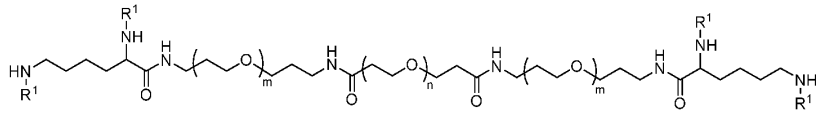
# CLAIMS

WHAT IS CLAIMED IS:

1. A process for synthesizing a compound of Formula I



I

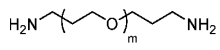
wherein, $R^1$ is a retinoid radical;

m is an integer 1-6; and

n is an integer 1-10

the process comprising,

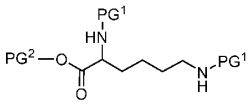
a) reacting a compound of Formula II



II

wherein, m is an integer 1-6;

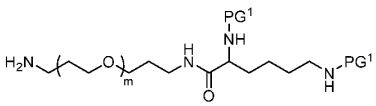
with a compound of Formula III



III

wherein, $PG^1$ and $PG^2$ are each independently a protecting group;

to form a compound of Formula IV

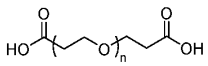


IV

wherein m is an integer 1-6; and

$PG^1$ is a protecting group

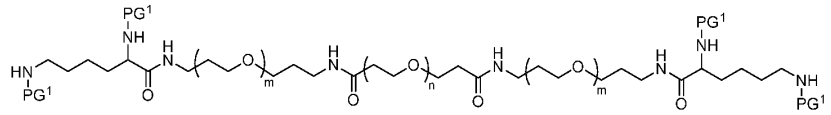
b) reacting a compound of Formula IV with a compound of Formula V



V

wherein, n is an integer 1-10;

to form a compound of Formula VI



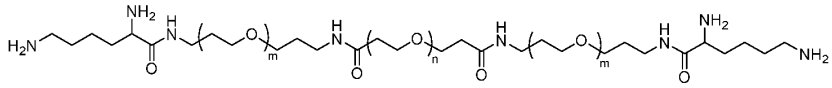
VI

wherein, m is 1-6;

n is 1-10; and

$PG^1$ is a protecting group;

c) reacting a compound of Formula VI under hydrogenation conditions to form a compound of Formula VII



VII

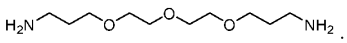
wherein m is an integer 1-6; and

n is an integer 1-10.

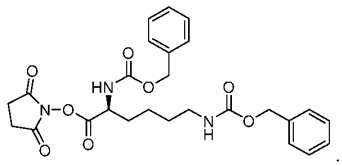
d) reacting the compound of Formula VII under coupling conditions with a retinoid to form a compound of Formula I.

2. The process of claim 1, wherein the retinoid is selected from vitamin A, retinoic acid, tretinoin, adapalene, 4-hydroxy(phenyl)retinamide, retinyl palmitate, retinal, saturated retinoic acid, and saturated demethylated retinoic acid.
3. The process of claim 2, wherein $R^1$ is retinoic acid.
4. The process of claim 1, wherein the hydrogenation conditions comprise reacting a compound of Formula I with $H_2$ and Pd/C.
5. The process of claim 1, wherein m is 3.
6. The process of claim 5, wherein n is 5.
7. The process of claim 1, wherein each $PG^1$ and $PG^2$ are independently selected from the group consisting of carboxybenzyl, *p*-methoxybenzyl carbonyl, *t*-butyloxycarbonyl, 9-fluorenylmetholoxycarbonyl, acetyl, trifluoroacetyl, benzoyl, benzyl, carbamate, *p*-methoxybenzyl, 3,4-dimethoxybenzyl, *p*-methoxybenzyl, tosyl, tricloroethyl chloroformate, (4-nitrophenyl)sulfonyl, methyl, ethyl, propyl, *n*-butyl, *t*-butyl, succinimide, 2,6-dimethylphenol, 2,6-diisopropylphenol, 2,6-di-*tert*-butylphenol, trimethylsilyl, allyl, 1,1-dimethylallyl, 2,2,2-trifluoro ethyl, phenyl, and 4-methoxybenzyl.

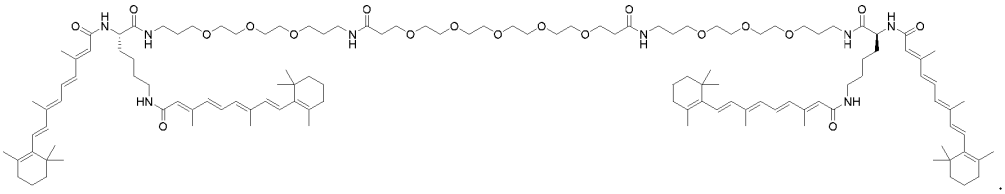
8. The process of claim 7 wherein $PG^1$ is carboxybenzyl.
9. The process of claim 7 wherein $PG^2$ is succinimide.
10. The process of claim 1, wherein the compound of Formula II is



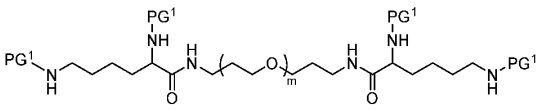
11. The process of claim 10, wherein the compound of Formula III is



12. The process of claim 1 wherein a) is done at between -20 °C and 0 °C.
13. The process of claim 1 wherein, the yield of a) is at least about 70%.
14. The process of claim 1, wherein in a) the compound of Formula II is present in between about 2 and about 8 equivalents and the compound of Formula III is present in about 1 equivalent.
15. The process according to claim 1 wherein, a) further comprises the addition of citric acid after formation of the compound of Formula IV.
16. The process of claim 1, wherein the compound of Formula I is



17. The process of claim 1, wherein the compound of Formula I is produced in at least about 50% yield from the compound of Formula III.
18. The process of claim 1, wherein the compound of Formula IV is produced in a ratio of greater than 9:1 with a compound of Formula VIII



**VIII**

19. A compound of Formula I prepared by the process of claim 1.
20. The compound of claim 19 that is

