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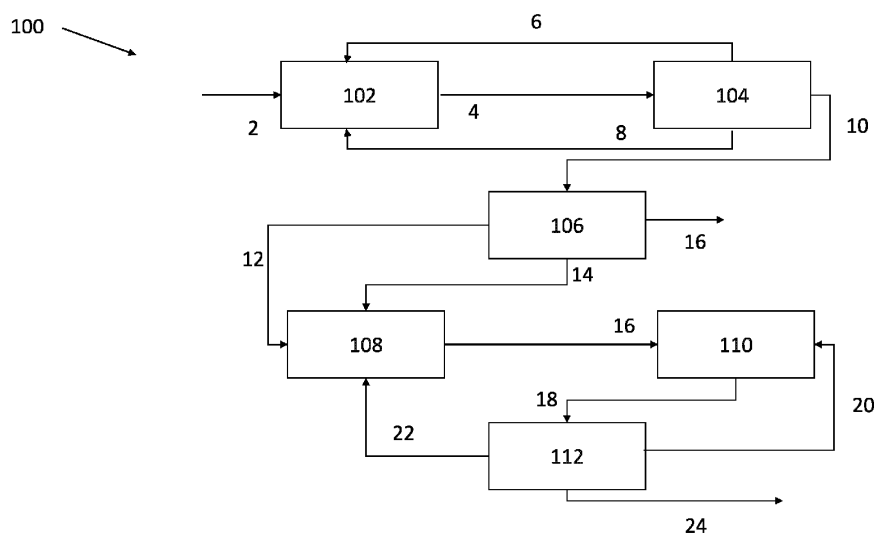


Figure 1

(57) Abstract: Prior to reaction in an isomerization unit, the feed may be purified by contact with a composition comprising an alumina based catalyst including Group I or Group II cations or combinations thereof in a range from about 0 wt% to about 20 wt% Group I or Group II cations. In some embodiments, the alumina based catalyst has one or more of the following properties: pore volume in pores of less than 70 Å pore diameter of less than about 15% of Total Pore Volume; a pore volume in pores of greater than 350 Å pore diameter of less than 10% of Total Pore Volume; a median pore diameter by volume of less than 120 Å; a water pore volume of less than 1.10 cc/g; and a surface area of greater than 160 m²/g.

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