

Title (en)
Micro-titer plate and method of making same

Title (de)
Mikrotiterplatte und Verfahren zu ihrer Herstellung

Title (fr)
Plaque de microtitrage et sa méthode de fabrication

Publication
EP 1110611 A1 20010627 (EN)

Application
EP 99204505 A 19991223

Priority
EP 99204505 A 19991223

Abstract (en)
The present invention provides a method of manufacturing a micro-titer test plate comprising a plurality of sample containers (10) connected to each other of which each sample container (10) has one or more side walls enclosing the interior of said sample container, a bottom wall with an outlet opening and an opposite upper end that is open and defines an inlet opening (14), said method comprising the steps of: providing a first (60,61,110,120) and second part (50,80,200), said first part (60,61,110,120) comprising a plurality of wells (30,115,125) connected to each other and each having an upper end that is open and that will define the inlet opening (14,114,124) of said sample containers (10) and an opposite bottom opening (16,116,126) and said second part (50,80,200) comprising a plurality of spouts (24) connected to each other, said spouts (24) conforming in arrangement and number to said wells (30,115,125) of said first part (60,61,110,120) and each spout (24) enclosing at a first end (23,201) an opening (22,202) that will define the outlet opening of said sample containers (10), and each spout (24) optionally having an upper opening (55) at said first end (23) for receiving a filter means (39); placing a filter sheet (1,5) that extends across each of said wells (30,115,125) of said first part (60,61,110,120) on one side of said first part or placing a filter sheet (1,5) that extends across each of said spouts (24) of said second part (50,80,200) on the side of said second part having said first ends (23,201); separating from said filter sheet (1,5) filter means (39) that conform in shape, size, arrangement and number to either the bottom opening (16,116,126) of the wells of said first part (60,61,110,120) or when present, to said optional upper openings (55) provided at the first end (23,201) of the spouts (24); placing said filter means (39) in each of the bottom openings (16,116,126) of the wells or when present in each of said upper openings (55) provided at the first end (23,201) of the spouts (24); removing the remainder of said filter sheet (1,5) from which the filter means (39) have been separated; bringing said first part (60,61,110,120) and said second part (50,80,200) in contact with each other such that the bottom opening (16,116,126) of said wells face the first end (23,201) of said spouts (24); and bonding said first part (60,61,110,120) and said second part (50,80,200) to each other by permanently and irreversibly bonding each of the wells (30,115,125) of said first part (60,61,110,120) to each of the spouts (24) of said second part (50,80,200) thereby forming a plurality of sample containers (10) connected to each other that are sealed with respect to each other. <IMAGE>

IPC 1-7
B01L 3/00; **B01D 61/18**

IPC 8 full level
G01N 33/48 (2006.01); **B01D 61/18** (2006.01); **B01L 3/00** (2006.01); **C12M 1/34** (2006.01)

CPC (source: EP)
B01L 3/50255 (2013.01)

Citation (search report)
• [A] WO 9855233 A1 19981210 - CORNING INC [US]
• [DAA] US 4948442 A 19900814 - MANNS ROY [US]
• [DA] US 4304865 A 19811208 - O'BRIEN JACQUELINE A, et al
• [DA] US 5464541 A 19951107 - AYSTA JAMES E [US], et al

Cited by
EP2181767A1; FR2887159A1; EP1591164A1; DE10321042A1; DE10321042B4; US7122155B2; US8007744B2; US9005549B2;
WO2006136514A1; WO2096563A3; WO2004007076A3; US7135117B2; US7371325B2

Designated contracting state (EPC)
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU MC NL PT SE

DOCDB simple family (publication)
EP 1110611 A1 20010627; AT E327829 T1 20060615; AU 2453101 A 20010703; DE 60028413 D1 20060706; DE 60028413 T2 20061130;
EP 1239960 A1 20020918; EP 1239960 B1 20060531; JP 2003518248 A 20030603; JP 4602623 B2 20101222; WO 0145844 A1 20010628

DOCDB simple family (application)
EP 99204505 A 19991223; AT 00988309 T 20001221; AU 2453101 A 20001221; DE 60028413 T 20001221; EP 00988309 A 20001221;
JP 2001546780 A 20001221; US 0035092 W 20001221