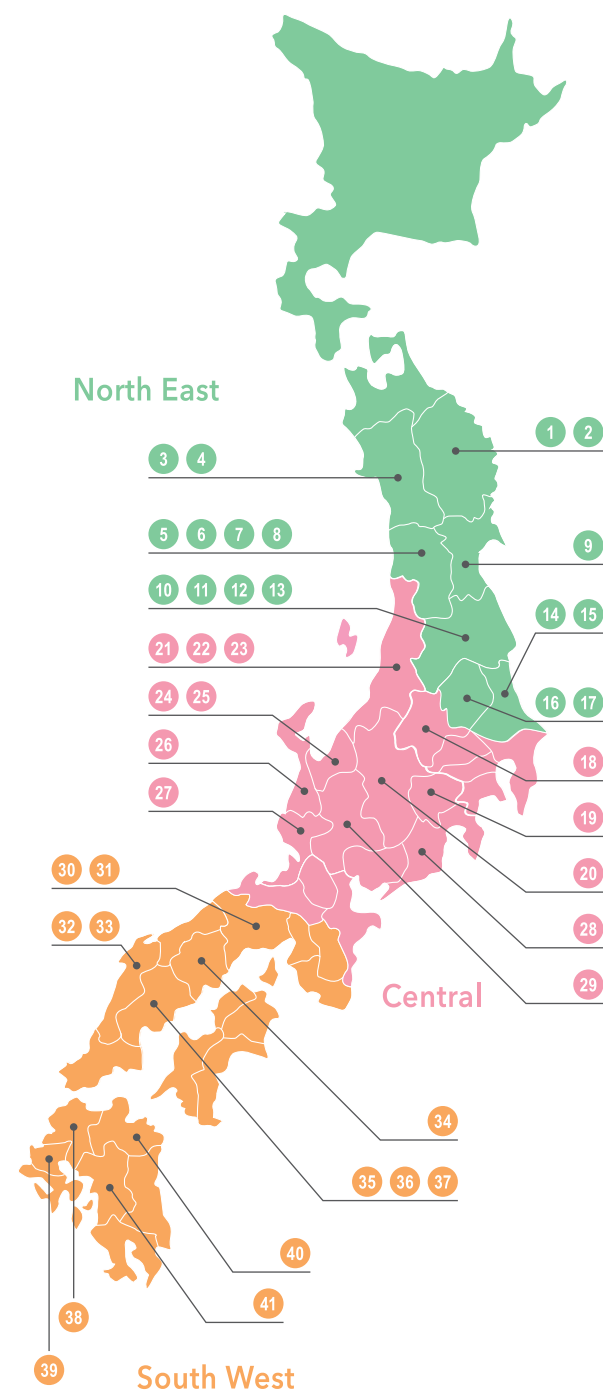


Brand	Producer
1 nanbubijin	nanbubijin
2 hamachidori	hamachidori
3 yamatoshizuku	akita seishu
4 tenju	tenju shuzo
5 yonetsuru	yonetsuru shuzo
6 eikofuji	fuji shuzo
7 dewazakura	dewazakura shuzo
8 kudokijozu	kameno shuzo
9 hoyo	uchigasaki shuzoten
10 kaito otokoyama	kaito otokoyama shuzo
11 suehiro	suehiro shuzo
12 naraman	yumegokoro shuzo
13 okunomatsu	okunomatsu shuzo
14 gokeiji	aoki shuzo
15 morishima	morishima shuzo
16 uroko	shimazaki shuzo
17 tentaka	tentaka shuzo
18 ozenoyukidoke	ryujin shuzo
19 shichiken	yamanashi meijo
20 masumi	miyasaka jozo
21 kanbara	kaetsu shuzo
22 kakurei	aoki shuzo
23 hakkaisan	hakkai jozo
24 wakatsuru	wakatsuru shuzo
25 masuizumi	masuda shuzoten
26 tedorigawa	yoshida shuzoten
27 kumono	yoshidakinemon shoten
28 kaiun	doi shuzojo
29 horaisen	sekiya jozo
30 kotsuzumi	nishiyama shuzojo
31 tatsuriki	honda shoten
32 rihaku	rihaku shuzo
33 gassan	yoshida shuzo
34 sakehitosuji	toshimori shuzo
35 fukucho	imada shuzohonten
36 kamoizumi	kamoizumi shuzo
37 seikyo	nakao jozo
38 shigemasu	takahashi shoten
39 shichida	tenzan shuzo
40 yatsushika	yatsushika shuzo
41 kohro	kumamotoken shuzo kenkyusho



Japan Premium Sake Association

The Premium Sake Association was established in 1981 by 43 sake producers committed to making competition-level premium sake, known as ginjoshu, more accessible to the everyday consumer. Since then, the association has staged countless events throughout Japan to promote premium sake to the drinks business and to the general public. The result is a growing following of ginjoshu lovers both in Japan and abroad, and an increase in the association's membership, which now stands at 41 sake makers.



Japan Premium Sake Association

<http://www.ginjyoshu.jp>

E-mail kyokai@ginjyoshu.jp

Sake Brewing Process

Raw ingredients: water, rice
Microbes: koji fungus (*aspergillus oryzae*)
yeast (*saccharomyces cerevisiae*)

1 | Rice Polishing

Remove protein-laden outer layers

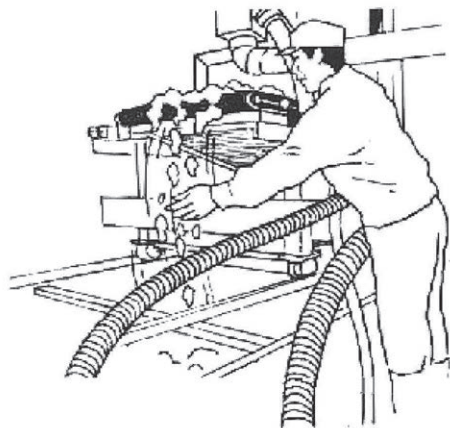
The outer layers of a rice grain have a lot of fat, minerals, and protein, which produce unpleasant aromas and flavors during fermentation. Polishing removes these layers, making it possible to create lighter, cleaner, and more aromatic sake. The more the rice is polished away, the lighter and more aromatic the sake becomes, so the amount of rice remaining after polishing is the main way that sake is graded.



2 | Washing & Soaking

Wash off protein-laced rice flour and absorb water for steaming

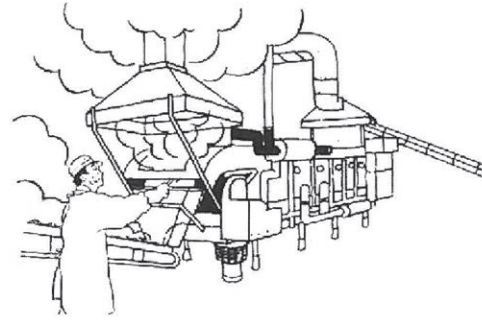
Washing away the rice flour clinging to the polished rice further reduces unwanted protein. The rice is then soaked to allow it to absorb just the right amount of water for steaming. Over-soaked or under-soaked rice cannot be used to make premium sake, so the brewers control the soaking time down to the second.



3 | Steaming

Soften the rice core

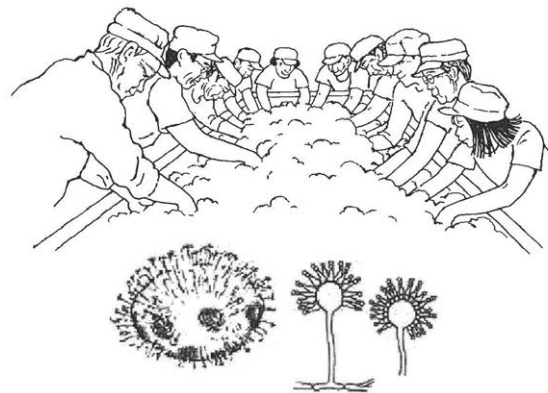
The soaked rice is steamed for 50 minutes. In order to make ideal koji (rice malt), and to ensure proper fermentation, the rice must be steamed in a way that results in a firm outer surface and a soft inner core.



4 | Koji Making

Produce enzymes that break down starch to sugar

About 20% of the steamed rice is used to grow koji, which is a fungus (*aspergillus oryzae*) that produces enzymes—chiefly amylase—that break down starch into sugar. The word koji also refers to the finished batches of rice on which the koji fungus has been grown. The quality and character of the koji strongly influences the character of the sake, so great care is taken during the two days required to make it.



5 | Yeast Starter Making

Create robust yeast culture

The next step is to create a yeast starter, which is a highly concentrated yeast culture. Koji rice malt, steamed rice, and water are added to a small tank, and then yeast and lactic acid are mixed in.

During yeast starter cultivation, enzymes in the koji slowly convert the starch from the steamed rice into sugar, which in turn fuels the rapid propagation of the yeast cells. A pristine environment must be maintained and the starter temperature must be strictly regulated over the fourteen days required to develop the full concentration of yeast.

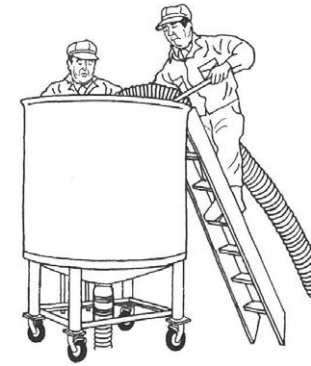


6 | Fermenting

Increase mash volume and produce sake

When the starter is ready, it is time to increase the volume of the mash by adding more koji, steamed rice, and water. Adding the full amount at once would weaken the yeast culture, so these ingredients are added in three stages over four days.

First, the starter is moved to a medium-sized tank, then the first addition is made. The mash rests for one day, and then it is moved to the main fermentation tank. The second and third batches of koji, steamed rice, and water are made on the third and fourth days, until the mash volume has reached nearly ten times that of the yeast starter. Fermentation continues under strictly controlled low temperatures (10C to 15C) for between 20 and 35 days.

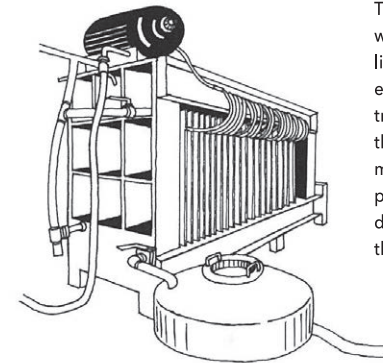


7 | Filtering

Separate sake from the rice solids

By the end of fermentation, the mash has reached 17% to 20% alcohol, the fragrance and flavor have fully developed, and the sake is ready to be filtered.

The techniques for separating the white rice solids (lees) from the liquid sake are constantly evolving, and range from the traditional method of dripping through cloth, the standard method of pressing through cloth panels, and the recently developed technique of spinning the mash in a centrifuge.



8 | Post-Production Options

After filtering, brewers have the option of applying or not applying these post-production techniques before the sake is sold.

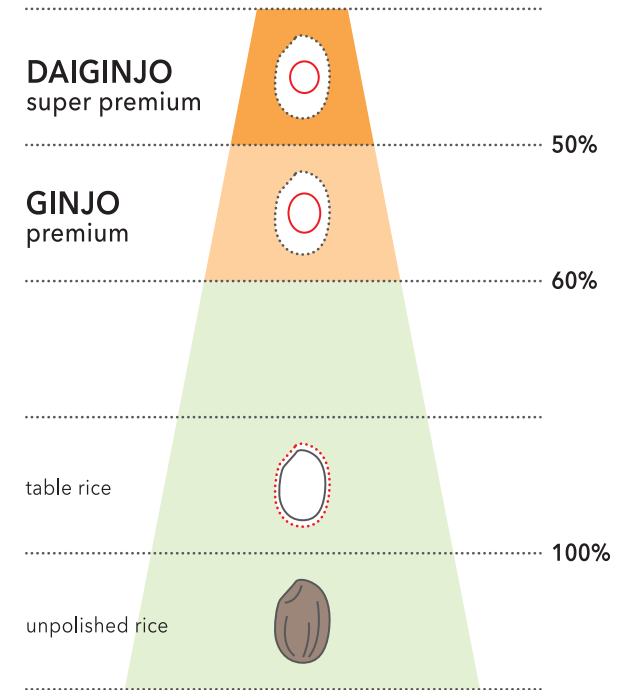
Pasteurizing
Micro-filtering (active charcoal, etc.)
Diluting with water
Aging



Sake Classification

Sake is classified depending on the amount of rice remaining after polishing. There are two special terms that identify higher grades of sake, as shown in the chart below.

Amount of rice remaining after polishing



The outer layers of sake rice grains contain a lot of protein, fat, and minerals, which can make the sake taste heavy and bitter. The more you polish the rice, the better the fragrance and flavor of the sake, so the amount of polishing is the main way that sake quality is determined.

