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**Development of an Automated
Magnetic Silica Bead Based
DNA/RNA Extractor**

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Abstract

Most of these first few pages are generated by the file header/frontpage.tex

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Acknowledgements

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Chapter 1

Introduction

1.1 Background

Needed: -Place in industry -Background of diagnosis -Requirement and fit in company -Existing equipment

Within the healthcare industry, there is a continuous need for fast and reliable diagnostics of pathogens within patients. Identifying the presence of pathogens responsible for disease in a patient allows the appropriate preventive or corrective action to be taken and represents a crucial step in treating or preventing illness. This thesis was conducted for the benefit of and in collaboration with AusDiagnostics Pty Ltd.

Successful diagnostics, within the context of this thesis, can be summarised in three overall stages. Namely these are extraction, amplification and finally analysis. This thesis concerns itself only with extraction. It should be noted that not all pathogen analysis and/or commercial diagnostic processes follow these steps strictly, however the processes and technologies applied by AusDiagnostics follow this procedure. The stages of this procedure may be

summarised as follows:

1. **Extraction** To begin the diagnosis, a clinical sample is obtained from the patient. This sample may consist of cerebrospinal fluid, faecal matter, urine or others, depending on the disease to be diagnosed. These samples contain the target DNA or RNA which will later be analysed to determine the presence of the pathogen and hence disease. They also contain however a number of inhibitors to the process of amplification and analysis. Extraction is the process of removing said inhibitors and retaining only the target DNA or RNA. The result is referred to as a clean sample.
2. **Amplification** Amplification takes the clean sample and by one of many methods increases the overall count of the DNA. This may be with the intention of allowing multiple targets to be detected or to increase the sensitivity of the analysis.
3. **Analysis** Analysis uses one of many available methods to search for the presence of biomarkers within the amplified clean sample. The presence of the biomarker indicates the result of the diagnosis.

AusDiagnostics currently supplies customers with the instruments and chemical products required to complete stages two and three (amplification and analysis) of the diagnosis. This requires customers to purchase extraction equipment from alternative suppliers and represents a significant weakness and loss of profit. Research and development conducted by AusDiagnostics has determined that the optimal approach, when considering speed and efficiency, is super-paramagnetic bead based extraction. The beads utilised are of the shell-core variety. The core is composed of an iron oxide, which provides the super paramagnetic properties required for physical manipulation of the

beads via a magnetic field. The shell is comprised of silica, which via chemical modification has the propensity to bond DNA and RNA to the bead surface. The techniques developed by researchers at AusDiagnostics utilising the magnetic silica beads have been validated and verified via manual operation. This thesis concerns itself with the automation of the developed extraction process, to produce a commercially viable robotic instrument. This instrument will be referred to as the Gene-Plex Extractor.

The extraction process to be automated has a number of notable requirements. These include liquid handling via precise pipetting, including mixing and liquid transfer. Also required is manipulation of the magnetic silica beads to separate the bonded and hence captured target DNA or RNA, along with heating to a specified, constant temperature to act to increase the rate of the chemical processes. The automation of the extraction process will be achieved by integrating the required capabilities into the robot produced by AusDiagnostics to conduct the amplification stage of diagnosis. The instrument, based of the Gene-Plex platform and sold as the High-Plex Processor, is pictured in it's current application in Figure 1.1. The Gene-Plex platform is essentially a liquid handling robot. The robot carries out the amplification stage by precisely pipetting and transferring liquid mixtures between the tubes and instruments on the deck, using disposable tips. Each individual assay (an analysis conducted to determine the presence and amount of a substance within a volume) utilises an individual layout of components on the robots deck. This makes the platform highly configurable for differing setups.



Fig. 1.1: The Gene-Plex liquid handling robot platform, as implemented as the High-Plex Processor.

1.1.1 The Extraction Process

In order to allow the aim and scope of the work to be clearly defined, a condensed overview of the extraction process developed by AusDiagnostics is presented. It should be noted that unless explicitly stated, all operations are to be automated.

The extraction process requires that the clinical sample undergoes a number of chemical steps across different locations on the robot. To aid in understanding the liquid handling involved, Figure 1.2 displays the important sites on the deck. The process will begin with the operator manually loading 24 individual clinical samples into the location labelled “Clinical Samples”. In

order to conform to existing products used by customers, it is then required that the chemical processing takes place in the locations labelled “Samples”. In order to transfer the liquid between locations, the robot will pick up 1000 μ L tips from the locations marked “Tips”.

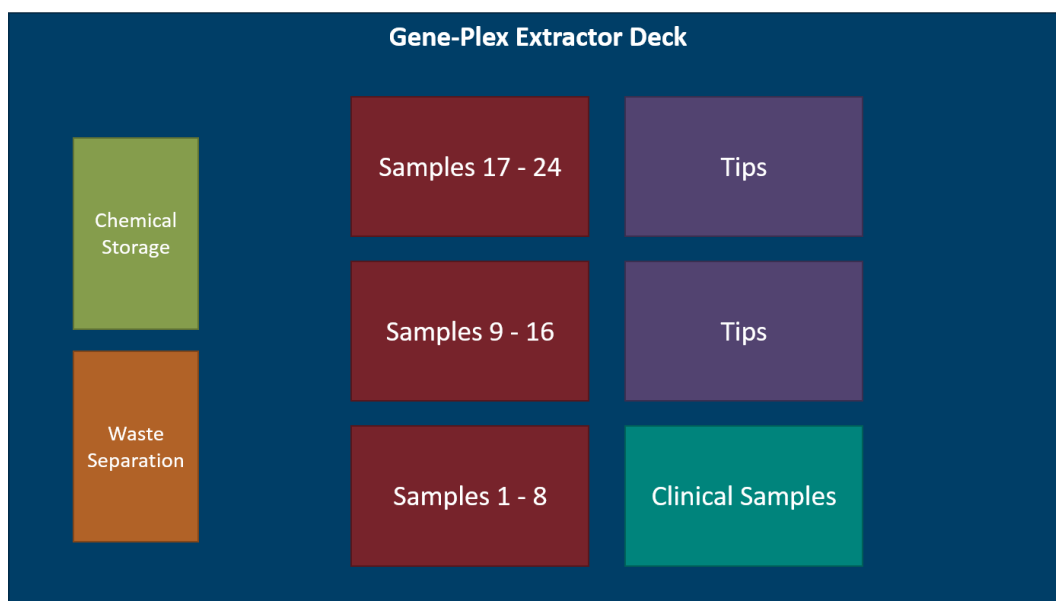


Fig. 1.2: The layout to be used for the Gene-Plex Extractor.

The sample processing locations must accept modules that fit within the standard block size (SBS) format. These blocks are required to each accept 8 cassettes, one for each sample (pictured in Figure 1.3). Each cassette includes 6 tubes, which will be the site of a particular chemical reaction in order to extract the target DNA and RNA:

1. 500 μ L of clinical sample is pipetted into tube location 2, as marked in Figure 1.3. Within this tube as supplied by AusDiagnostics, there will already be 10 μ L of magnetic bead mixture along with 440 μ L of lysis buffer. The lysis buffer will destroy the cell walls, releasing the target

DNA or RNA to be bound to the magnetic silica beads. This process is required to take place at 60°C in order to increase the rate of reaction. Due to the low volume of liquid in this step, it is to be completed in one of the 1mL low profile tubes. This aids with liquid handling precision.

2. The target DNA or RNA is now bound to the beads, which are suspended in the waste liquid (supernatant). In order to capture only the bead suspension, the entire liquid mixture is aspirated via pipette tip and subsequently move to the location marked “Waste Separation”. In this location, a magnetic field is to be applied to capture the magnetic silica beads within the pipette tip. While captured, the supernatant must then be expelled into a waste container in this location. The tip now contains only the magnetic beads with bound targets.
3. Despite the supernatant having been expelled, there will still be a significant amount of waste retained on the bead surface. To remove this and clean the beads, a sequence of 3 wash steps must then occur in tube locations 1, 5 and 6. To achieve this, the beads are first re-suspended in the tube, which contains 800 μ L of a particular wash buffer. The suspension must then be mixed via pipetting in order to ensure the bead surface is properly exposed. The entire liquid mixture is then aspirated once again and transferred to the waste location, where via the same means as step 2, the waste liquid is disposed of while the beads are retained. This process is repeated 3 times in the tubes noted above to ensure no waste matter clings to the bead surface.
4. With the beads now clean and still bound to the target, the mixture is transferred to location 3 of the cassette. The elution buffer is used to break the bond between the target DNA and RNA and the magnetic

silica beads. This process is also required to be completed at 60°C to reduce the time required. Following this step, the target DNA or RNA of interest is now contained within the elution buffer, along with the magnetic silica beads which are now waste.

5. The final step is to capture only the target DNA or RNA within the elution buffer, leaving behind the magnetic beads. This is required to take place in tube location 4. This is a low volume reaction, containing only 100 μ L of elution buffer and is therefore completed in the final small profile tube. The pipette must then aspirate this mixture, following bead removal, and contain only the elution buffer and target mixture required for amplification in stage 2 of the assay.

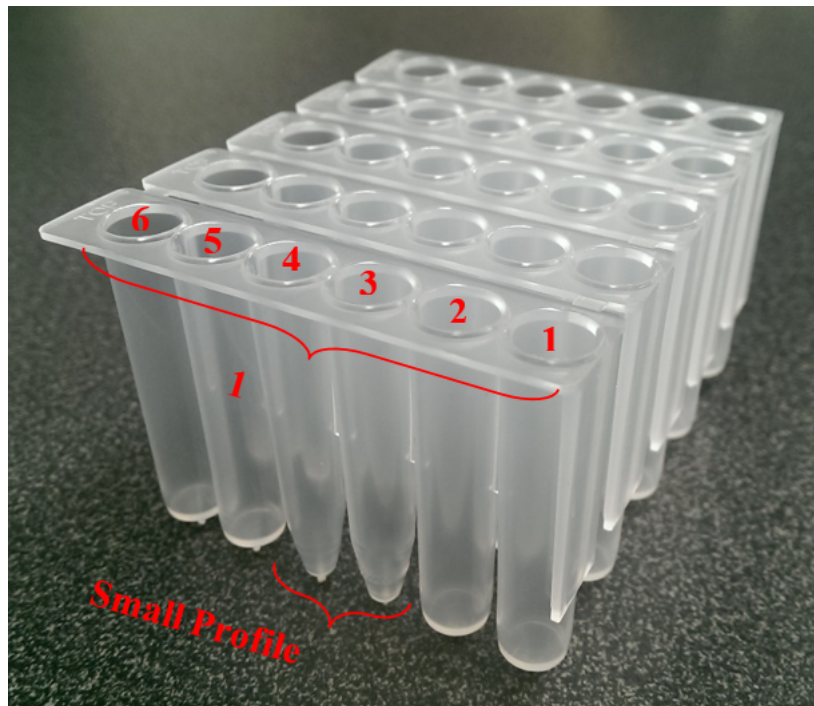


Fig. 1.3: The tube format to be used as the site of the sample processing.

1.2 Aim

This work aims to develop and integrate into the Gene-Plex Robot Platform the hardware necessary for carrying out the described chemical processes, the required magnetic manipulations and the controller necessary to maintain the stipulated constant 60°C temperature.

1.3 Scope

The features required by the Gene-Plex Extractor, over those already part of the Gene-Plex Processor, can be grouped into 3 overall categories. These are detailed below, including clear definition of their inclusion or exclusion from the scope of this work.

1.3.1 Mechanical

The summary of the extraction process to be implemented, given in Section 1.1.1, revealed a number of missing mechanical components when compared to the description of the Gene-Plex Processor given in Section 1.1.

SBS Processing Module As was noted in Section 1.1.1, the extraction process is to take place within cassettes consisting of 6 tubes. These must be located in the 3 SBS deck locations as marked in Figure 1.2, with each SBS location accepting 8 cassettes. The design of the module which will accept these cassettes is within the scope of this thesis and will form a large component of the design work undertaken.

Heating Element In order to create a commercially viable product, it has been stipulated that the tubes within each cassette where the the lysis buffers and elution buffers are held (tubes 2 and 4), a temperature of 60°C must be

maintained for the duration of processing. This is a core requirement of the extraction process and is included in the scope of this project.

Magnetic Separation The Gene-Plex Extractor can be seen to require magnetic manipulation of the silica beads in two different locations. In order to allow the extracted DNA or RNA to be captured after separation from the beads in tube 4, the beads must be retained in the tube while the liquid is aspirated by the pipette. Secondly, the magnetic beads must be captured within the pipette tip during the expulsion of the waste supernatant after all wash steps are completed. The magnetic separation required in both of these processes is defined to be within the scope of this work.

Waste Disposal Following the wash steps and the subsequent separation of the magnetic beads and the bound DNA or RNA from the wash buffer, the supernatant must be hygienically disposed of. This waste disposal method is required in order to ensure that no contamination occurs between the clinical samples being processed. It is also crucial to ensure that no contact can occur between the operator and the biological matter which is a by product of the extraction process. The development of this waste disposal hardware is included in the scope of this work.

1.3.2 Electronic

In order to account for the newly integrated capabilities in the Gene-Plex Extractor, some modifications to the Gene-Plex Processor electronics are required. Due to the temperature control requirements of the extraction process, an electronics board capable of communicating with the robot software and driving the heating elements appropriately is required. This however is not included in the scope of this work for a number of reasons. One of the com-

ponents of the Gene-Plex processor is a device called the MTX Cyclor. This device controls the temperature of the already extracted sample (during stage 2, amplification) precisely between set temperatures to enable PCR (Polymerase Chain Reaction) to occur and hence amplify the sample. The MTX Cyclor controls the temperature of liquid volumes significantly smaller than those involved in extraction and in a different form factor, making it unsuitable for this application. It does however provide the necessary electronics and interfaces required to drive any standard form of heating element used here. Further to this, the electronic board used to control the MTX Cyclor is currently being integrated into a newly developed control board for the Gene-Plex Platform by AusDiagnostics engineers. This new board will also be capable of driving the heating elements selected for this application. Therefore, due to the redundancy of work on this component of the Gene-Plex Extractor and due to a suitable requirement existing, the development of the required electronic is not within the scope of this work.

1.3.3 Software

In order to enable the Gene-Plex Platforms controlling software to utilize the newly integrated capabilities, two main components of software must be created:

Temperature Controller In order to control the heating elements to maintain a stable and accurate 60°C for the lysis and elution stages, a temperature controller must be implemented. This temperature controller must be designed according to the temperature response of the heated hardware using appropriate methods and implemented as a controller in software. This element of the Gene-Plex Extractor's requirements will also form a core part of this

work and is included within the project scope.

Routine Addition A was briefly noted in Section 1.1, the Gene-Plex Platform is highly adaptable in its ability to perform assays requiring differing liquid handling operations. The platform achieves this by utilizing a number of library routines which may be called upon the assay requiring a particular movement, such as expelling liquid, moving to a certain robot position etc. While the vast majority of these library routines will be directly effective within the Gene-Plex Extractor, due to the newly integrated capabilities further routines will be required. These will include routines for the mixing of liquids in the cassette tubes, magnetic separation and a table of definitions which specifies the locations of each of the tubes and pieces of deck hardware. These software additions are not included within the scope of this work and will be implemented by software engineers at AusDiagnostics.

Chapter 2

Literature Review

2.1 Heating

The thermal requirements for the extractor to be developed, as outlined in Chapter 1, are very similar in nature to those of a Polymerase Chain reaction (PCR) Thermal Cycling Device, albeit with simplified operations. The requirements of a PCR thermal cycler are driven by the need to cycle the temperature of an array of tubes containing a small volume of sample liquid through temperatures of 55°C, 72°C, followed by 92°C [1]. Due to the process involving upwards of 20 cycles between these temperature set points, ramp times for these changes in steady state must also be minimised to ensure the total processing time is commercially viable. The thermal requirements of the Gene-Plex Extractor are highly matched, with two exceptions. In this application the temperature of the sample liquid shall be held at a constant 60°C, as determined by research conducted by AusDiagnostics, as opposed to the multiple temperatures of a PCR cycler. Secondly, the cool down ramp rates for a PCR cycler are of equal importance to its ramp rates during heating, in order to achieve temperatures lower than the current steady state in

adequate times [2] [3]. In the application of the Gene-Plex Extractor, there is no need to pay attention to cooling ramp rates as the system will only cool at the completion of its operation. Due to the similarities evident between these two applications, a great deal of information may be gathered from PCR cyclers design.

In order to generate the heat necessary to reach the required sample temperature, some form of thermal pump is required. A Thermoelectric Cooler (TEC), also known as a Peltier, is often used for liquid sample thermal cycling [4] among its many other applications. A TEC is a solid state heat pump, controlled by the directional application of electric current across its two terminals [5]. The direction of the applied current determines the direction of heat pumping across the module [5]. TEC's are constructed of pellets of n-type and p-type bismuth telluride semiconductors, connected in an alternating series [6]. The connections, made of copper, are bound to a substrate of ceramic alumina. This substrate forms the surface by which the heat generated is transferred. Figure 2.1 displays the arrangement of a TEC in a general case application. The TEC has shown through the reviewed literature to be common in PCR thermal cycler applications due to the above mentioned ability to pump heat in either direction, allowing ramping of temperature to be precisely controlled equally in both directions.

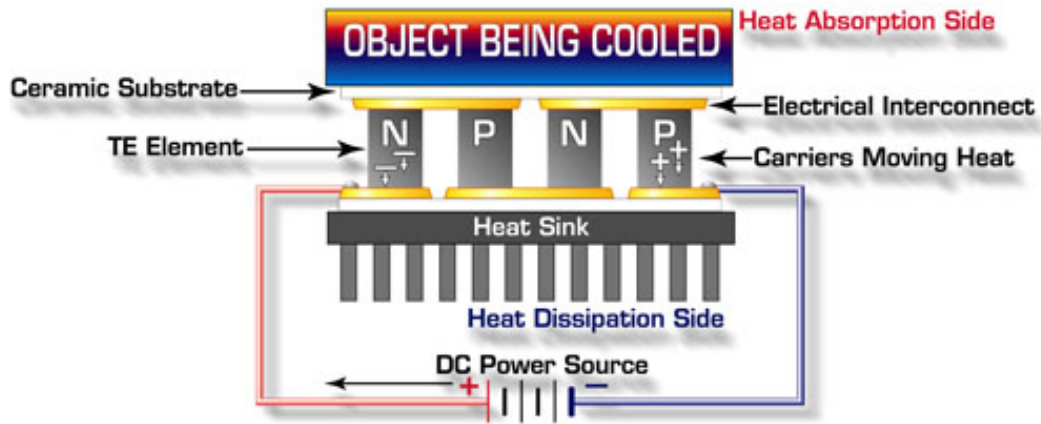


Fig. 2.1: Thermoelectric module as assembled in a typical application. [7]

When used in control applications, a TEC has the advantage of being able to not only add but to also remove heat energy as is required by the controller to achieve the desired response. Despite the TEC's ability to actively remove heat from a component, other active temperature removal methods may also be implemented. A passive approach to heat removal is that employed by a heat sink, or any simple surface area [8] [9]. This differs from an active approach, where airflow over the heat sink surface area is controlled via a fan, for example [8]. Such methods may be substituted for the directional heat pumping capabilities of the TEC, in order to achieve a similar level of temperature control. This leads to simpler possible options for heat pump selection, namely electronic resistive heaters. Despite no reviewed literature describing these devices as the main heat source in thermal control for PCR in particular, they have been demonstrated to provide a crucial supporting role by Williams et al. The thermal cycler described in the work of Williams utilizes resistive heat strips to control the temperature of a sealing lid, preventing sample evaporation at the upper operating temperatures of a PCR thermal cycler [10]. While the application noted here differs from the intended application within

the extractor, where the device will be the primary source of heat, Gene-Plex Extractor, it demonstrates the feasibility of driving component temperature to a steady state value and hence represents a design possibility.

2.2 Cooling

In order to be able to control the temperature of the liquid sample as required, a method of evacuating heat must be present. A passive method alone, such as a heat sink in isolation, will not allow the process controller to drive a reduction in heat beyond the limits of conduction to the surrounding air [9] and as such performance will not be satisfactory. Along with heat dissipation being essential for control, the TEC elements have a maximum temperature differential of which they are capable of generating across their surfaces. This imposes the following constraint on the thermal system:

$$T_{hot} - T_{cold} \leq dT_{max} \quad (2.1)$$

This has been noted as highly significant in PCR cycler design [5], where one end of the TEC must be kept at ambient temperature to enable the maximum steady state value of 92°C to be reached safely. It should be noted that due to the maximum steady state temperature in this application being limited to 60°C and assuming a reasonable TEC differential limit, dT_{max} , this constraint is not critical. However, a TEC becomes less efficient as its temperature differential is increased [11]. As such, a method of heat evacuation must be present.

2.3 Controllability

In order to create a thermal system which is controllable within the context of stability and speed of response, attention must be paid to the thermodynamics of the device. Due to manufacturing constraints and standards, the tube which contains the sample itself is not optimal. A wall thickness of 1mm results in poor heat transfer characteristics from the heated block to the sample [12]. Another source of poor dynamics is any regions of mechanical connection between the heated block and external components [10]. Recommendations from the reviewed literature included the use of gasket material to limit thermal material between any surface contacts (Williams et al specifically recommends the use of ethylene propylene), along with the use of a groove extending through the majority of the thickness and hence limiting heat transfer to the mechanical connections [13] [11]. Mechanical connections are however only one cause of significant thermal gradient within the device. Care must be taken to reduce the severity and frequency of the occurrence of these gradients to maintain stability and performance in temperature response. After heat pumping has ceased, a temperature gradient will persist for a period of time that is proportional to the square of the distance between the hot and cold locations [10]. This has important implications for the number of sample tubes that may be heated within a single block. If the size of the sample array to be heated is too large, difficulty will be encountered achieving a uniform and stable steady state temperature [10]. Widomski et al note that despite efforts to reduce heat loss and hence gradients around the system boundaries via methods such as insulation, the region of location of the heat source will continue to maintain a higher temperature. To counter this, it is suggested to use a rod of material with lower thermal conductivity (such as stainless steel within an aluminium

block) to reduce the heat retained in this volume [11].

A number of measures may also be taken directly related to the heated block itself to ensure optimal thermal response. The concepts of static local balance and static local symmetry may be applied to obtain desirable heat transfer within the medium [10]. A state of static local balance refers to a state of constant temperature where all heat sinks are equalled by heat sources in a local area [10]. This essentially describes a state of thermal equilibrium, where the following condition is satisfied:

$$Q_{in} = Q_{out} \quad (2.2)$$

To ensure this balance is obtained, a device design should not incorporate overly effective heat sinks, without a proportional increase in the heat source capacity, and visa versa. The condition of static local symmetry requires that for a constant temperature and within a local region, the center of mass of the heat source is coincident to the center of mass of the heat sink [10]. Satisfying this condition will ensure that a constant, steady state temperature is achievable, without the presence of a permanent temperature gradient between the two centers of mass. The selection of heated block material along with manufacturing methods may also act to improve transfer properties. Aluminium 6061 is recommended due to its purity [10], which aids in even heat transfer [14]. It is further recommended that the heated block be manufactured via machining, due to the homogeneous structure that results. This is beneficial in reducing any temperature gradients that may occur within the heated element due to mechanically or otherwise joined components or impurities or inconstancies that exist as a result of other manufacturing methods such as

casting.

2.4 Temperature Sensors

The literature reviewed has presented various differing selections of temperature sensing technologies, the most prominent of which have been thermocouples and thermistors. Despite the overlapping application, the specifications of the two technologies are significantly different. The thermocouple has a large temperature range, with measurements capable of ranging from -270°C to 1800°C compared to the limited range of thermistors of usually around -90°C to 130°C [15] [3] [16]. The thermocouple and thermistor possess similar response rates along with similar accuracy, however due to the wider resistance range available, thermistors are able to achieve a high measurement resolution [15] [3] [16]. The two significant differences between the technologies are power supply requirements and linearity. Due to the welding of differing metal conductors at the measuring point, the thermoelectric effect results in a temperature dependant voltage being generated across the thermocouple terminals [15] [16] [3]. While this means the sensor does not require a power supply, it can introduce complications requiring a reference/compensating wire. Furthermore, changes to the conductor materials such as corrosion require that the sensor be calibrated on a regular basis, often as frequently as 3 months [15] [3] [16]. Thermistors use semi-conductive material that changes resistance with temperature. As such, measuring the temperature requires a current be passed through the device [15] [3]. While the output voltage of thermocouples changes linearly with temperature, this is not true of thermistors. Hence, the output signal requires linearisation before it may be of use [3]. In commercial applications, thermistor technology is often also preferred due

to its cost effectiveness [16]. While Resistive Thermal Detectors (RTD's) and Integrated Temperature Sensors appeared in a number of reviewed sources, they are not considered in depth due to the high level of signal conditioning required [16] [15] and the lack of observed uses in relevant thermal control applications.

2.5 Temperature Sensing

To utilize the thermal system to control the liquid sample temperature accurately, a method of obtaining a feedback signal is required. Complications exist however due to the constraint that the sample temperature itself cannot be directly measured. Due to the thermal transfer characteristics discussed above, the placement of the sensing device is critical to the stability of the controlled substance [13]. Vilchiz et al studied the issues of sensor hardware placement and provide numerous recommendations to increase baseline stability. Using experimental methods, it was verified that the following one-dimensional heat equation holds:

$$s = \frac{L}{a} \quad (2.3)$$

Where s is the time taken for energy to flow from location A to location B, L is the distance between the two locations, and a is the thermal diffusivity of the material. This is relevant as it allows the time lag between a controlled heating action at the heat source to the arrival of the generated heat at the location of interest to be determined. The experiment conducted tested two temperature sensing cases. One sensor was placed within the center of mass of the heated block, while the other was located as close as was possible to the heat source. The results obtained found that “there is a general advantage of control via

sensing close to the heater, whether by temperature measurement, or by heat-flow control sensing.” [13]. Equation 2.3 is accountable for this result. When the sensor is placed at a greater distance to the heat source, the control effort is determined using a measurement that is not yet equalised due to the more severe temperature gradient. This error in feedback signal is reduced by the recommended placement strategy, such that “the reduction in the magnitude of the heater-induced oscillations achieved by this control strategy is at least one order of magnitude better than that of the temperature control at the core” [13].

A number of aspects of the experiments and findings the work of Wilchiz et al should however be considered. The sensing device used to make the presented conclusions were thermocouples, one of many sensing devices available. Despite the variances in accuracy and stability of measurements that are expected between differing sensing technologies, the results can be assumed independent of any associated error. Any error as a result of sensor output stability is of an insignificant order to magnitude of time when compared to the 1.07 min thermal lag situation generated by the experiment. Furthermore, one would expect a sensor technology of differing accuracy to produce a controlled output different to the desired reference input. This error is however not influential to the results given, which are concerned exclusively with the stability of the controlled response. The focus of the experiment was the application of thermocouple technology in Tian-Calvet microcalorimeter devices. This does not detract from the relevance of the reviewed work for a number of reasons. The motivation for the study was to improve baseline stability in temperature control, via the application of improved temperature measurement strategies; a general outcome that is relevant to the work of this thesis. Further to this,

the scale of the experiment conducted closely resembles the device to be developed, with the distance between sensor locations set equal to 3.5cm. Therefore, despite the differing applications of the work conducted, the recommendations and strategies found may be concluded as directly applicable.

2.6 Controller Design

With the necessary hardware in place and optimally set up, as has been discussed above, controller design and theory may be considered. The large majority of the reviewed literature, along with the instruments currently employed by AusDiagnostics, recommend or employ the Proportional Integral Derivative (PID) controller. As summarised by Vilchiz et al, “Although other types of controllers are also feasible, e.g., those based on fuzzy logic or artificial neural networks, the simplicity, good response, and low cost of PID-based control loops have motivated their popularity in industrial applications” [13] [5]. Despite the common application of the PID controller in thermal control applications, if a TEC is the selected source of heat, complications are presented. Due to the non-linearity of the device, PID coefficient selection involves the process of trial and error [5]. The strategies for PID design given were however applied to the thermal cycling requirements of PCR. This requires that 3 separate temperature controllers be implemented for each of the temperature set points, to ensure the required performance is met equally at each [5]. While the characteristics of the PID controller are not effected by this difference, it does significantly increase the complications of coefficient selection in comparison to the application in the Gene-Plex Extractor. Further to the controller to be implemented itself, a number of sources give recommendations regarding relevant hardware. Cellatoglu et al investigated the dynamic per-

formance of a process control system, with a focus on temperature controllers. The findings reveal that the word length of the ADC utilised is an important factor in reducing output error. A case study was conducted to assess the impact of increased word length on error, with results suggesting that 8 bits is the optimal value [17]. It was further found that an increase in word length beyond this point yields no reduction in error. The analysis conducted was however completed as a simulation, with no experimental verification evident. The electronic hardware implemented in other sources, such as the work of Shirafkan et al, differs from this recommendation. While not providing evidence to suggest the 8-bit recommendation is problematic, the successfully implemented controller utilized a 24-bit ADC.

2.7 Magnetic Separation

To ensure the target DNA is extracted as required, the device must include a robust means of capturing the magnetic beads. Despite offering an alternative means of magnetic bead manipulation, electromagnets are not investigated for application in the thesis due to a high level of complexity that is not required for this static, constant force implementation. Therefore, the review of literature focuses on permanent magnets. While there are numerous compositions of magnets available, the rare earth variety and in particular the Neodymium composition (ND-Fe-B) are most suitable. Neodymium magnets offer the strongest solution, with an energy product of up to 56 MGOe [18]. Good mechanical characteristics and energy to size ratio make them suitable for fastening within a manufactured product, without undue difficulty. Importantly, given the requirement to capture beads within the heated block element,

Neodymium magnets are stable in temperatures near ambient. Progressive loss of magnetism occurs at temperatures greater than 80°C [18], providing a 20°C margin of safety between the operating temperature of 60°C. This composition also holds a very high coercive force [18], allowing it to resist demagnetisation in the presence of external magnetic fields that will be present within the GenePlex Extractor, as a result of other hardware. Despite the specification of the superparamagnetic silica beads being a constraint determined by completed research at AusDiagnostics, a number of characteristics should be noted in order to obtain reliable bead capture capabilities. Shevkoplyas et al describes the force acting on a superparamagnetic bead due to an applied force. The context of this paper is the motion prescribed by the beads within a microfluidic chamber, however the general characteristics of the interaction between the beads and magnetic field are applicable to the capture required here. In order to saturate a suspension of superparamagnetic beads, an external magnetic field greater than 0.5T must be applied [19]. Saturation is the state where all beads magnetic poles are aligned. In a state of saturation, the magnetic beads behave simply as permanent magnets [19] [20]. In order to ensure the complete separation of the magnetic bead dispersion within the sample liquid, this condition must be achieved.

The literature reviewed has allowed a number of critical elements of thermal control and magnetic separation, being the main requirements of the extraction system, to be recognised and evaluated within the context of this thesis. The similarity between the processes demanded by the extraction technique and the works discussed allow the information gathered to be applied directly to the benefit of the developed instrument. Those works which were an exception to this allowed general strategies and design characteristics to be collected, which

may be applied with consideration in future development.

Chapter 3

Methodology

With the scope of the work now defined, the manner in which the required results will be obtained can now be detailed. The necessary additions as defined in Section 1.3, Scope, may will be implemented in the form of two independent assemblies in order to meet the requirements of the work. These two assemblies will be refereed to as the Processor Module and the Magnetic Separation Station. The former will be the site of the chemical reactions as described in Section 1.1.1, The Extraction Process, and will be the hardware element that forms the SBS block on the Gene-Plex Extractor deck. Therefore, given it will house the full set of reactions, it will also encompass the software and hardware requirements of the liquid temperature control (including the associated controller), along with the magnetic separation required in tube number 4 of the cassette. The Magnetic Separation Station will be the location of disposal of the supernatant and therefore shall include the magnetic hardware required to physically manipulate the magnetic silica beads in order to retain them in the pipette tip while the waste is expelled. Given the biological nature of the liquid waste involved, this station will also include provisions for hygienically disposing of and storing this waste.

3.1 Processor Module

3.1.1 Hardware

The hardware component of the Processor Module design is concerned with ensuring the module accepts the required cassette tubes, fits within the stipulated SBS space and provides a stable platform for the required temperature control using the knowledge gained in Section 2.3, Controllability. The work in this sections will also include the selection of an appropriate heat pumping device. In order to ensure the requirements of the hardware elements are met, the design process is applied as follows:

1. Generation of concepts related to thermally isolating the heated and non-heated regions of the block. This includes a focus on the manufacturability of the resulting components.
2. Investigation into and selection of an appropriate heating method.
3. Full CAD design of hardware including provisions to accommodate the required tubes.
4. Utilization of 3D printing to test the fit of the cassette tubes in the block design.
5. CFD simulation to verify the performance of the selected heating element and the thermal stability of the final design.

3.1.2 Temperature Controller

This work will output a software temperature controller capable meeting the liquid heating requirements of the chemical reaction as detailed in Section

1.1.1, The Extraction Process. The following method is followed to ensure the desired output is obtained:

1. Assembly of the fully manufactured Processor Module.
2. Utilize sensors in the locations given in below to gather data of the temperature at relevant points over time:
 - The temperature at the centre of the block will be taken as this sensor data is what will be used as feedback for the controller to be implemented. This follows the recommendations given in Section 2 by Vilchiz et. al.
 - The temperature of the heatsink will be plotted to monitor the temperature differential created across the module if TEC's are selected as the heat pump device.
 - The temperature of the heated region of the module will be taken on its outer surface to determine the success of the design in creating a component that responds to temperature control in responsive and stable manner.
 - The temperature of the liquid within the cassette tubes will be measured as the final output of the system. The ability of the controller to drive this temperature to the desired set point will determine the success of the design.
3. An Arduino will be used as an interface device to connect to MATLAB, which will be used as a data logger and analysis tool. The real time data will be displayed along with stored for future use.
4. The software and electronics used to control the MTX Cycler (see Section 1.3) will be modified to provide a step input to the system.

5. The response of the system to the step input will then be logged and the temperature response of the block centre will be used to identify the modules plant function via MATLAB.
6. A Simulink simulation will then be created to validate the estimated system parameters produce an output which matches the response obtained experimentally.
7. A discrete controller will then be designed via the direct method.
8. The designed controllers ability to drive the system to a steady state of 60°C will then be validated via Simulink simulation.
9. The validated controller will then be implemented via the MTX Cyclor software with any required modifications.

Experimental Verification

In order to verify the performance of the resulting controller, the following experimental verification will be conducted. The experiment will determine the ability of the controller to meet the steady state error, disturbance rejection, response time, overshoot and stability requirements when controlling temperature in the module. The method is as follows:

1. Assemble 4 complete Processor Modules
2. Using an Arduino as an interface and MATLAB as the data logger and analyser, measure the temperature in the tubes shown in Figure 3.1 for the duration of the experiment. This distribution will allow the performance at the extremes of the device to be determined.

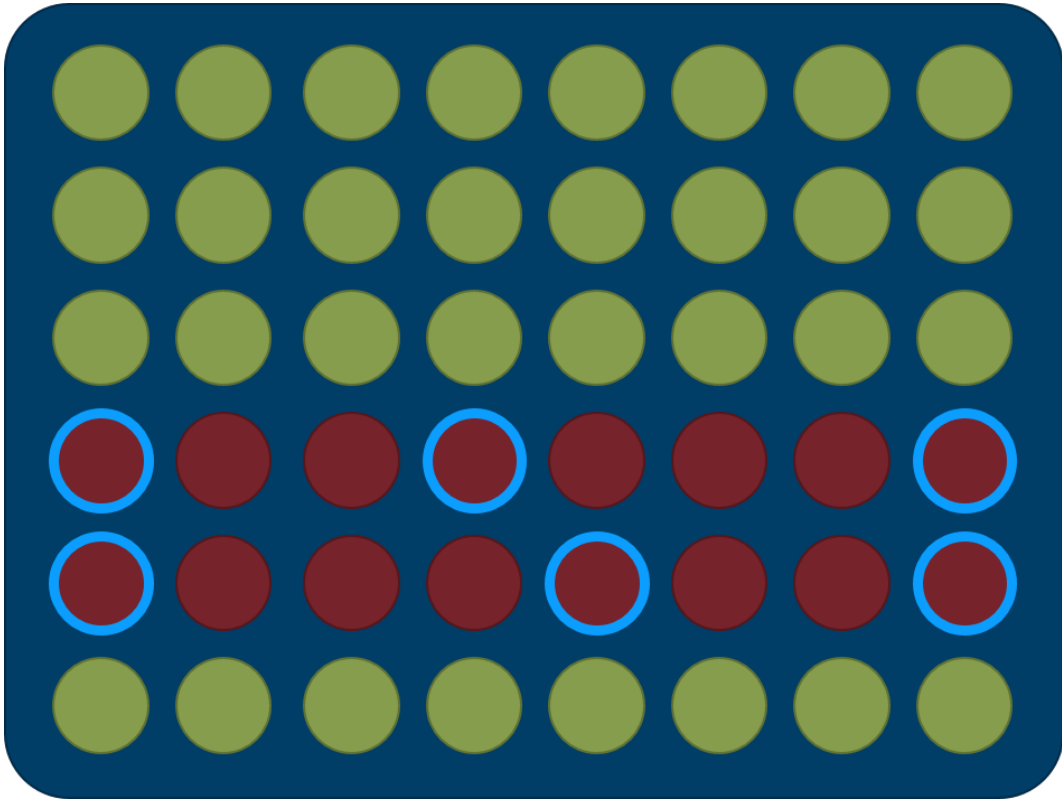


Fig. 3.1: Tube locations to be measured during temperature control verifications experiment. Non-Heated tubes are coloured green, heated tubes are coloured red, measured tubes are outlined in blue.

3. Begin data logging and live plotting.
4. Set the reference input to the controller to 60°C.
5. Collect data for a total of 30 minutes to capture the long term steady state performance of the module (to allow any slow heat transfers to be observed) along with the transient response.
6. Repeat the experiment for all four assembled modules. This allows for the controllers ability to reject disturbances caused by the differing of the plant properties to be determined as is caused by the slight differences in assembly.
7. Repeat experiment in differing environmental conditions. The experi-

ment should be conducted in rooms at temperatures of 18°C, 22°C and 26°C. This allows for the disturbance rejection of the controller to be assessed where the disturbance is due to altered environmental conditions.

8. Use the collected data to assess the consistency of the heating profile and the temperature stabilisation across the tubes of the module. These results will be used to make conclusions regarding the designed controller along with the thermal characteristics of the hardware. It should be noted that the worst case response will be used to draw conclusions regarding performance to ensure all samples fall within the requirements.

3.1.3 Magnetic Separation

As the final stage of the extraction process is the removal of the clean sample from the waste beads, the success of extraction depends on the complete and reliable separation in tube number 4. To ensure this is achieved, the following design process and experimental verification will be conducted:

1. An investigation will be conducted into the various possible methods of magnetic separation in this application, taking into account the recommendations to use ND-Fe-B magnet compositions as found in the reviewed literature.
2. 3D Printed test jigs will be created to test the effectiveness of the most suitable configurations via manual inspection.
3. With a preferred design selected, the a test module will be 3D printed including the magnetic arrangement. This test module will be assembled on the robot deck and verified experimentaly via the method described below.

Experimental Verification

To allow a confident conclusion to be made regarding the effectiveness of the magnetic separation within the Processor Module to be made, the following experiment will be conducted. This experiment will replicate the setup used by the robot and its processes to ensure the result is representative of the true scenario.

1. Place test module with magnetic separation on Gene-Plex Extractor deck within one of the SBS spaces.
2. Place a 5mL tube on the robot deck to collect the experiment output.
3. Place a full set of 8 cassettes in the test module with 100 μ L of filtered water and 10 μ L of magnetic beads in tube 3. The water will simulate the elution buffer. Both volumes are equal to that used in the final process.
4. Instruct the robot to aspirate the mixture in tube 3 and expel it into tube 4, the location of the magnetic separation.
5. Wait for 5 seconds for separation to take place. It should be noted that this waiting period is a design variable and may be adjusted and this experiment repeated to determine the optimal wait time.
6. Aspirate the separated liquid at a distance of 1mm from the tube bottom. This distance once again may be adjusted, however is a sound starting point for experimentation.
7. Expel the liquid from the tip into the 5mL tube on the deck.
8. Repeat this separation procedure for all 8 cassettes.

9. Refill all cassettes with equal volumes of water and beads, as was defined in step 3.
10. Repeat the separation for a total of 3 modules to equal the total volume of liquid which will be processed by the Gene-Plex Extractor during the processing of all 24 samples.
11. Place the 5mL tube with extracted contents adjacent to a large ND-Fe-B magnet to draw any beads to the tube wall. Examine the tube contents for any sign of magnetic beads. The presence of a bead within the tube indicated a failed separation within tube 4. Such a result may lead to severe complications in step 2 (amplification), such as the failed diagnosis of a patient. Therefore, for a successful verification, it is required that no beads are present.

3.2 Magnetic Separation Station

The magnetic separation station is a standalone module on the robot deck which will fulfil two requirements of the extraction process. Firstly, the station will provide the means of separating the waste liquid from the magnetic beads and captured DNA/RNA, as necessary after step 2 (refer to Section 1.1.1) of the extraction process. Following the successful separation of the supernatant, the separation station will provide a means of hygienically disposing of the associated biological waste. The work will be completed via the methodology described below.

3.2.1 Magnetic Separation

This stage of the extraction process carries a high level of significance in relation to the final result. Poor magnetic separation may effect the reliability of the diagnosis due to a reduction in the sensitivity of the step 2 amplification, or failure of step 3 analysis due to the presence of inhibitors. The former may be caused by a lack of concentration of the target DNA or RNA in the extracted clean sample. Failed magnetic separation could cause this by not properly capturing the magnetic beads and bound target, allowing them to be expelled into waste. This loss of target will lower the sensitivity of the amplifications stage and hence may lower the accuracy of diagnosis. The second scenario of inhibitors may occur if some of the waste liquid remains after washing, contaminating the sample and lowering the effectiveness of the amplification and analysis steps. Therefore, the method used for the design of the magnetic separation capabilities of the Magnetic Separation Station is aimed at ensuring a strong and reliable separation.

1. An investigation will be carried out to determine the most suitable magnetic arrangement for providing reliable separation. Similar to the treatment of the magnetic separation capabilities within the Processor Module, the investigation will focus on those employing the ND-Fe-B composition.
2. The selected configuration will then be implemented as a design concept and a CAD model generated. This detailed design will also account for a number of secondary requirements. These include maintaining a minimum distance between the pipette tip and the Separation Station at all points to remove the possibility of cross contamination occurring through liquid transfer.

3. The detailed design will then be prototyped using 3D printing to allow experimental verification.
4. The prototype Separation Station will then be assembled on the Gene-Plex Extractor deck along with the necessary tubes to perform magnetic separation via the experimental procedure detailed below.

Experimental Verification

In order to verify the required performance is achieved by the designed Magnetic Separation Station, the following experiment will be performed.

1. The prototyped Magnetic Separation Station will be fully assembled and positioned on the deck of the Gene-Plex Extractor.
2. 3 cassettes and therefore 24 tubes will be positioned on the deck with 640 μ L of water and 10 μ L of magnetic silica beads in each. These volumes are equal to those used in the extraction process and this will be repeated 24 times, once for each of the 24 samples. Therefore, this setup matches the volumes to be processed by the implemented extractor.
3. The robot will then be setup to aspirate the liquid mixture from one of the tubes.
4. The pipette will then be positioned within the magnetic separation station and lowered to full depth.
5. The pipette tip will then be raised and lowered with the full liquid height passing along the magnetic arrangement a total of 2 times.
6. With the beads now separated from the liquid and captured on the pipette wall, the water will be ejected into the waste disposal system.

For this experiment, the waste disposal will be replaced by a small glass container that may be used to collect and analyse the ejected liquid.

7. This procedure will then be repeated for all 24 “samples”.
8. The contents of the waste container will then be subjected to a magnetic field to collect any beads which were not correctly separated by the process. The presence of any bead within the waste liquid indicated a failed separation.

3.2.2 Waste Disposal

The work on this component of the Magnetic Separation Station is concerned with ensuring the product meets key standards and requirements in order to dispose of the biological waste in a hygienic manner. The disposal of the waste generated by the process is a key factor in ensuring a successful sample extraction. Any failure to safely dispose of this waste may introduce the risk of a cross contamination occurring between two independent samples and therefore a failure to correctly diagnose the patient.

To ensure the waste disposal system negates these risks, the process used will focus on researching the related standards initially in order to determine the best practices which must, by regulation, be adhered to. This research will be supplemented by end user feedback. To gain this, a group of key product users will be consulted on preferred methods of waste disposal and hygiene to guide the design process. Using the results of this investigation, the design process will be used to form a final design which takes into account the gathered information and requirements and therefore produce a functional and hygienic waste disposal system.

Chapter 4

Results

The problem at hand along with the need for a solution are now well defined. Paired with an understanding of important previous works in this area and the technologies available, the design of each of the components may be given consideration. This chapter will present the designs of the required additions to the Gene-Plex Extractor, as were defined in Section 1.3, Scope. This will include relevant aspects of the design process, the conducted simulations along with validations and verifications via experimental methods. Through the sections below, the reader will be familiar with the design of each of the components along with the resulting performance of the realised and implemented component.

4.1 Processor Module Hardware

4.1.1 Requirements

4.1.2 Design

4.1.3 Simulation

4.2 Temperature Controller

4.2.1 Requirements

4.2.2 Design

4.2.3 Simulation

4.3 Processor Module

4.3.1 Validation

4.3.2 Verification

4.4 Magnetic Separation Station

Chapter 5

Discussion

Chapter 6

Conclusions

Chapter 7

Future Work

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Appendix A

Raw Results