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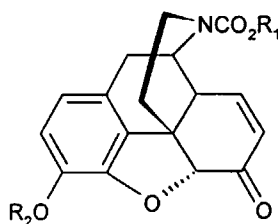
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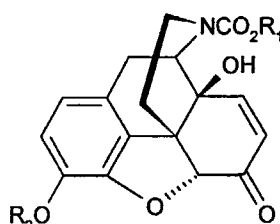
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(54) Title: PROCESS FOR THE PREPARATION OF A 14-HYDROXYNORMORPHINONE DERIVATIVE



III



IV

(57) **Abstract:** The present invention relates to process for the preparation of a 14-hydroxynormorphinone derivative of formula (IV) comprising reacting the compound of formula (III), with a cobalt (II) oxidant in the presence of a mild base and air or oxygen as the cooxidant; wherein R₁? is (1C-7C) alkyl optionally substituted with one or more chlorines, butenyl, vinyl, benzyl, phenyl or naphthyl; and R₂? is benzyl or benzyl substituted with one ore more (1C-6C) alkoxy group or benzyl substituted with one or more halogen. The process is very

suitable in the production of noroxymorphone.