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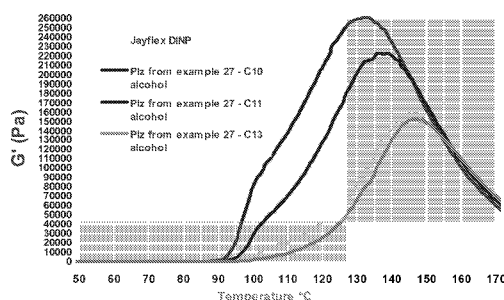
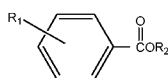
(54) Title: ALKYL AROMATIC HYDROALKYLATION FOR THE PRODUCTION OF PLASTICIZER

Figure 1



(57) **Abstract:** Provided are compounds of the following: wherein R_1 is a saturated or unsaturated cyclic hydrocarbon optionally substituted with an alkyl and/or an OXO-ester, and R_2 is a C_4 to C_{14} hydrocarbonyl, preferably the residue of a C_4 to C_{14} OXO-alcohol. Also provided are processes for making the compounds and plasticized polymer compositions containing said compounds.