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1 **Etching of multimode optical glass fibers: A new method for shaping the measuring tip and**
2 **immobilization of indicator dyes in recessed fiber-optic microprobes**

3

4

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15 Running title: Etching and coating of multimode optical fibers

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17

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25

25 **Abstract.**

26 We describe a new procedure for making recessed tips on multimode optical glass
27 fibers. The method is based on etching fiber tips in 40% hydrofluoric acid for defined
28 immersion times. As the etching velocity decreases radially from the core center in
29 multimode graded index fibers, a recess can be formed in the tip of flat-cut tapered or
30 untapered fibers. Etched fiber tips showed improved focussing of excitation light
31 coupled into the fiber at the opposite end, and very efficient excitation of thin layers of
32 optical indicators immobilized into the recess. The sensor chemistry is well protected
33 when immobilized in recessed fiber tips and allows the construction of O₂
34 microoptodes with improved mechanical stability that can measure repeatedly even in
35 very cohesive biofilms, tissue and dry soil.

36 **1. Introduction.**

37 Fiber-optic chemical microsensors (microoptodes) allow measurements at high
38 spatio-temporal resolution and have been developed for various analytes [1,2]. Such
39 microsensors measure a chemical (e.g. O₂, pH, CO₂, salinity) or physical (e.g.
40 temperature, refractive index) variable via an analyte-dependent reversible change in
41 the optical properties of an indicator, which is embedded in a polymer matrix
42 immobilised onto the fiber tip. The indicator chemistry has mostly been applied to the
43 fiber tip via dip coating or by mechanical deposition of a small droplet onto the end of
44 the fiber tip. The first microoptodes were developed for microscale measurements of
45 O₂ [3] and were based on the dye, ruthenium(II)-tris-4,7-diphenyl-1,10-
46 phenanthroline (Ru(dpp)₃) immobilized in polystyrene, but several other combinations
47 of O₂ sensitive dyes and immobilization matrices have been described in recent years
48 [4-9], and microoptodes are commercially available (www.pyro-science.com;
49 www.presens.com).

50 Although the tip configuration of fiber-optic microsensors plays an important
51 role for their performance, not much attention has been given to improve the design of
52 the measuring tip and the immobilization of the indicator with respect to improved
53 mechanical and optical properties. Various fiber taper geometries and their influence
54 on the performance of e.g. biosensors and lensed fibers [10-13] have mainly involved
55 use of single mode fibers, and it was shown that tapered fibers have a superior
56 performance in collecting and transmitting light as compared to untapered fibers
57 [11,12]. Furthermore, it was shown that fiber tips with relatively steep and conical
58 tapers collect/focus light more efficiently than fiber tips with long and slender tapers
59 [14].

60 Tapering of optical glass fibers can be done either by etching the fiber tip in
61 hydrofluoric acid (HF) [11,13,15,16] or by pulling the fiber in an IR laser-beam, in an
62 electric arc [17] or in a small flame from a micro torch (e.g. [2,18]). A constant tension
63 during the melting process can be kept by a capillary puller [4,12] or by the force of
64 gravity (as described here). The size of the flame, the pulling strength, and the timing
65 all influence the final taper dimensions. While most work on chemical etching of
66 optical fibers has been done on single mode fibers, we found that the cladding of fused
67 silica multimode graded-index optical fibers is more resistant to hydrofluoric acid than
68 the core and, therefore, a concave recess can be etched into the tip. In this study, we
69 describe a simple method for etching recesses in tapered and untapered multimode
70 optical fibers, we describe the optical performance of such etched fibers and explore
71 whether immobilization of an optical O₂ indicator in the recess yields O₂ microprobes
72 with improved mechanical stability.

73

74 **2. Materials and methods**

75

76 *2.1 Fabrication of tapered fiber tips*

77 We used fused-silica multimode graded index optical fibers with a 100/140 μm
78 core/cladding diameter ratio. A 5 m long single strand optical fiber patchcord (Radiall
79 Fiber-Optic GmbH, Rödermark, Germany) with a standard ST-connector at each end
80 was cut in two. The protective PVC coating and Kevlar fibers were removed over a
81 length of 5-10 cm, and the Tefzel® polymer jacket enclosing the fiber was removed
82 mechanically over several cm's by use of a fiber stripper (Micro-Strip®, Thomas &
83 Betts, Memphis, Tennessee). For better handling, the fiber was fixed in a hypodermic
84 needle mounted on a syringe [2,18] or, alternatively, in a tapered Pasteur pipette. The

85 fiber was secured with epoxy resin in such a way, that the exposed fiber was free of
86 the needle or pipette tip. The syringe or the pipette was mounted vertically in a
87 micromanipulator (MM33, Märtzhäuser, Wetzlar, Germany) with a small weight of
88 3.75 g attached to the bare fiber end.

89 A taper was made by heating the fiber with a small O₂/propane flame from a
90 miniature brazing and welding set (Roxy-Kit®, Rothenberger, Frankfurt a. M.,
91 Germany). Thereafter, the taper was cut back manually under a dissection microscope
92 with a ceramic knife and a sharpened forceps to the desired diameter of the tapered tip.
93 The length of the taper and the tip diameter were measured using a calibrated
94 compound microscope. Typical taper lengths and tip diameters were 300-800 μm and
95 20-40 μm, respectively. Finally, the tip was cleaned in hexane. Untapered fibers were
96 cut with an optical fiber cleaving tool (Thomas & Betts, Raritan, New Jersey, USA) to
97 obtain a straight and flat-cut fiber tip before etching and subsequent rinsing.

98

99 *2.2 Etching of fiber tips*

100 A recess in the fiber tip was made by etching a cavity with 40% hydrofluoric
101 acid as follows:

102 A small volume (0.1 ml) of the HF was placed in an Eppendorf tube and
103 carefully covered with 1 ml paraffin oil (Fig. 1). The paraffin oil prevented HF
104 evaporation, the formation of aerosols, and removed adherent HF from the fiber tip
105 when withdrawing it from the etching bath. The fiber was mounted vertically and was
106 introduced into the etching bath with a computer-controlled motorized
107 micromanipulator (Unisense A/S, Denmark). The micromanipulator software (Profix,
108 Unisense A/S, Denmark) controlled the time the tip was immersed in the HF and the
109 velocity with which the fiber was withdrawn from the etching solution. After etching,

110 the fiber tip was cleaned by successive immersion in distilled water, acetone (99%),
111 and xylene (98%).

112 For material etching rate experiments, only untapered fibers with straight and
113 flat cut tips were used. Several 2-3 cm long fiber pieces were made from the same
114 fiber cable and each piece was fixed with plasticine on the tip of a glass Pasteur
115 pipette. The effect of etching on the fiber dimensions was observed and measured on a
116 calibrated optical microscope.

117 For untapered fibers, the dimensions of the recess only depended on the time
118 the tip was immersed in the HF, and the total depth of the recess could therefore be
119 calculated from the etching rate. The actual recess depth was confirmed by observation
120 of etched tips on a calibrated optical microscope. For tapered fiber tips, the shape of
121 the recess also depended on the tip diameter and geometry, due to differences in the
122 relative thickness of the cladding and core material in the tapered region after pulling.
123 Thus for very thin and long tapers, the etching process became more undefined, but a
124 central cavity was always formed in the fiber tip during etching for <15 min. By
125 combining the etching procedure with sealing off parts of the the fiber tip with
126 polystyrene, it was also possible to create different shaped tips, e.g. conical tips.

127

128 *2.3 Characterization of recessed fibers*

129 The light emission from bare fiber tips was investigated under an optical
130 microscope. For this, the fibers were coupled to either a fiber-optic fluorometer [19] or
131 a fiber-optic O₂ meter (MICROX 1, Presense GmbH, Regensburg, Germany) from
132 which light from a blue LED was coupled into the optical fiber. The light emitting
133 fiber tip was placed into a flat glass capillary (internal dimensions 8 by 0.8 by 40 mm;
134 VitroCom Inc., Mt.Lks., N.J., USA) filled with diluted milk. The milky suspension

135 enabled visualization of the emitted light field from the fiber tip via scattering. The
136 milky solution was replaced by an aqueous solution of ruthenium(II) tris(4,7-diphenyl-
137 1,10-phenanthroline 4',4''-disulfonic acid) dichloride, i.e., a water-soluble O₂
138 indicator. The indicator was synthesized according to Lin et al. [20] from potassium
139 penta-chloro-aquoruthenate(III), which was changed from RuCl₃ (Fluka Chemie,
140 Buchs, Switzerland) [21], and 4,7-diphenyl-1,10-phenanthroline 4',4''-disulfonic acid
141 (Fluka Chemie, Buchs, Switzerland). The emitted light field was monitored via the
142 induced luminescence of the indicator around the fiber tip. Photographs of the fiber
143 tips and the emitted light field were taken in a dark room with a Leica camera
144 equipped with a 42 cm bellows and a light sensitive film Fujichrome Provia Daylight
145 400 F, RHP III 135 (Fuji Photo Film Co., Ltd., Tokyo, Japan) using a fixed aperture
146 and an exposure time of 30 seconds.

147

148 *2.4 Immobilization of sensor chemistry in recessed fibers*

149 An O₂ sensitive indicator was immobilized to the fiber tips as a filtered
150 polymer solution of 4 % (w/v) polystyrene (Goodfellow, Cambridge U.K.) in
151 chloroform with 5 mmol Pt(II) meso-tetra(pentafluorophenyl)porphine per kg
152 polymer. The indicator/polymer mixture was applied to the fiber tip with a small
153 spatula under a dissection microscope. The spatula was dipped into the polymer
154 solution and was moved to the fiber tip until the drop on the spatula touched it. A
155 small fraction of the drop adhered to the tip. It was necessary to wait a few seconds for
156 letting some of the CHCl₃ evaporate to make the indicator/polymer mixture more
157 viscous and adhesive, while touching the fiber tip.

158 For fiber tips with a deep recess, it was difficult to get the sensor solution into
159 the bottom of the recess without enclosure of air, when CHCl₃ was used as a solvent.

160 To prolong the evaporating of the solvent it was thus necessary to use a less volatile
161 solvent such as 1,1,2-trichloroethane. After the spatula was dipped into the sensor
162 solution, the drop on the spatula was moved until it touched the fiber tip and some of
163 the solution went into the recess. The spatula was removed awaiting the air in the
164 bottom of the recess to penetrate to the surface of the solution. The recess was then
165 refilled with the polymer solution. To avoid detachment of deposited layers, this
166 procedure was done repeatedly until a small meniscus of the polymer mixture just
167 protruded out of the recess after the solvent evaporated.

168

169 *2.5 Characterization of microoptodes*

170 Microoptodes were connected to a fiber-optic O₂ meter (Microx 3, Presens
171 GmbH, Regensburg, Germany) for characterization. For two sets of straight cut
172 sensors (8 without recess and 8 with ~25 μm recess), the O₂ dependent phase angle
173 and the fluorescence intensity (amplitude) were measured in air-saturated water, and in
174 an aqueous solution of 1% sodium sulfite (zero oxygen). The response time was
175 measured as the time before the signal reached 95% of the full response when the
176 optode was rapidly moved from air-saturated water to the sodium sulphite solution.

177

178 *2.6 Mechanical stability of microoptodes*

179 Recessed optodes were tested for mechanical stability measuring O₂
180 concentration profiles in different media. The sensors were mounted in the
181 micromanipulator and connected to the O₂ meter. After testing, the fiber tips were
182 examined under an optical microscope. Two sets of sensors with tapered tips were
183 tested: 12 sensors without recess and 11 sensors with recess. A sensor was placed in
184 the micromanipulator and four or more profiles were done in a 2% agarose gel. The

185 agar was then substituted with a very dense and cohesive bacterial biofilm, i.e., a
186 microbial mat from a solar saltern [22].

187 In addition to these short-term tests of mechanical stability in the laboratory,
188 the recessed sensors were also tested for long term stability in soil. Recessed sensors
189 were applied in the soil over an extended period of 12 days to measure the
190 development of anoxia and the reintroduction of O₂ following liquid manure injection.

191

192 **3. Results and discussion.**

193

194 *3.1 Etching rates*

195 Examples of an etched straight cut fiber and a tapered fiber are shown in
196 Figure 2. For etching times <10 minutes, a central cavity was always formed in the
197 fiber tip. The depth of this recess at 22°C and the fiber radius at 22°C and 23°C were
198 determined as a function of etching time (Fig. 3). While the cladding (70-50 μm) was
199 etched with a constant velocity, the etching rate increased through the core with the
200 highest etching rate in the centre of the core. As the etching rates were constant
201 through both the cladding and in the centre of the core glass material, they could be
202 calculated from the slopes of the two lines. At 22°C, the etching rates for the cladding
203 and the centre of the core glass material were found to be ~0.014 μm s⁻¹ and ~0.28 μm
204 s⁻¹, respectively (Fig. 3B). The etching rate for the cladding was found to be ~0.016 μm
205 s⁻¹ at 23°C. The measurement at 0 s was performed by setting the etching time to zero
206 in the micromanipulator software. It was not possible to measure any change in the
207 diameter of the fiber, but a small recess ~3 μm was etched at the tip. As the etching
208 rate was highest in the centre of the core, a conical parabolic shaped cavity was
209 formed.

210 3.2 Light emission

211 Light emission from a flat cut untapered tip (Fig. 4A, B) showed strongest light
212 closest to the fiber surface within a nearly cylinder-shaped beam with a diameter
213 corresponding to the fiber core over a distance of 1-2 times the fiber diameter. From a
214 tapered tip without recess (Fig. 4E, F), the emitted beam was broad, but also more
215 concentrated close to the 37 μm wide tip. This agrees with the fact that tapered
216 optodes produce a stronger signal than untapered, due to focussing of light in the
217 tapered region [14].

218 Untapered fiber tips with a recess depth of 50 μm (Fig. 4C, D) showed that the
219 recess apparently acts as a parabolic reflector concentrating the light beam in the
220 recess before it is spread out. Light emitted from tapered tips with a recess also
221 showed a pronounced focusing of the light within the recess leading to enhanced
222 excitation of the O_2 indicator (Fig. 4G, H).

223

224 3.3 Response time

225 Response time signal curves of fiber-optic O_2 sensors with and without recess
226 are shown in Figure 5. Average response times for the two sensor sets were calculated
227 to 29.3 ± 8.8 s (without recess) and 11.7 ± 4.7 s (with recess) with no significant
228 difference between the luminescence amplitude between the two sensor types (Table
229 1). The signal changes were fully reversible and no hysteresis was found.

230

231 3.4 Mechanical stability

232 All sensors survived the agar test. In the cohesive mat, malfunction occurred
233 when the sensor tip was pulled back from the mat. The sensors without recess lost
234 their entire signal and the sensor chemistry was completely torn off without damaging

235 the tip itself, whereas recessed sensors still showed good signals albeit some were a bit
236 damaged at the edge of the recess.

237 It is normally not possible to avoid some mechanical stress to sensor tips
238 during prolonged insertion in soils, primarily due to shrinking or expansion of the soil
239 as a consequence of changing water contents. Consequently, O₂ recordings with
240 normal optodes (without recess) in similar experiments have hitherto often failed.
241 Since extended deployment in wet environments (in this case a mix of soil and liquid
242 manure) can result in a softening of the sensor coating, it is easily lost and the
243 experiment must be aborted. In 3 experiments however, recessed sensors maintained
244 signal over >10 days in soil. A plot of the O₂ measurement together with the amplitude
245 of the luminescence signal normalized to the amplitude under anoxic conditions is
246 shown in Figure 6. The experiment was interrupted after 12 days. The recessed sensor
247 was still in good condition and the normalized amplitude plot indicates no detachment
248 of the sensor chemistry.

249

250 *3.5 Refractive index and etching rate correlation*

251 The etching of multimode fibers in HF showed an apparent correlation between
252 refractive index of the glass material and etching rate. The core was etched at faster
253 rates relative to the cladding, and a parabolic recess was formed. The core refractive
254 index profile in multimode graded-index fibers is parabolic with the index decreasing
255 from the centre of the core to the core-cladding interface, while the refractive index in
256 the cladding is constant [23]. The concave etched recess is consistent with the use of
257 GeO₂ in multimode optical fibers for variation of the refractive index in the core with
258 decreasing concentration of GeO₂ from the centre to the core resulting in a gradual
259 increase in the refractive index. The HF etch rate is found to exhibit a monotonic

260 dependency of the germanium concentration in SiO₂ [24] and the etch rate thus
261 increased with increasing GeO₂ contents. The cladding is usually pure SiO₂ or it can
262 be doped with B₂O₃ or F; both will lower the refractive index [23-25]. Annealed SiO₂
263 doped with B₂O₃ shows a lower HF etch rate than pure glass [26].

264 These effects of dopants on etching rate are well described. The dissolution of
265 vitreous SiO₂ into an aqueous HF solution can be described by the simplified overall
266 reaction:



268 Vitreous SiO₂ consist of tetragonal Si units connected at all four corners covalently
269 with siloxane bonds. For a specific HF concentration the rate-determining step for
270 dissolution of SiO₂ is the breakage of the siloxane bond. The breakage of the
271 equivalent bond in the presence of Ge is faster and more GeO₂ thus means faster
272 etching-rate [23-26].

273

274 **4. Conclusions**

275 Recessed fibers showed a stronger focusing of light at the fiber tip in
276 comparison to normal flat cut fibers. This has important implications for
277 manufacturing fiber-optic microsensors, where fluorescent indicator dyes are
278 immobilized onto the tip of fibers, i.e., microoptodes. The focussing of excitation light
279 in the recess meant that it was possible to manufacture sensors with thinner layers of
280 fluorescent indicator chemistry and therefore faster response times. Another important
281 feature for microoptodes is their mechanical stability. In cohesive biofilms both flat-
282 cut and recessed sensors lasted longer when having a larger tip diameter and therefore
283 more chemistry attached to the tip. However, the sensing layer was considerably
284 thinner for the recessed sensors obtaining the same signal and better mechanical

285 stability as for the flat-cut sensors with the same tip diameter. When used in cohesive
286 materials, the sensor chemistry was easily dragged off when dip-coated sensors were
287 withdrawn from the measuring object, while the sensor material was better protected
288 inside recessed sensors. Immobilizing the dye inside a recess thus yielded
289 microoptodes with a better mechanical stability and faster response times. Tip etching
290 and immobilization of indicator material in recessed fibers therefore represents an
291 important improvement in the construction of the microoptodes.

292 Recessed fiber tips may also allow easier construction of other types of optical
293 microsensors such as fiber-optic irradiance microprobes for quantifying light intensity
294 at high spatial resolution. Such probes currently require a complex manufacturing
295 procedure, where a miniature disk of a TiO₂-methacrylate compound is fixed to the
296 fiber tip and polished [27,28] and such probes also exhibit a limited mechanical
297 stability when profiling in cohesive media. Immobilization of the scattering matrix
298 into a recessed fiber tip may resolve these limitations.

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309 **Figure legends**

310

311 **Figure 1** – Schematic diagram of the setup for etching optical fiber tips with
312 hydrofluoric acid. The same setup was used for testing the mechanical stability of O₂
313 microoptodes. For this, the Eppendorf tube was replaced with a glass beaker
314 containing the test media and a microoptode was connected to a fiber-optic O₂ meter.

315

316 **Figure 2** – Photographs of etched fiber tips. A flat-cut optical fiber tip etched in HF
317 for 240 s (**A**). A tapered optical fiber tip etched for 90 s (**B**).

318

319 **Figure 3** – Fiber radius of untapered optical fibers as a function of the etching time at
320 22°C and 23°C. The position of the core and cladding is indicated (**A**). The depth of
321 the recess (22°C) and the amount of cladding material removed as a function of
322 etching time (22°C and 23°C) (**B**).

323

324 **Figure 4** - Images of the light emission from different types of optical fiber tips. The
325 light source was a blue LED. The fiber tips were inserted in a dilute milk suspension
326 (left panels A, C, E, G) and in a solution of the water soluble O₂ indicator
327 Ru(dpp(SO₃Na)₂)₃ (right panels B, D, F, H). After pictures were taken of the flat-cut
328 tips (A, B), the tips were etched and an additional set of pictures was taken (C, D).

329

330 **Figure 5** – Response time curves for 16 flat cut sensors; 8 without recess (red) and 8
331 with a ~25 μm deep recess (blue). Each fiber was moved from air saturated water to
332 anoxic water (1% Na₂SO₃) at time 0 s.

333

334 **Figure 6** - Development of anoxia and reintroduction of O₂ to an agricultural soil
335 following injection of liquid manure as measured with a recessed etched microoptode.
336 Curves show the calibrated O₂ measurements (-) as well as the luminescence amplitude
337 signal normalized to the amplitude under anoxic conditions (-).

338

339

340

341

342 **Table 1.** Comparison of response time and signal amplitude of flat cut fiber O₂
343 optodes with and without recess. Numbers indicate means±standard deviation (n=8).

344

345

346

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	Response time 100-0% seconds	Amplitude 0% (anoxic) a.u.	Amplitude 100% (air saturated) a.u.
Straight cut sensors without recess	29.3±8.8	17,715±6,388	7,609±2,482
Straight cut sensors with ~25 μm recess	11.7±4.7	15,100±7,897	7,331±4,090

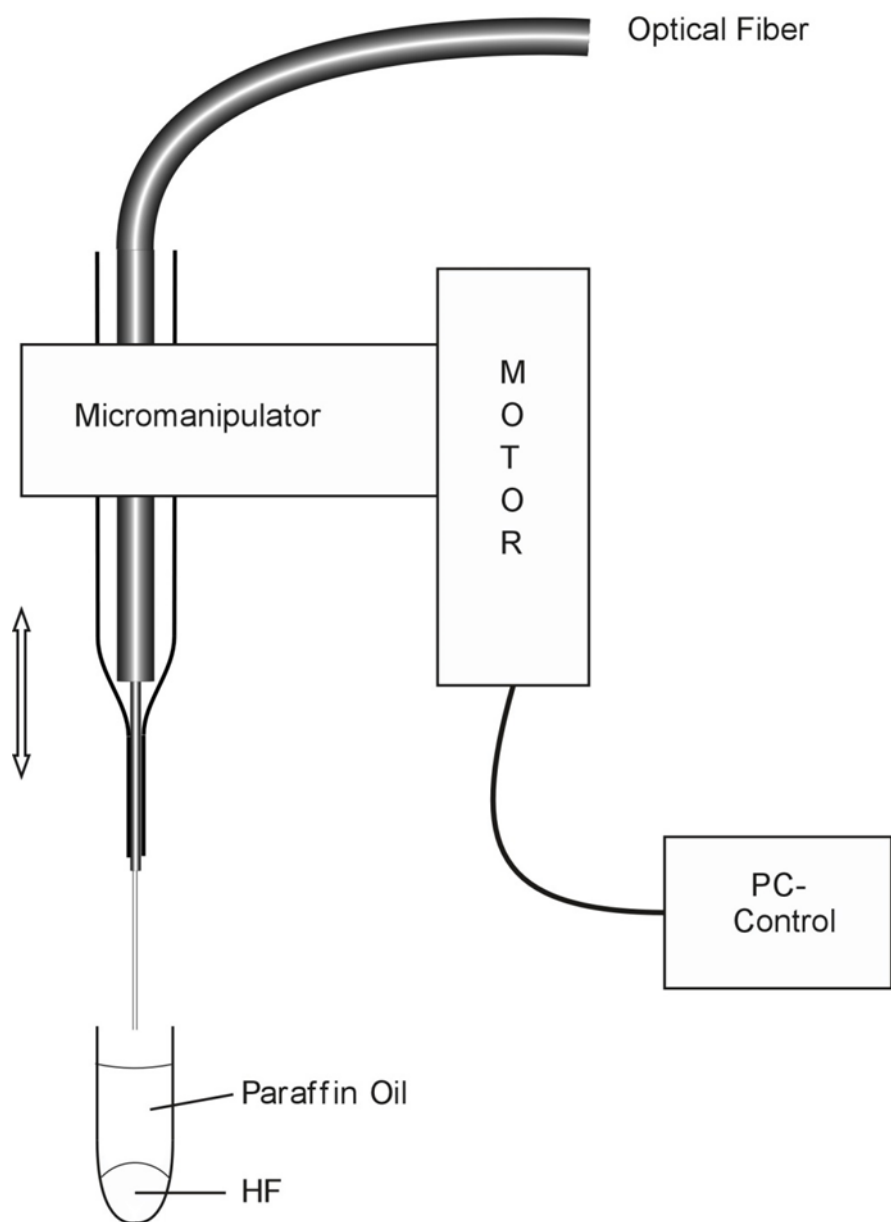
Biographies

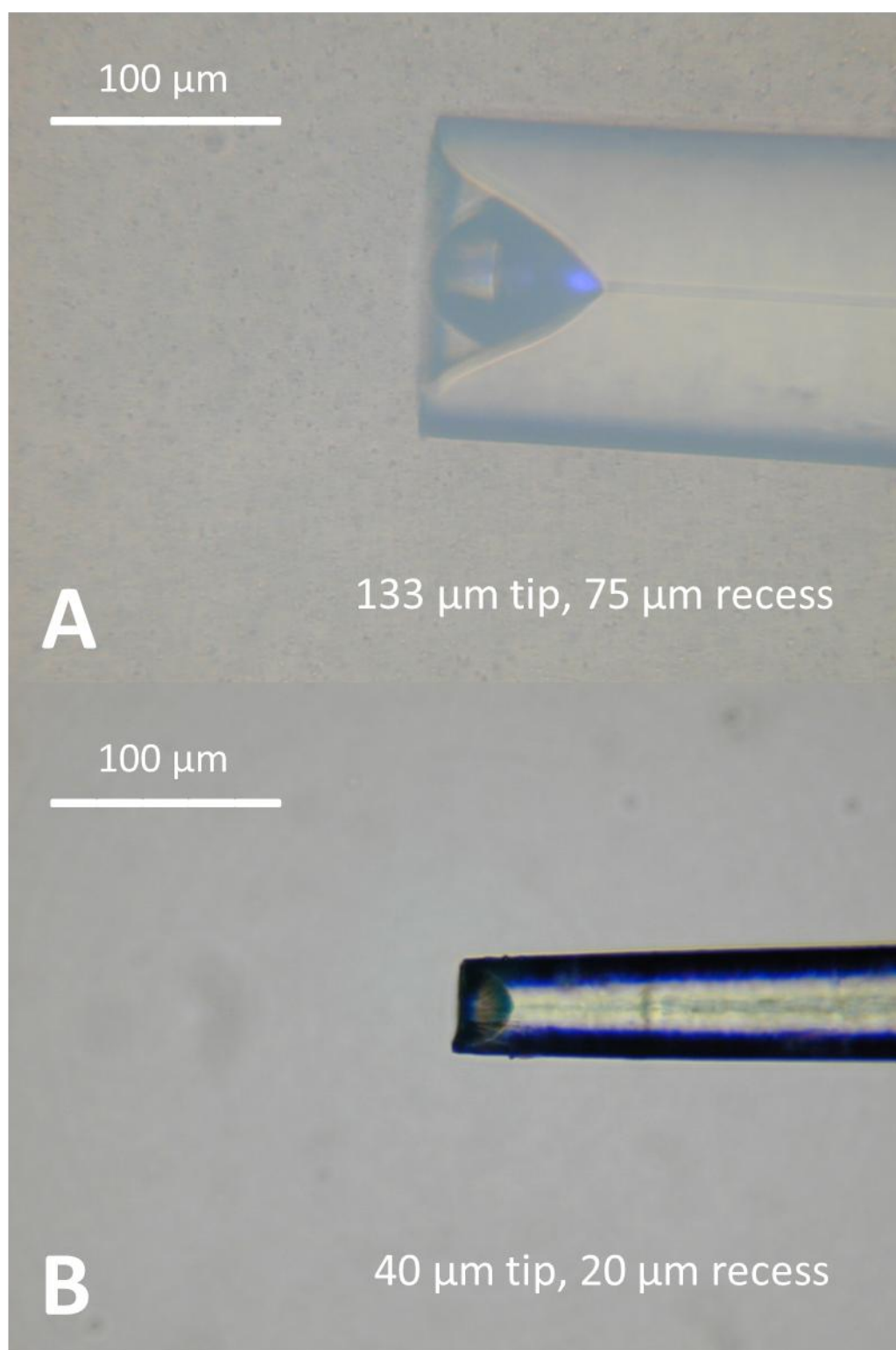
Lars Fledelius Rickelt was born on December 8, 1954. He received his M.Sc. in chemical engineering (1983) at the Technical University of Denmark, where he did research in natural products chemistry at the Institute of Organic Chemistry (1988-1993). After employment in the industry, he became a member of a diabetes research group at the Institute of Medical Physiology, University of Copenhagen (1996-1999). Since 2000, he is a member of the *Microenvironmental Ecology* research group at the Marine Biological Section, Department of Biology, University of Copenhagen (Denmark), where he is developing fiber-optic microsensors and advanced imaging techniques for environmental analysis.

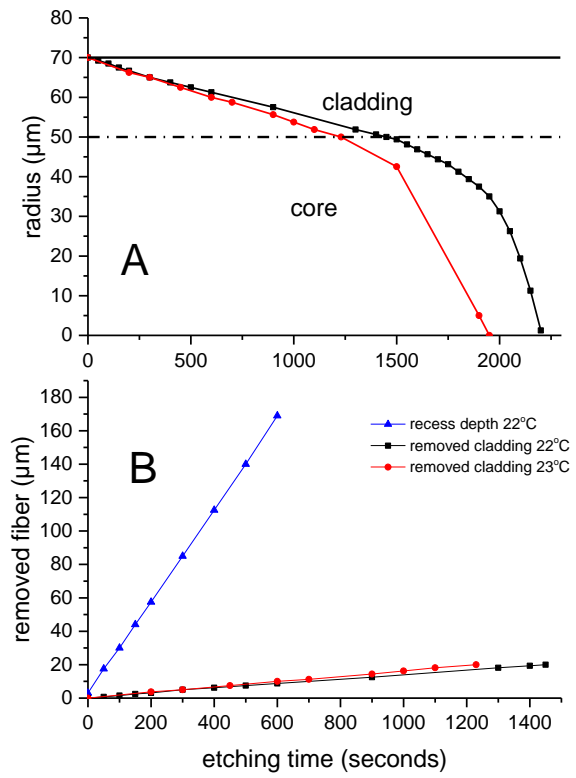
Lars D. M. Ottesen was born in April 1971. He received a PhD in Microbial Ecology in 2000. Following a degree in Economics, also in 2000, he started worked in the industry, with strong focus on research and development. In 2007-2009 he worked as assistant professor at the microbiology department at AU before returning to industry until 2013, where he became associate professor and head of the biological and chemical engineering department at AU Engineering. Lars D.M. Ottosens work, both in industry and academia, has focused on applied microbiology and chemistry. In addition to industrial R&D insight, he has more than 20 scientific papers and patents.

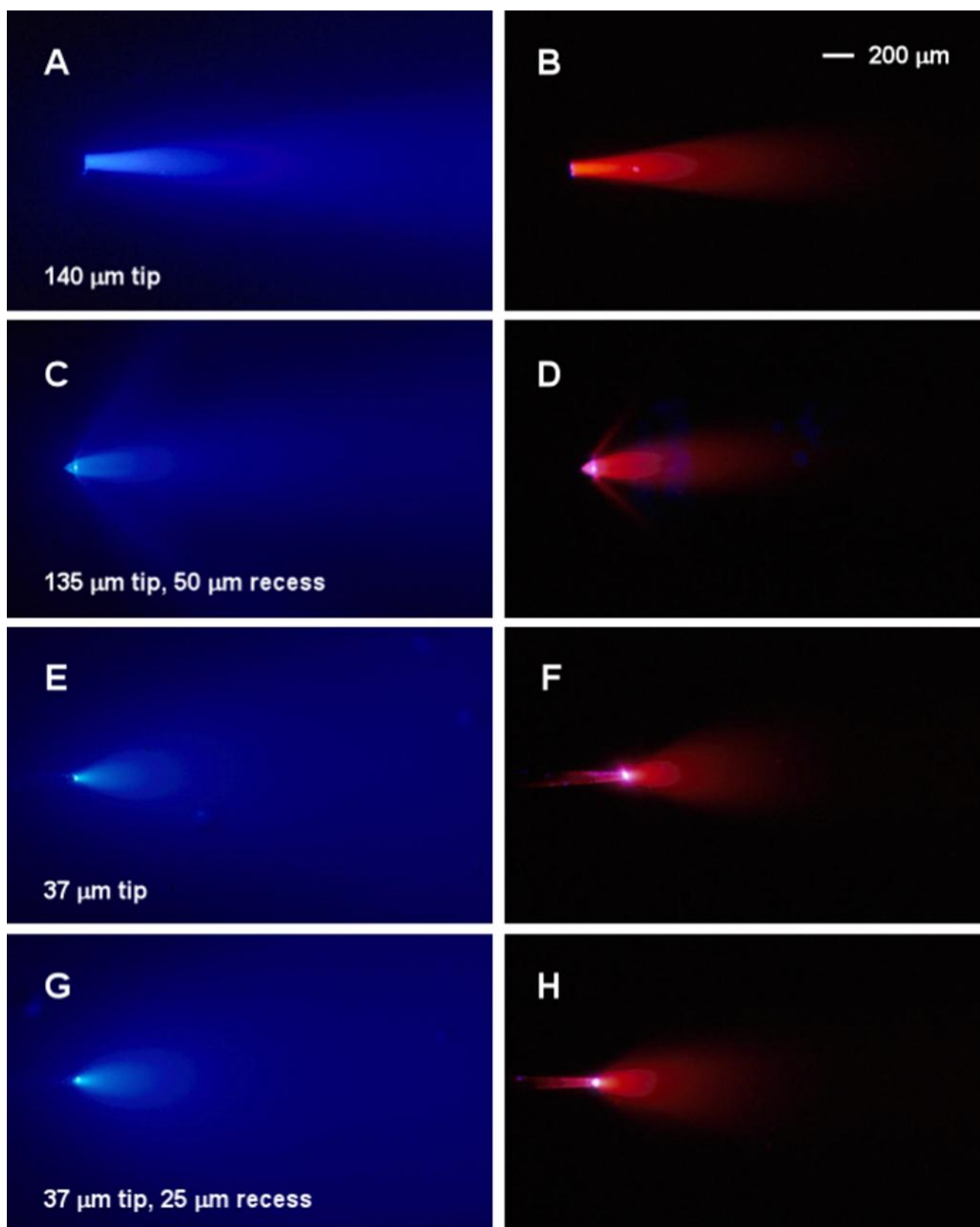
Michael Kühl was born on June 16, 1964. He received his M.Sc. in biology (1988) and Ph.D. in microbiology (1992) from the University of Aarhus, Aarhus (Denmark). From 1992-1998 he established and headed the microsensor research group at the Max-Planck-Institute for Marine Microbiology, Bremen (Germany) developing

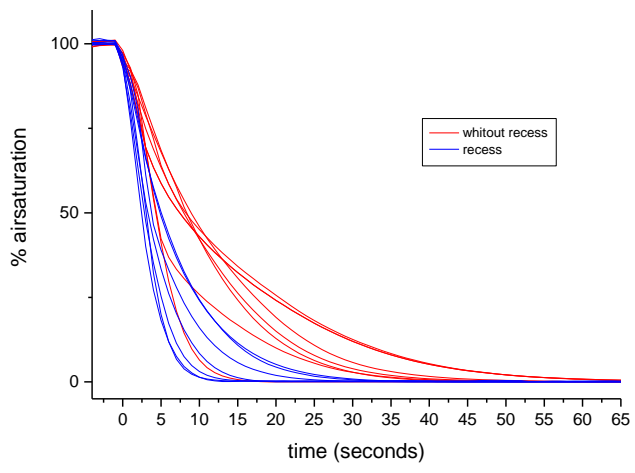
electrochemical and fiber-optic microsensors and advanced imaging techniques for environmental analysis. Since 1998 he has continued this research at the Marine Biological Section, Department of Biology, University of Copenhagen (Denmark) where he is full professor in microbial ecology and heads the *Microenvironmental Ecology* research group. He is also adjunct professor at the University of Technology Sydney, Australia and a visiting professor at the Nanyang Technological University, Singapore. He is a member of the *Royal Danish Academy of Sciences and Letters*, associate editor of *Marine Biology*, *Aquatic Microbiology*, *Environmental Biology*, and *Faculty of 1000/Environmental Microbiology*.



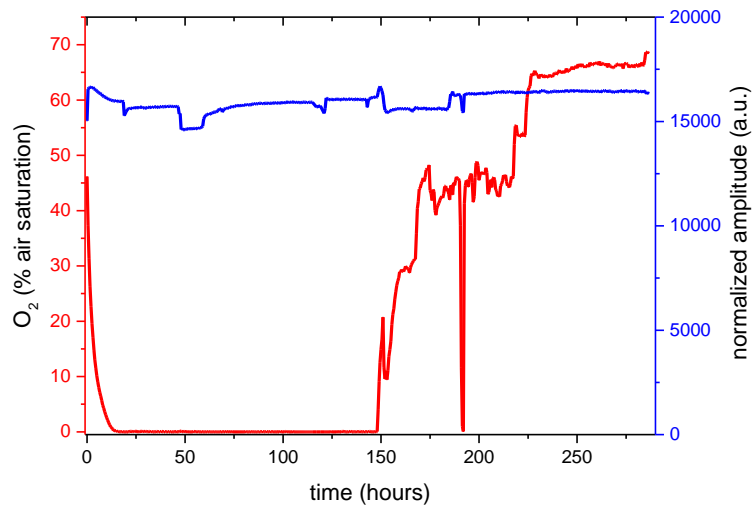








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