The claims defining the invention are as follows:

1. A process for preparing an oxycodone hydrochloride composition having less than 100 ppm 14-hydroxycodeinone comprising hydrogenating an oxycodone hydrochloride composition having at least 100 ppm 14-hydroxycodeinone in a suitable solvent to produce an oxycodone composition having less than 100 ppm 14-hydroxycodeinone.

2. The process of claim 1, wherein said hydrogenation is performed with a hydrogen donor and a catalyst.

3. The process of claim 2, wherein the hydrogen donor is selected from the group consisting of hydrogen gas, formic acid, indoline, cyclohexene, sodium borohydride, tetrahydroquinoline, 2,5-dihydrofuran, phosphoric acid, and combinations thereof.

4. The process of claim 3, wherein the hydrogen donor is hydrogen gas.

5. The process of any one of claims 2 to 4, wherein the catalyst is palladium on carbon.

6. The process of any one of the preceding claims, wherein the solvent is a combination of isopropanol and water.

7. The process of any one of claims 1 to 6, wherein the solvent is an alcohol.

8. The process of claim 7, wherein the alcohol is selected from the group consisting of methanol, ethanol and isopropanol.

9. The process of any one of claims 1 to 8, further comprising recovering the oxycodone hydrochloride composition having less than 100 ppm 14-hydroxycodeinone from the solvent.

10. The process of claim 9, wherein the recovery step comprises crystallizing the oxycodone hydrochloride composition having less than 100 ppm 14-hydroxycodeinone and filtering the crystallized composition from the solvent.

11. The process of claim 9 or 10, comprising further hydrogenating the oxycodone hydrochloride composition having less than 100 ppm 14-hydroxycodeinone.

12. The process of any one of claims 1 to 11, comprising further reacting hydrochloric acid with an oxycodone free base composition comprising an amount of 8α,14-dihydroxy-7,8-dihydrocodeinone to provide the oxycodone hydrochloride composition having a 14-hydroxycodeinone level of at least 100 ppm.

13. The process of claim 12, wherein the hydrochloric acid is present in an amount of more than 1 molar equivalents to the oxycodone free base composition.

14. The process of claim 12, wherein the hydrochloric acid is present in an amount of more than about 1.2 molar equivalents.

15. The process of claim 12, wherein the hydrochloric acid is present in an amount of more than about 1.5 molar equivalents.

16. The process of any one of claims 1 to 15, further comprising increasing the pH of the solution with a basic agent after the hydrogenation.

17. The process of claim 16, wherein the pH of the solution is less than 1.0 and is adjusted to a pH of about 1.5 to about 2.5.

18. The process of claim 16 or 17, wherein the basic agent is sodium hydroxide.

19. A process for preparing an oxycodone hydrochloride composition having a 14-hydroxycodeinone level in an amount of less than 100 ppm comprising
reacting in a suitable solvent an oxycodone base composition having an amount of 8,14-dihydroxy-7,8-dihydrocodeinone; with hydrochloric acid in an amount greater than 1.0 molar equivalent as compared to the oxycodone base composition to promote the dehydration of the 8α,14-dihydroxy-7,8-dihydrocodeinone to 14-hydroxycodeinone; the reacting step being performed under reducing conditions to promote the conversion of 14-hydroxycodeinone to

oxycodone, thus forming an oxycodone hydrochloride composition having a 14-hydroxycodeinone level in an amount of less than 100 ppm.

20. The process of claim 19, further comprising recovering the oxycodone hydrochloride composition having a 14-hydroxycodeinone level in an amount of less than 100 ppm.

21. The process of claim 20, wherein the recovery step comprises crystallizing the oxycodone composition having a 14-hydroxycodeinone level in an amount of less than 100 ppm and filtering the crystallized composition from the solvent.

22. The process of any one of claims 19 to 21 comprising increasing the pH of the solution with a basic agent after the hydrogenation.

23. The process of claim 22, wherein the pH of the solution is less than 1.0 and is adjusted to a pH of about 1.5 to about 2.5.

24. The process of any one of claims 19 to 23, comprising further hydrogenating the resultant oxycodone hydrochloride composition having a14-hydroxycodeinone level in an amount of less than 100 ppm.

25. A composition comprising (i) oxycodone hydrochloride and (ii) 14-hydroxycodeinone in an amount of less than 100 ppm.

26. The composition of claim 25, wherein at least a portion of the 14-hydroxycodeinone is derived from 8α,14-dihydroxy-7,8-dihydrocodeinone.

27. A composition of claim 25 or 26 when made by the process of any one of claims 1 to 24.

28. A pharmaceutical dosage form comprising the composition of any one of claims 25 to 27 and at least one excipient.