Hiroshima's Sake
About Sake

Japanese sake is an alcoholic beverage made from rice, koji mold and water as its major ingredients, with brewing techniques peculiar to Japan that involve fermentation and maturation. Although sake was traditionally drunk at room temperature, with the advancement of technology, it is enjoyed nowadays in more diverse ways, such as being heated in a tokkuri (jar) or chilled in a refrigerator. Further, sake is called "the chief of all medicine," which enhances beauty and health as long as it is consumed in moderation.

Sake is not just for drinking; it is also used as seasoning in cooking to remove smell and add flavor.

Various kinds of sake with unique features are merchandised throughout Japan, depending on differences in ingredients and production methods, from highly fragrant or well-matured varieties, to refreshing and smooth ones, to full-bodied ones. Just like wine, the diverse features of sake can be felt and enjoyed all the more by paring with dishes that match the specific kind.

Types of Sake

Japanese sake can be roughly divided into ordinary sake (Futsu-shu) and special designation sake (Tokutei-meisho-shu), depending on the ingredients, the degree to which the rice kernels are milled away before brewing, the production methods, and so forth. In Japan's Liquor Tax Act, special designation sake is categorized into eight groups, depending on differences in ingredients, production methods and so forth.

Below are the three major types of sake based on quality indication standards regarding production methods.

<table>
<thead>
<tr>
<th>Special Names</th>
<th>Ingredients</th>
<th>Percentage of Remaining Rice Kernels after Milling</th>
<th>Percentage of Koji Rice Used</th>
<th>Flavor, Fragrance and Other Features</th>
</tr>
</thead>
<tbody>
<tr>
<td>Junmai</td>
<td>Rice, Malted Rice</td>
<td>60% or less</td>
<td>15%</td>
<td>Sake made from highly milled rice, unique fragrance, fine color and texture</td>
</tr>
<tr>
<td>Daiginjo</td>
<td>Rice, Malted Rice, Distilled Alcohol</td>
<td>50% or less</td>
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<tr>
<td>Tokubetsu-Junmai</td>
<td>Rice, Malted Rice</td>
<td>60% or less, or those that were made by special methods (explanation must be indicated)</td>
<td>15%</td>
<td>Especially fine fragrance, color and texture</td>
</tr>
<tr>
<td>Honjozo</td>
<td>Rice, Malted Rice, Distilled Alcohol</td>
<td>70% or less</td>
<td>15%</td>
<td>Fine fragrance, color and texture</td>
</tr>
<tr>
<td>Tokubetsu-Honjozo</td>
<td>Rice, Malted Rice, Distilled Alcohol</td>
<td>60% or less, or those that were made by special methods (explanation must be indicated)</td>
<td>15%</td>
<td>Especially fine fragrance, color and texture</td>
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(Source: Standards for Manufacturing Methods and Quality Indication for Sake (National Tax Agency))

The above three types can be indicated by the special names listed below if they meet more rigorous requirements.

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(Source: Standards for Manufacturing Methods and Quality Indication for Sake (National Tax Agency))

*Percentage of Remaining Rice Kernels after Milling: This indicates the weight ratio of polished white rice to the original brown rice. When the percentage is 60%, it means that the 40% of the rice kernel surface has been milled away.

*Distilled Alcohol: The amount of distilled alcohol used in the production of Ginjo-shu and Honjozo-shu must be 10% or less of the entire weight of the white rice.

Ordinary sake without special designation (Futsu-shu) constitutes about 70 percent of the entire market. There are other types of sake that are not included in the above for their special production features, such as Nama-zake, which does not have any pasteurization process, and Kijo-shu, for which sake is used instead of water in the brewing process.
Features of Hiroshima’s Sake

Sake produced in Hiroshima is characterized by its clean flavor in harmony with a rich fragrance and rich taste. Surrounded by the Chugoku Mountains, the Seto Inland Sea and basins, Hiroshima Prefecture is blessed with a mild climate and produces a variety of different kinds of sake with distinct features, from sweet, to dry, to highly fragrant.

Among many sake-producing regions within the prefecture, Saijo in Higashi-hiroshima City is renowned as one of the three major sake-brewing locations in the country, along with Nada in Hyogo Prefecture and Fushimi in Kyoto Prefecture.

Why Hiroshima’s Sake Is So Much Appreciated throughout Japan — Water Holds Key Importance

Water plays a crucial role in bringing out the uniqueness of Hiroshima’s sake.

Since the flavor of sake is created based on a subtle balance between the conversion of starch into sugar by koji mold and alcoholic fermentation by yeast, water that contains rich amounts of calcium is considered to be ideally suited for sake production due to calcium’s function of accelerating fermentation. However, spring water in Hiroshima is soft water that is low in calcium content because of the granitic strata that forms its land. Therefore, the original method called the soft-water brewing method is used in Hiroshima to produce sake.

While young koji mold is used with hard water since yeast works actively in hard water, mature koji is used with soft water so that the mold can penetrate deep into the rice kernels. This enhances the saccharification of rice and facilitates the next step of fermentation. Although this brewing method in soft water takes more time and labor compared to that in hard water, it can create clear and tasty sake varieties without off-flavors, as exemplified by Ginjo.

The Innovative Spirit of Hiroshima that Created Excellent Sake — The Birthplace of Ginjoshu

Sake brewed in Hiroshima is known for its rich and mild taste. The innovative spirit of the people of Hiroshima has created such sake.

At the end of 19th century, Senzaburo Miura, a brewer from Hiroshima, developed a sake brewing method suitable for the soft water in Hiroshima, which had up to then been regarded as unsuitable for sake brewing. This enabled brewers in Hiroshima to brew the high-quality sake which is called “ginjoshu” today. Setting the foundation of the Hiroshima sake industry, Miura is regarded as the father of modern sake. Brewmasters from Hiroshima introduced this innovative brewing method across the country. Today, ginjoshu is brewed all over Japan.

Another driving force that encouraged the development of modern sake was also developed in Hiroshima: Japan’s first rice polisher with a motor developed by Riichi Satake, the founder of Satake, a rice-polishing machine manufacturer in Hiroshima. As this innovative rice polishing technique enabled the provision of high-quality, polished rice indispensable for the brewing of ginjo-shu, sake brewed in Hiroshima has become famous throughout the country.

The National Research Institute of Brewing, the only national institute of alcoholic beverages, is situated in Higashihiroshima City, Hiroshima Prefecture. The institute conducts state-of-the-art research on brewing and appreciation of alcoholic beverages.
Hiroshima’s Sake and Breweries

Experience the diversity of flavors, from sweet to sharp and light to rich.
A city where you can enjoy the unique flavor of a range of Japanese sake all in the one place.

1. Yahatagawa Brewery Co., Ltd
2. Chugoku Jozo Co., Ltd
4. Kubota Shuzo Co., Ltd
5. Kyokuhou Shuzo Co., Ltd
6. Miyake Honten ‘Senpuku’ Sake Brewery Co., Ltd
7. Enoki Shuzo Co., Ltd
8. Kamotsuru Sake Brewing Co., Ltd
9. Hakubotan Shuzo Co., Ltd
10. Nakao Sake Brewery Co., Ltd
11. Imada Sake Brewery Co., Ltd
12. Morikawa Shuzo Co., Ltd
13. Kirei Shuzo Co., Ltd
14. Fuji Shuzo Co., Ltd
15. Kamoizumi Shuzo Co., Ltd
16. Suisin Yamane Honten Co., Ltd
17. Tenpoichi Co., Ltd
18. Hibabijin Shuzo Co., Ltd
19. Yamaoka Shuzo Co., Ltd
20. Aihara Shuzo Co., Ltd

Comparison of Japanese Sake

Japanese sake can be divided into four types according to their flavor and aromatic characteristics using two axes: strong to delicate aroma and rich to light flavor. Knowing how to select sake enables you to better know and appreciate the depth of Japanese sake. You can see the characteristics of the sake produced by each brewery.

Opulent aroma and refreshing flavor

KUNSHU

- Appearance: light, refreshing image
- Aroma: opulent, refreshing, transparent aroma
- Flavor: a well-balanced combination of freshness and tartness
- Recommended dishes: tends to be selected for Japanese, Western, and Chinese dishes alike; suitable as an aperitif.

AromaStrong

Mellow aroma and rich flavor

JUKUSHU

- Appearance: smooth and thick, tinged with amber or brown
- Aroma: strong, complex, individualistic
- Flavor: mildly sweet with a rounded mellow tartness; a heavy aftertaste and lingering afterglow
- Recommended dishes: compliments strongly- or richly flavored dishes

FlavorLight

Fresh aroma and light flavor

SOSHU

- Appearance: extremely light and fluid
- Aroma: mild and gentle aroma with a crisp freshness
- Flavor: smooth flavor with a short, crisp aftertaste
- Recommended dishes: wide range of compatible dishes; suitable as an aperitif or with meals

AromaDelicate

Well-rounded aroma and rich flavor

JUNSHU

- Appearance: slightly strong color with depth
- Aroma: well-rounded, soft aroma suggestive of the taste
- Flavor: sweet, mildly tart, well-rounded flavor
- Recommended dishes: extremely wide range of compatible dishes

FlavorRich
**1. Special Junmai Shin-Miyajima**

**Company Name**: Yahatagawa Brewery Co., Ltd

**Address**: 2-10-10 Yahata, Saeki-ku, Hiroshima-shi, Hiroshima Prefecture 731-8602

**URL**: http://www.yahatagawa.co.jp/

**Contact Person**: HIROFUMI UMEDA  TEL: 81-82-822-0511

**Characteristics**
- This sake has won honors in the Junmai division of the autumn awards ceremony recognizing excellence in sake conducted by the Hiroshima Regional Taxation Bureau. Please enjoy the mellow taste and aroma drawn from the core of the rice grains as either chilled or warm sake.
- Specific Class Name: Tokubetsu-Junmai
- Main Ingredients: rice, malted rice
- Rice-polishing Ratio*: 60%
- Volume: 720 ml
- Alcohol Content: 15%
- Domestic Sales Price (excl. tax): 1,630 yen

**Dishes that go very well with this product**: Grilled or stewed whitefish

**Master Brewer’s Point of Pride**

This sake has a rich and elegant aroma and full-bodied taste as well as mild taste and crisp aftertaste, and can also be enjoyed by sake beginners.

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**2. Shusho-ichidai Aimisen**

**Company Name**: Chugoku Jozo Co., Ltd

**Address**: 2-3-3 Funakoshi, Aki-ku, Hiroshima-shi, Hiroshima Prefecture 731-0081

**URL**: http://www.chugoku-jozo.co.jp/

**Contact Person**: HIROFUMI UMEDA  TEL: 81-82-822-2031

**Characteristics**
- This sake is made using 100% Hiroshima-grown Hattan Nishiki rice, which is very delicate, and we take great care in fermenting the rice slowing at a low temperature to produce the sake. Please enjoy the mellow aroma.
- Specific Class Name: Junmai
- Main Ingredients: rice, malted rice
- Rice-polishing Ratio*: 65%
- Volume: 720 ml
- Alcohol Content: 16.8%
- Domestic Sales Price (excl. tax): 1,150 yen

**Dishes that go very well with this product**: Whitefish sashimi, oyster dishes

**Master Brewer’s Point of Pride**

Using brewer’s rice produced locally for local consumption, we emphasize sake brewing by hand that values teamwork and bonds between people. We also incorporate new technologies in view of market and customer preferences while maintaining traditional brewing techniques passed down from long ago.

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**3. Honshu-ichi Muroka Junmai**

**Company Name**: Umeda-Shuzoujou & Co.

**Address**: 2-3-3 Funakoshi, Aki-ku, Hiroshima-shi, Hiroshima Prefecture 731-0081

**URL**: http://www.honshu-ichi.com

**Contact Person**: HIROFUMI UMEDA  TEL: 81-82-822-2031

**Characteristics**
- This Junmai-shu with rich aroma and gentle taste is brewed using “Senbon Nishiki” rice grown in Hiroshima Prefecture, which is the most suitable for brewing sake, and “Hiroshima Ginjo” yeast. This sake won the Gold Medal in the Junmai-shu division of the International Wine Challenge competition in 2008, 2012, and 2013.
- Specific Class Name: Junmai
- Main Ingredients: rice, malted rice
- Rice-polishing Ratio*: 65%
- Volume: 720 ml
- Alcohol Content: 16.8%
- Domestic Sales Price (excl. tax): 1,150 yen

**Master Brewer’s Point of Pride**

Enjoy chilled or at room temperature.

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**4. Kinsho Hishimasamune Daiginjo**

**Company Name**: Kubota Shuzo Co., Ltd

**Address**: 1-12-1 Sakurao, Hatsukaichi-ku, Hiroshima-shi, Hiroshima Prefecture 731-0221

**URL**: http://www.hishimasamune.co.jp

**Contact Person**: Bunya KUBOTA  TEL: 81-82-812-2185

**Characteristics**
- Produced from Hiroshima-grown “Senbon Nishiki” rice polished to 40%, this Daiginjo truly achieves the grassroots of Japanese sake, with its opulent aroma, mild and mellow taste, and sharp deliciousness. Enjoy chilled or at room temperature.
- Specific Class Name: Daiginjo
- Main Ingredients: rice, malted rice, brewer’s alcohol
- Rice-polishing Ratio*: 60%
- Volume: 720 ml
- Alcohol Content: 16.8%
- Domestic Sales Price (excl. tax): 2,700 yen

**Master Brewer’s Point of Pride**

Using brewer’s rice produced locally for local consumption, we emphasize sake brewing by hand that values teamwork and bonds between people. We also incorporate new technologies in view of market and customer preferences while maintaining traditional brewing techniques passed down from long ago.

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*The ratio of the weight of polished rice to that of the weight before polishing.
Characteristics
Brewed from Hiroshima-grown “Hattan Nishiki” rice, this sake has an opulent fruity aroma and mild taste. Extremely popular with women also, this is Kyokuhō’s representative Junmai Ginjo.

- Specific Class Name: Junmai Ginjo
- Main Ingredients: rice, malted rice
- Rice-polishing Ratio*: 50%
- Volume: 720 ml
- Alcohol Content: 16.1%
- Domestic Sales Price (excl. tax): 1,359 yen

Dishes that go very well with this product: This sake pairs well with seafood, ... eel with sauce.

Master Brewer’s Point of Pride
Using only rice produced locally in Hiroshima Prefecture, in our sake brewing we emphasize the importance of valuing each rice grain, striving daily to be able to produce sake of uncompromising high quality and taste.

Master Brewer’s Point of Pride
This brewery has the distinction of being the first brewery in Japan to produce “Kijoshu”, for which sake is used instead of water in the brewing process, beginning in 1974. We aim to create a “sake that relaxes you” when you’re feeling tired.

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Characteristics
This sake comes in a white bottle with a design inspired by our brewhouse. Please enjoy this sake with a mild yet full-bodied taste brewed by us with pride. It is recommended to enjoy this sake on the rocks—it is a perfect drink for time spent your loved ones. This sake won the Monde Selection Gold Prize for 10 consecutive years (2007-2016).

- Specific Class Name: Junmai Daiginjo
- Main Ingredients: rice, malted rice
- Rice-polishing Ratio*: 50%
- Volume: 720 ml
- Alcohol Content: 17.5%
- Domestic Sales Price (excl. tax): 2,500 yen

Dishes that go very well with this product: Stewed fish, grilled conger eel with sauce.

Master Brewer’s Point of Pride
We are proud of our 100% locally-brewed Junmai-daiginjo “Kura” brewed using ingredients (water, rice, and yeast) only from Hiroshima Prefecture in a brewery located in Hiroshima Prefecture. Although there are several methods for brewing sake, this sake is brewed by our brewmasters with the traditional Hiroshima Brewing method, emphasizing the full development and complete fermentation of malt to extract the flavor of the rice.

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Characteristics
The eight-year maturation process gives the sake a complex flavor suggestive of vanilla, nuts, and dried fruits. Enjoy the harmony of sweetness and tartness. This sake pairs wonderfully with rich foods and dishes such as foie gras, cheese, Japanese simmered pork, and tempura.

- Specific Class Name: —
- Main Ingredients: rice, malted rice, Junmai-shu
- Rice-polishing Ratio*: 65%
- Volume: 500 ml
- Alcohol Content: 16-17%
- Domestic Sales Price (excl. tax): 2,000 yen

Characteristics
This sake is produced using only selected rice highly suited to sake-making that is grown in the highlands of northern Hiroshima Prefecture. The rice is carefully polished and slowly soaked in natural underground well water over the winter months.

- Specific Class Name: Daiginjo
- Main Ingredients: rice, malted rice, distilled alcohol
- Rice-polishing Ratio*: 50%
- Volume: 720 ml
- Alcohol Content: 16-17%
- Domestic Sales Price (excl. tax): 2,500 yen

Dishes that go very well with this product: Sushi, Sashimi

Master Brewer’s Point of Pride
While naturally treasurering the taste crafted by our forebears, we also utilized our own techniques in the brewing process. This is one sake we definitely recommend that you try.

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*The ratio of the weight of polished rice to that of the weight before polishing.
The rice used in brewing this sake is called “Hattan Nishiki,” a well on the brewery grounds, this sake can be enjoyed with meals. The wooden placard hanging from the bottle’s neck is made from Yoshino Japanese Cedar and can be used like a muddler, giving it a “taruzake” (barreled sake) taste.

Brewed using natural ultra-soft water drawn from a well on the brewery grounds, this sake can be enjoyed with meals. The wooden placard hanging from the bottle’s neck is made from Yoshino Japanese Cedar and can be used like a muddler, giving it a “taruzake” (barreled sake) taste.
Kirei Daiginjo So

Company Name: Kirei Shuzo Co., Ltd
Address: 2-18 Saijo-Honnachi, Higashihiroshima-shi, Hiroshima Prefecture 739-0011
E-mail: kirei@5.dion.ne.jp
Contact Person: Sotaro Ishii  TEL: 81-82-422-2171

Characteristics
This daiginjo using “Yamada Nishiki” rice harvested in Hiroshima Prefecture (polished to 45% of the original size) is slowly brewed at a low temperature. Please enjoy this dry and crisp sake with an elegant aroma and rice flavor. In 2015, this sake won the excellent award at a seishu competition held by Hiroshima Regional Taxation Bureau.

Master Brewer’s Point of Pride
Sake brewing involves continuing to experiment until the desired product is achieved. Focusing completely on hand-production methods passed down over generations. Low-temperature long-term fermentation is used to draw out the delicious flavor of the rice.

Master Brewer
Masahiro NISHIGAKI

Kamoizumi Junmai Ginjo Shusen Honjikomi

Company Name: Kamoizumi Shuzo Co., Ltd
Address: 2-4 Saijo-Kamiichicho, Higashihiroshima-shi, Hiroshima Prefecture 739-0006
URL: http://www.kamoizumi.co.jp
E-mail: info@kamoizumi.co.jp
Contact Person: Shinji WATANABE  TEL: 81-82-423-2118

Characteristics
In order to preserve its original taste, this full-bodied, rich-taste, golden-colored sake is brewed without carbon filtration. In 2016, this sake won the Gold Award at the SFJ Warmed Sake Competition.

Master Brewer’s Point of Pride
We aim to produce an impressive sake suitable for drinking warm that carefully preserves the Kamoizumi flavor. We therefore take special care with our rice malt production to ensure the sweetness of the rice is liberally extracted.

Master Brewer
Masao FUJII

Ryusei Junmai Daiginjo Black Label

Company Name: Fujii Shuzo Co., Ltd
Address: 3-4-14 Hon-machi, Takehara-shi, Hiroshima Prefecture 725-0022
URL: http://www.fujiishuzou.com
E-mail: info@fujiishuzou.com
Contact Person: Yoshifumi FUJII  TEL: 81-846-22-2029

Characteristics
This sake with a rich and well-balanced flavor is brewed with “Yamada Nishiki” sake rice only. Please enjoy the sake with meals. In 2007, this sake won the Gold Trophy in the Junmai-daiginjo/ginjo category at the International Wine Challenge (IWC).

Master Brewer’s Point of Pride
Using the traditional techniques coexistent with nature that were crafted by our predecessors and modern technology and hygiene management, we aim to brew sake with the deep, sharp flavor inherent to Japanese sake.

Master Brewer
Masao FUJII

Junmai Ginjo “Suishin Inaho”

Company Name: Suishin Yamane Honten Co., Ltd
Address: 1-5-58 Higashi-machi, Mihara-shi, Hiroshima Prefecture 739-0011
URL: http://www.suishinsake.co.jp/
E-mail: yamanehonten@suishinsake.co.jp
Contact Person: Kunio SAKAI  TEL: 81-848-62-3251

Characteristics
“A sake brewed with ultra-soft water that one never tires of drinking.”
This sake was a favorite of the great Japanese artist Taikan YOKOYAMA, who enjoyed it to his dying day. This “Aji-Ginjo” sake has an elegant, smooth taste and a deep, delicate flavor.

Master Brewer’s Point of Pride
We use “famous, extremely rare ultra-soft water” from under the foot of Mt. Takanosu, which lies in the central area of Hiroshima Prefecture. We carefully create sake with a soft, delicate, and deep flavor, always keeping in mind the “sake that one never tires of drinking”.

Master Brewer
Terushige HIRA

Suishin Yamane Honten Co., Ltd

Address: 2-4 Saijo-Kamiichicho, Higashihiroshima-shi, Hiroshima Prefecture 739-0006
E-mail: yamanehonten@suishinsake.co.jp
Contact Person: Shinji WATANABE  TEL: 81-846-22-2029

Characteristics

This daiginjo using “Yamada Nishiki” rice harvested in Hiroshima Prefecture (polished to 45% of the original size) is slowly brewed at a low temperature. Please enjoy this dry and crisp sake with an elegant aroma and rice flavor. In 2015, this sake won the excellent award at a seishu competition held by Hiroshima Regional Taxation Bureau.

Master Brewer’s Point of Pride
Sake brewing involves continuing to experiment until the desired product is achieved. Focusing completely on hand-production methods passed down over generations. Low-temperature long-term fermentation is used to draw out the delicious flavor of the rice.

Master Brewer
Masahiro NISHIGAKI

Kamoizumi Junmai Ginjo Shusen Honjikomi

Company Name: Kamoizumi Shuzo Co., Ltd
Address: 2-4 Saijo-Kamiichicho, Higashihiroshima-shi, Hiroshima Prefecture 739-0006
URL: http://www.kamoizumi.co.jp
E-mail: info@kamoizumi.co.jp
Contact Person: Shinji WATANABE  TEL: 81-82-423-2118

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Master Brewer
Masao FUJII

Ryusei Junmai Daiginjo Black Label

Company Name: Fujii Shuzo Co., Ltd
Address: 3-4-14 Hon-machi, Takehara-shi, Hiroshima Prefecture 725-0022
URL: http://www.fujiishuzou.com
E-mail: info@fujiishuzou.com
Contact Person: Yoshifumi FUJII  TEL: 81-846-22-2029

Characteristics
This sake with a rich and well-balanced flavor is brewed with “Yamada Nishiki” sake rice only. Please enjoy the sake with meals. In 2007, this sake won the Gold Trophy in the Junmai-daiginjo/ginjo category at the International Wine Challenge (IWC).

Master Brewer’s Point of Pride
Using the traditional techniques coexistent with nature that were crafted by our predecessors and modern technology and hygiene management, we aim to brew sake with the deep, sharp flavor inherent to Japanese sake.

Master Brewer
Masao FUJII

Junmai Ginjo “Suishin Inaho”

Company Name: Suishin Yamane Honten Co., Ltd
Address: 1-5-58 Higashi-machi, Mihara-shi, Hiroshima Prefecture 739-0011
URL: http://www.suishinsake.co.jp/
E-mail: yamanehonten@suishinsake.co.jp
Contact Person: Kunio SAKAI  TEL: 81-848-62-3251

Characteristics
“A sake brewed with ultra-soft water that one never tires of drinking.”
This sake was a favorite of the great Japanese artist Taikan YOKOYAMA, who enjoyed it to his dying day. This “Aji-Ginjo” sake has an elegant, smooth taste and a deep, delicate flavor.

Master Brewer’s Point of Pride
We use “famous, extremely rare ultra-soft water” from under the foot of Mt. Takanosu, which lies in the central area of Hiroshima Prefecture. We carefully create sake with a soft, delicate, and deep flavor, always keeping in mind the “sake that one never tires of drinking”.

Master Brewer
Terushige HIRA

Suishin Yamane Honten Co., Ltd

Address: 2-4 Saijo-Honnachi, Higashihiroshima-shi, Hiroshima Prefecture 739-0011
E-mail: yamanehonten@suishinsake.co.jp
Contact Person: Shinji WATANABE  TEL: 81-846-22-2029

Characteristics
This daiginjo using “Yamada Nishiki” rice harvested in Hiroshima Prefecture (polished to 45% of the original size) is slowly brewed at a low temperature. Please enjoy this dry and crisp sake with an elegant aroma and rice flavor. In 2015, this sake won the excellent award at a seishu competition held by Hiroshima Regional Taxation Bureau.

Master Brewer’s Point of Pride
Sake brewing involves continuing to experiment until the desired product is achieved. Focusing completely on hand-production methods passed down over generations. Low-temperature long-term fermentation is used to draw out the delicious flavor of the rice.

Master Brewer
Masahiro NISHIGAKI
**Master Brewer’s Point of Pride**

Our rice malt production is characterized by our focus on obtaining a moist rice flavor, the rice malt bacteria is allowed to multiply to ensure that each rice grain is completely covered with the bacteria. We put our hearts into breeding our sake so that those who drink our products can experience happiness.

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**Characteristics**

- **Specific Class Name**: Junmai
- **Main Ingredients**: Hattan Nishiki rice
- **Rice-polishing Ratio**: 60%
- **Volume**: 720 ml
- **Alcohol Content**: 15.8%
- **Domestic Sales Price (excl. tax)**: 1,250 yen

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This sake is brewed using the legendary “Omachi” rice harvested in Akawa City, Okayama Prefecture (polished to 40% of the original size), and underflow water (soft water) from Mt. Noro situated in the Setonaikai National Park. As its name suggests, this excellent sake with a gorgeous taste has an elegant and clear flavor.

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**Characteristics**

- **Specific Class Name**: Junmai Daiginjo
- **Main Ingredients**: Rice (Yamadanishiki)
- **Rice-polishing Ratio**: 35%
- **Volume**: 720 ml
- **Alcohol Content**: 17.1%
- **Domestic Sales Price (excl. tax)**: 3,500 yen

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I actually cultivate brewer’s rice myself. We are committed to traditional small-batch manual production and this sake has a rich yet refreshing taste, making a perfect accompaniment for meals. Please enjoy the delicious traditional taste inherent in Japanese sake.

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**Characteristics**

- **Specific Class Name**: Junmai
- **Main Ingredients**: Rice, malted rice
- **Rice-polishing Ratio**: 60%
- **Volume**: 720 ml
- **Alcohol Content**: 18-19%
- **Domestic Sales Price (excl. tax)**: 1,550 yen

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Sake Production Process

Sake is a kind of alcoholic drink made by fermenting ingredients and is categorized as brewed beverage like beer and wine. Since it does not contain sugar as an ingredient, sake production requires a process called saccharification along with fermentation. The relatively high alcohol percentage of sake can be attained by this brewing process, known as multiple parallel fermentation.

① Rice Milling
By milling the rice, the fats, proteins and minerals on the surface of rice kernels that adversely affect the flavor of sake are removed. This process allows koji mold to penetrate deeper into the rice kernels.

② Washing and Soaking
Rice bran powder left on the surface of rice kernels is then washed away. Following this, rice is immersed in water until the moisture penetrates to the core of the rice kernels.

③ Rice Steaming
The moistened rice kernels, after being left overnight, are moved into a steamer called a koshiki and are steamed for around 40 to 60 minutes. Steamed rice of high quality has both elasticity and firmness. The steamed rice is then cooled with air in a cooling room.

④ Koji Making
Koji mold is propagated in a special room in which the temperature is maintained at approximately 30°C. This step is the heart of the entire brewing process, since the developed koji greatly influences the taste and quality of the resulting sake.

⑤ Moto Making
Finished koji, plain steamed white rice, water, and yeast are mixed to make shubo or moto, which constitutes the base of the sake. Lactic acid is added to protect the moto from unwanted bacteria that block the action of the yeast.

⑥ Shikomi
Shubo is mixed with more rice, more koji and more water to make moromi. This is usually done in three stages, a process unique to sake production. Mixing the ingredients in successive stages allows the yeast to maintain its activity and facilitates smooth fermentation, while preventing contamination of the moromi by unwanted bacteria at the same time.
8 Pasteurization
Squeezed sake is pasteurized in order to deactivate the yeast and kill bacteria. Pasteurization is usually done at a temperature of approximately 60-65°C, which stops the action of the yeast. Pasteurized sake is then moved into storage tanks and left to age. The tanks are usually kept at a temperature of 15-20°C. Ginjo is kept at approximately 2°C.

7 Squeezing
Fermented moromi is put into bags and pressed to be divided into fresh sake and lees (called sake-asa).

9 Bottling
When sake gets matured, the flavor is checked and rounded out by charcoal filtering and other processes. It is then pasteurized one more time to prevent decay before bottling.

How to Drink Sake

Types of Sake Enjoyed Chilled
Sakes with a fruity and deep flavor elicit their features when drunk cold. Generally, the optimal temperature is considered to be around 12°C. Ginjo loses its flavor when warmed.

Types of Sake That Suit Chilling
- Ginjo, Junmai-Ginjo
- Wine-type sake
- Shiboritate (freshly squeezed sake), Nama-zake (unpasteurized sake), Nigori-zake (cloudy sake)

Types of Sake Enjoyed Warmed
Sakes with a simple and full-bodied taste elicit their features when warmed, as the heat enhances their fragrance and flavor, which are difficult to sense when the sake is served chilled. Generally, a temperature of around 45°C is considered optimal.

Types of Sake That Suit Warming
- Ordinary sake (Futsu-shu)
- Honjozo, Junmai (sake without high fragrance)
- Yamahai-Junmai, Kimoto-Junmai (sake made by the original method)

Unique Style — Mizore-zake
Freeze sake in a glass and, just before serving, add sake of the same kind and stir well. This drink is perfect as an appetizer or to be enjoyed in mid-summer.
Enthralling
Hiroshima’s Sake

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