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(54) **OXYCODONE HYDROCHLORIDE HAVING LESS THAN 25 PPM 14-HYDROXYCODEINONE**

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This patent is subject to a terminal disclaimer.

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(52) **U.S. Cl.**

CPC ***C07D 489/08*** (2013.01); ***C07D 489/02*** (2013.01)

(58) **Field of Classification Search**

USPC 514/282; 546/45

See application file for complete search history.

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(57) **ABSTRACT**

In certain embodiments the invention is directed to a process for preparing an oxycodone hydrochloride composition having less than 25 ppm of 14-hydroxycodeinone.

20 Claims, 5 Drawing Sheets