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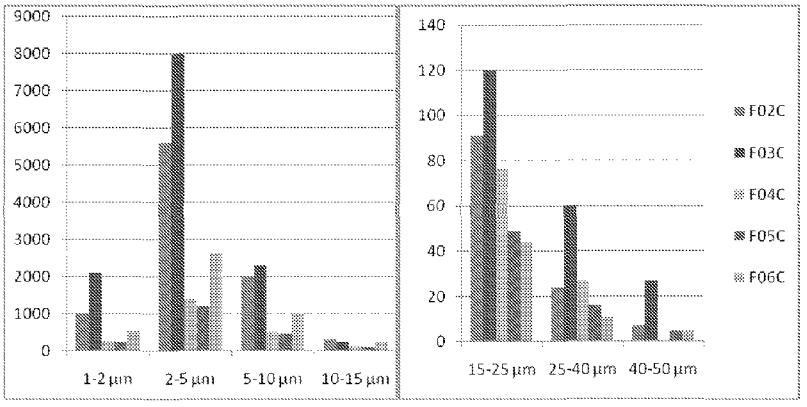
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(54) **Title**: ETANERCEPT FORMULATIONS EXHIBITING MARKED REDUCTION IN SUB-VISIBLE PARTICLES

FIGURE 1



(57) **Abstract**: The invention provides stabilized aqueous pharmaceutical etanercept compositions suitable for long-term storage of etanercept, with substantial reduction in sub-visible particles, and methods of manufacture of these compositions, methods of administration, and articles of manufacture.

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