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Thin-film conformal fluorescent SU8-phenylenediamine†

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The SU8 polymer is a negative photoresist widely used to produce high-quality coatings, with controllable thicknesses ranging from nanometers to millimeters, depending on fabrication protocols. Apart from conventional use cases in microelectronics and fluidics, SU8 is quite an attractive platform in nanophotonics. This material, being straightforwardly processed by ultraviolet lithography, is transparent to wavelengths longer than 500 nm. However, introducing fluorescent agents within the SU8 matrix remains a challenge owing to its high hydrophobicity. Here, we develop a process, where colorful quantum dots co-participate in the polymerization process by epoxide amination and become a part of a new fluorescent material – SU8-phenylenediamine. Through comprehensive characterization methods, including XPS and ¹H-NMR analyses, we demonstrate that *m*-PD covalently binds to SU8 epoxy sites with its molecular amine, virtually forming a new material and not just a mixture of two compounds. After characterizing the new strongly fluorescent platform, thin 300 nm films were created on several surfaces, including a conformal coverage of a nanofluidic capillary. This new process provides opportunities to incorporate various functional molecules into optoelectronic devices without the need for multistep deposition and surface functionalization.

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Introduction

The SU8 epoxy-based photoresist has gained significant attention since it was first introduced in 1995.¹ Since epoxy groups are crosslinked by being exposed to ultraviolet (UV) light (typically 365–405 nm) and form a stable solid structure, the polymer belongs to the family of negative photoresists.^{2,3} After revealing numerous advantages of SU8, it became a technological platform across many disciplines, including microfluidics,^{4–7} micromechanics,⁸ biomedicine,⁹ optoelectronics,^{10,11} and many others.^{12–15}

Superior mechanical and thermal stability along with great adhesion to a vast majority of commonly used surfaces (*e.g.*, glasses,⁷ metals,¹⁶ semiconductors,¹⁷ and many others¹⁸) make SU8 a platform of choice in cases where facile low-cost fabrication of microstructures is required.^{18,19} For example, structures with sharp edges and high aspect ratios approaching 1 : 20, 1 : 40, and even higher can be fabricated by photolithographic methods.²⁰ Furthermore, spin-coating protocols with accurately controlled parameters allow fabricating films with thicknesses ranging from sub-microns up to millimeters.¹⁵

Apart from its mechanical properties, SU8 is also an optically transparent material. Having a strong absorption in the UV range owing to benzene rings, the material is transparent for wavelengths longer than ~500 nm.^{21,22} Due to its optical and mechanical properties, SU8 is employed for fabricating micro-fluidic channels, routinely used in various biological studies, *e.g.*, for cell culturing.²³ Three-dimensional SU8-based devices allow mimicking microenvironments experienced by cells in a complex tissue.^{9,24} Incredible advances in the growth and differentiation of neural and muscle cells²⁵ encompass significant microfluidic components, where engineered thin-layer polymers play a role.³¹ Microfluidic channels were developed to guide axonal development towards the muscle cells, paving the way for a deeper understanding of the pathology of amyotrophic lateral sclerosis (ALS).²⁶ Along with biological studies, many photonic applications have been explored.

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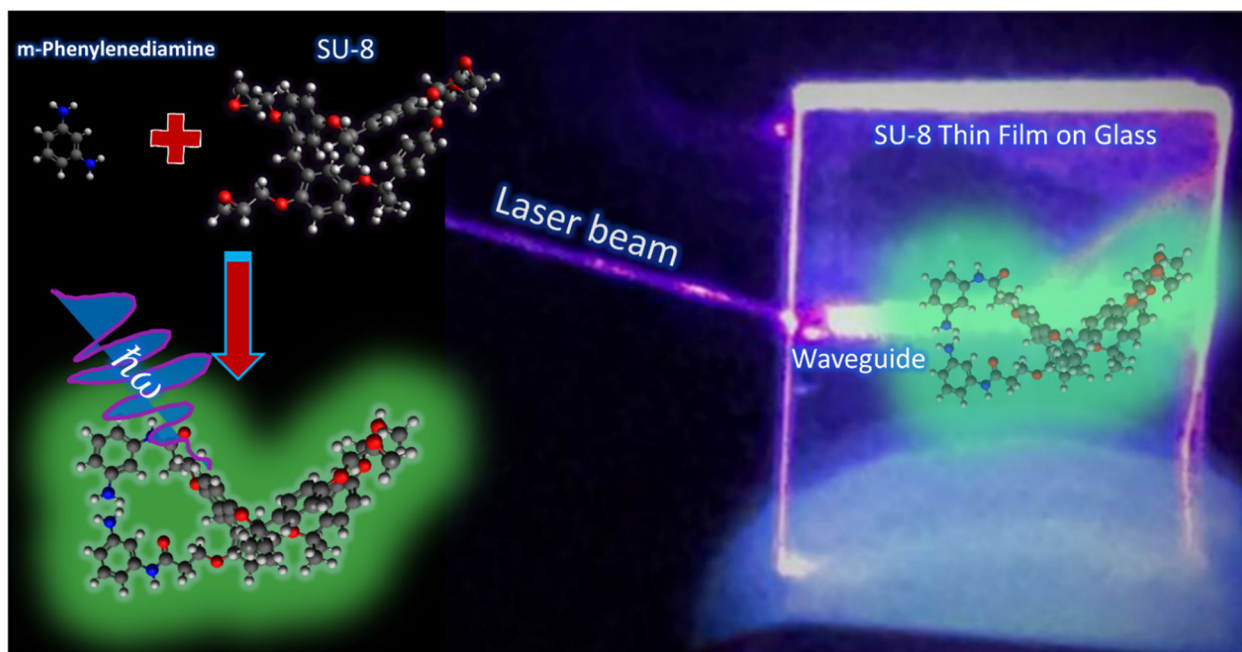



Fig. 1 Graphical illustrations and a practical application of the SU8 polymer before and after conjugation with *m*-phenylenediamine (*m*-PD). The upper left panel represents the dimeric form of the SU8 polymer prior to the conjugation process with *m*-PD. The lower left panel shows the resulting structure post-conjugation, depicting the modifications imparted to the SU8 polymer by *m*-PD. The right panel showcases a possible opto-electronic application: a glass slide with the polymer deposited onto its surface, and a waveguide fabricated within the polymer using a laser.

Waveguiding structures for sensing applications and integration within on-chip photonic circuits,^{11,12} Mach-Zehnder SU8-based interferometers,^{27,28} and on-chip microresonator-based biosensors with near-edge resonance^{10,29} have been demonstrated to name just a few. Consequently, functionalized photonic and microfluidic SU8 technologies have emerged at the forefront of this rapidly evolving field, offering promising new possibilities and applications.

To endow SU8 with additional optical properties, structural functionalization with nanoparticles was demonstrated, introducing a range of plasmonic phenomena into light-matter interaction scenarios.³⁰ A direct linkage between molecular species and SU8 is quite appealing, and it is mainly done with the APTMS-GLut chemical binding to the surface enabling covalent attachment of desired molecules. The SU8's high hydrophobicity limits the interaction to the same kind of materials.³¹ The low interaction forces with different materials along with the high chemical potential from the radical ester make its specific and labile bonding a nontrivial target. Since SU8 is widely used in biomedical studies, its functionalization is better to be performed with biocompatible fluorescent materials.^{32–34} The biocompatibility of fluorescent agents is a significant area of its own, demanding the development of new platforms. Our focus is on phenylenediamine carbon dots, as we recently mastered their facile fabrication and sensing applications.³⁵ Specifically, a 90% reaction yield of carbon dots with a 70% quantum yield was demonstrated. As a result, matching those emitters with the low-cost SU8 polymer might have future technological benefits.

Here, we take advantage of the epoxy group in the SU8 polymer to spontaneously bind amine groups of phenylenediamine carbon dots. The covalent bonding of the molecules is integrated into the organic polymer skeleton, virtually forming a new material. This process makes the structure exhibit an inherently efficient fluorescence, which motivates the use of this new polymer in nanophotonics applications. To demonstrate the concept, we fabricated a series of devices by spin-coating thin films on flat coverslips and inner surfaces of micron-scale capillaries, which can be further designed for fluidic applications.

The manuscript is organized as follows: fabrication methods are presented first and then followed by an analysis and discussion on possible chemical reactions, responsible for the material formation. Then optical properties are presented of the bulk material with different aniline isomers. The characterization results are used for the structure analysis with molecular dynamic methods to predict the chemical composition and band gap. Fabrication of thin films and surface conjugation are discussed before the Conclusions section (Fig. 1).

Methods

Materials

Photoresists SU8-2000.5, -3005, and -3050, poly(ethylene glycol) methyl ether acrylate (PEGMEA) and the SU8 developer were purchased from Bachem (UK) Ltd, *meta*-phenylenediamine (*m*-PD), *ortho*-phenylenediamine (*o*-PD), *para*-



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Fig. 2 Optical properties of SU8 polymers with varying viscosities (SU8-2000.5, SU-8-3005, and SU-8-3050) conjugated with *m*-PD molecules and the influence of different amounts of hydrochloric acid being added to the reaction medium. The first column represents SU-8-2000.5, the second – SU8-3005, and the third – SU8-3050. (a–c) Absorbance spectra at 330 nm to 700 nm illustrate the impact of polymer viscosity. (d–f) PLE spectra (normalized) of the 530 nm emission peak, measured between 330 nm and 500 nm, highlighting the excitation-dependent behavior of the conjugates with varying viscosities. (g–i) Normalized emission spectra of conjugated SU-8 polymers at 450 and 650 nm range with excitation at 420 nm.

3050 exhibit similar absorption characteristics (Fig. 2(b and c)). A deeper insight into the corresponding PLE spectra is shown in Fig. 2(d–i) and the variations in emission intensities can be referred to in the ESI.†

To provide a comprehensive understanding of the optical modifications that emerge in the conjugated polymers, the characteristic peak values have been plotted against the proton concentration as shown in Fig. S2.† The identified trends imply that both the polymer's viscosity and the reaction medium's acidity exert a substantial influence on the conjugation efficiency and the enhancement of fluorescence properties.

It is hypothesized that polymers with a higher viscosity hinder the mobility of phenylenediamine molecules, consequently affecting the rate of conjugation and influencing the resulting absorbance and emission properties. Additionally, the acidity of the reaction medium can significantly impact

the conjugation process. In this context, understanding the complex interactions between the polymer viscosity, the acidity of the reaction medium, and the conjugation efficiency becomes crucial for optimizing the optical properties of these innovative conjugated materials.

The collected data indicate that the absorbance of the conjugated SU8-2000.5 drops with the inclusion of HCl, while SU8-3005 and SU8-3050 seem to reach saturation at 0.65 M acid. This observation can likely be attributed to the medium's viscosity, which facilitates more substantial conjugation and intricate pathways, as suggested, and will be further elaborated using our hypothesized model in section 3.2. This insight also implies that comprehensive conjugation of *m*-PD molecules occurs at the polymer chains, leading to enhanced absorbance or extinction, as presented in Fig. S2(a).†

Interestingly, the SU8-2000.5 polymer displays a maximum PLE intensity in 0.13 M HCl, while the other polymers present



There was, however, debate around the existence of primary and secondary amines. Some suggested that terminal groups could remain as primary or secondary amines, despite the absence of clear evidence in the FTIR data. Also, the possibility of hidden peaks under the dominant signals around 3000 and 3600 cm^{-1} was raised. A different perspective on the formation of N-N or N-O bonds was also presented. Although the FTIR spectra didn't show clear evidence, the theoretical feasibility was suggested through DFT calculations.

The data from the ^1H -NMR spectrum in Fig. 4 lends further credence to our proposed reaction mechanism and complements our FTIR findings. The subtle yet discernible changes across different regions of the spectrum paint a coherent picture of the chemical transformation underway.

Table S1† elucidates the atomic percentages for the SU8 sample, highlighting prominent peaks for carbon (C 1s, 71.93%) and oxygen (O 1s, 22.44%). Upon conjugation to *m*-PD, as presented in Table S2,† the carbon content slightly elevates to 73.01%, while the oxygen experiences a marginal decrement to 21.90%. However, the defining evidence is the emergence of the N 1s peak at 1.22%, absent in the pure SU8 sample.

Further addition of *m*-PD resulted in a continued decrease in intensities of epoxy-associated peaks, as shown in Fig. 3(d). Concurrently, there was an increase in the intensity of peaks around 3680.24 cm^{-1} and 3705.38 cm^{-1} , hinting at the conversion of epoxy groups to free hydroxyl groups. It is also worth



Fig. 3 (a) Full-range ATR Fourier-transform infrared (FTIR) spectra of the conjugation process between *meta*-phenylenediamine (*m*-PD) and SU8, indicating the characteristic peaks corresponding to the functional groups involved. This spectrum provides an overview of the complex interactions that transpire during the conjugation process. (b) Detailed FTIR spectra in the 2800–3100 cm^{−1} region, highlighting the specific vibrations attributed to various functional groups. (c) FTIR spectra in the 1150–1800 cm^{−1} region, further delineating the presence of different functional group vibrations, including the potential formation of secondary amine and amide bonds. (d) FTIR spectra in the 1150–550 cm^{−1} region, emphasizing the broad range of potential functional group interactions. The distinct peaks in this region are instrumental in deducing the nature of the interactions. (e) Several structures among the proposed configurations, while other options are analyzed further and hypothesized as less probable, and (except for model 2) the others are in the first stage toward tertiary amination.

Mathematically, let the content of *m*-PD in the SU8-*m*PD composite be represented by *p*. Based on the atomic ratios derived from the XPS data and the structure of *m*-PD, we estimate:

$$p \approx \frac{1.22\% (\text{N } 1s)}{6(\text{C atoms}) + 2(\text{N atoms})} \quad (1)$$

From this equation, we deduce that the *m*-PD content in the SU8-*m*PD composite ranges between 4.88% and 9.95%. This gives us an *m*-PD:SU8 monomer ratio ranging from 1:19.5 to 1:10.05. These XPS findings, evident from Tables S1 and S2,[†] consistently align with the transformations observed in Fig. 3 from the FTIR analysis and the variances in aromatic

and aliphatic regions seen from the ¹H-NMR spectrum in Fig. 4. Collectively, these results form a cohesive narrative, reinforcing the hypothesis of the successful conjugation of *m*-PD to the SU8 structure. Moreover, the XPS data extend our understanding by offering quantitative insight into this conjugation, strengthening the foundation for further explorations into modified SU8 systems.

DFT calculations

The *m*-PD and SU8 reaction is hypothesized relying on DFT calculations and available experimental data. A range of plausible molecular configurations will be proposed next, offering a





Fig. 4 ^1H -NMR analysis of the SU8-*m*PD conjugate. (a) Provides a full view of the entire spectrum. Region-specific magnifications further elucidate the interactions: (b) emphasizing the 6.5–8 ppm range, which is dominated by aromatic proton resonances, indicative of the SU8 and *m*-PD aromatic structures. (c) The 2.25–4.5 ppm region, highlighting potential transitional groups and intermediates; and (d) focusing on the 0–2.25 ppm range, predominantly showcasing aliphatic proton environments.

unique perspective on how *m*-PD and SU8 interact, as illustrated in Fig. 5(a–d).

Starting with Fig. 5(a), tertiary amine formation is shown, which involves an *m*-PD molecule and an SU8 monomer. Here, the *m*-PD molecule forms bonds with two epoxy groups of the SU8 monomer, leading to a tertiary amine configuration. This is in line with the well-established behavior of amines reacting with epoxy groups. Furthermore, the calculated band gap for this configuration, 4.4 eV does not fall within the range of the observed green light emission in our absorption and emission spectra. Fig. 5(b) presents an alternative configuration where one *m*-PD molecule bridges two SU8 monomers by forming two amide bonds. The calculated band gap for this structure is 3.6 eV, which aligns with the energy range corresponding to green fluorescence. This configuration supports the FTIR spectra, where a new peak at 1080 cm^{-1} , indicative of C–N stretching vibrations associated with amide bonds, is evident. Fig. 5(c) shows another possible configuration, this time featuring the formation of nitro (N–O) groups. In this scenario, one amine group from the *m*-PD molecule forms an amide bond with the SU8 monomer, while the other amine group creates an N–O bond. The band gap for this structure is calculated to be 3.6 eV, which fits well within the energy requirements for green light emission. Yet, this structure is not fully supported by FTIR. Lastly, Fig. 5(d) shows a complex scenario involving *m*-PD dimerization *via* N–N bond formation. The resulting dimer interacts with SU8 epoxy groups, leading to

the formation of amide bonds. Despite the theoretically calculated band gap of 2.6 eV being compatible with green fluorescence, the FTIR spectra do not provide explicit indications of N–N bond formation, suggesting that this configuration may not substantially contribute to the overall characteristics of the *m*-PD-SU8 composite.

Our DFT calculations and corresponding experimental data suggest that tertiary amine formation involving two epoxy groups is the most probable outcome of the *m*-PD-SU8 interaction, as shown in Fig. 3(e). Other plausible configurations, such as those involving secondary amines, amide bonds, and potentially N–N and N–O bonds, may also exist but likely contribute less significantly to the overall properties of the synthesized material. For a more comprehensive analysis of possible molecular structures, see Fig. S4† and discussion.

Thin film deposition and surface functionalization

Owing to the well-established adhesive properties of SU8 on a wide range of surfaces, it is crucial to evaluate the performance of our newly developed fluorescent derivative when forming thin film deposition on BK7 glass and indium tin oxide (ITO) coated glass. These substrates were chosen due to their common usage in optical and electronic applications, respectively. To explore the adhesion and film formation of SU8-*m*-PD, we prepared thin films of each material using the spin coating method. Consistent parameters were maintained to ensure comparability. The spin-coating process was conducted





Fig. 5 (a–d) Probable molecular structures of the *m*-PD-SU8 composite. The structures visualize the possible conformations resulting from the interaction between *m*-PD molecules and SU8 polymers. Each structure is presented as (a), (b), (c) and (d), demonstrating different plausible formations with band gap energies suitable for green emission. These structures were visualized and rendered using the VESTA software. Alongside each molecular structure, the calculated band gaps are provided, accompanied by the respective highest occupied molecular orbital (HOMO, shown at the bottom) and the lowest unoccupied molecular orbital (LUMO, shown at the top) charge distributions.

at speeds of 2k, 3k, and 4k rpm. Importantly, we found that the film thickness is identical to what appears in the SU8 2000.5 datasheet.

The cross-sections of the SU8-*m*-PD conjugate thin films deposited on glass substrates are depicted in the HRSEM images in Fig. 6. Specifically, Fig. 6(b) showcases a cross-section captured in backscatter mode, revealing a consistent thickness of about 300 nm. Fig. 6(a), captured in normal mode, illustrates the uniformity of the film structure, with its inset providing a closer look at a specific area at higher magnification. These images attest to the effectiveness of the spin-coating process executed at 6000 rpm.

Fig. 6(c) shows an Atomic Force Microscopy (AFM) topographical depiction of a compact $5 \times 5 \mu\text{m}$ area of the SU8-*m*-PD thin film. The image effectively demonstrates the film's minimal surface roughness and superb uniformity, both critical attributes for enhancing the device performance. The confocal microscopy images presented in Fig. 6(d) offer a comprehensive perspective on the fluorescence profiles of the SU8-*m*-PD conjugate films in three Cartesian planes (XY, XZ, and YZ). The uniform distribution of fluorescence throughout the film shows the effectiveness of the *m*-PD conjugation process, which has potentially broad applications in bioimaging. For instance, the film could serve as a contrast agent in fluorescence microscopy or as a biomarker in cellular imaging, offering enhanced visualization of biological samples.

In the ESI, Fig. S4† provides a deeper insight into the surface features of the *m*-PD-SU8 thin film. The Atomic Force



Fig. 6 Characterization of the SU8-*m*-PD conjugated thin films. (a) HRSEM image of the *m*-PD conjugated film in normal mode, showcasing the adherence and consistency of the film with an inset displaying an enlarged view of a marked area at higher magnification. (b) HRSEM image of a cross-section of the *m*-PD conjugated film on a substrate, captured in backscatter mode, illustrating the film's thickness and uniformity, with an inset providing a magnified perspective of a designated region. (c) High-resolution AFM image of a $5 \times 5 \mu\text{m}$ area of the *m*-PD-SU8 film, demonstrating minimal surface roughness and high uniformity. (d) Confocal images in XY, XZ, and YZ planes of the *m*-PD film deposited on a glass substrate under 488 nm excitation, presenting the film's fluorescence profiles and spatial distribution.



Kolchanov: investigation and formal analysis. Mohammad Attrash: investigation, formal analysis, and DFT. Razan Unis: investigation and formal analysis. Janis Alnis: investigation and formal analysis. Toms Salgals: investigation and formal analysis. Ibrahim Yehia: investigation and formal analysis. Pavel Ginzburg: conceptualization, writing – review & editing, and supervision.

There are no conflicts to declare.

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