing major surface of the film in fluid communication with the at least one second active formulation microfluidic channel; and
 - 30 (D) at least one second active formulation microneedle in fluid communication with the at least one second active formulation outlet port; and

(b) filling the at least one first active formulation liquid reservoir with a liquid comprising a first benefit agent through the first active formulation inlet port; and

(c) filling the at least one second active formulation liquid reservoir with a liquid comprising a second benefit agent through the second active formulation inlet

5 port; and

(d) closing the active formulation inlet ports.

30. The method of claim 29 wherein the transdermal delivery device further comprises:

(iv) a third active formulation subsystem comprising:

10 (A) at least one third active formulation liquid reservoir disposed within the film and having an inlet port;

(B) at least one third active formulation microfluidic channel (having a major transverse dimension between about 100 nm and 0.5 mm) disposed within the film and in fluid communication with the at least one third active formulation liquid reservoir;

15 (C) at least one third active formulation outlet port operatively connected to the first outwardly facing major surface of the film in fluid communication with the at least one third active formulation microfluidic channel; and

20 (D) at least one third active formulation microneedle in fluid communication with the at least one third active formulation outlet port;

and wherein the process further includes:

25 (e) filling the at least one third active formulation liquid reservoir with a liquid comprising a third benefit agent through the third active formulation inlet port.

31. The method of claim 29 or 30 wherein the first benefit agent comprises solution of Phenylephrine HCl or a pharmaceutically equivalent Phenylephrine compound in a pharmaceutically acceptable solvent.

30

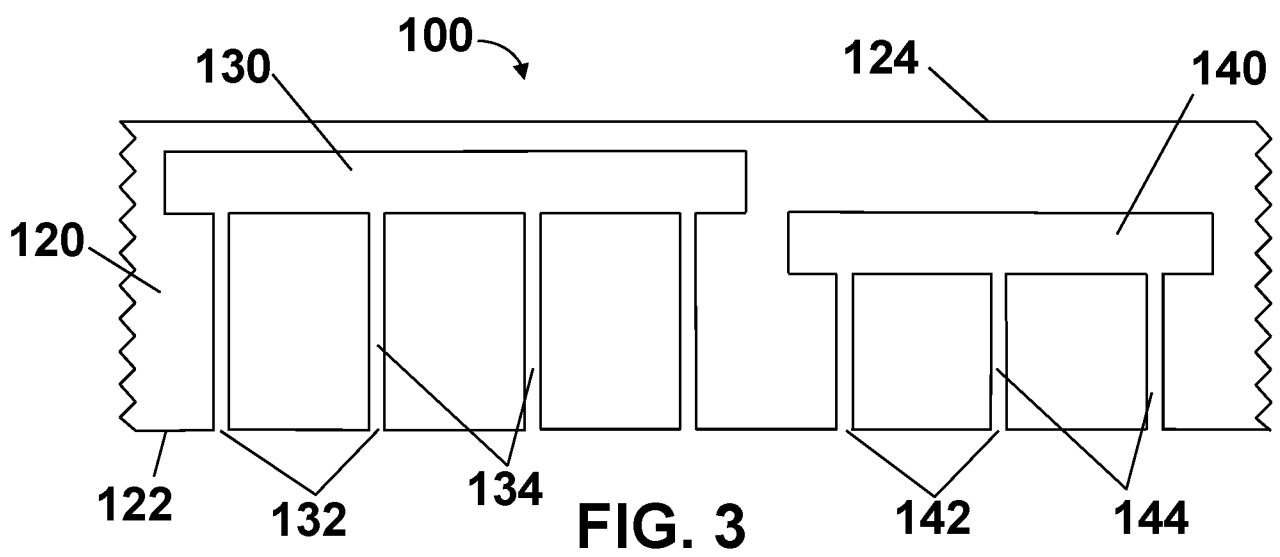
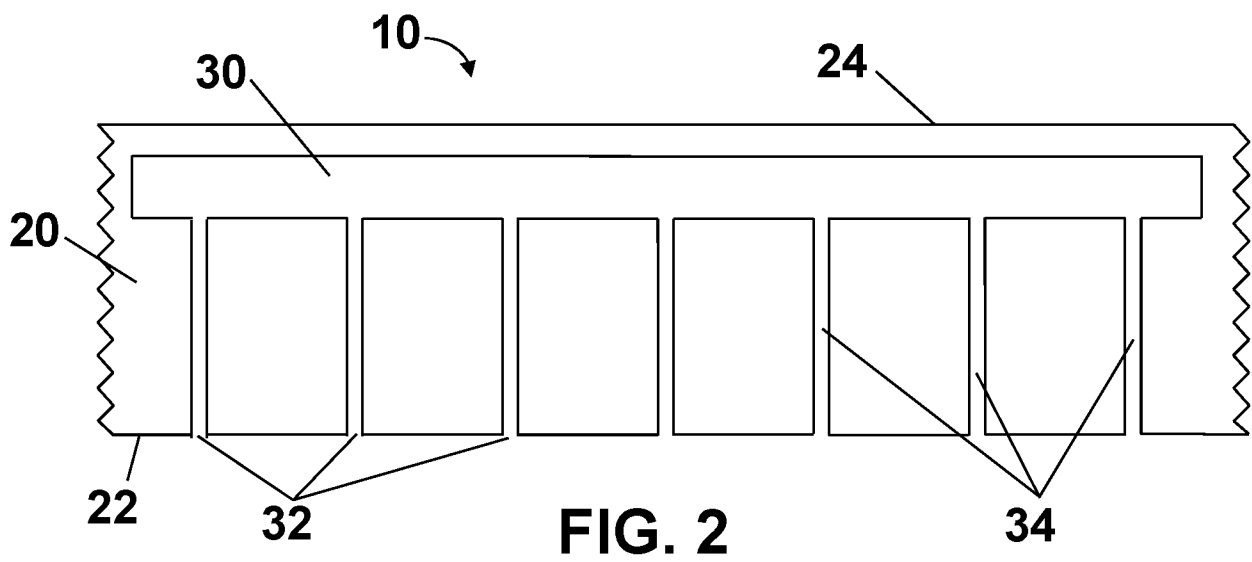
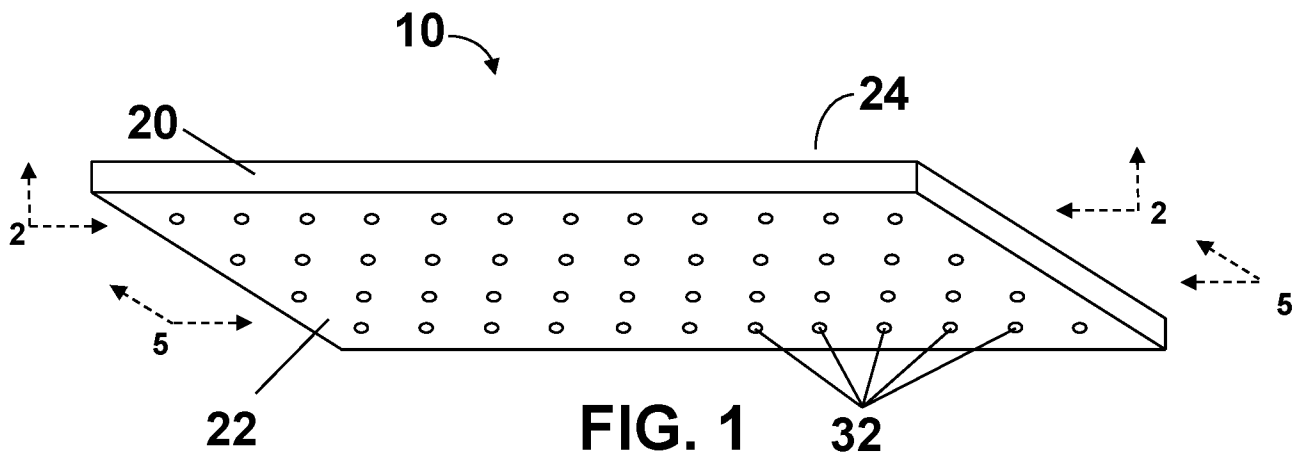
32. The method of claim 29 or 30 wherein the second benefit agent comprises solution of Dextromethorphan Hydrobromide Hydrate or a pharmaceutically equivalent Dextromethorphan compound in a pharmaceutically acceptable solvent.

33. The method of claim 30 wherein the third benefit agent comprises solution of Pseudoephedrine HCl or a pharmaceutically equivalent Pseudoephedrine compound in a pharmaceutically acceptable solvent.

5

34. The method of any of claims 29-33 further comprising sensing an amount of liquid delivered over time.

10



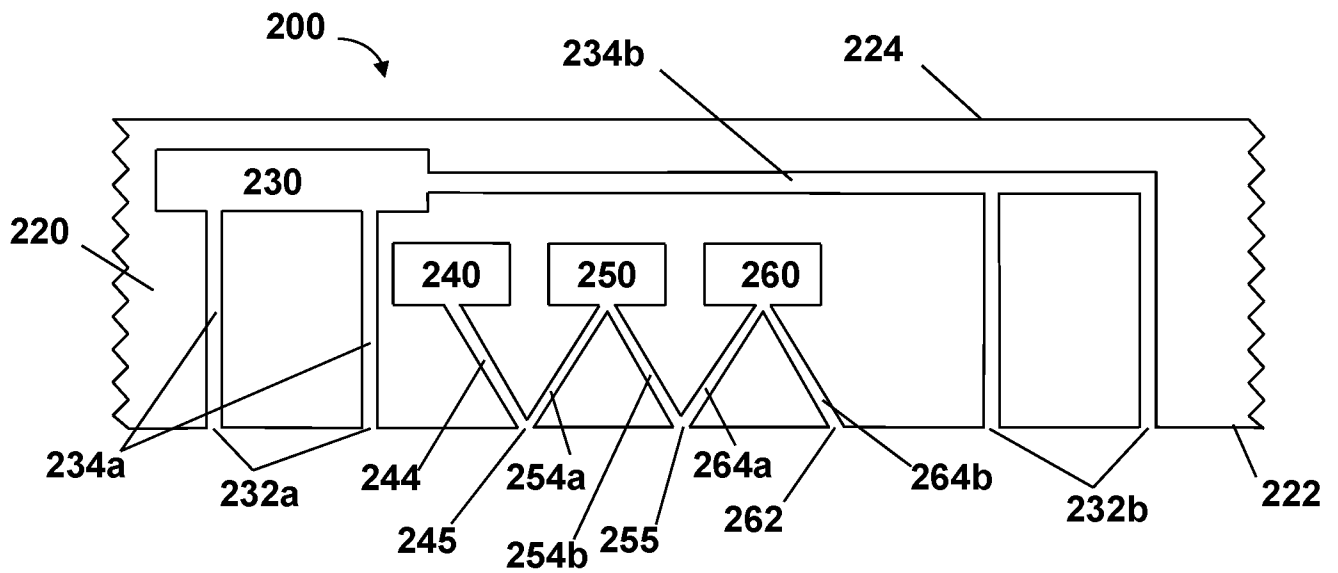


FIG. 4

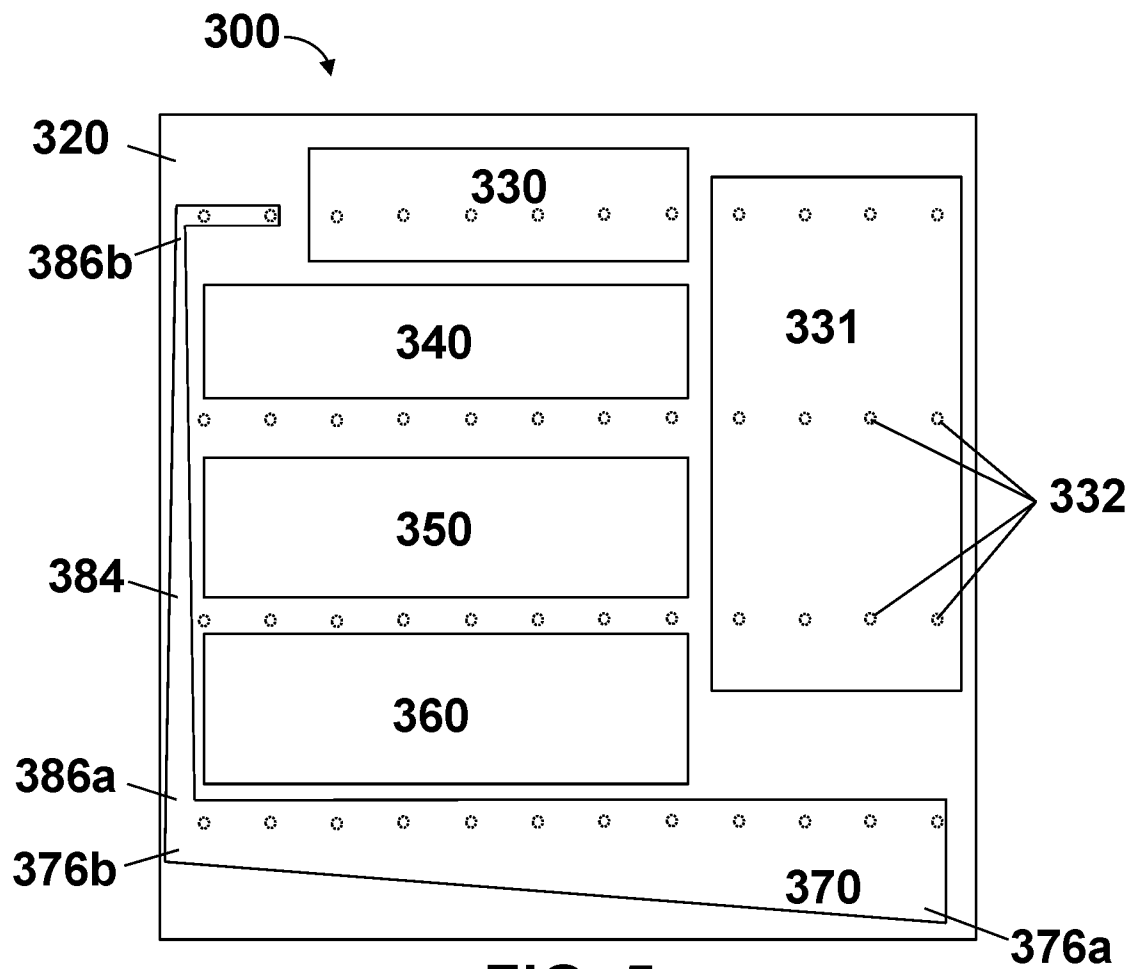
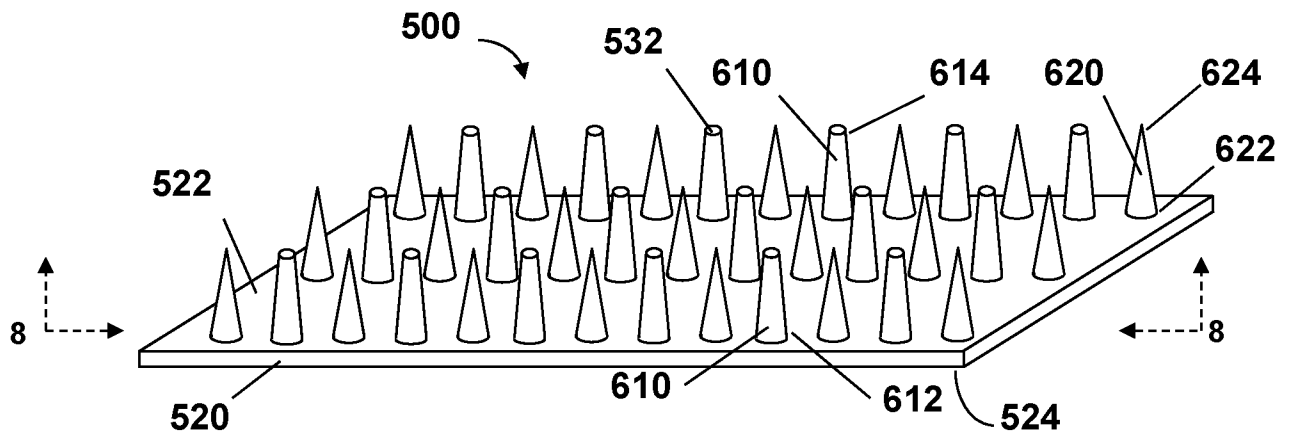
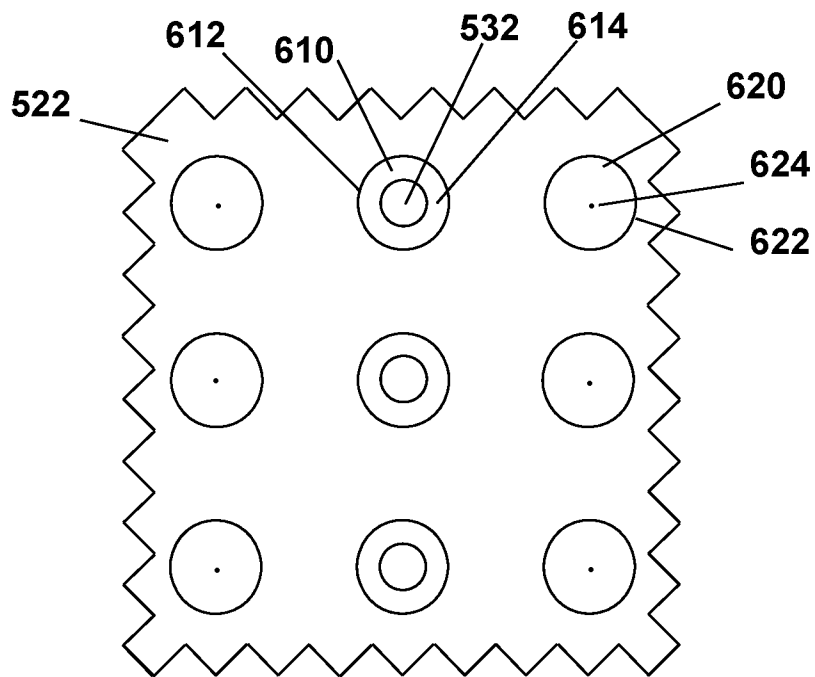
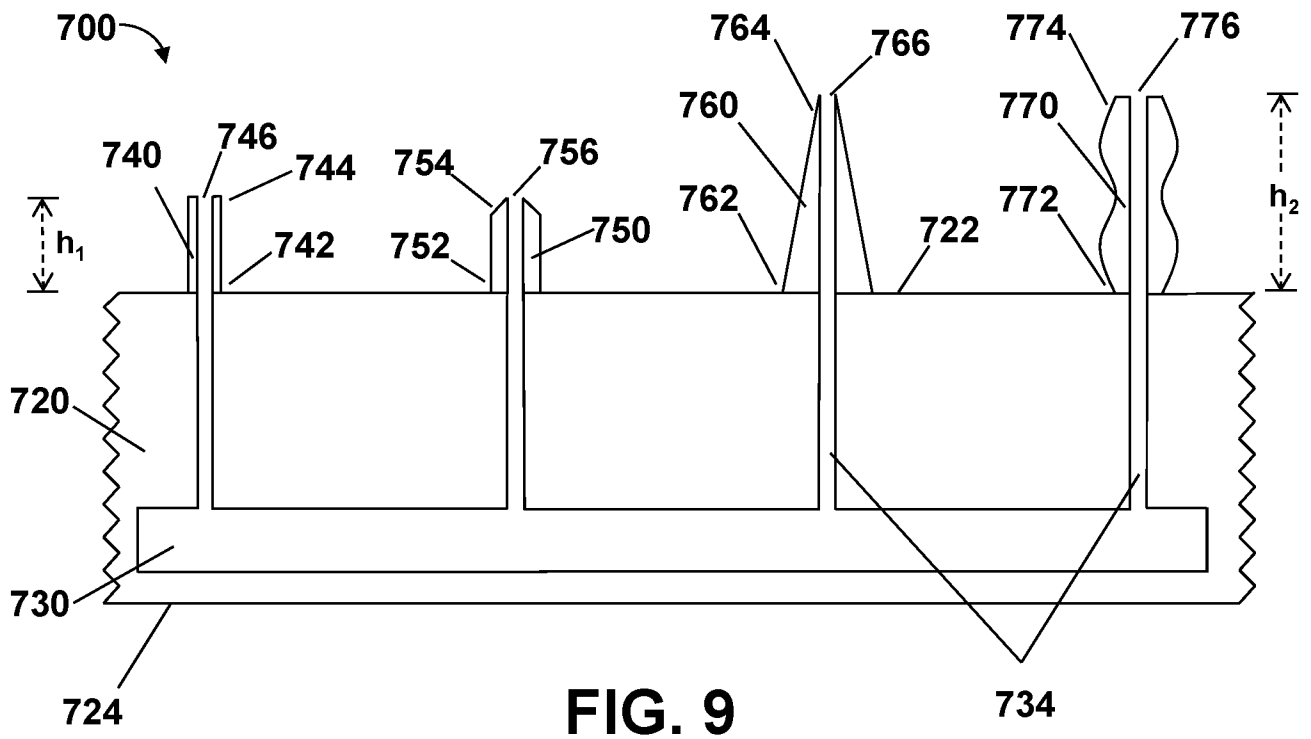
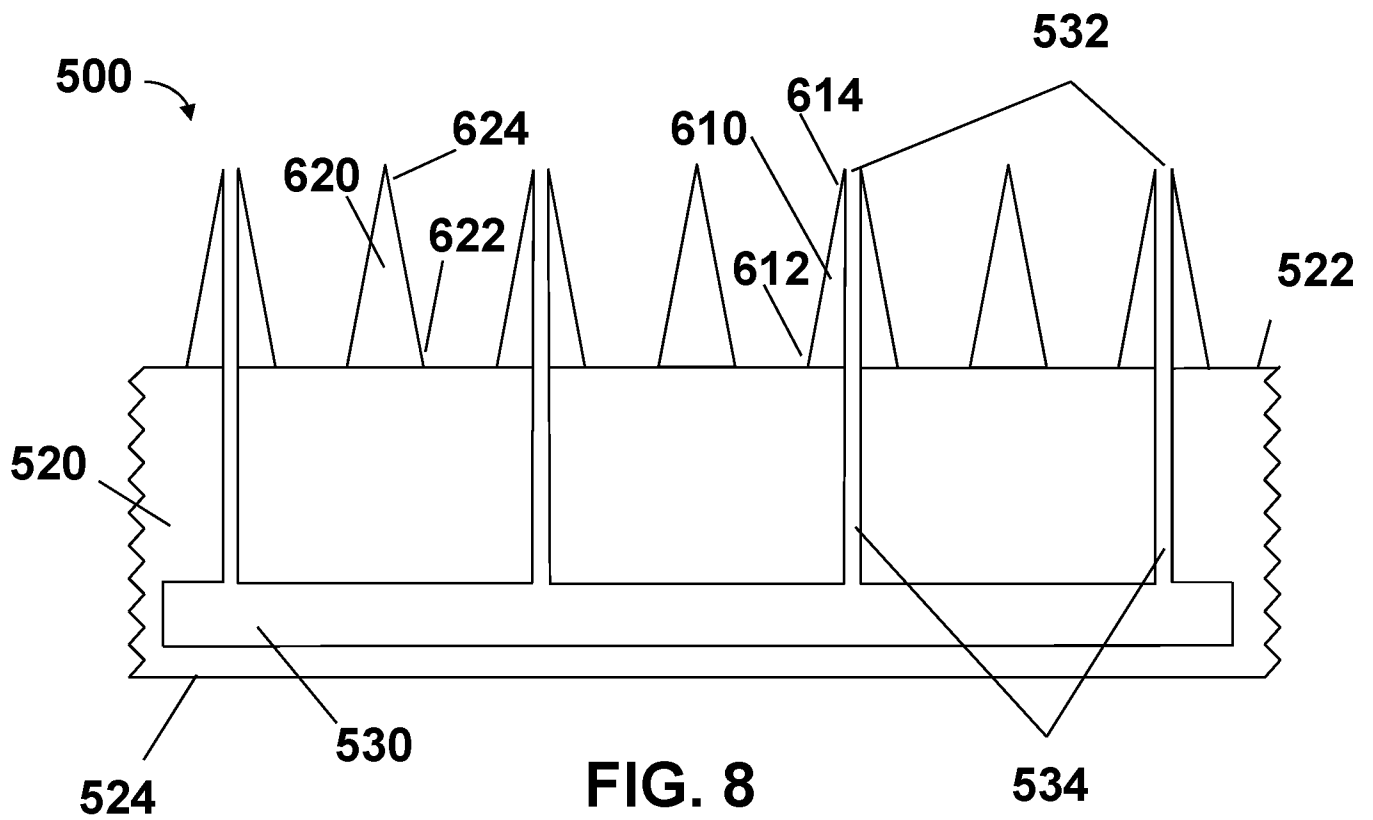
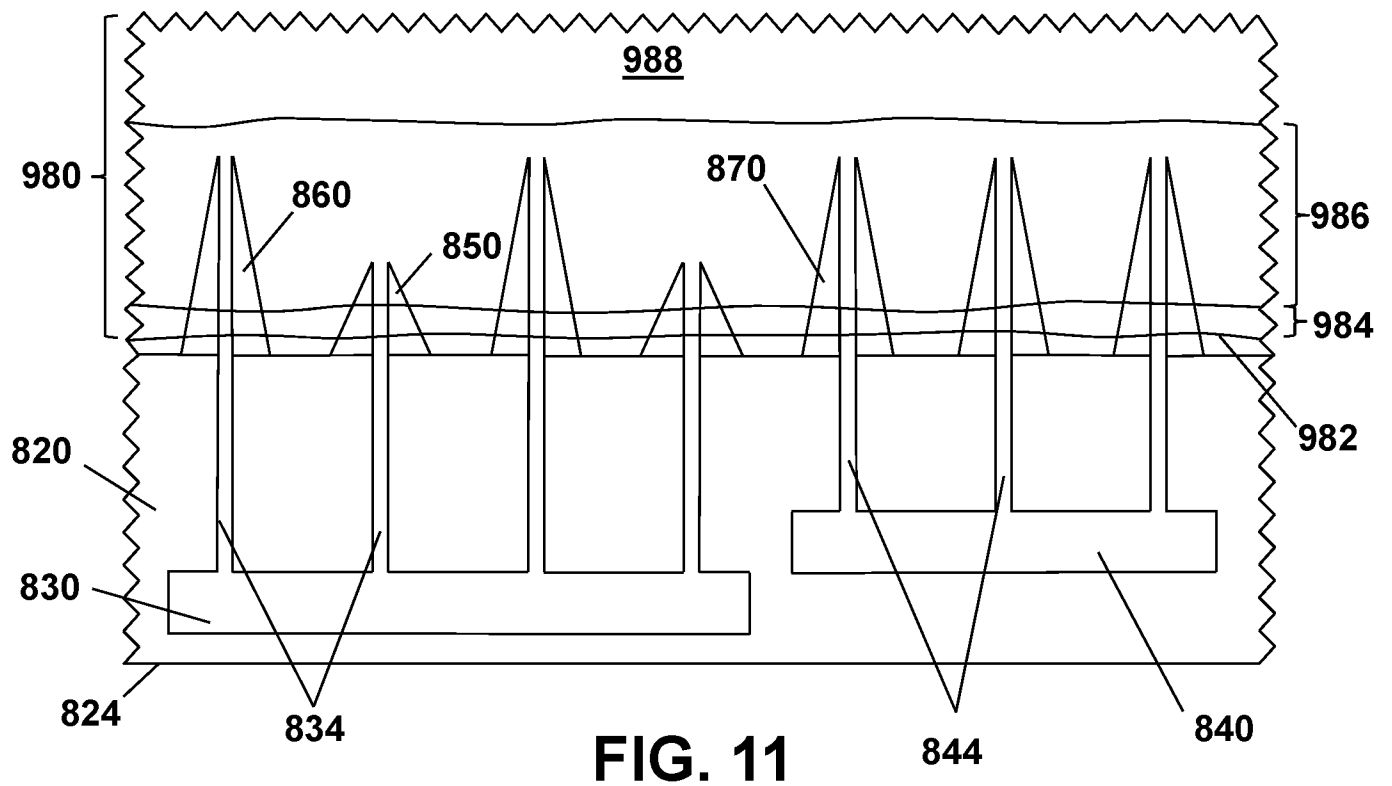
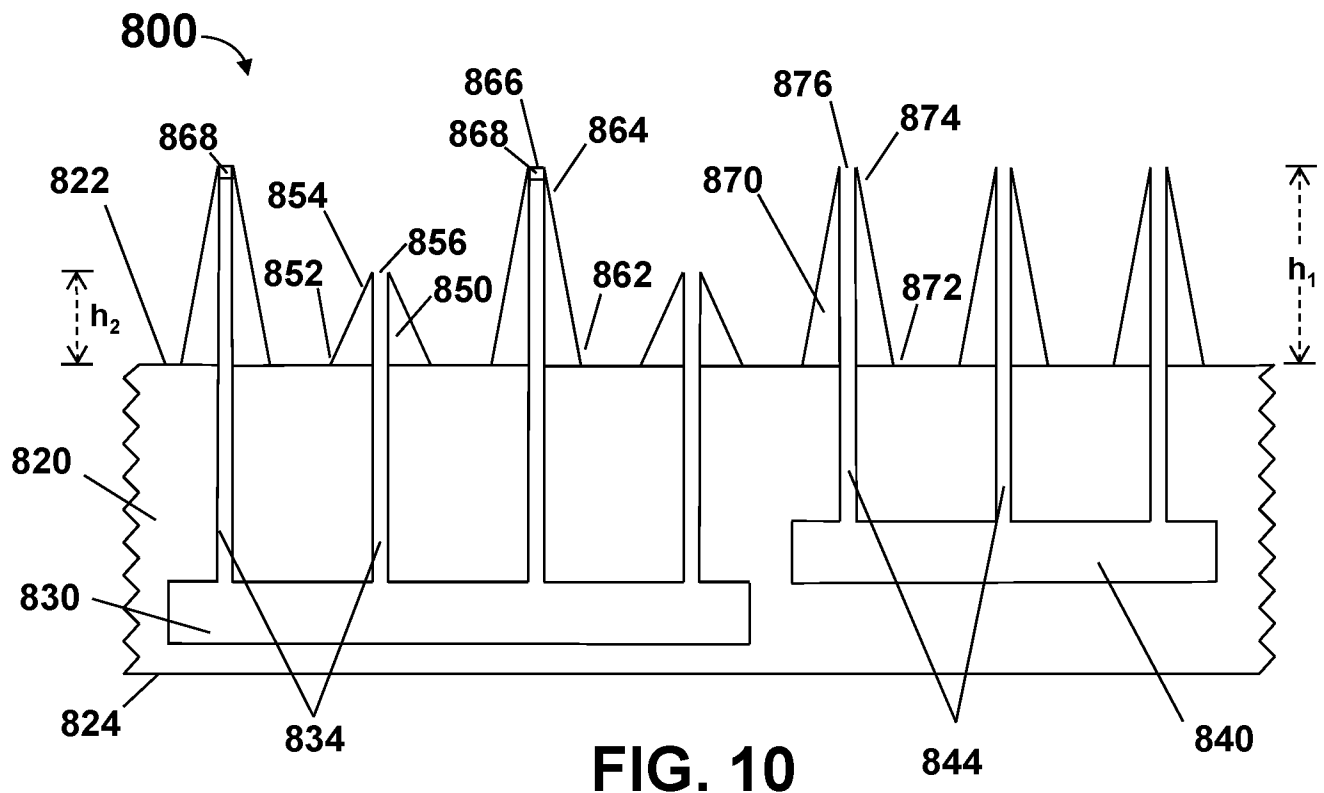


FIG. 5

**FIG. 6****FIG. 7**





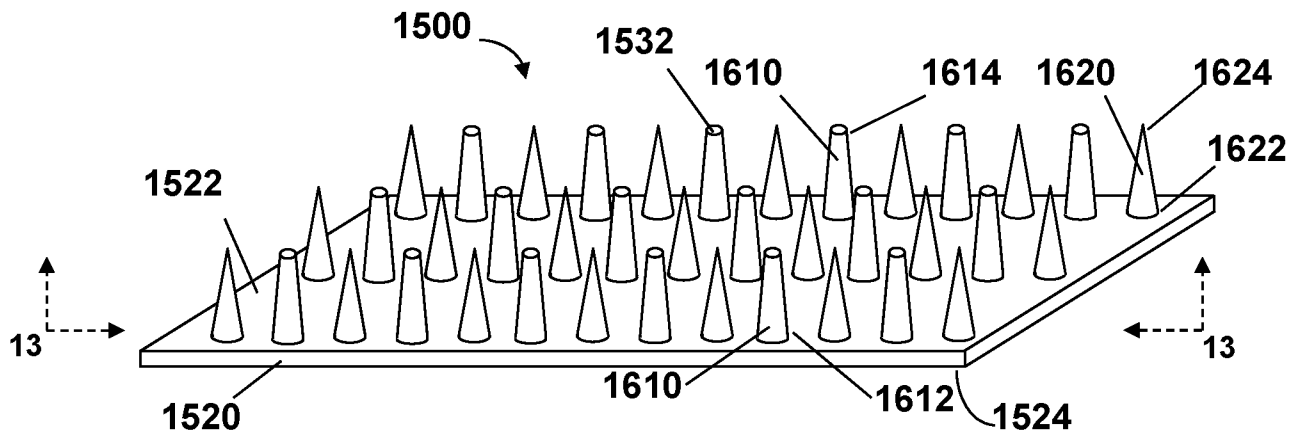


FIG. 12

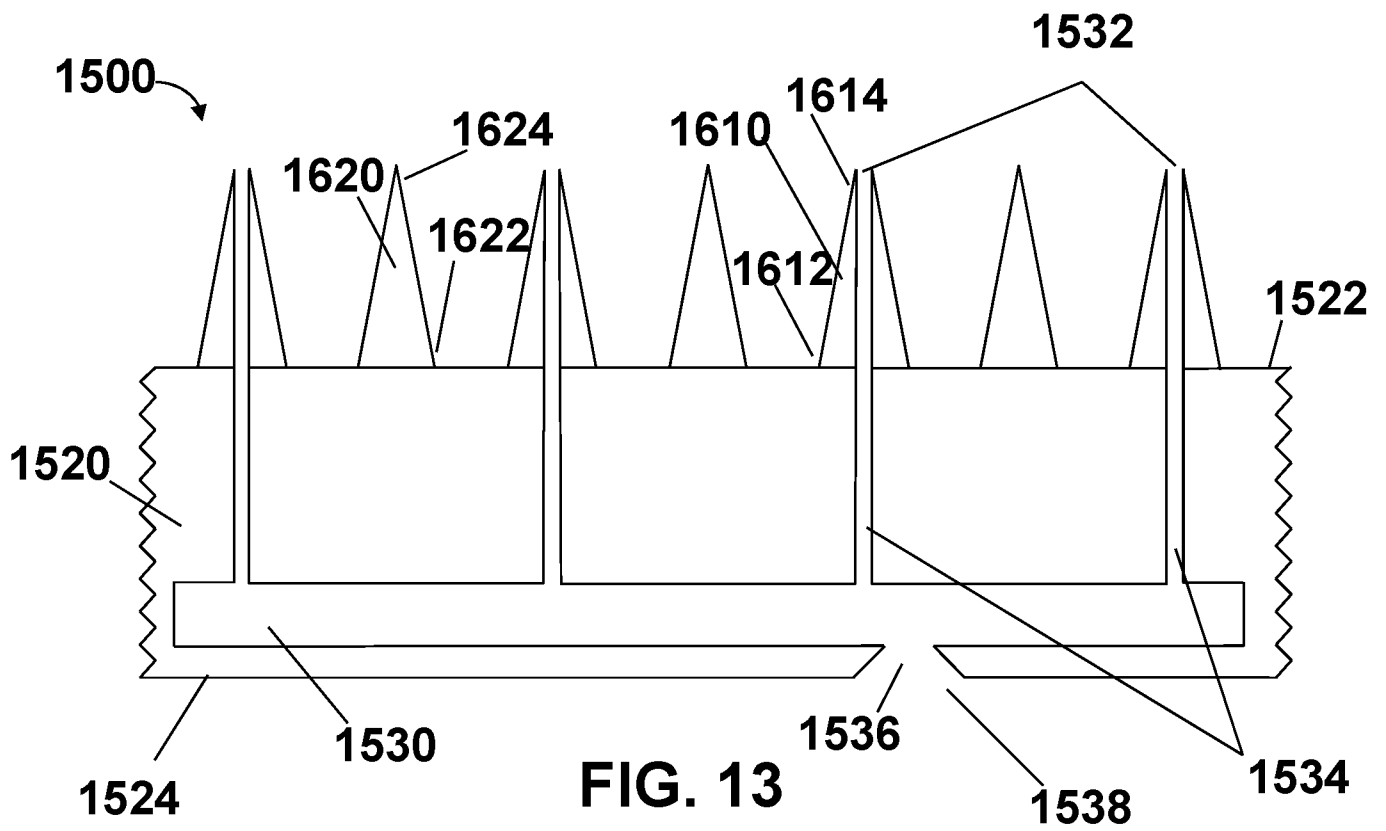


FIG. 13

INTERNATIONAL SEARCH REPORT

International application No
PCT/IB2019/055531

A. CLASSIFICATION OF SUBJECT MATTER
INV. A61K31/137 A61K31/167 A61K31/192 A61K31/495 A61K31/439
ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
A61K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

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X	US 6 611 707 B1 (PRAUSNITZ MARK R [US] ET AL) 26 August 2003 (2003-08-26) claim 19; figures 1-3,4a -----	1-34
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Further documents are listed in the continuation of Box C.



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Date of the actual completion of the international search

6 December 2019

Date of mailing of the international search report

19/12/2019

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INTERNATIONAL SEARCH REPORT

Information on patent family members

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