
CONTENTS

| | |
|--|-----------|
| Preface | xv |
| 1 Introduction | 1 |
| 1.1 Introduction / 1 | |
| 1.1.1 Scope / 1 | |
| 1.1.2 What Is HPLC? / 2 | |
| 1.1.3 A Brief History / 3 | |
| 1.1.4 Advantages and Limitations / 4 | |
| 1.2 Modes of HPLC / 5 | |
| 1.2.1 Normal-Phase Chromatography (NPC) / 5 | |
| 1.2.2 Reversed-Phase Chromatography (RPC) / 7 | |
| 1.2.3 Ion-Exchange Chromatography (IEC) / 7 | |
| 1.2.4 Size-Exclusion Chromatography (SEC) / 9 | |
| 1.2.5 Other Separation Modes / 10 | |
| 1.3 Some Common-Sense Corollaries / 11 | |
| 1.4 How to Get More Information / 12 | |
| 1.5 Summary / 13 | |
| 1.6 References / 13 | |
| 2 Basic Terms and Concepts | 15 |
| 2.1 Scope / 16 | |
| 2.2 Basic Terms and Concepts / 17 | |
| 2.2.1 Retention Time (t_R), Void Time (t_M), Peak Height (h), and Peak Width (w_b) / 17 | |
| 2.2.2 Retention Volume (V_R), Void Volume (V_M), and Peak Volume / 18 | |
| 2.2.3 Retention Factor (k) / 19 | |
| 2.2.4 Separation Factor (α) / 20 | |
| 2.2.5 Column Efficiency and Plate Number (N) / 21 | |
| 2.2.6 Peak Volume / 22 | |
| 2.2.7 Height Equivalent to a Theoretical Plate or Plate Height (HETP or H) / 23 | |

| | |
|-------|---|
| 2.2.8 | Resolution (R_s) / 23 |
| 2.2.9 | Peak Symmetry: Asymmetry Factor (A_s) and Tailing Factor (T_f) / 24 |
| 2.3 | Mobile Phase / 27 |
| 2.3.1 | General Requirements / 27 |
| 2.3.2 | Solvent Strength and Selectivity / 28 |
| 2.3.3 | Buffers / 31 |
| 2.3.4 | Acidic Mobile Phases / 32 |
| 2.3.5 | Ion-Pairing Additives / 32 |
| 2.3.6 | High pH Mobile Phase / 33 |
| 2.3.7 | Other Operating Parameters: Flow Rate (F) and Column Temperature (T) / 33 |
| 2.4 | The Resolution Equation / 34 |
| 2.5 | The Van Deemter Equation / 35 |
| 2.6 | Isocratic vs. Gradient Analysis / 39 |
| 2.6.1 | Peak Capacity (n) / 40 |
| 2.6.2 | Key Gradient Parameters (Initial and Final Solvent Strength, Gradient Time [t_G], and Flow Rate) / 41 |
| 2.6.3 | The $0.25\Delta t_G$ Rule: When Is Isocratic Analysis More Appropriate? / 42 |
| 2.7 | Concept of Orthogonality / 42 |
| 2.8 | Sample Capacity / 44 |
| 2.9 | Glossary of HPLC Terms / 44 |
| 2.10 | Summary and Conclusion / 45 |
| 2.11 | References / 46 |

3 HPLC Columns and Trends

47

| | |
|-------|---|
| 3.1 | Scope / 48 |
| 3.2 | General Column Description and Characteristics / 48 |
| 3.2.1 | Column Hardware—Standard vs. Cartridge Format / 49 |
| 3.3 | Column Types / 50 |
| 3.3.1 | Types Based on Chromatographic Modes / 50 |
| 3.3.2 | Types Based on Dimensions / 51 |
| 3.3.3 | Column Length (L) / 51 |
| 3.4 | Column Packing Characteristics / 52 |
| 3.4.1 | Support Type / 53 |
| 3.4.2 | Particle Size (d_p) / 54 |
| 3.4.3 | Surface Area and Pore Size (d_{pore}) / 54 |
| 3.4.4 | Bonding Chemistries / 54 |
| 3.4.5 | Some General Guidelines for Bonded Phase Selection / 56 |
| 3.5 | Modern HPLC Column Trends / 57 |
| 3.5.1 | High-Purity Silica / 58 |

- 3.5.2 Hybrid Particles / 58
- 3.5.3 Novel Bonding Chemistries / 59
- 3.5.4 Fast LC / 64
- 3.5.5 Micro LC / 66
- 3.5.6 Monoliths / 68
- 3.6 Guard Columns / 69
- 3.7 Specialty Columns / 70
 - 3.7.1 Bioseparation Columns / 70
 - 3.7.2 Chiral Columns / 70
 - 3.7.3 Application-Specific Columns / 70
- 3.8 Column Selection Guides / 70
- 3.9 Summary / 73
- 3.10 References / 74
- 3.11 Internet Resources / 75

4 HPLC Instrumentation and Trends

77

- 4.1 Introduction / 78
 - 4.1.1 Scope / 78
 - 4.1.2 HPLC Systems and Modules / 79
- 4.2 HPLC Solvent Delivery Systems / 81
 - 4.2.1 High-Pressure and Low-Pressure Mixing Designs in Multisolvant Pumps / 82
 - 4.2.2 System Dwell Volume / 83
 - 4.2.3 Trends / 84
- 4.3 Injectors and Autosamplers / 84
 - 4.3.1 Operating Principles of Autosamplers / 85
 - 4.3.2 Performance Characteristics and Trends / 86
- 4.4 Detectors / 87
- 4.5 UV/VIS Absorbance Detectors / 87
 - 4.5.1 Operating Principles / 87
 - 4.5.2 Performance Characteristics / 88
 - 4.5.3 Trends in Absorbance Detectors / 89
- 4.6 Photodiode Array Detectors / 91
 - 4.6.1 Operating Principles / 91
 - 4.6.2 Trends in PDA Detectors / 93
- 4.7 Other Detectors / 93
 - 4.7.1 Fluorescence Detector (FLD) / 93
 - 4.7.2 Refractive Index Detector (RID) / 94
 - 4.7.3 Evaporative Light Scattering Detector (ELSD) / 94
 - 4.7.4 Corona-Charged Aerosol Detector (CAD) / 94
 - 4.7.5 Chemiluminescence Nitrogen Detector (CLND) / 95
 - 4.7.6 Electrochemical Detector (ECD) / 95

- 4.7.7 Conductivity Detector / 95
- 4.7.8 Radiometric Detector / 95
- 4.8 Hyphenated and Specialized Systems / 96
 - 4.8.1 LC/MS, LC/MS/MS / 96
 - 4.8.2 LC/NMR / 97
 - 4.8.3 Other Hyphenated Systems / 97
 - 4.8.4 Prep LC and Bio-Purification Systems / 97
 - 4.8.5 Proteomics Systems: Capillary LC and Multi-Dimensional LC / 98
 - 4.8.6 High-Throughput Screening (HTS) and Parallel Analysis Systems / 99
 - 4.8.7 Ultra-High-Pressure Liquid Chromatography / 101
 - 4.8.8 Lab-on-a-Chip / 101
 - 4.8.9 Specialized Applications Systems / 101
- 4.9 HPLC Accessories and Data Handling Systems / 102
 - 4.9.1 Solvent Degasser / 102
 - 4.9.2 Column Oven / 102
 - 4.9.3 Column Selector Valve / 103
 - 4.9.4 Data Handling and HPLC Controllers / 103
- 4.10 Instrumental Bandwidth (IBW) / 104
- 4.11 Trends in HPLC Equipment / 107
- 4.12 Manufacturers and Equipment Selection / 108
- 4.13 Summary / 109
- 4.14 References / 109
- 4.15 Internet Resources / 110

5 HPLC Operation Guide

111

- 5.1 Scope / 112
- 5.2 Safety and Environmental Concerns / 112
 - 5.2.1 Safety Concerns / 112
 - 5.2.2 Environmental Concerns / 114
- 5.3 Mobile Phase Preparation / 114
 - 5.3.1 Mobile Phase Premixing / 114
 - 5.3.2 Buffers / 114
 - 5.3.3 Filtration / 115
 - 5.3.4 Degassing / 116
- 5.4 Best Practices in HPLC System Operation / 116
 - 5.4.1 Pump Operation / 117
 - 5.4.2 HPLC Column Use, Connection, and Maintenance / 117
 - 5.4.2.1 Column Use / 117
 - 5.4.2.2 Column Precautions / 118

| | |
|---------|---|
| 5.4.2.3 | Column Connection / 118 |
| 5.4.2.4 | Column Maintenance and Regeneration / 118 |
| 5.4.3 | Autosampler Operation / 120 |
| 5.4.4 | Detector Operation / 120 |
| 5.4.5 | System Shutdown / 121 |
| 5.4.6 | Guidelines for Increasing HPLC Precision / 122 |
| 5.4.6.1 | Guidelines for Improving Retention Time Precision / 122 |
| 5.4.6.2 | Guidelines for Improving Peak Area Precision / 122 |
| 5.5 | From Chromatograms to Reports / 123 |
| 5.5.1 | Qualitative Analysis Strategies / 128 |
| 5.5.2 | Quantitation Analysis Strategies / 128 |
| 5.6 | Summary of HPLC Operation / 129 |
| 5.7 | Guides on Performing Trace Analysis / 129 |
| 5.8 | Summary / 132 |
| 5.9 | References / 132 |

6 Pharmaceutical Analysis **135**

| | |
|-------|--|
| 6.1 | Introduction / 136 |
| 6.1.1 | Scope / 136 |
| 6.1.2 | Overview: From Drug Discovery to Quality Control / 136 |
| 6.1.3 | Sample Preparation Perspectives in Drug Product Analysis / 137 |
| 6.1.4 | High-Throughput LC/MS in Drug Discovery Support / 137 |
| 6.2 | Identification / 138 |
| 6.3 | Assays / 139 |
| 6.3.1 | Drug Substances / 140 |
| 6.3.2 | Drug Products / 140 |
| 6.3.3 | Content Uniformity / 142 |
| 6.3.4 | Products with Multiple APIs and Natural Products / 142 |
| 6.3.5 | Assay of Preservatives / 145 |
| 6.4 | Impurity Testing / 145 |
| 6.4.1 | Trends in Impurity Testing / 148 |
| 6.5 | Dissolution Testing / 148 |
| 6.6 | Cleaning Validation / 148 |
| 6.7 | Bioanalytical Testing / 150 |
| 6.8 | Chiral Analysis / 151 |
| 6.9 | Case Study: HPLC Methods in Early Development / 152 |
| 6.10 | Summary / 153 |
| 6.11 | References / 155 |

| | | |
|----------|--|------------|
| 7 | Food, Environmental, Chemical, and Life Sciences Applications | 157 |
| 7.1 | Introduction / 158 | |
| 7.1.1 | Scope / 158 | |
| 7.2 | Food Applications / 158 | |
| 7.2.1 | Natural Food Components / 159 | |
| 7.2.1.1 | Sugars / 159 | |
| 7.2.1.2 | Fats, Oils, and Triglycerides / 160 | |
| 7.2.1.3 | Free Fatty Acids and Organic Acids / 162 | |
| 7.2.1.4 | Proteins and Amino Acids / 162 | |
| 7.2.2 | Food Additives / 164 | |
| 7.2.2.1 | Flavors: A Case Study on HPLC Analysis of Capsaicins / 166 | |
| 7.2.3 | Contaminants / 167 | |
| 7.2.3.1 | Mycotoxins / 168 | |
| 7.2.3.2 | Antimicrobial Additives / 168 | |
| 7.2.3.3 | Pesticide Residues / 169 | |
| 7.3 | Environmental Applications / 169 | |
| 7.3.1 | Listing of Important U.S. EPA HPLC Methods / 170 | |
| 7.3.2 | Pesticides Analysis / 170 | |
| 7.3.2.1 | Carbamates and Glyphosate / 170 | |
| 7.3.3 | Polynuclear Aromatic Hydrocarbons (PAH) / 172 | |
| 7.3.3.1 | Case Study: Quick Turnaround Analysis of PAHs by HPLC in Multimedia Samples / 172 | |
| 7.4 | Chemical, GPC and Plastics Applications / 173 | |
| 7.4.1 | Gel-Permeation Chromatography (GPC) and Analysis of Plastics Additives / 175 | |
| 7.5 | Ion Chromatography / 178 | |
| 7.6 | Life Sciences Applications / 179 | |
| 7.6.1 | Proteins, Peptides, and Amino Acids / 179 | |
| 7.6.2 | Bases, Nucleosides, Nucleotides, Oligonucleotides, Nucleic Acids, and PCR Products / 186 | |
| 7.7 | Summary / 188 | |
| 7.8 | References / 190 | |
| 8 | HPLC Method Development | 193 |
| 8.1 | Introduction / 194 | |
| 8.1.1 | Scope / 194 | |
| 8.1.2 | Considerations Before Method Development / 194 | |
| 8.1.3 | Strategy for Method Development / 195 | |

| | | |
|---------|--|--|
| 8.1.4 | HPLC Method Development Trends in Pharmaceutical Analysis / 195 | |
| 8.2 | Defining Method Types and Goals / 196 | |
| 8.2.1 | Method Goals / 196 | |
| 8.3 | Gathering Sample and Analyte Information / 197 | |
| 8.3.1 | Defining Sample Preparation Requirements / 197 | |
| 8.4 | Initial HPLC Method Development / 198 | |
| 8.4.1 | Initial Detector Selection / 198 | |
| 8.4.2 | Selection of Chromatographic Mode / 199 | |
| 8.4.3 | Initial Selection of HPLC Column / 199 | |
| 8.4.4 | Generating a First Chromatogram / 200 | |
| 8.4.4.1 | Case Study: Initial Method Development Using a Broad Gradient and Mobile Phase Selection / 200 | |
| 8.5 | Method Fine-Tuning / 204 | |
| 8.5.1 | Mobile Phase Parameters (%B, Buffer, pH, Solvent Type) / 205 | |
| 8.5.2 | Operating Parameters (F, T, $\Delta\phi$, t_G) / 206 | |
| 8.5.3 | Column Parameters (Bonded Phase Type, L, d_p , d_c) / 206 | |
| 8.5.4 | Detector Setting and Sample Amount / 206 | |
| 8.5.5 | Summary of Method Development Steps / 207 | |
| 8.6 | Phase-Appropriate Method Development / 208 | |
| 8.7 | Method Development Software Tools / 210 | |
| 8.8 | Case Studies / 210 | |
| 8.8.1 | Composite Assay Method for a Neutral Drug Substance / 210 | |
| 8.8.2 | Composite Drug Substance Method for a Basic Drug Substance / 214 | |
| 8.8.3 | Impurity Method for a Drug Product with Two APIs / 215 | |
| 8.9 | Summary and Conclusions / 217 | |
| 8.10 | References / 220 | |

9 Regulatory Aspects of HPLC Analysis: HPLC System and Method Validation **221**

| | |
|-------|---------------------------------------|
| 9.1 | Introduction / 222 |
| 9.1.1 | Scope / 222 |
| 9.1.2 | The Regulatory Environment / 222 |
| 9.2 | HPLC System Qualification / 224 |
| 9.2.1 | Design Qualification (DQ) / 225 |
| 9.2.2 | Installation Qualification (IQ) / 225 |
| 9.2.3 | Operational Qualification (OQ) / 225 |

- 9.2.4 Performance Qualification (PQ) / 225
- 9.2.5 Documentation / 226
- 9.2.6 System Calibration / 227
- 9.3 Method Validation / 227
 - 9.3.1 Validation Parameters / 230
- 9.4 System Suitability Testing (SST) / 235
- 9.5 Case Study on Method Validation / 237
- 9.6 Cost-Effective Regulatory Compliance / 239
- 9.7 Summary and Conclusions / 240
- 9.8 References / 240
- 9.9 Internet Resources / 241

10 HPLC Maintenance and Troubleshooting Guide 243

- 10.1 Scope / 244
- 10.2 HPLC System Maintenance / 244
 - 10.2.1 LC Pump / 244
 - 10.2.2 UV/Vis Detectors / 247
 - 10.2.3 Injector and Autosampler / 248
- 10.3 HPLC Troubleshooting / 248
 - 10.3.1 General Problem Diagnostic and Troubleshooting Guide / 248
 - 10.3.2 Common HPLC Problems / 250
 - 10.3.2.1 Pressure Problems and Causes / 250
 - 10.3.2.2 Baseline Problems (Chromatogram) / 251
 - 10.3.2.3 Peak Problems (Chromatogram) / 253
 - 10.3.2.4 Data Performance Problems / 256
- 10.4 Case Studies / 257
 - 10.4.1 Case Study 1: Reducing Baseline Shift and Noise for Gradient Analysis / 257
 - 10.4.2 Case Study 2: Poor Peak Area Precision Encountered During HPLC System Calibration / 258
 - 10.4.3 Case Study 3: Poor Assay Accuracy Data, an Out-of-Specification Investigation / 260
 - 10.4.4 Case Study 4: Equipment Malfunctioning / 261
- 10.5 Summary and Conclusion / 263
- 10.6 References / 263
- 10.7 Internet Resources / 263

11 Modern Trends in HPLC 265

- 11.1 Columns: Shorter and Narrower Packed with Small Particles / 266

| | | |
|-------|---------------------------------------|-----|
| 11.2 | Column Packing: Novel Bonded Phases / | 266 |
| 11.3 | Pumps / | 266 |
| 11.4 | Autosamplers / | 267 |
| 11.5 | Detectors / | 267 |
| 11.6 | HPLC Systems / | 268 |
| | 11.6.1 Low-Dispersion Instruments / | 268 |
| | 11.6.2 Ultra-High-Pressure LC / | 268 |
| | 11.6.3 Multi-Dimensional LC / | 268 |
| | 11.6.4 Parallel Analysis / | 269 |
| 11.7 | Lab-on-a-Chip / | 269 |
| 11.8 | Data Handling / | 269 |
| 11.9 | Regulatory Compliance / | 269 |
| 11.10 | Greener HPLC Methods / | 270 |
| 11.11 | Summary and Conclusions / | 270 |
| 11.12 | References / | 271 |