

**SUPPRESSION OF HIGHLY ALKYLATED PHENOLS IN THE CATALYTIC
ALKYLATION REACTION OF PHENOL**

ABSTRACT

Selective catalytic reduction of the formation of alkylated phenols by transalkylation of ortho- and para-positions of alkylated phenols is accomplished by reacting ortho- and/or para-alkylated phenols with unreacted alkylated phenols in the presence of a metal oxide selected from the
5 group consisting of Mg, Zn, Fe, V, Ce, Cs, Mn, or combinations thereof. This invention can be easily executed by recycling the alkylated phenols into the normal feed stream of the alkylation reactor.