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(54) **HPLC COLUMN**

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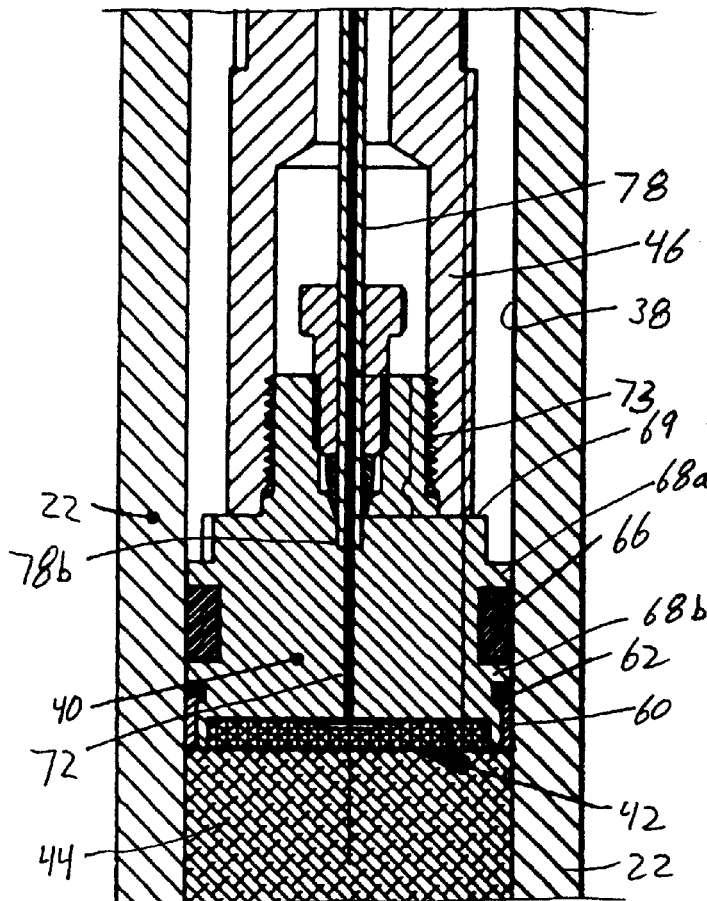
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(57) **ABSTRACT**

A slurry chamber is fastened to and held in coaxial alignment with a chromatography column by a V-band. One end of the column has an end cap and frit. A slurry of fluid and chromatographic media is placed in the column and chamber. A piston is forced through the chamber and into the column by a hydraulic ram to expel the fluid and form a media bed in the column. The slurry chamber is removed, and a split end cap is fastened to the column. A threaded recess in the split end cap receives a split, threaded collet. The collet is tightened until it pushes against the piston with the same force as the ram, at which point the ram is released and the column removed for use.



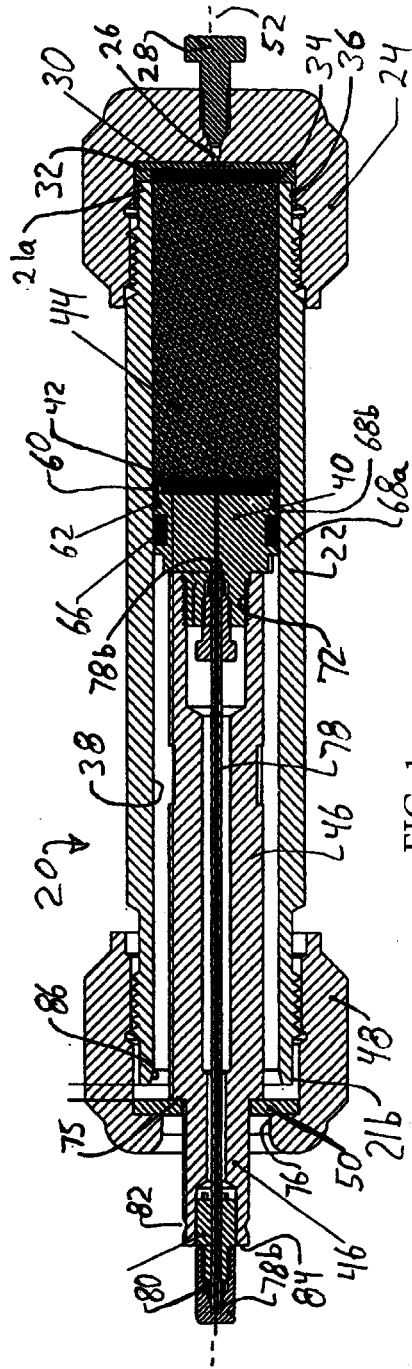


FIG. 1

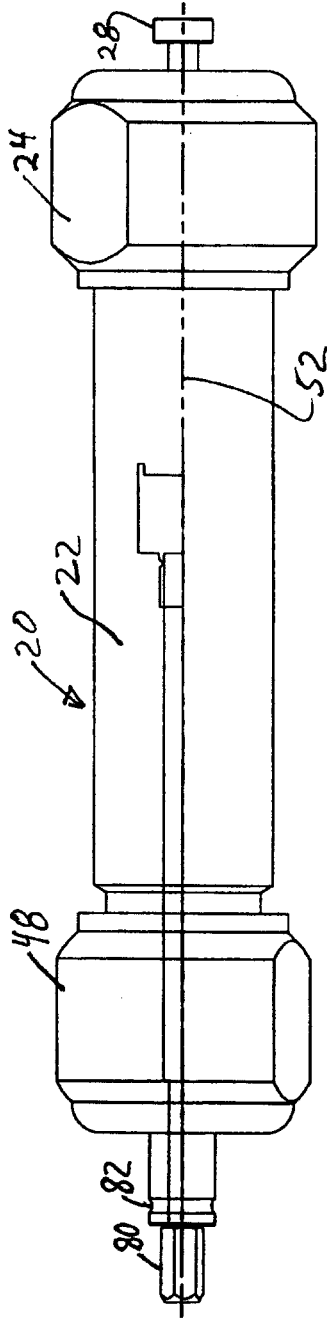


FIG. 2

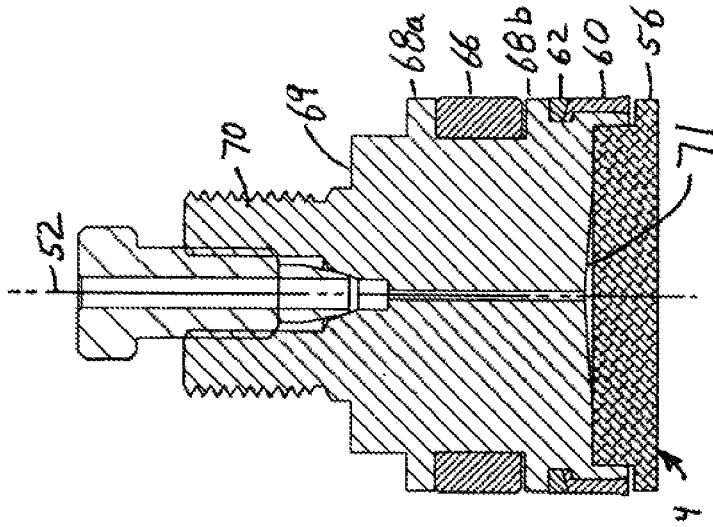


FIG. 3A

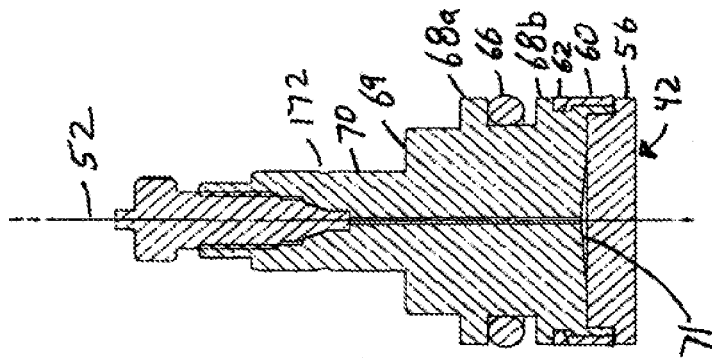


FIG. 3B

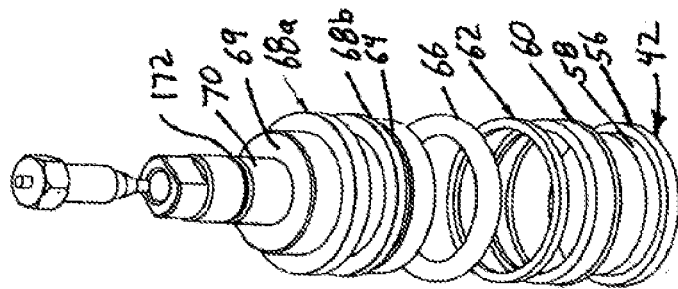


FIG. 3C

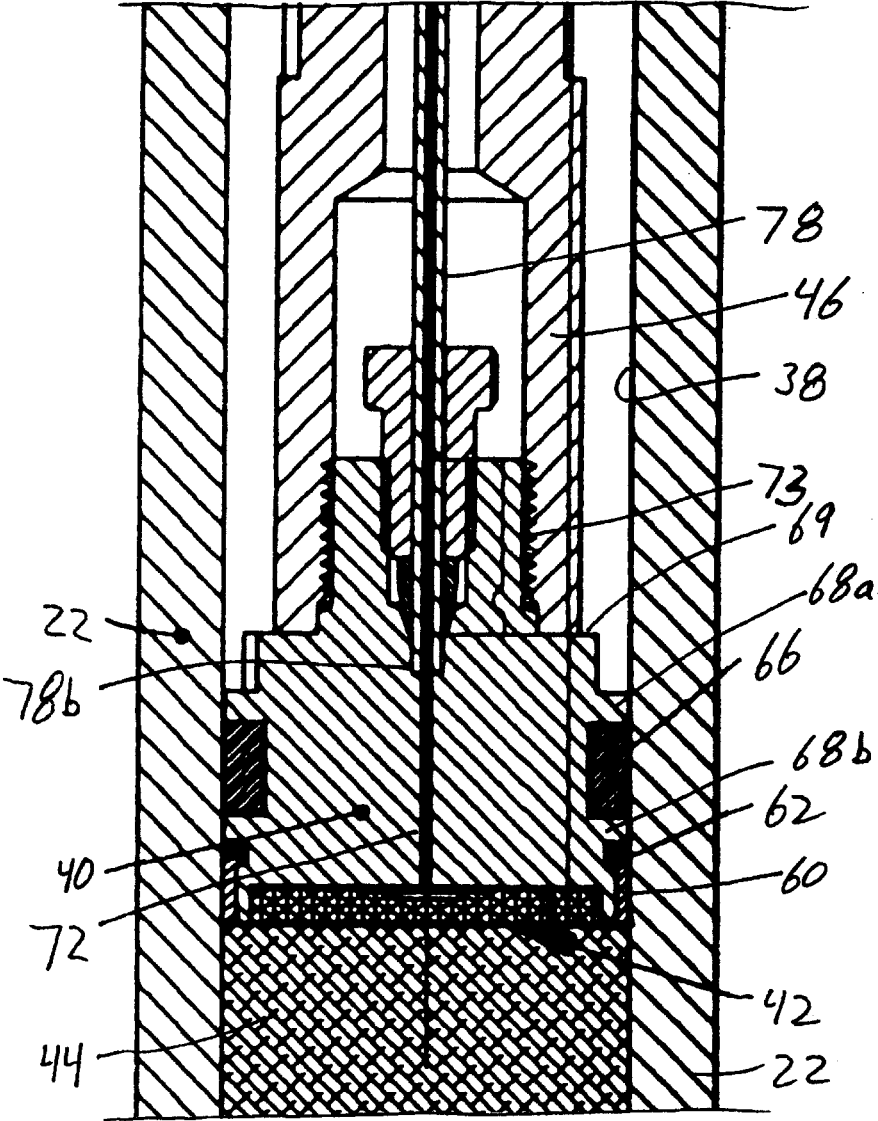


FIG. 4

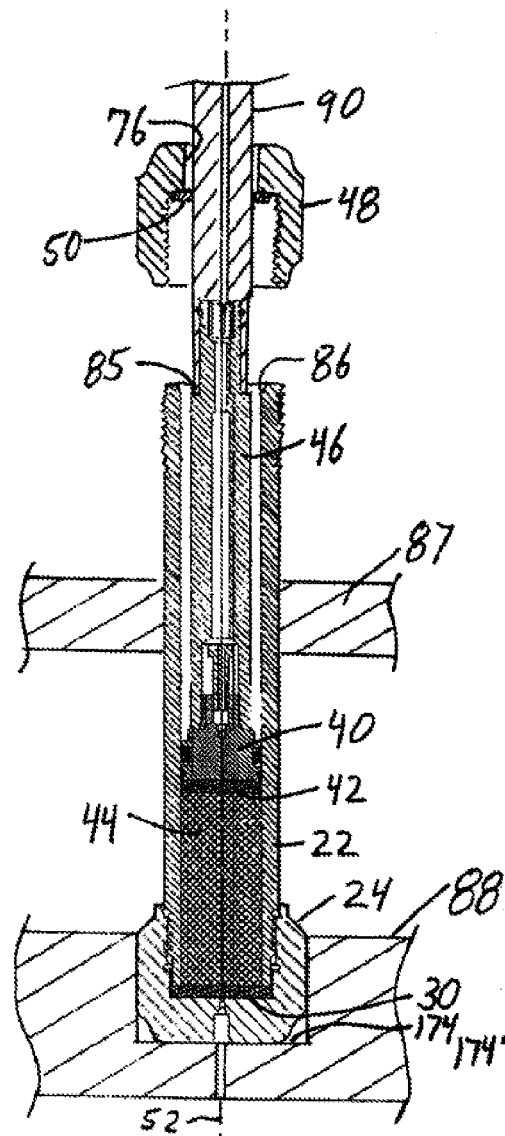


FIG. 5

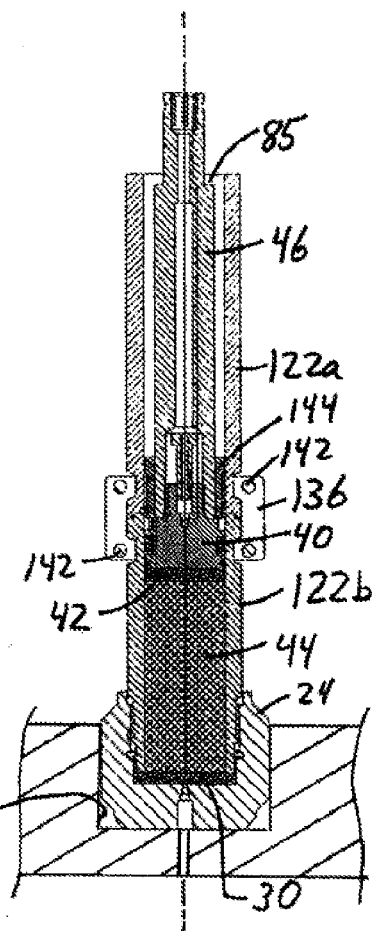


FIG. 11

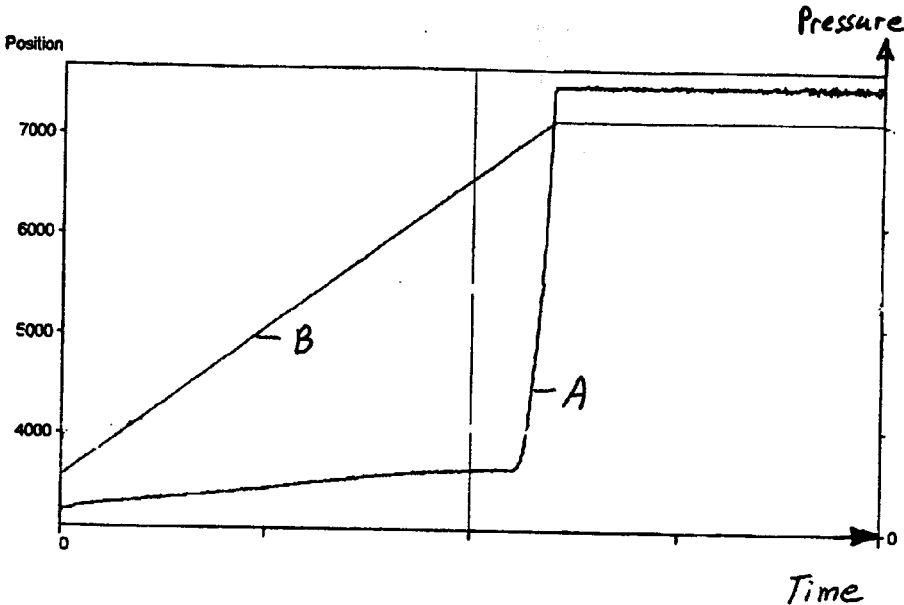
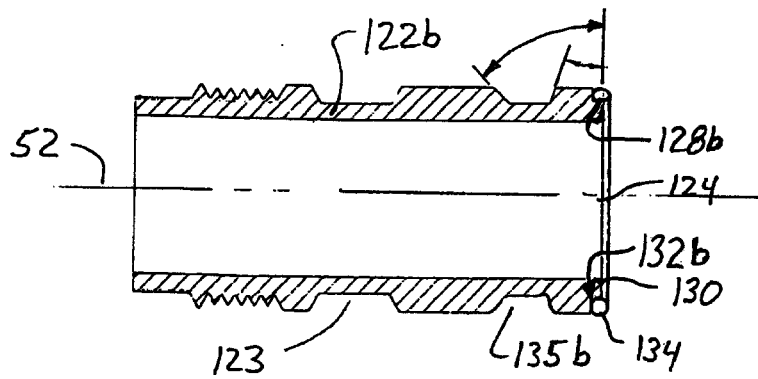
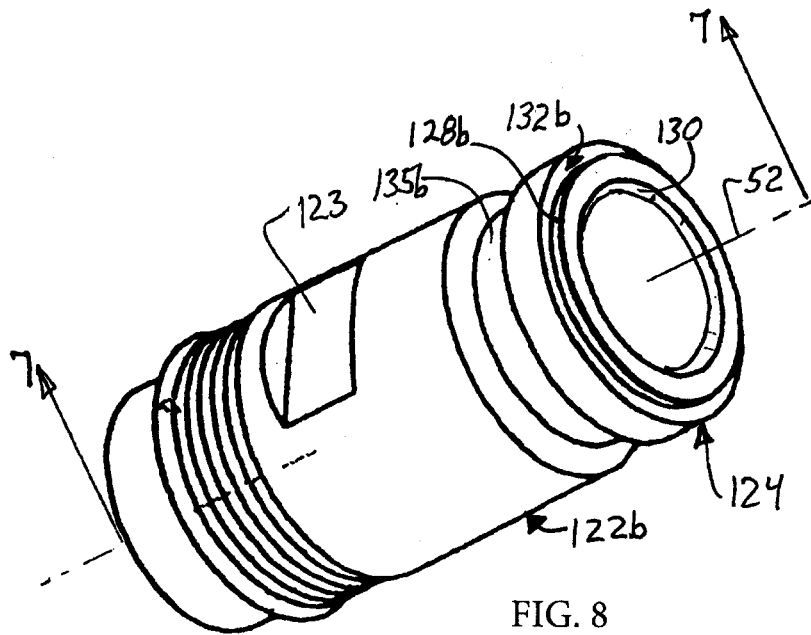
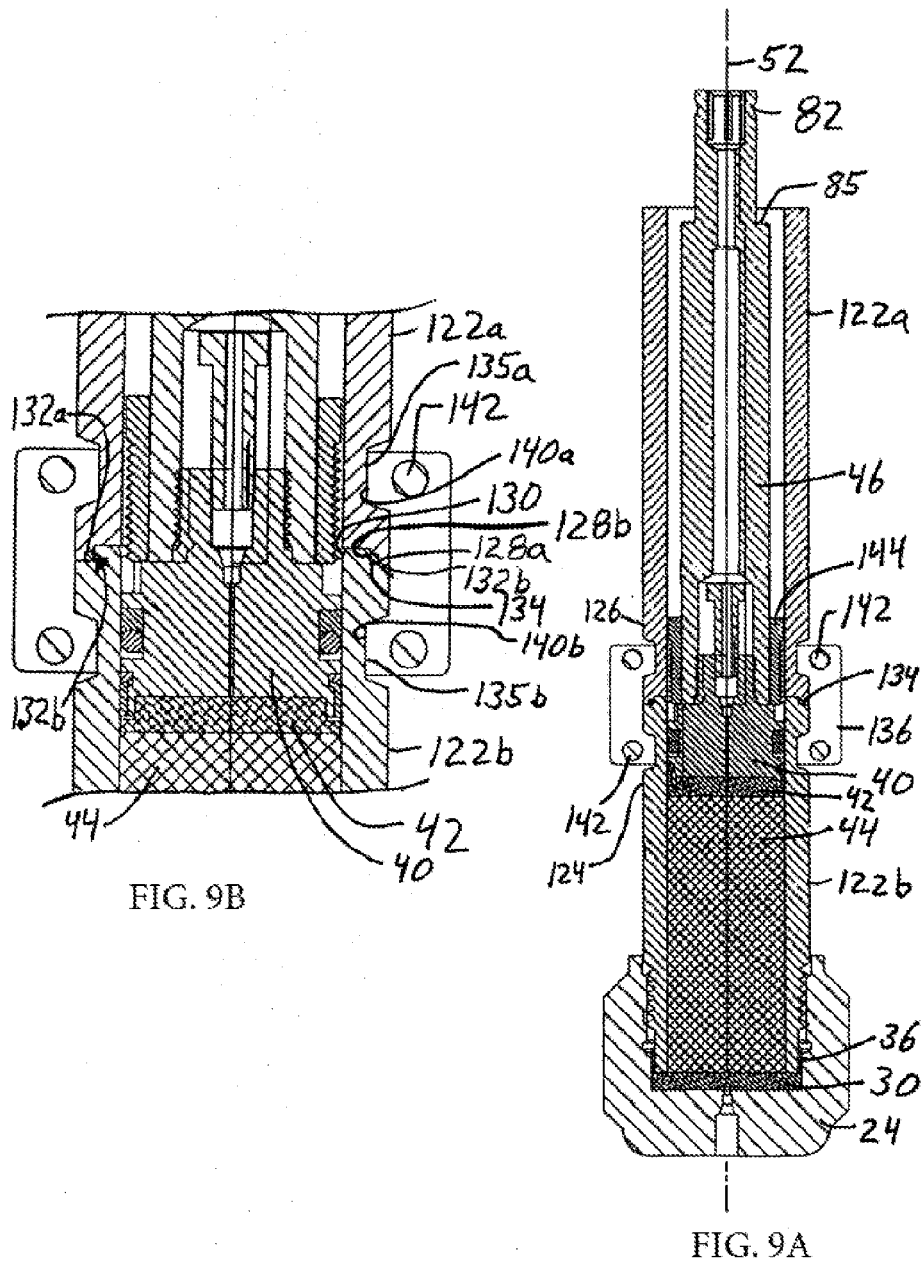


FIG. 6





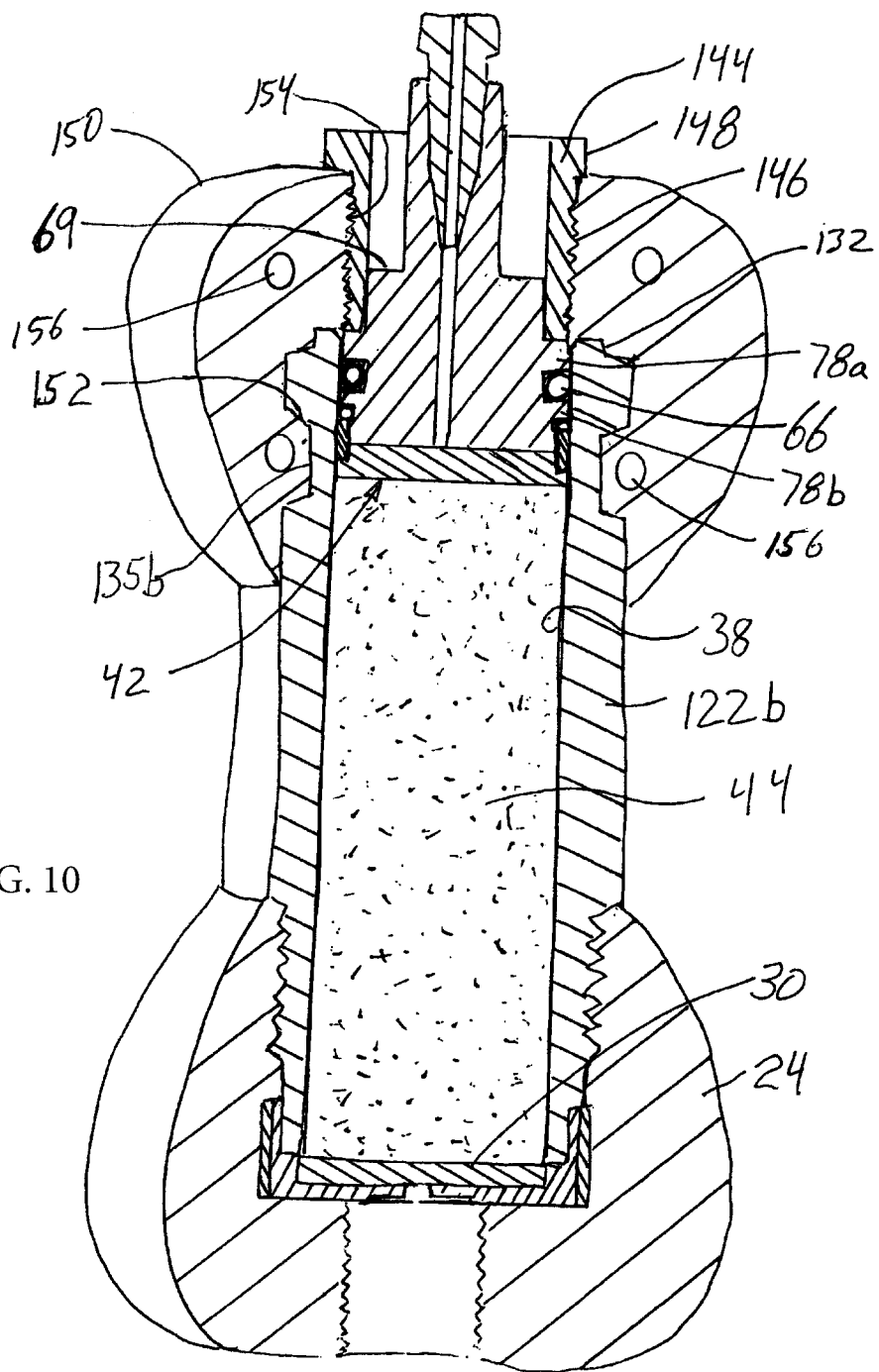


FIG. 10

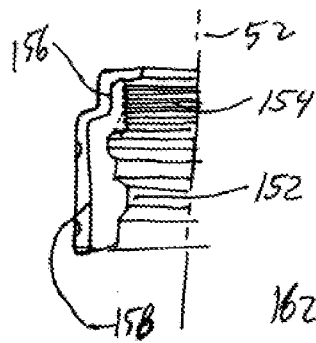


FIG. 12

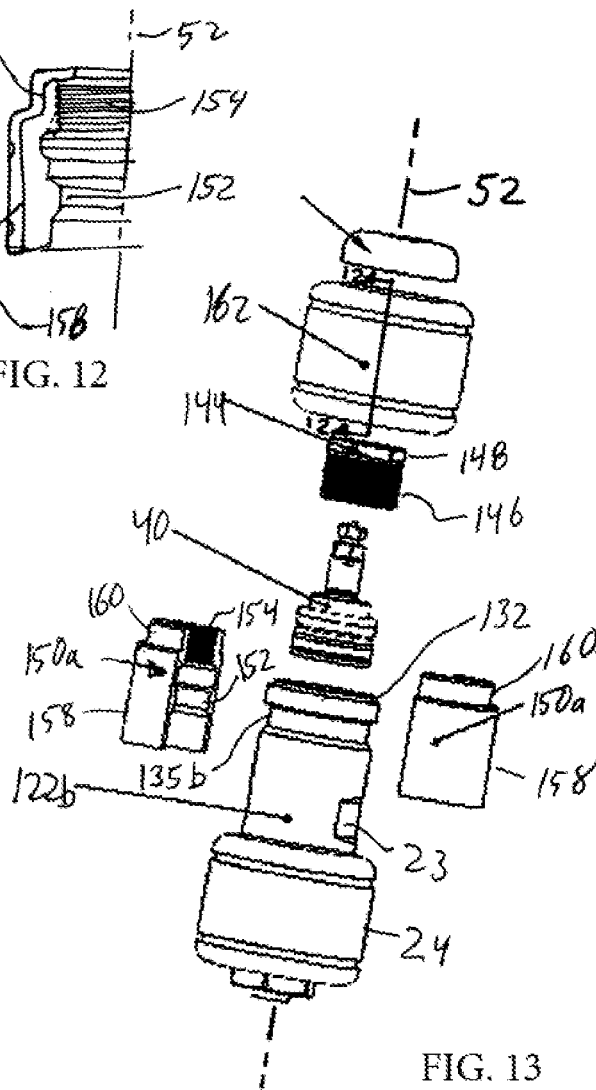


FIG. 13

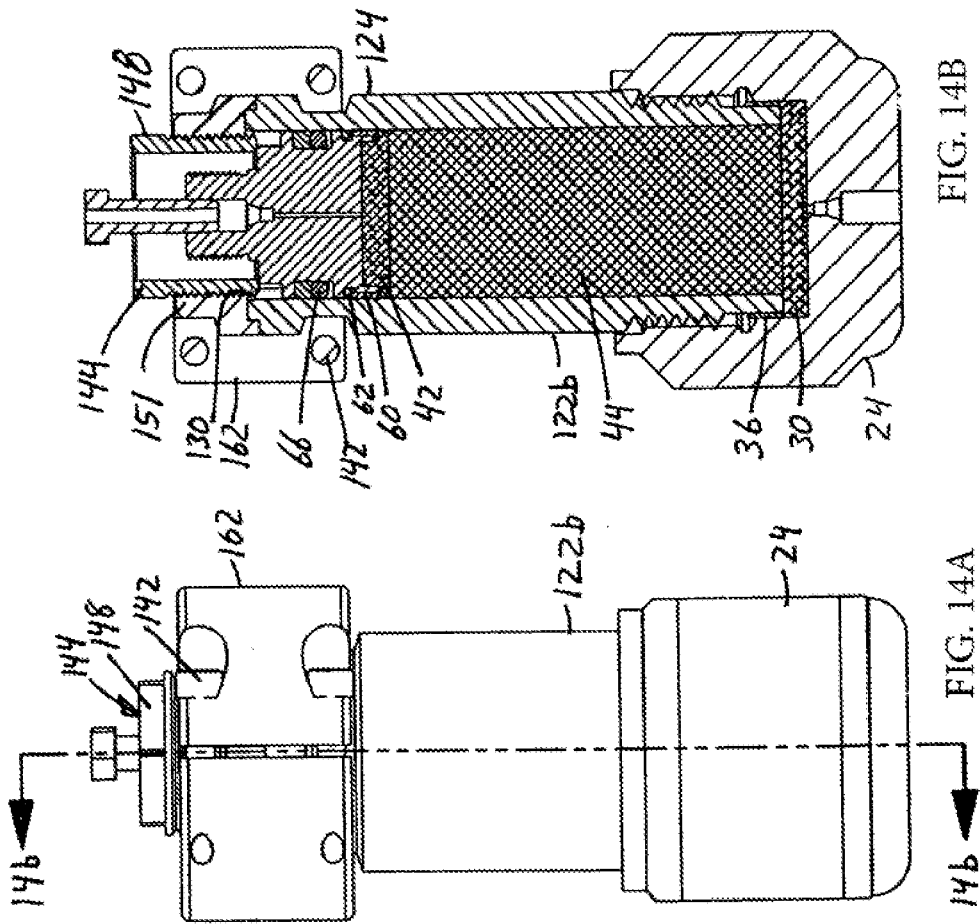


FIG. 14B

FIG. 14A

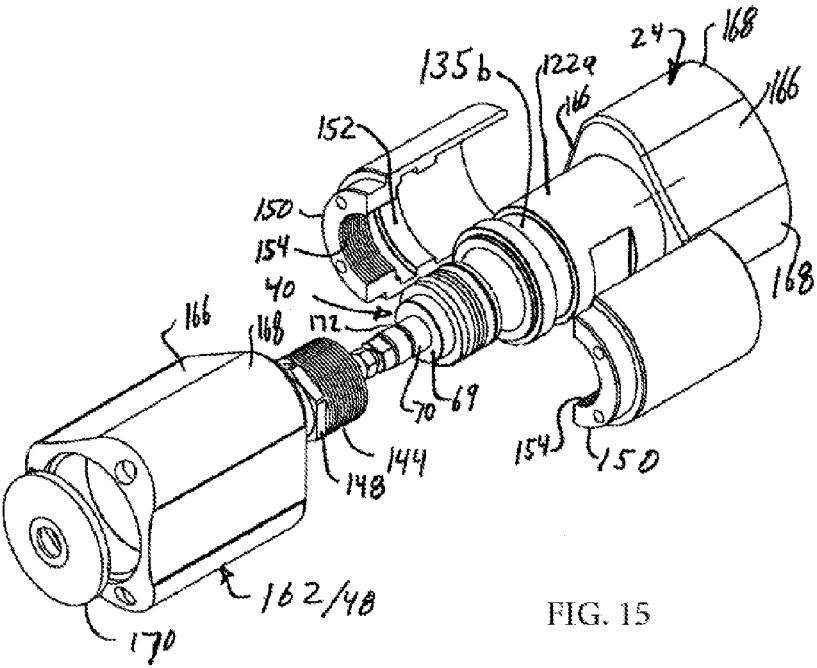


FIG. 15

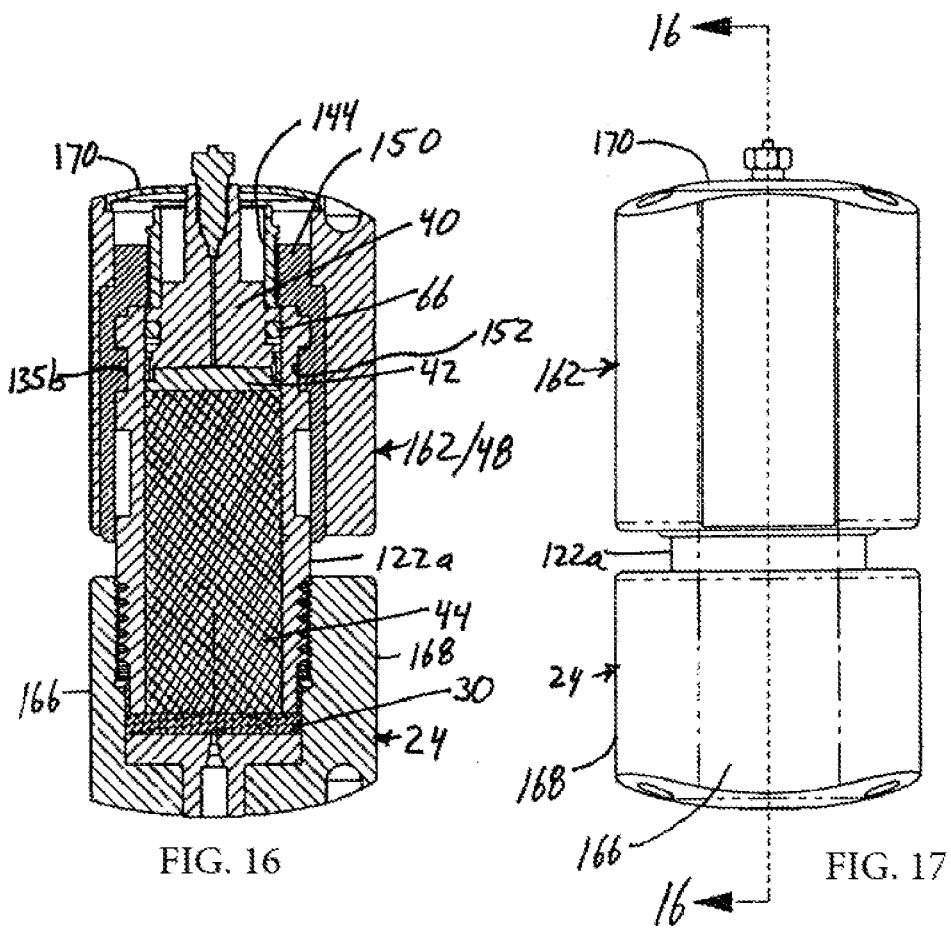


FIG. 16

FIG. 17

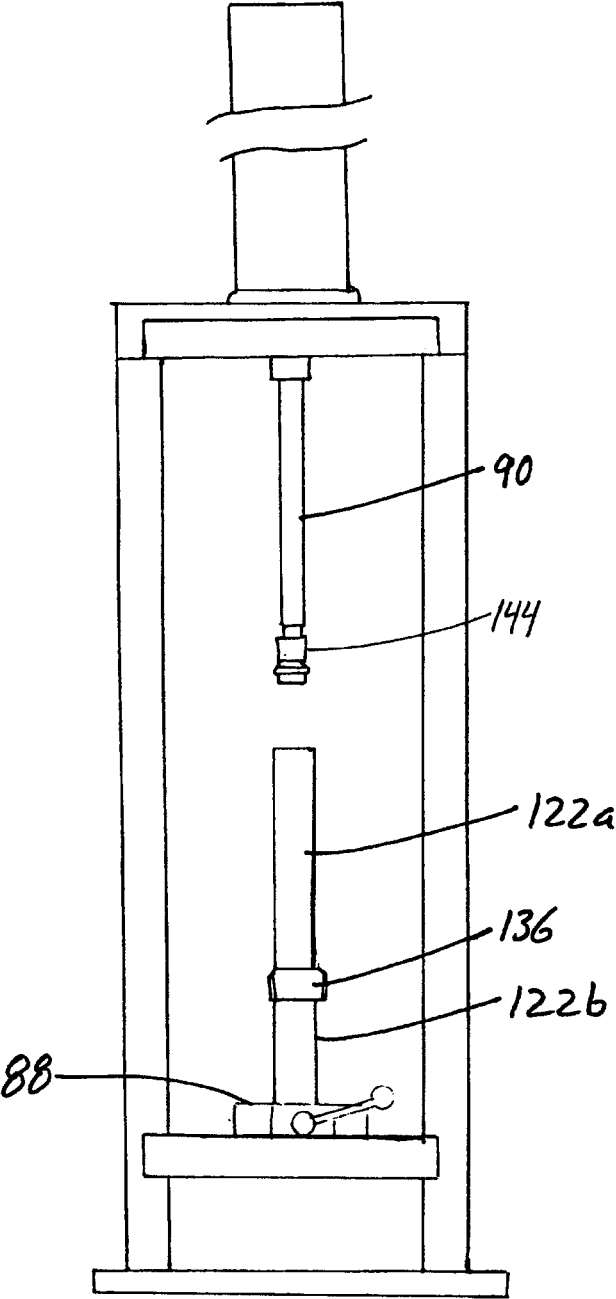


FIG. 18

HPLC COLUMN

BACKGROUND OF THE INVENTION

[0001] This application relates to a method apparatus for packing tubular columns with particles, such as packing HPLC columns with media.

[0002] Liquid Chromatography is a method for the separation of compounds from a mixture by encouraging a different distribution between the solid particles in the stationary phase of a column and the liquid phase that is passed through the column. The column packing material needs to be well packed and uniformly packed to provide a consistent surface for the separations to occur. Depending on the individual compounds affinity for the column packing material compared to the affinity for the liquid passing through the column determines the difference in time that the compounds reside inside the column. After the compounds exit the column, they are either detected (analytical liquid chromatography) or the compounds are individually collected (preparative liquid chromatography). For the chromatographic separations to be carried out efficiently the column packing material bed must be uniformly and densely dispersed in the column with no channels or voids or stratification of the media that would create re-mixing of the separated compounds.

[0003] To achieve this high performance, liquid chromatography columns are generally formed by dispersing or suspending the spherical or irregular chromatographic particles in a suitable solvent creating a slurry. The slurry is placed inside the column tube and the particles are settled to form the column bed by exerting a force onto or through the slurry. This force causes the particles to sediment or "pack" into the column tube. During the packing process, the slurry solvent evacuates through a porous disk called a "frit" which is sufficiently porous to allow liquid to evacuate, but retain the chromatographic particles. As the slurry solvent is evacuated, the chromatographic particles are compressed into a uniform and dense "bed", and the column is then ready for use.

[0004] Compressing or packing the column bed is achieved by one of two methods. One common technique of forming chromatographic beds is to produce a slurry inside the column and then using high solvent flow through the column to push the particles towards the outlet of the column. To produce these columns using the slurry technique, the chromatographic column is open at the top during the packing process and this end is attached to one end of a slurry chamber. The chromatographic media slurry fills the slurry chamber and the column tube. The outlet end of the column holds the frit that retains the chromatographic media but permits the liquid to exit the column. The inlet end of the slurry chamber is attached to a high pressure, high volume pump that forces a liquid through the chamber. The high flow liquid forces the particles to migrate towards the exit of the column and the chromatographic media is slowly compressed into a uniform and dense bed.

[0005] The slurry technique requires high-pressure pumps to provide the liquid flow until the bed is packed, which may take as long as one hour. This relatively long packing time at high flow significantly increases cost of the final column due to large volume of solvent required, and reduces manufacturing throughput. Once the chromatographic bed is formed, the packed column tube is removed from the slurry chamber and a permanent end fitting is placed onto the

column. Another major disadvantage with this high pressure high flow rate slurry packing technique is that the chromatographic media is subjected to very high pressures during the packing process to form the compressed chromatographic bed but this pressure must be released when the column is removed from the slurry chamber. When the pressure is removed from the column, the compacted chromatographic media decompresses or relaxes and the chromatographic bed expands and can move within the column tube. To close the column, the excess media is removed from the top of the column and another frit and end cap is placed onto the column tube to prevent anymore shifting or expansion of the packed bed. The bed shift and subsequent removal of the excess media causes a variable and somewhat reduced bed density, particularly at the head of the column. This variation and reduction in bed density creates performance problems such as settling or voiding of the bed, particularly when the column is operated under high flow rates. This phenomenon is most pronounced on columns that have a relatively low aspect ratio (length/internal diameter) of <25. Currently users in high throughput, high volume preparative applications experience reduced lifetimes with columns prepared using this slurry technique, especially when the column lengths are short due to the lower density beds.

[0006] An alternative technique to packing a column is the use of axial compression, as generally described in U.S. Pat. No. 5,893,971. However, most chromatographic columns packed by axial compression are integrated into a single system which includes both the column and the packing apparatus. The column itself is not removable from the system itself, meaning the column is operated as part of the system. Also, the column tube is only partially filled with chromatographic media as most of the tube volume is used as a slurry chamber. Furthermore, as the packing system and column are integrated into a single unit, cost and complexity are also higher.

[0007] A newer variation of axial compression packing is described in U.S. Pat. Nos. 5,951,873 and 6,036,755. The column can be removed from the packing system by incorporating a removable spring-rod and piston that maintain active pressure on the column bed. But even this system requires a relatively long column tube, even if the desired bed length may be only $\frac{1}{3}$ to $\frac{1}{4}$ that of the overall column length. The reason for this is that a significant portion of the overall column tube length is required simply to accommodate the uncompressed slurry prior to compression and/or the spring assembly. Thus the design suffers from long and sometime very heavy column assemblies that are inconvenient, impractical and difficult for operators to use in a typical laboratory or purification lab.

[0008] These designs are especially impractical in high-throughput purification laboratories where 4-8 columns may be run in parallel, and/or where space is limited. Furthermore, the high cost of the column hardware of this longer and more complex design limits their acceptance in high use or high-throughput environments as they become too costly to operate in large numbers.

[0009] Yet another disadvantage of some axial packed columns is that the frit diameter is much smaller than the column diameter. This reduced diameter is due to the space required for a seal or seal assembly that presses against the column wall to prevent leaking of solvent or media when high pressures are applied to the column during axial compression. This reduced diameter leaves an unused area

of the column near the outer walls where the frit does not cover the chromatographic bed and the sample is not applied to this area. With short bed columns the distribution of the sample across the entire surface is critical since the bed length is very short and the sample needs to be quickly and uniformly dispensed across the surface. In slurry packed columns the frit diameter is generally equal to or greater than the column diameter.

[0010] Therefore, there is a need for more compact, disposable column designs that can be produced by axial compression packing methods and components to improve lifetime and not be cumbersome for the chemist to use.

SUMMARY

[0011] A slurry chamber (tube) is fastened to and held in coaxial alignment with a chromatography column by a V-band. One end of the column has an end cap, and frit. A slurry of fluid and chromatographic media is placed in the column and slurry chamber. A piston abuts a stepped diameter frit, with the piston and frit forced through the chamber and into the column by a hydraulic ram to expel the fluid and form a media bed in the column. The slurry chamber is removed, and a split end cap or split retainer are positioned around the column and held in place by a sleeve (1 piece or 2 piece). A threaded recess in the split end cap or split retainer receives a threaded collet. The collet is tightened until it pushes against the piston with the same force as the ram, at which point the ram is released and the column removed for use. The frit preferably has a seal interposed between a smaller diameter of the frit and the adjacent column wall. Likewise, the piston has a stepped diameter, with a seal interposed between a smaller diameter of the piston and the adjacent column wall, with the smaller diameter preferably abutting the frit.

[0012] One aspect of the present invention relates to an improved method for the formation of economical and robust liquid chromatography columns by axial compression. Another aspect of this invention relates to a method for removing the slurry chamber while maintaining axial compression on the bed resulting in a column that is compressed but shorter and less complex than traditional axial packed columns while maintaining the flexibility to accommodate bed length variation. A further aspect of this invention significantly reduces the amount of solvent and production time required to pack the column bed compared to the slurry packing technique.

[0013] There is advantageously provided a removable slurry/pre-compression chamber. A segmented column or chamber assembly is used that includes a first segment, which is a slurry pre-compression chamber, and a second segment, which is the column chamber. The first segment serves as a slurry and pre-compression chamber to accommodate the chromatographic slurry prior to packing, and during the initial stages of compression. A piston driven by a piston rod or piston sleeve assembly moves the piston towards the fixed end of the column chamber (second segment). The piston itself passes through the first segment and enters the second segment. The piston travels a short distance into the second segment until the media has been adequately compressed to form a stationary bed. The design allows the slurry pre-compression chamber (first segment) to be removed while the piston rod or piston sleeve applies force to the piston to maintain the bed compression. A securing mechanism can then be attached to secure the

piston in place, allowing the piston rod to be detached from the piston and removed. The ability to pack by axial compression, and then remove the slurry chamber while keeping the piston in place provides very desirable advantages.

[0014] The design also advantageously allows for small variations in final column bed length. A bed compression screw and a V-band clamp design provide fine adjustment of the piston position based on the final bed height achieved when the media is packed into the column. This ability to accommodate variable bed heights ensures that a set compression force can be maintained while accommodating variations (preferably small variations) in the amount of media packed in a column. A variation of up to about one inch (25 mm) in bed height is believed achievable with a given column length.

[0015] A two-stepped, hat shaped frit design is also advantageously provided. The frit design increases the amount of the column bed surface area covered by frit allowing quicker dispersion of the sample across the column bed. Older axial compression designs use a piston seal to engage the column wall and the frit was smaller in diameter than the column bed. The older design leaves an area between piston assembly and the wall that was not available for separations. The two-stepped, hat-shaped frit design is very useful for short bed length columns where the sample must be dispersed across the media as quickly as possible. This frit design is also believed to provide advantages for longer length columns.

[0016] There is also provided a mechanism and method for maintaining axial compression on the column bed while the slurry chamber is removed and replaced by a bed compression mechanism, such as a screw. Advantageously, the column bed is not allowed to relax or expand after packing. The compacted bed is compressed once during the packing process and this pressure is maintained when the inlet end fitting is attached. This avoids the need for springs to maintain the bed compression.

[0017] In one aspect of this invention there is provided a portable tubular chromatography column having a tubular body with an inner diameter with first and second ends covered by first and second end caps, respectively. The column has a bed of chromatographic media placed between a first and second frit all located inside the body. A piston abuts the first frit and exerts a predetermined pressure on the bed. An adjustable locking mechanism has a support fastened to the body and has a threaded adjuster interposed between the support and the piston such that rotation of the threaded adjuster increases or decreases the force the piston exerts on the bed.

[0018] In a further variation of this above described embodiment the support clamps to an exterior of the body, and preferably forms a V-band clamp. Further, the threaded adjuster optionally comprises a collet having one end abutting the piston. Advantageously, the collet has multiple lead threads, with two leads being preferred. In a further variation the support comprises a split end cap that is clamped to the body. The split end cap can optionally enclose one end of the tube or chamber and is optionally held together by an encircling structure. Preferably the split end cap has a threaded recess therein to receive the adjustable fastener. The recess also preferably has multiple lead threads. Further, the collet preferably has a wrenching surface.

[0019] In further variations, the frit extends to adjacent the inner diameter of the column body with no seal interposed

between the frit and the column wall. The frit preferably has a first diameter about the same as but slightly smaller than the inner wall with no seal interposed between the frit and the inner wall. Advantageously, the frit has first and second concentric diameters with the diameter of the frit abutting the media being the first diameter and being larger than the second diameter. The piston preferably has at least one seal interposed between the piston and the inner wall with at least one seal selected to provide a seal at fluid pressures of several thousand psi. Moreover, a portion of the piston preferably extends outside an end of the tubular body.

[0020] In a further aspect of this invention, a new frit is provided. The frit is preferably, but optionally for use with a chromatography column having a tubular body with a cylindrical interior having a first diameter. The frit has a first cylindrical portion having a diameter about the same as but slightly smaller than the first diameter of the column. The frit has a second cylindrical portion having a smaller diameter, with the first and second portions being concentric. In further variations the frit is integrally and unitarily formed from a single piece of material, or alternatively the frit is formed from two abutting frits of different diameter.

[0021] In a further aspect of this invention there is provided a method for packing a tubular chromatographic column having a first and second opposing ends defining a first length and having an end cap on the first end of the column. The column has an interior diameter. The method includes abutting a slurry chamber to the second end of the column and coaxially with the column and forming a fluid tight seal between the slurry chamber and the second end of the column. A slurry is placed in the column tube and slurry chamber, with the slurry containing fluid and chromatographic media. A piston is placed in the slurry chamber, with the piston having seals interposed between the piston and the slurry chamber and a frit interposed between the piston and the slurry. The piston is advanced through the slurry chamber and at least part way into the column. Advancement of the piston is stopped when the media in the slurry forms a bed that is compacted to a desired pressure or length.

[0022] In a preferred form, the method includes locking the piston to the column. More preferably the method includes removing the slurry chamber and locking the piston to the column without releasing the pressure on the bed. Advantageously, the frit comprises a stepped disk having first and second concentric and different diameters with a larger diameter abutting the slurry. More preferably, a seal is interposed between the smaller diameter and the inner diameter of the column and no seal is interposed between the larger diameter and the inner diameter of the column. Further, a chamfer is preferably formed on an interior edge of the second end of the column, although the chamfer is optional and can especially be omitted if the mating parts are sufficiently concentric.

[0023] In a further preferred variation, the method includes removing the slurry chamber while maintaining the position of the piston and placing two parts of a split end cap over the second end of the column, where the end caps each have a portion of a threaded recess formed therein. A split, threaded collet or split piston retaining ring with a threaded recess is fastened to the second end of the column. An outside collar is placed over the piston retaining ring and fastened in place. Finally, the threaded collet is advanced in the recess until the collet holds the piston in place.

[0024] In a preferably variation on this later preferred method, advancing the piston comprises placing a hydraulic ram in contact with a shoulder on the piston and advancing the hydraulic ram. The slurry chamber can be removed from the column with the ram in place, after which the piston is locked in place, with the ram position being maintained until the slurry chamber is removed from contact with the column and until the piston is locked in place. After completion of packing and locking the piston in place, the column is removed from the ram, and the outlet in the first and second ends of the column are plugged. In further variations of the above methods, forming the fluid tight seal includes placing a V-band clamp over the juncture of the slurry chamber and the column. The locking step also can include placing a V-band clamp around the second end of the column.

[0025] In a further aspect of this invention, a multiple segment chromatography assembly is provided. The assembly includes a slurry chamber having a first and second open end, the chamber having walls defining an inner cylinder of diameter D, and a chromatography column having an first and second opposing ends and an end cap over the second end. The second end of the slurry chamber abuts the first end of the column. The column has walls defining an inner cylinder of diameter D. An annular seal is placed in a recess formed in part in an exterior surface of the first end of the column and formed in part by an exterior surface of the second end of the chamber. A V-band clamp encircles the seal and cooperates with at least one of recesses or protrusions in the exterior of the chamber and column to hold the chamber and column in coaxial alignment.

[0026] In further variations of this apparatus a chamfer is formed on an interior edge of the first end of the column. Preferably a chamfer is also formed on an interior edge of the first end of the slurry chamber. A slurry of fluid and chromatographic media is placed in the chamber and column. A piston is placed in one of the chamber or column. The piston has at least one seal interposed between the piston and the cylindrical wall of the chamber or column in which the piston is located. Preferably, the piston extends at least part way into the column and the piston has a frit with a first diameter about diameter D and having a second, smaller diameter.

BRIEF DESCRIPTION OF THE DRAWINGS

[0027] These and other advantages and features of the invention will be better appreciated in view of the following drawings and descriptions in which like numbers refer to like parts throughout, and in which:

[0028] FIG. 1 is a sectional view taken along 1-1 of FIG. 2;

[0029] FIG. 2 is a plan side view of a chromatography column;

[0030] FIG. 3A is a cross sectional view of one embodiment of a piston and frit;

[0031] FIG. 3B is a cross-sectional view of a second embodiment of a piston and frit show in the piston and frit of FIG. 1;

[0032] FIG. 3C is an exploded perspective view showing a piston and frit of FIGS. 1 and 3B;

[0033] FIG. 4 is a partial sectional view illustrating the piston of FIG. 3B in a packed column;

[0034] FIG. 5 is a sectional view showing the configuration of a column of FIG. 1 held in a chuck and a recessed support plate before the packing of the column;

[0035] FIG. 6 is a graph showing how pressure on a bed of media increases as it is dynamically and hydraulically packed using the column of FIGS. 1 and 9;

[0036] FIG. 7 is a sectional view taken along 7-7 of FIG. 8;

[0037] FIG. 8 is a perspective view of a column of a further embodiment;

[0038] FIGS. 9A and 9B are a sectional view and an enlarged portion of that sectional view showing column and slurry chamber of FIGS. 7-8 held by a V-band;

[0039] FIG. 10 is a sectional view of a column of FIG. 8 packed with media and held by a piston locked in position;

[0040] FIG. 11 is sectional view showing the configuration of a column of FIGS. 7 and 9 held in a recessed support plate before the packing of the column;

[0041] FIG. 12 is sectional view taken along 12-12 of FIG. 13;

[0042] FIG. 13 is an exploded perspective view of a further embodiment of a locking mechanism for the column of FIG. 10;

[0043] FIG. 14A is a plan view of a further embodiment of a packed column;

[0044] FIG. 14B is a sectional view taken along 14b-14b of FIG. 14A;

[0045] FIG. 15 is an exploded perspective view of a further embodiment for locking the piston to the column;

[0046] FIG. 16 is a sectional view taken along 16-17 of FIG. 17;

[0047] FIG. 17 is a side plan view of the column of FIG. 15; and

[0048] FIG. 18 is a side plan view of a press holding the assembly of FIG. 9A before the media is packed.

DETAILED DESCRIPTION

[0049] Two primary embodiments are shown, with the first embodiment using a single-piece, longer body and the second embodiment using a two-piece, segmented body.

[0050] Referring to FIGS. 1-4, a chromatography column 20 is provided having a tubular body 22 that is preferably cylindrical and has opposing downstream and upstream ends 21a, 21b (also referred to as first and second ends, respectively). A downstream end cap 24 (also referred to as first end cap 24) is fastened over the first, downstream end 21a, preferably the downstream or outlet end. The first or downstream end cap 24 preferably, but optionally, is cup-shaped and has a generally flat end with a tubular skirt having interior threads that mate with exterior threads on the outside of the tubular body 22 to fasten the downstream end cap 24 to the body. An outlet 26 is formed in the generally flat end of the downstream cap 24 and a threaded plug 28 engages mating threads on the outlet passage to releasably block the outlet 26.

[0051] A first frit 30 (also referred to as downstream frit 30) is placed in or over the first, downstream end 21a and held in place by the first or downstream end cap 24. A cup-shaped frit holder 32 is preferably, but optionally interposed between the first or downstream frit 30 and the first or downstream end cap 24. The frit holder 32 has a generally flat end with a two-stepped skirt forming a first, smaller diameter recess 34 into which the frit nests during use, and forming a second, larger diameter recess 36 which receives a stepped end, downstream end 21a of the tubular body 22. A lip on the distal portion of downstream end 21a abuts a shoulder formed between the different diameters of the

recesses 34, 36 to form a seal, with the larger diameter recess 36 overlapping the (stepped) downstream end 21a to form a further seal. The first or downstream end cap 24 holds the frit holder 32 and first or downstream frit 30 in place and in sealing engagement with the first or downstream end 21a of tubular body 22. The frit holder 32 has an outlet aligned with outlet 26.

[0052] The interior of the tubular body 22 preferably has a cylindrical cavity 38 within which slides a piston 40 has a downstream end that preferably, but optionally, abuts a second frit 42. Between the frits 30 (downstream), 42 (upstream) is a media 44 typically forming a stationary phase for chromatographic analysis. The media typically comprises silica or polymer particles coated with various chemicals suitable for chromatographic analysis.

[0053] The piston 40 is urged against the upstream frit 42 and media 44 by piston sleeve 46 that in turn is held in place by second end cap 48 and thrust washer 50 as described in more detail below. The column 20 has a longitudinal axis 52 that preferably extends through the center of the piston 40. As used herein, the downstream end or direction refers to a direction along longitudinal axis 52 as used during packing, and in the illustrated embodiments that direction is from the end cap 48 toward the first or downstream end cap 24, and the upstream direction is opposite thereto. In actual use the mobile phase preferably passes in the same direction, but it can pass through the column in either direction so upstream and downstream could be reversed during actual use.

[0054] Referring to FIGS. 1 and 3B-3C, the piston 40 and second or downstream frit 42 are described. The downstream end of piston 40 has a wall 54 extending downstream toward the first or downstream end cap 24 and along the longitudinal axis 52. The wall 54 forms a cylindrical recess sized to receive a portion of upstream frit 42. The second or upstream frit 42 is generally hat-shaped having a first disk shaped portion forming flange 56 with a circular periphery slightly smaller than the inner diameter of the walls 38, preferably about 0.001 inches smaller in diameter. The disk-shaped flange 56 extends radially outward from the longitudinal axis 52 beyond a smaller diameter cylindrical boss 58 located on the upstream side of the flange 56. The upstream frit 42 thus comprises the flange 56 and boss 58, which are preferably formed with internal passageways to distribute fluid evenly across the downstream face of flange 56.

[0055] The recess formed by wall 54 on the piston 40 receives the cylindrical boss 58, with the downstream end of the wall 54 preferably abutting the flange 56 of the upstream frit 42.

[0056] A first seal 60 is preferably, but optionally interposed between the exterior of the wall 54 and the adjacent inner wall 38 of the tubular body 22. The first seal 60 advantageously has a rectangular cross-section with its longer dimension along the longitudinal axis 52 and with a downstream end of the seal 60 preferably abutting the flange 56. The first seal 60 is preferably an elastomer or polymer such as polyethylene or polypropylene or polytetrafluoroethylene or rubber. A St. Gobain #450151883 seal is believed suitable. The first seal helps restrict media 44 and liquid from passing between the piston 40 and inner wall 38.

[0057] An optional second seal 62 abuts the upstream end of the first seal 60. The second seal 62 is preferably an elastomer seal, located in a corresponding groove 64 in the piston 40. The second seal 62 is preferably an elastomer or

polymer such as polyethylene or polypropylene or polytetrafluoroethylene or rubber. The second seal 62 could be an O-ring seal. The second seal 62 helps keep the first seal 60 from moving upstream along longitudinal axis 52. It may also optionally help seal against media 44 and liquid passing between the piston 40 and inner wall 38.

[0058] A wear ring 66 is located between two axially spaced flanges 68a, 68b on piston 40. The ring 66 also optionally provides a further sealing surface. The flanges 68a, 68b extend radially outward from longitudinal axis 52 to form a circular periphery slightly smaller than the inner diameter of interior wall 38. The wear ring 66 preferably has a rectangular cross section, and has an axial length abutting the inner wall 38 sufficient to reduce rocking of the piston within the cylindrical wall 38 as the piston 40 moves along the longitudinal axis 52. Wear ring 66 could be polyethylene or polypropylene or polytetrafluoroethylene. It could have an O-ring configuration, or other configurations.

[0059] A shoulder 69 (FIG. 3B) is formed on the upstream end of the piston 40 with an upstream boss 70 of smaller dimension extending upstream from the shoulder 69. The shoulder 69 is preferably a continuous annular surface facing upstream but intermittent surfaces could be used. The boss 70 preferably has a cylindrical exterior with threads thereon. A fluid passage 72 extends through the piston 40, preferably coincident with longitudinal axis 52. The fluid passage 72 has a downstream end in fluid communication with upstream frit 42, and preferably opens onto boss 58 of upstream frit 42.

[0060] The wall 54 forms a recess having a top or upstream surface 71 that is generally orthogonal to the longitudinal axis 52. Preferably, however, as seen in the figure, the surface 71 is slightly inclined upstream and toward the longitudinal axis to form a shallow conical recess between the surface 71 and the adjacent upstream frit 42. This conical space avoids clogging in the event the sample contains some particulates, and it also helps spread the sample over the frit. An inclination angle of about 3° is believed suitable to form this conical space.

[0061] The piston sleeve 46 preferably comprises a tubular shaft having a downstream end configured to abut shoulder 69, with an interior sized to fit over the boss 70. Preferably, but optionally, the interior on the downstream end of the piston sleeve 46 is threaded and configured to threadingly engage threads on boss 70. A shoulder 75 on an upstream portion of piston sleeve 46 abuts one of the end cap 48 or the thrust washer 50. The thrust washer 50 is preferably a relatively thick stainless steel in order to maintain the position of the piston accurately. The piston sleeve 46 preferably extends through an opening 76 in the end portion of upstream end cap 48. A tube 78 extends through the piston sleeve 46, preferably coincident with longitudinal axis 52. An upstream end 78a of the tube 78 is adapted to be placed in fluid communication with chromatography equipment to introduce a mobile phase into the column 20. A downstream end 78b of the tube 78 is configured to fasten to be placed in fluid communication with the upstream end of piston 40 and its fluid passage 72. A cap 80 blocks the inlet end 78a.

[0062] A detent 82 is placed adjacent the upstream end of the piston sleeve 46. A circular recess extending around the outer periphery of the piston sleeve 46 is believed suitable to form detent 82. The upstream end of the piston sleeve 46 forms a driving surface 84, or if desired an additional driving shoulder is formed on the piston sleeve 46 facing upstream

to serve the purpose of the driving surface 84 as described later. The locking surface 75 is formed in the sleeve 46. Preferably the locking surface 75 takes the form of a shoulder on the sleeve, and more preferably comprises an annular shoulder rather than intermittent surfaces.

[0063] The second or upstream end 21b of the tubular body 22 is preferably formed with a chamfer 86 on the inside of the tubular body 22 and angled outward from longitudinal axis 52. The chamfer 86 extends to the flattened or rounded lip of the tubular body 22 which faces upstream.

[0064] Referring to FIGS. 1 and 5, the packing of the column 20 is described. The downstream end cap 24 is placed on body 20 to hold the downstream frit 30 in place. The column 20 is placed in a holder with the first or upstream end 21b being open rather than covered. Preferably, but optionally, the column 20 is placed in a chuck 87 which is tightened to abut the tubular body 22 and hold the column so the longitudinal axis 52 aligns with the centerline of the chuck. A three part chuck 87 is preferred. The downstream end of downstream end cap 24 can abut a support surface 88 as shown, or the chuck 87 can grip the tubular body 22 sufficiently for the following packing.

[0065] A predetermined amount of media 44 is placed in a beaker and mixed with a fluid to form a slurry. The slurry is preferably sonicated to remove air and further mix the media 44 and fluid. The slurry is then poured into the inside of the tubular body 22. The flask is rinsed with the fluid, preferably twice, and the fluid poured into the tubular body 22 in order to ensure all the media is placed into the tubular body 22. Additional fluid is added, if needed to fill the fluid level to the chamfer 86. It is undesirable to force air through the column, so the fluid level is high enough to avoid air entrapment or a release valve is provided. Alternatively, the slurry could be pumped from a tube or other filling methods could be used. The outlet passage 26 is preferably not blocked at this stage so fluid can exit through the outlet 26 under the force of gravity.

[0066] The piston 40 is placed onto the piston sleeve 46 so the end of the sleeve abuts the shoulder 69 on piston 40. Preferably mating threads on boss 70 engage mating threads on the inside of sleeve 46 to form a threaded engagement that prevents relative axial movement of the sleeve and piston. Advantageously a metal cap is placed over the end of sleeve 46 to block fluid flow out of the upstream end 78a of tube 78. The hat-shaped, upstream frit 42 is placed in the piston, and the upstream end cap 48 and thrust washer 50 are placed on the piston sleeve 46. As desired, a locking mechanism can also be placed over the piston sleeve 46.

[0067] The piston sleeve 46 is placed into a press 90. The press 90 preferably, but optionally comprises a hydraulic ram and will be described as such. The detent 82 can engage a mating releasable detent pin in the press 90 to hold the piston sleeve 46 in place, along with any locking mechanism and piston 40 attached to the sleeve. The piston sleeve 46 is positioned in the ram 90 such that the longitudinal axis of the sleeve coincides with the longitudinal axis 52 of the tubular body 22.

[0068] The ram 90 then advances the piston into open end of the tubular body 22, with the chamfer 86 helping to guide the mating parts and accommodate slight misalignments. Preferably a slight amount of excess fluid is forced over the chamfered lip 86 in order to ensure no air is entrapped between the upstream frit 42 and the fluid. The advancement of the ram 90 and piston 40 is slow during this initial

engagement portion. The ram 90 advances the piston 40 into the tubular body 22 until the wear ring 66 abuts the interior wall 38 at which point the speed of the ram can increase if desired. The advancing piston 40 forces fluid out the outlet passage 26 while the frit first or downstream 30 retains the media inside the tubular body 22. When the fluid is largely expelled from the tubular body 22 the piston 40 compresses the media 44 at which point the pressure rapidly increases.

[0069] The ram 90 advances the piston 40 until a desired pressure is reached at which point movement of the piston 40 is halted. At that point the fluid is largely pressed out through passage 26 and the media 44 is compacted to form a stationary phase for a desired use, preferably for chromatographic analysis. The relative movement of the piston 40 and shaft 46 relative to the tubular body 22 is then fixed. This is preferably, but optionally achieved by moving thrust washer 50 until it abuts locking shoulder 75, or if no thrust washer is used, the cap 48 is advanced until a portion of the cap abuts the locking surface 75. Preferably, but optionally, the locking shoulder 75 extends adjacent the opening 76 in the cap 48, so that the thrust washer 50 does not have a significant unsupported or free length extending between the cap 58 and the shoulder 75. The cap 48 has interior threads engaging mating threads on the outside upstream end of the tubular body 22. The length of the sleeve 46 and location of the locking shoulder 75 are selected relative to the length of tubular body 22 and location of these mating threads so that the threads can urge and thrust washer 50 along longitudinal axis 52 to abut the locking surface 75.

[0070] The cap 48 is tightened until it causes thrust washer 50 to push against shoulder 75 and sleeve 46 to further compact media 44. A linear movement gauge 92 in communication with the ram 90 shows a slight increase in piston movement. The linear movements 92 can preferably, but optionally, read movement to the second or third decimal point. When the media 44 is further compacted a slight amount of 0.01 or 0.001 or preferably 0.0001 on the linear movement gauge, then the ram 90 is released and the cap 48, thrust washer and locking surface 75 hold the sleeve 46 and piston 40 in place. The column 20 is removed from the chuck 87. The plug 28 blocks the outlet passage 26. The metal cap on the upstream end 78a is removed if desired, and replaced with a plastic cap and/or union. The packed cartridge is then suitable for shipping and/or use. A force gauge could also be used instead of or in addition to a linear movement gauge.

[0071] Referring to FIG. 6, an illustrative graph of the pressure exerted by ram 90 on the left vertical graph, versus the position of piston 40 shown on the horizontal graph. The piston movement is represented in time. As the piston 40 expels the excess fluid from the tubular body 22 and outlet 26, the pressure on ram 90 increases fairly linearly as the media 44 is compacted and the fluid being forced through the bed experiences increased flow resistance. When the fluid is largely expelled through outlet 26 the pressure increases significantly as further motion of the piston 40 compacts the media 44 in the remaining fluid. If the pressure increase too much the media 40 will deform or it will crush and form fines, each of which decreases flow through the media bed 44. The desired compaction pressure will vary with the particular media being used. The movement of piston 40 is stopped when the pressure reaches a desired pressure.

[0072] This first embodiment achieves a uniform hydraulic packing of the media 44 by piston 40 which is desirable for uniform flow of mobile phases passing through the stationary bed formed by the compacted media 44. But this embodiment requires a long tubular body 22 and a long sleeve 46 which make the end column heavy, and which requires more material than desired. The tubular body 22, sleeve, end caps 24 (downstream), 48 (upstream) are made of metal, typically stainless steel, and that material is not only heavy, but expensive. It is thus desirable to reduce the length of tubular body 22 and eliminate, if possible, piston sleeve 46.

[0073] Referring to FIGS. 7-10, a second embodiment is described which uses the same piston 40 described above, but which uses a segmented tubular body 122. For parts that are not changed the part numbers are not altered and are the description is not repeated.

[0074] The tubular body 122 is formed of two parts, a removable, upstream tube 122a and a remaining downstream tube 122b. Both parts, upstream and downstream tubes 122a, 122b are used for packing while removable upstream tube 122a is removed for use, as described later in more detail. The upstream tube 122a forms a slurry chamber, while the downstream tube 122b forms the column. The upstream tube 122a may be referred to as a slurry chamber or slurry tube. The downstream tube 122b may be referred to as the column. Upstream and downstream tubes 122a, 122b are releasably joined by a removable, V-Band clamp. An optional wrenching surface 133 can be provided on the outside of tubular body 122.

[0075] The slurry tube formed by upstream tube 122a has a length sufficient to hold the desired slurry media 44 prior to the media being packed. Preferably, but optionally, the length is also sufficient to accommodate at least a portion of piston 40. The upstream end 124 of upstream tube 122a is configured to seal against the downstream end 126 of the slurry chamber formed by upstream tube 122a. The seal is designed to withstand the hydraulic packing pressures, which typically range from 2000-6000 psi, but which can be larger or smaller depending on the particular column and media. The seal is preferably a face seal between the abutting faces of the upstream and downstream tubes 122a, 122b. But the seal could be an axial seal extending along the length of longitudinal axis 52, or it could be both a face seal and an axial seal.

[0076] One illustrated seal is described. The mating ends of upstream and downstream tubes 122a, 122b each have a wall 128a, 128b on the inside of the tubular body forming upstream and downstream tubes 122a, 122b extending parallel to longitudinal axis 52. Each wall 128a, 128b forms a short cylinder. Each wall 128a, 128b also forms a recess 132a, 132b on the exterior of the wall. When the ends of the walls 128a, 128b abut each other, the recesses 132a, 132b face each other and form a single annular recess that is large enough to accommodate a ring seal, such as an O-ring seal for O-ring 134. The interior corner of wall 128b has a chamfer 130. Adjacent each recess 132a, 132b, and located away from the respective wall 128a, 128b, is a tapered recess 135a, 135b. Each tapered recess has a trapezoidal cross-section.

[0077] When the ends of the walls 128a, 128b abut each other, a V-band clamp 136 engages the recesses 135 to hold the parts (upstream and downstream tubes) 122a, 122b together. The V-Band clamp has two semi-circular or clam-

shell segments, each of which has two projections **140a**, **140b** with tapered sides configured to mate with one of the recesses **135a**, **135b**. The clamshells segments are fastened together, for example by threaded fasteners **142** such as screws, with the projections **140a**, **140b** wedging into the mating recesses **134a**, **134b** to fasten the segments (upstream and downstream tubes) **122a**, **122b** together. The seal **134** maintains a fluid tight seal alone, or in cooperation with the V-band clamp **136**. The V-band clamp **136** also maintains the slurry chamber of upstream tube **122a** and column **122b** in coaxial alignment.

[0078] The removable slurry chamber of upstream tube **122a** has an upstream end **124** with a chamfer **86** on the inside of the lip on the end of the chamber.

[0079] Referring to FIGS. 9A, 9B and 11, when assembled the initial use is similar to that of the first embodiment of FIG. 5. The slurry chamber of upstream tube **122a** and downstream tube **122b** are joined by a V-band **136**. The first or downstream end cap **24** is placed on column formed by upstream tube **122b** to hold the downstream frit **30** in place. The joined slurry chamber (upstream tube) **122a** and downstream tube **122b** are placed in a holder with the upstream end of the upstream tube **122a** being open rather than covered. Preferably, but optionally, the joined upstream tube **122a** and downstream tube **122b** are placed in a chuck **87** (FIG. 5) or a recess **174** in support **88** which holds the joined columns so the longitudinal axis **52** aligns with the centerline of the chuck. The first or downstream end of cap **24** can abut a support surface **88** as shown, or if the chuck **87** alone is used it can grip the joined upstream and downstream tubes **122a**, **122b** sufficiently for the following packing. It is preferably to abut the column against support **88**.

[0080] A predetermined amount of media **44** is placed in a beaker and mixed with a fluid to form a slurry. The slurry is preferably sonicated to remove air and further mix the media **44** and fluid. The slurry is then poured into the opening of the upstream tube **122a** which acts as a slurry chamber. The slurry chamber or upstream tube **122a** serves the purpose of a removable, pre-compression chamber in this second embodiment. The flask is rinsed with the fluid, preferably twice, and the fluid poured into the slurry chamber or upstream tube **122a** in order to ensure all the media is placed into the joined bodies of upstream and downstream tubes **122a**, **122b**. Additional fluid is added, if needed to fill the fluid level to the chamfer **86** on the slurry chamber or upstream tube **122a**. It is undesirable to force air through the column, so the fluid level is high enough to avoid air entrapment or a release valve is provided. The outlet passage **26** is preferably not blocked at this stage so fluid can exit through the outlet **26** under the force of gravity.

[0081] The piston **40** is placed onto the piston sleeve **46** so the end of the sleeve abuts the shoulder **69** on piston **40**. Preferably mating threads on boss **70** engage mating threads on the inside of sleeve **46** to form a threaded engagement that prevents relative axial movement of the sleeve and piston. Advantageously a metal cap is placed over the end of sleeve **46** to block fluid flow out of the upstream end **78a** of tube **78**. The hat-shaped, upstream frit **42** is placed in the piston, and the upstream end cap **48** and thrust washer **50** are placed on the piston sleeve **46**. As desired, a locking mechanism is placed on the sleeve **46**. The piston sleeve **46** placed into a press **90** (FIG. 18). The detent **82** can engage a mating releasable detent pin in the press **90** to hold the piston sleeve **46** in place, along with any locking mechanism

and piston **40** connected to the sleeve **46**. The piston sleeve **46** is positioned in the ram **90** such that the longitudinal axis of the sleeve coincides with the longitudinal axis **52** of the tubular body **22**.

[0082] The ram **90** (FIGS. 5 and 18) then advances the piston into open end of the upstream tube **122a**, with the chamfer **86** helping to guide the mating parts and accommodate slight misalignments. The advancement of the ram **90** and piston **40** is slow during this initial engagement portion. Preferably the movement of the piston **40** is paused before the first seal **60** engages the upstream tube **122a** in order to verify alignment. Preferably a slight amount of excess fluid is forced over the chamfered lip **86** in order to ensure no air is entrapped between the upstream frit **42** and the fluid.

[0083] The ram **90** advances the piston **40** into the joined bodies of the upstream and downstream tubes **122a**, **122b**. The pressure increases linearly, and slowly while the piston **40** is in the upstream tube or slurry chamber **122a** because there is enough fluid that the media **44** has not yet been compacted into a stationary bed. The tubular chamber of upstream tube **122a** thus effectively forms a pre-compression chamber. The chamfer **130** on wall **128b** at the juncture of the upstream and downstream tubes **122a**, **122b** helps avoid the catching the seals **60**, **62** and sealing wear ring **66**. The chamfer **130** is preferably small, because media **44** can collect in the chamfer.

[0084] The advancing piston **40** forces fluid out the outlet passage **26** while the first or downstream frit **30** retains the media inside the downstream tube **122b**. When the fluid is largely expelled from the downstream tube **122b** the piston **40** begins to compress the media **44** at which point the pressure rapidly increases as indicated by FIG. 6.

[0085] The ram **90** advances the piston **40** until a desired pressure is reached at which point movement of the piston **40** is halted and maintained in position. At that point the fluid is largely pressed out through passage **26** and the media **44** is compacted to form a bed of stationary phase for a desired use, preferably for chromatographic analysis. At this point the packed tube could be used for chromatographic analysis, but the ram **90** would have to maintain the pressure, and that is undesirable as it restricts mobility of the packed column of downstream tube **122b** and restricts use of ram **90**.

[0086] The length of the downstream column or downstream tube **122b** is selected so that the media **44** and preferably, but optionally, at least a portion of the piston **40** is in the downstream tube **122b**. Advantageously the seals **60** and **62** engage the wall **38** of the downstream tube **122b**, and preferably the wear ring **66** also engages the wall of the downstream tube **122b**, so a substantial portion of the piston is in the downstream tube **122b** or column. The V-band **136** is then released so the removable slurry chamber or upstream tube **122a** can be moved out of contact with the column formed by downstream tube **122b**, while the piston is fastened to the column or downstream tube **122b** and while the pressure on the media **44** is maintained by sleeve **46** and ram **90**. The pre-compression chamber formed by slurry chamber of upstream tube **122a** is thus removable and does not form a portion of the final assembled column **20** in this embodiment.

[0087] The piston **40** can be fastened to the downstream tube **122b** various ways. Conceptually the preferred mechanisms involve clam-shell or split-ring devices which engage a flange or recess on the column or downstream tube **122b**

and also engage part of the piston 40 in order to prevent relative movement of the piston 40 relative to the downstream tube 122b. One way of locking the piston in place relative to downstream tube 122b is shown in FIG. 10. The piston 40 is pressed at least part way into the downstream tube 122b, preferably with the wear ring 66 and ridges 68a, 68b abutting the inner wall 38 of the downstream tube 122b. A collet, referred to herein as locking collet 144, is placed around a portion of the piston 40, preferably abutting the upstream ridge 78a. The locking collet 144 acts as a piston compression screw.

[0088] Advantageously, but optionally, the exterior of the locking collet 144 has threads 146 and a wrenching surface 144 is also provided, preferably on the upstream end of the collet. The locking collet 144 thus advantageously comprises a cylindrical tube having threads on an outer surface, with the tube being split—preferably along a longitudinal axis of the downstream tube 122b. A two-piece locking sleeve 150 then encloses a portion of the locking collet 144 and the column or downstream tube 122b. The locking sleeve 150 serves as a piston retainer and may be referred to as such. Preferably, but optionally, the locking sleeve 150 is a clam-shell or split-ring configuration having a protrusion 152 configured to mate with recess 135b in the downstream tube 122b. Optionally, the locking sleeve 150 is preferably configured to mate with the exterior profile of upstream end of downstream tube 122b. Further, the locking sleeve 150 optionally has a threaded portion 154 located to threadingly engage threads 146 on locking collet 144. The threads 146 and threaded portion 154 preferably, but optionally, have multiple lead threads, with double lead threads being preferred. The locking collet 144 can be threaded into the threaded portion 154 before or after the split locking sleeve 150 is joined together.

[0089] In use, after the upstream (slurry) tube 122a or slurry chamber is removed by sliding it up the piston sleeve 46, the two halves of the locking sleeve 150 are then fastened together, as for example, by threaded fasteners such as screws through holes 156 in the locking sleeve 150. Alternatively, a hoop fastener encircling the exterior of the locking sleeve 150 could be used, such as a hose clamp, a wire, a ring, or a cylinder could be used.

[0090] After the two parts forming locking sleeve 150 are joined, the locking collet 144 is then threadingly advanced or tightened in the locking sleeve 150 until the downstream end of locking collet 144 pushes against the ridge 78a on piston 40, and slightly increases the force detected by ram 90. The ram is then removed from engagement with shoulder 69 of piston 40, with the locking collet 144 and locking sleeve 150 maintaining substantially the same preload as provided by the ram 90. The packed column of packed downstream tube 122b is then removed from the chuck 87 or recess 174, the downstream end plugged with plug 28 (FIG. 1), and the metal cap on the upstream end is replaced, as desired.

[0091] The locking collet 144 provides an axially positionable or adjustable device that accommodates variation in the position of the piston 40 along longitudinal axis 52. The locking collet 144 is preferably a unitary piece, or it can optionally be split into two or more pieces. The split locking sleeve 150 provides a radially locking device that engages the collet radially relative to longitudinal axis 52, to prevent movement of the locking collet 144 along the longitudinal axis 52. By providing a locking collet 144 and multi-part

locking sleeve 150, the ram 90 and piston sleeve 46 can maintain compressive pressure on the media 44 while the force to maintain that pressure is mechanically transferred to the locking sleeve 150 and downstream tube 122b without substantially releasing the pressure. While a single piece locking collet 144 and two-piece locking sleeve 150 are described, more than two parts could be used for each or the collet could be two-parts.

[0092] The wrenching surface 148 on the locking collet 144 is shown as being located on a flange that extends radially outward from longitudinal axis 52 a distance greater than the inner diameter of wall 38 of column or downstream tube 122b. If the wrenching surface 148 is slightly smaller than the diameter of inner wall 38 of the downstream tube 122b, then the locking collet 144 could fit through the inside of the upstream slurry chamber or upstream tube 122a. Thus, it is believed possible that a single-piece locking collet 144 could be placed on the sleeve 46 and pass through the upstream tube 122a or chamber to be fastened to the locking sleeve 150 after the V-band clamp 136 is released.

[0093] Referring to FIGS. 12-13, an alternative locking mechanism is shown. The column or downstream tube 122b has a downstream end cap 24 and a body wrenching surface 123 and an upstream end as described above with recess 135b for receiving a part of the V-band clamp 136. Piston 40 is shown, along with locking collet 144 which acts as a compression screw. In this embodiment the locking sleeve 150 has an interior configured to conform to at least a portion of the exterior of the upstream end of downstream tube 122b, and preferably with a protrusion 152 configured to engage at least the recess 135b in the downstream tube 122b. The end of locking sleeve 150 also has a threaded portion 154 configured to engage threads 146 on the locking collet 144.

[0094] The locking sleeve 150 may have two sleeve pieces or locking sleeve halves 150a, and the exterior of each of the two locking sleeve halves 150a has a substantially cylindrical lower portion 158 and a smaller sized cylindrical upper portion 160. The two halves 150a are fitted to engage the piston 40 and upstream end of column or downstream tube 122b. A holding piece 162 (FIG. 14B) is then slipped over the outside of the two locking sleeve halves 150a to prevent them from moving radially outward. The holding piece 162 has an interior profile shaped to mate with the exterior profile of the two locking sleeve halves 150a. The holding piece 162 has downstream end that is large enough to pass over the outside of the lower portion 158, and has an upstream end large enough to pass over slurry chamber or upstream tube 122a. The interior of holding piece 162 nests over the exterior of locking sleeve 150.

[0095] As the locking collet 144 is screwed into the threads in the threaded portion 154 and is forced against the shoulder on ridge 78a, the locking sleeve pieces 150a will move radially outward away from longitudinal axis 52 so they push against the inside of holding piece 162. Outward movement of the split locking sleeve halves 150a will wedge against the holding piece 162 so that frictional engagement between the locking sleeves 150a and holding piece 162 will restrain axial movement of locking sleeve halves 150a and holding piece 162 (FIG. 12), with the shoulder formed by the different diameters of the upper and lower portions 158, 160 also restraining axial movement in one direction. The holding piece 162 can be placed over the piston sleeve 46 before the ram 90 pushes the piston 40 into

the upstream tube **122a** (slurry chamber). After the upstream tube **122a** is disengaged, the holding piece **162** passes over the upstream tube **122a** to be fit over the end pieces of locking sleeve halves **150a** and hold them in place.

[0096] Referring to FIGS. **14A** and **14B**, a further embodiment is shown. This embodiment is as generally described above, but has a two or more piece segmented locking or retaining sleeve **150** surrounding the compression screw or locking collet **144**. The holding piece **162** is also segmented, preferably with two segments. The segments enclose the locking collet **144** and the top end **124** of the column or downstream tube **122b** to hold them in relative position. The segments of the holding piece **162** are fastened together by screws, bolts or pins including threaded fasteners **142**.

[0097] This construction eliminates the need to have the sleeve **46** (FIG. **5**) remain with the packed column **20**, and it eliminates the need for a tube long enough to accommodate the length of sleeve **46**. The resulting column **20** is shorter, lighter, and simpler, uses less hardware, and is less expensive. Moreover, the dynamic, hydraulic packing of media **44** is more accurate and repeatable, the stationary phase is more uniformly formed, and the bed density is increased—while avoiding crushing the bed and creating fines. The column performance is improved.

[0098] Further, the hydraulic packing of media **44** takes significantly less time to achieve than conventional packing methods which continuously run slurry through the tube to pack the tube, by a factor of about 10 to 100 times faster. The tubes **22** (upstream **22a**, downstream **22b**), **122** (upstream **122a**, downstream **122b**) can be packed to the desired pressure in less than a minute for tube diameters of an inch or less and lengths of a few inches or less.

[0099] Moreover, less media **44** is used, and the media is expensive. The prior continuous flow (slurry) packing technique can have up to about 40% of the media remaining in the tube or chamber used with the packing equipment.

[0100] Still further, the dynamic, hydraulic packing by piston **40** compresses the media **44** to form a stationary bed of compressed media, and that compressed bed of media is locked into position without being allowed to relax or expand. The locking of the bed into the desired compression is achieved in the first embodiment by locking the piston sleeve **46** into position in order to hold the piston **40** in position. In the second embodiment the piston **40** is locked into position and then the piston sleeve **46** is removed. In both embodiments the pressure exerted by piston **40** on the bed of media **44** is preferably maintained substantially unchanged. Actually because the locking mechanism in both instances preferably is not actuated until a piston movement or slight pressure increase is detected by the ram **90**, the locking pressure is preferably slightly higher, preferably within a fraction of a psi higher, and less preferably within a few psi or tens of psi higher than of the packing pressure at which the ram **90** stops moving. Because the pressure on piston **40** is electronically monitored by the ram **90** (e.g., through strain gauges, pressure transducers, etc.), it is possible, but not preferable, to lock the piston **40** at a pressure greater than or less than the pressure at which the ram **90** initially stops the compression.

[0101] Advantageously, no springs are interposed between the piston and the locking end **48** and locking sleeve **150** which hold the piston **40** and bed of packed media **44** in compression.

[0102] The frits **30** (downstream), **42** (upstream) are made of sintered metal, or polymerized PEEK. The two-diameter upstream frit **42** allows fluid distribution across the entire stationary phase provided by the packed media **44**. The outer diameter of upstream frit **42** is smaller than the inner diameter of wall **38** to avoid scratching the wall as the upstream frit **42** is moved by press **90** and piston **40** along the wall. The hat shaped upstream frit **42** allows the frit to extend across substantially all the interior diameter of the tubes forming tubular body **22** and its downstream tube **122b**, and to extend across the entire stationary bed formed from media **44**. That provides more uniform distribution of the mobile phase and sample over the media **44**, and that is especially useful when the columns **20** are short. Further, the boss **58** allows a substantial portion of the frit, about 70-80% to be thickened to better withstand packing pressures, and provides a thinner peripheral rim of thinner material. The upstream frit **42** is preferably a unitary frit formed into the hat-shaped structure at the time of manufacture. Alternatively, but less preferably, the upstream frit **42** can be formed from placing a larger diameter frit abutting a narrower diameter frit. A stainless steel frit **47** having a boss **58** of about 3.5 mm axial thickness, with a flange **56** having about 1.3 mm axial thickness, for a flange diameter of about 21 mm and a boss diameter of about 18 mm, is believed suitable for a porosity of about 2 microns. The frit allows passage of a fluid containing substances in solution to be separated while not allowing solid particles in the chromatographic medium to pass. Ideally, radial grooves inside the frit or on an upstream surface of the frit allow the solution to spread more evenly across the surface of the fit to help more evenly spread the fluid across the bed of chromatographic media **44**.

[0103] The stepped-diameter upstream frit **42** can be made by taking a disk having the desired maximum thickness and diameter, and then turning the smaller diameter boss **58**. This part can also be molded or sintered of metal, and possibly of ceramic. Preferably the upstream side of the boss **58** and the downstream facing side of the flange **56** are porous, with the edges and the annular space between boss **58** and the periphery of the larger flange **56** being substantially impervious to fluid flow.

[0104] The seal **60**, and any additional seals, are sufficiently fluid tight to sweep any media along the length of the tubular chamber **22** and upstream and downstream tubes **122a**, **122b**. The seal **60**, and any optional further seals are configured for the desired packing and operating pressures which typically range from 1,000-6,000 psi to 10,000 psi and possibly higher. While specific seal configurations are shown, other seal configurations, seal arrangements, and seal materials can be used within the spirit and scope of the present invention.

[0105] The seal between the ends of upstream tube **122a** and downstream tube **122b** can be simplified greatly if the downstream tube **122b** is sized so the maximum pressure increase occurs after the seal **60** or seals **60**, **62** and **66** have passed the chamfered **130** on the downstream tube **122b**. That simplifies the construction, assembly and disassembly of the upstream tube **122a** and downstream tube **122b**. The chamfer **130** is preferably formed only on the downstream tube **122b** in order to avoid forcing media into the joint between upstream tube **122a** and downstream tube **122b** as the piston passes the chamfer **130**.

[0106] Referring to FIGS. **9A** and **9B**, a further embodiment is shown. An upstream tube or chamber **122a** is joined

to a downstream tube **122b** (or column) by a split retainer. The top or upstream end **124** of the downstream tube **122b** has a top end recess **135b** and the bottom or downstream end of the upstream tube **122a** has a bottom end recess **135a**. A threaded locking collet **144** or bed compression screw threadingly engages mating threads on the inside of the upstream end of the downstream tube **122b**. The piston **40** (FIG. **13**) is urged against the media bed by the compression screw.

[0107] The locking sleeve **150** (FIG. **13** or FIG. **10**) has a threaded upstream end to mate with the exterior threads on bed compression screw or locking collet **144**. The locking sleeve **150** has a downstream end configured to engage the recess **135b**, or the rim forming the recess **135b**, to restrain axial movement of the sleeve **150**. The locking sleeve **150** thus restrains movement of the locking collet **144** relative to the downstream tube **122b** along the longitudinal axis **52**. An outer sleeve or holding piece **162** holds the split locking sleeve **150** formed by locking sleeve halves **150a**, from radial expansion. The outer sleeve **162** is also a split or clamshell design with the two or more pieces held together by threaded fasteners **142** extending through aligned holes in the mating parts of the outer sleeve **162**. The interior of the outer sleeve **162** is configured to generally conform to the exterior of the split locking sleeve **150** or collet. The outer sleeve **162** holds the parts (locking sleeve halves **150a**) of the locking sleeve **150** together.

[0108] The initial use is as described above wherein a V-band clamp **136** holds the upstream (slurry) tube **122a** and downstream tube **122b** in alignment during filling and packing as the piston **40** (not shown) compresses the media to form a chromatographic bed. The V-band clamp is removed.

[0109] Referring to FIG. **14**, the split collar formed by locking sleeve halves **150a** forming locking ring **150** is then placed around the downstream tube **122b** to engage the recess **135b**. The split collar formed by locking sleeve halves **150a** and locking ring **150** serves to retain the piston in place and for ease of understanding the collar or locking sleeve **150** will be referred to as a piston retainer **151** in describing the operation of FIG. **14** (FIGS. **14A**, **14B**). The bed compression screw or sleeve **144** is then slid down so its threads engage the threads on the piston retainer **151**. The bed compression screw or sleeve **144** is tightened until the piston is locked in place. As the bed compression screw is tightened it pushes in an upward or upstream direction against the piston retainer **151** and recess **135b**. The inclined surfaces on the recess **135b** allow the piston retainer **151**, which is split into two parts, to move outward from longitudinal axis **52**, and the outer sleeve **162** restrains that motion, locking everything in place. The packed downstream tube **122b** can then be removed from the press **90**, and flow through the column formed by downstream tube **122b** blocked by plugs **28** and cap **80**.

[0110] Instead of using a split outer sleeve **162** and locking fasteners **142** to restrain outward expansion of the (split) piston retainer **151**, the piston retainer could be held together and held in place by wire, by an encircling ring slid axially over the piston retainer **151**, or by a cylindrical sleeve slid axially over the piston retainer **151**. The use of single-piece rings or sleeves is simpler in that it avoids the use of split parts and fasteners to hold the split parts together. But the single piece rings or sleeves requires that they be positioned on the longitudinal axis **52** before bed compression begins,

and that can complicate arranging all the parts on the axis while still accommodating compression by the press **90**.

[0111] Referring to FIGS. **15-17**, a further embodiment is shown. The downstream end cap **24** has a plurality of flat surfaces **166** and corners **168** that can be used to align the downstream tube **122a** for packing with the press **90**. Preferably, but optionally, the (split) locking sleeve **150** is elongated to extend along a substantial length of the downstream tube **122b**, and for columns shorter than 50 mm a substantial length is about half or more. For longer columns the length is shorter and does not comprise a substantial length. The locking sleeve **150** has internal threaded portion **154** to engage threads on the piston compression screw or locking collet **144**. A protrusion **152** mates with recess **135b** in the upstream tube **122a** to prevent relative axial motion of the piston retaining sleeve or locking sleeve **150** and the upstream tube **122a**. The protrusion **152** is preferably shaped to conform with the shape of recess **135b** and more preferably has inclined walls to wedge radially and form a tight fit that restrains axial motion. The locking sleeve **150** preferably conforms to the distal end of the upstream tube **122a** to provide further engaging surfaces that restrain relative axial movement between the locking sleeve **150** and downstream tube **122b**. The locking sleeve **150** has a cylindrical exterior along its length, with a reduced diameter adjacent threaded portion **154**.

[0112] The upstream end cap **48** preferably, but optionally, has similar flat surfaces **166** and corners **168** as does the downstream end cap **24**. The upstream end cap **48** forms the holding piece **162** to confine radial expansion of the (split) locking sleeve **150**. This is achieved by having an interior recess configured to conform to the exterior of the locking sleeve **150**, or to conform to substantial portions of that exterior. As illustrated, a number of mating protrusions and recesses can be used to provide resistance to axial movement of the locking sleeve **150** relative to the downstream tube **122b**.

[0113] When the parts of the locking sleeve **150** are positioned to engage the downstream tube **122b**, the holding portion **162** is moved axially to fit over the locking sleeve **150** and prevent radial expansion. As the locking collet **144** engages threads in threaded portion **154** and is tightened to abut piston **40**, the tightening of the mating threads will cause radial motion of the locking sleeve **150**, which abuts the holding piece **162** to frictionally lock the parts together.

[0114] Upon suitable tightening of the locking collet **144**, the press **90** is disengaged and the downstream tube **122b** with packed media is removed. An end cover **170** can optionally be placed over a larger diameter recess in the holding piece **162** (that forms the end cap **48**). The larger diameter recess allows easier access to the wrenching surface **148** on the locking collet **144**. As desired, suitable plugs or caps are added to block the fluid flow channels through the packed column of downstream tube **122b**.

[0115] The flat surfaces **166** and/or corners **168** allow the column **122a** to be placed in a recess **174** (FIG. **11**) in support **88** where the recess is configured to conform to the flats and/or corners, in order to align the longitudinal axis of the downstream tube **122b** with the longitudinal axis of the press **90**. That avoids the need for a chuck **87**. Any suitable number of flats and/or corners can be used as long as a suitable alignment is achieved.

[0116] The embodiment of FIGS. **15-17** also has a modified piston **40** as shown in FIGS. **3A** and **3B**. The boss **70** has

no threads, and instead has a detent groove 172 which mates with a detent pin or detent ring (not shown) in the piston sleeve 46 to releasably hold the piston in the press during use. The detent ring and groove 172 are easier to use than mating threads on the piston sleeve 46 and boss 70 as shown in FIGS. 1 and 3A.

[0117] As used herein, the terms upstream and downstream are relative to an initial packing orientation for the tubular body 20 and tube 122. The relative directions can be referred to as first and second, and the directions themselves can be reversed, and the parts referred to can also be reversed. The frits 30 (downstream), 42 (upstream) are formed of sintered metal (stainless steel, titanium or other suitable porous material).

[0118] As required, detailed embodiments of the present invention are disclosed herein; however, it is to be understood that the disclosed embodiments are merely exemplary of the invention, which may be embodied in various forms. Therefore, specific structural and functional details disclosed herein are not to be interpreted as limiting, but merely as a basis for the claims and as a representative basis for teaching one skilled in the art to variously employ the present invention in virtually any appropriately detailed structure.

[0119] The above description is given by way of example, and not limitation. Given the above disclosure, one skilled in the art could devise variations that are within the scope and spirit of the invention, including various ways of locking the piston in place inside the column 20 and various ways to releasably join the slurry chamber 122a to the downstream tube 122b. Further, the various features of this invention can be used alone, or in varying combinations with each other and are not intended to be limited to the specific combination described herein. Thus, the invention is not to be limited by the illustrated embodiments.

1.-37. (canceled)

38. A chromatography column having a tubular body with an inner diameter, the column having opposing inlet and outlet ends, the column comprising:

- a bed of chromatographic media that has just been compressed to its maximum axial compression packing pressure during formation of the chromatographic bed;
- an upstream and downstream frit inside the tubular body and located on respective upstream and downstream ends of the bed of chromatographic media;
- a piston having opposing, upstream and downstream ends, the downstream end of the piston urging the upstream frit against the bed of chromatographic media and maintaining the axial compression packing pressure on the bed of chromatographic media, with no spring interposed between the first frit and the piston, the upstream end of the piston having an annular surface encircling a longitudinal axis of the column and facing away from the upstream frit;
- a fluid seal interposed between the piston and the inner diameter of the tubular body;
- a locking sleeve with multiple-parts that are connected together to encircle the inlet end of the column, each part of the locking sleeve having sleeve threads located thereon to form a threaded surface encircling the longitudinal axis;
- an annular locking collet having collet threads located to threadingly engage the sleeve threads so that rotation of the locking collet moves the locking collet along the

longitudinal axis toward the bed of chromatographic media, the locking collet having opposing upstream and downstream ends with the downstream end contacting the piston, the locking collet cooperating with the annular surface on the piston to define an annular void space above the annular surface encircling the longitudinal axis and extending from the annular surface to an upstream end of the locking collet.

39. The chromatography column of claim 38 wherein the parts of the multi-part locking sleeve are connected by threaded fasteners.

40. The chromatography column of claim 38, further comprising a hoop fastener encircling an exterior of the locking sleeve parts and the inlet end of the column to hold the parts of the locking sleeve together to restrain radial expansion of those sleeve parts.

41. The chromatography column of claim 38, further comprising a holding piece that encircles the upper end of the column and fits axially over an exterior surface of each locking sleeve part to hold the multi-part locking sleeve together.

42. The chromatography column of claim 38, wherein the locking sleeve comprises two halves.

43. The chromatography column of claim 38, wherein the threads on the locking sleeve comprises multiple lead threads.

44. The chromatography column of claim 38, wherein the annular surface is intermittent.

45. The chromatography column of claim 38, wherein the annular surface is continuous.

46. The chromatography column of claim 38, wherein the annular surface comprises a shoulder of the piston, with the locking collet pushing against the shoulder.

47. The chromatography column of claim 38, wherein the locking sleeve is connected to the column by a V-clamp.

48. The chromatography column of claim 38, wherein the locking sleeve is connected to the column by a clam-shell device.

49. The chromatography column of claim 38, wherein the upstream end of the piston has a cylindrical boss extending along the longitudinal axis, with external threads on the cylindrical boss.

50. A chromatography column having a tubular body with an inner diameter, the column having opposing inlet and outlet ends, the column comprising:

- a bed of chromatographic media compressed to its maximum axial compression packing pressure during formation of the chromatographic bed;
- a first and second frit inside the tubular body with each frit on a different opposing end of the bed of chromatographic media, with the first frit closer to the inlet end of the column and the second frit closer to the outlet end of the column;
- a piston having first and second opposing ends, the second end of the piston urging the first fit against the chromatographic media, with no spring interposed between the first fit and the piston, the first end of the piston having an annular surface encircling a longitudinal axis of the column, and a fluid seal interposed between the piston and the inner diameter of the tubular body;
- a locking sleeve with multiple-parts that are connected together to encircle the inlet end of the column, each

part of the locking sleeve having sleeve threads located thereon to form a threaded surface encircling the longitudinal axis;

- a locking collet having collet threads located to threadingly engage the locking sleeve threads so that rotation of the locking collet moves the locking collet along the longitudinal axis, the locking collet having opposing first and second ends with the second end urging the piston toward the bed of chromatographic media to maintain axial compression pressure on the bed of chromatographic media, the locking collet encircling the annular surface and cooperating with the annular surface to define an annular void space encircling the longitudinal axis and extending from the annular surface to an upstream end of the locking sleeve.

51. The chromatography column of claim **50**, wherein the locking sleeve comprises two parts separated along the longitudinal axis.

52. The chromatography column of claim **51**, wherein the locking sleeve parts are held together by a hoop fastener encircling an exterior of the parts.

53. The chromatography column of claim **50**, wherein the threads on the locking sleeve comprises multiple lead threads.

54. The chromatography column of claim **50**, wherein the annular surface is intermittent.

55. The chromatography column of claim **50**, wherein the annular surface is continuous and orthogonal to the longitudinal axis.

56. The chromatography column of claim **50**, wherein the annular surface comprises a shoulder of the piston, with the locking collet pushing against the shoulder to urge the piston toward the bed of chromatographic media as the collet rotates.

57. The chromatography column of claim **50**, wherein the locking sleeve is connected to the column by a V-clamp.

58. The chromatography column of claim **50**, wherein the locking sleeve is connected to the column by a clam-shell device.

59. The chromatography column of claim **50**, wherein the first end of the piston has a cylindrical boss extending along the longitudinal axis, with external threads on the cylindrical boss.

60. The chromatography column of claim **50**, further comprising a holding piece that encircles the upper end of the column and fits over an exterior surface of each locking sleeve part to hold the multi-part locking sleeve together.

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