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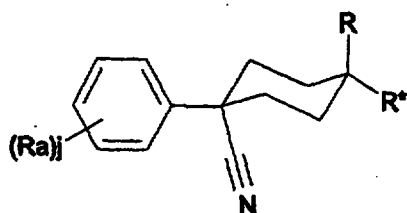
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(54) Title: PROCESS AND INTERMEDIATES FOR MAKING 4-CYANOSUBSTITUTED CYCLOHEXANOIC ACIDS



(I)

(57) Abstract: Herein is provided a process for preparing substituted cyclohexanoic acids of formula (I), where R_a is a carbon-containing group optionally linked by oxygen, sulfur or nitrogen to the phenyl ring and j is 1-5; and one of R and R* is hydrogen and the other is C(O)OH.