

Hiroshima's Sake



JETRO

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.

Special Names	Ingredients	Percentage of Remaining Rice Kernels after Milling	Percentage of <i>Koji</i> Rice Used	Flavor, Fragrance and Other Features
Ginjo	Rice, Malted Rice, Distilled Alcohol	60% or less	15%	Sake made from highly milled rice, unique fragrance, fine color and texture
Daiginjo	Rice, Malted Rice, Distilled Alcohol	50% or less	15%	Sake made from highly milled rice, unique fragrance, fine color and texture
Junmai	Rice, Malted Rice	—	15%	Unique fragrance, fine color and texture

[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.

Special Names	Ingredients	Percentage of Remaining Rice Kernels after Milling	Percentage of <i>Koji</i> Rice Used	Flavor, Fragrance and Other Features
Junmai-Ginjo	Rice, Malted Rice	60% or less	15%	Sake made from highly milled rice, unique fragrance, fine color and texture
Junmai-Daiginjo	Rice, Malted Rice	50% or less	15%	Sake made from highly milled rice, unique fragrance, especially fine color and texture
Tokubetsu-Junmai	Rice, Malted Rice	60% or less, or those that were made by special methods (explanation must be indicated)	15%	Especially fine fragrance, color and texture
Honjozo	Rice, Malted Rice, Distilled Alcohol	70% or less	15%	Fine fragrance, color and texture
Tokubetsu-Honjozo	Rice, Malted Rice, Distilled Alcohol	60% or less, or those that were made by special methods (explanation must be indicated)	15%	Especially fine fragrance, color and texture

[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.

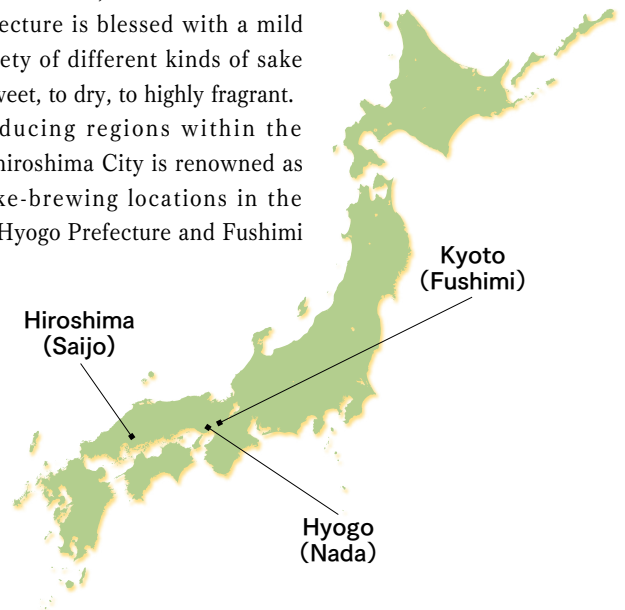
Ordinary sake without special designation(*Futsu-shu*) constitutes about 70 percent of the entire market.

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.



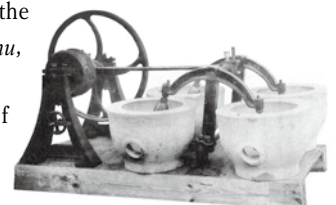
The Innovative Spirit of Hiroshima that Created Excellent Sake — The Birthplace of *Ginjoshu*

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.



Picture provided by Satake

Hiroshima's Sake and Breweries

Experience the diversity of flavors, from sweet to sharp and light to rich.

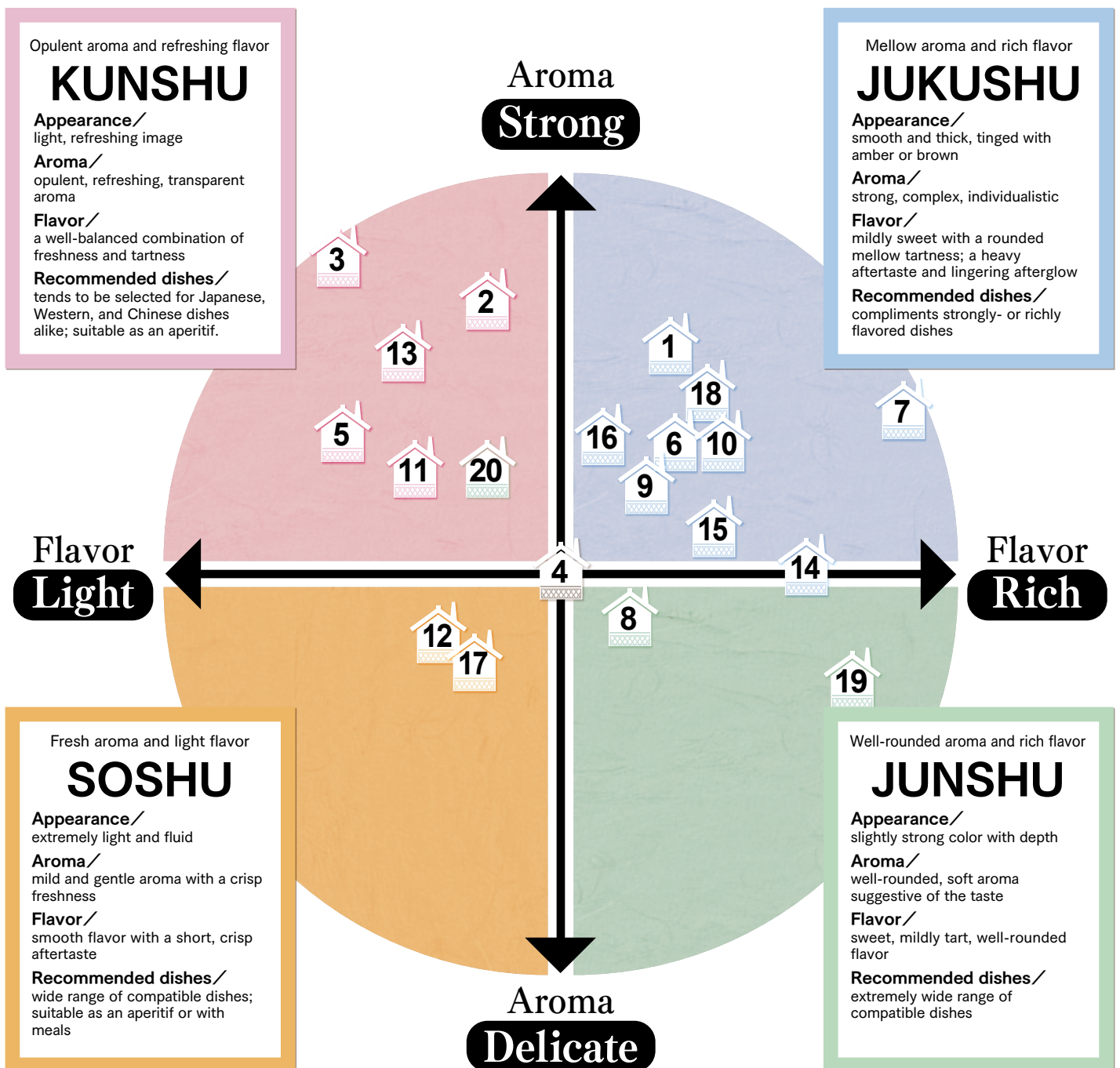
A city where you can enjoy the unique flavor of a range of Japanese sake all in the one place.

- | | | |
|---|----------------------------------|---------------------------------|
| ①Yahatagawa Brewery Co., Ltd | ⑦Enoki Shuzo Co., Ltd | ⑭Fuji Shuzo Co., Ltd |
| ②Chugoku Jozo Co., Ltd | ⑧Kamotsuru Sake Brewing Co., Ltd | ⑮Kamoizumi Shuzo Co., Ltd |
| ③Umeda-Shuzoujou & Co. | ⑨Hakubotan Shuzo Co., Ltd | ⑯Suishin Yamane Honten Co., Ltd |
| ④Kubota Shuzo Co., Ltd | ⑩Nakao Sake Brewery Co., Ltd | ⑰Tenpoichi Co.,Ltd |
| ⑤Kyokuhou Shuzo Co., Ltd | ⑪Imada Sake Brewery Co., Ltd | ⑱Hibabijin Shuzo Co., Ltd |
| ⑥Miyake Honten 'Senpuku' Sake Brewery Co.,Ltd | ⑫Morikawa Shuzo Co., Ltd | ⑲Yamaoka Shuzo Co., Ltd |
| | ⑬Kirei Shuzo Co., Ltd | ⑳Aihara 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.



① Special Junmai Shin-Miyajima

Company Name Yahatagawa Brewery Co., Ltd

Address: 3-13-20 Yahata, Saeki-ku, Hiroshima-shi, Hiroshima Prefecture 731-5116

URL: <http://www.yahatagawa.co.jp/>

E-mail: info@yahatagawa.co.jp

Contact Person: Saburo MENDE TEL: 81-82-928-0511



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 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.

② Shusho-ichidai Aimesen

Company Name Chugoku Jozo Co., Ltd

Address: 1-12-1 Sakurao, Hatsukaichi-shi, Hiroshima Prefecture 738-8602

URL: <http://www.chugoku-jozo.co.jp/>

E-mail: customer@chugoku-jozo.co.jp

Contact Person: MASAOMI TAKEUCHI TEL: 81-829-32-2113



Characteristics

The ultimate brewer's rice, "Yamada Nishiki," is polished to 35% and fermented using clear water from beneath Mt. Gokurakuji to create this Daiginjo masterpiece. While fully providing an opulent, fruity aroma and the taste and sweetness of rice, this sake also has the sharpness and excellent aftertaste unique to Daiginjo.

- ◆ Specific Class Name: Daiginjo
- ◆ Main Ingredients: rice, malted rice, distilled alcohol
- ◆ Rice-polishing ratio*: 35%
- ◆ Volume: 720 ml
- ◆ Alcohol Content: 16%
- ◆ Domestic sales price (excl. tax): 3,000 yen

Dishes that go very well with this product Whitefish sashimi and other mild-tasting dishes using citrus fruits and fruit sauce

Master Brewer's Point of Pride

Using our well-honed five senses, we use a strong malt production process that brings out the delicious flavor of the rice to seal in the aroma through carefully controlled low-temperature, long-term fermentation in order to produce a unique "Misen" Daiginjo that is delicious to drink.

③ Honshu-ichi Muroka Junmai

Company Name Umeda-Shuzoujou & Co.

Address: 6-3-8 Funakoshi, Aki-ku, Hiroshima-shi, Hiroshima Prefecture 736-0081

URL: <http://www.honshu-ichi.com>

E-mail: info@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

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

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.

④ Kinsho Hishimasamune Daiginjo

Company Name Kubota Shuzo Co., Ltd

Address: 2-34-24 Kabe, Asakita-ku, Hiroshima-shi, Hiroshima Prefecture 731-0221

URL: <http://www.hishimasamune.co.jp>

E-mail: kubota@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*: 40%
- ◆ Volume: 720 ml
- ◆ Alcohol Content: 16.5%
- ◆ Domestic Sales Price (excl. tax): 2,700 yen

Dishes that go very well with this product Whitefish sashimi, oyster dishes, *okonomiyaki* (Hiroshima-style)

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 maintain traditional brewing techniques passed down from long ago.

*The ratio of the weight of polished rice to that of the weight before polishing

⑤ Kyokuhou Junmai Ginjo Hattan Nishiki

Company Name Kyokuhou Shuzo Co., Ltd

Address: 3-8-16 Kabe, Asakita-ku, Hiroshima-shi, Hiroshima Prefecture 731-0221

URL: <http://www.kyokuhou.co.jp/>

Contact Person: Ikuko HAMAMURA TEL: 81-82-812-3344



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 Kyokuhou’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 Whitefish sashimi, grilled or stewed fish, grilled conger 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.

⑥ Sempuku Junmai Daiginjo Kura

Company Name Miyake Honten 'Sempuku' Sake Brewery Co., Ltd

Address: 7-9-10 Hondori, Kure-shi, Hiroshima Prefecture 737-0045

URL: <http://www.sempuku.co.jp/>

E-mail: main@sempuku.co.jp

Contact Person: Kiyoshi MIYAKE TEL: 81-823-22-1029



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

Master Brewer’s Point of Pride



Tomio SETO

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 *seishu*, 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.

⑦ Hanahato Kijoshu Hachinen Chozo

Company Name Enoki Shuzo Co., Ltd

Address: 2-1-15 Minamiondo, Ondo-cho, Kure-shi, Hiroshima Prefecture 737-1205

URL: <http://www.hanahato.co.jp>

E-mail: info@hanahato.co.jp

Contact Person: Toshihiro ENOKI TEL: 81-823-52-1234



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

Dishes that go very well with this product This sake goes very well with cheese, foie gras, tempura, and other rich-tasting dishes such as pork kakuni. Also enjoy together with chocolate. Add this sake to the top of vanilla ice cream to make a dessert for adults.

Master Brewer’s Point of Pride



Tadashi FUJITA

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.

⑧ Daiginjo Tokusei Gold Kamotsuru

Company Name Kamotsuru Sake Brewing Co., Ltd

Address: 4-31 Saijo-Honmachi, Higashihiroshima-shi, Hiroshima Prefecture 739-0011

URL: <http://www.kamotsuru.jp>

E-mail: order@kamotsuru.co.jp

Contact Person: Yumi SHINTANI TEL: 81-82-422-2121



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



Koji TOMOYASU

While naturally treasuring 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.

⑨ Nihonshu Hakubotan Junmai Ginjo

Company Name Hakubotan Shuzo Co., Ltd

Address: 15-5 Saijo-Honmachi, Higashihiroshima-shi, Hiroshima Prefecture 739-0011

URL: <http://www.hakubotan.co.jp>

E-mail: mail@hakubotan.co.jp

Contact Person: Harumasa SHIMA TEL: 81-82-422-2142



Characteristics

We produce flavorful, sharp-tasting sake that can only be produced in Saijo, a region blessed with harsh cold in winter and brewers as well as excellent quality water and rice highly suitable for sake brewing. The name "Hakubotan" was bestowed in 1839 by the Takatsukasa Family of Kyoto, one of the Five Regent Houses.

- ◆ Specific Class Name: Junmai Ginjo
- ◆ Main Ingredients: rice, malted rice
- ◆ Rice-polishing Ratio*: 60%
- ◆ Volume: 720 ml
- ◆ Alcohol Content: 15%
- ◆ Domestic Sales Price (excl. tax): 1,500 yen

Dishes that go very well with this product: Gratins, cheese



Tadashi KASHIMA

Master Brewer's Point of Pride

The foundation of our sake is swollen rice malt grains with good hazekomi conditions. The fermenting mash is carefully managed to produce a Junmai Ginjo with a refreshing, slightly sweet flavor and the tartness characteristic of Junmai.

⑩ Junmai Ginjo Maboroshi

Company Name Nakao Sake Brewery Co., Ltd

Address: 5-9-14 Chuo, Takehara-shi, Hiroshima Prefecture 725-0026

URL: <http://www.maboroshi.co.jp>

E-mail: sake@maboroshi.co.jp

Contact Person: Tsuyoshi YOSHIMURA TEL: 81-846-22-2035



Characteristics

This Junmai Ginjo is brewed using "Hattan Nishiki," a brewer's rice that has been grown continuously in Hiroshima since ancient times. We put special effort into making rice malt—the most important process in sake brewing—spending more than 50 hours on this process to ensure the sake produced has a soft, deep flavor.

- ◆ Specific Class Name: Junmai Ginjo
- ◆ Main Ingredients: rice, malted rice
- ◆ Rice-polishing Ratio*: 55%
- ◆ Volume: 720 ml
- ◆ Alcohol Content: 15.4%
- ◆ Domestic Sales Price (excl. tax): 1,300 yen

Dishes that go very well with this product: Seafood salad, sea bream sashimi, chicken tempura



Akio ARATANI

Master Brewer's Point of Pride

We invest time and effort greater than the product price as well as our hearts into the brewing process. In sake brewing, insistence on small matters shows in a huge difference in sake quality, and this is conveyed to those who taste this sake.

⑪ Fukucho Junmai Daiginjo Myokafu

Company Name Imada Sake Brewery Co., Ltd

Address: 3734 Mitsu, Akitsu-cho, Higashihiroshima-shi, Hiroshima Prefecture 739-2402

URL: <http://fukucho.info>

E-mail: info@imada-shuzo.co.jp

Contact Person: Miho IMADA TEL: 81-846-45-0003



Characteristics

The rice used in brewing this sake is called "Hattanso." The brewery was drawn to using this rice because it is native to the Hiroshima region, and so independently revived its cultivation and was ultimately successful after several years of trial and error. The sake is produced from this Hattanso rice.

- ◆ Specific Class Name: Junmai Daiginjo
- ◆ Main Ingredients: rice, malted rice
- ◆ Rice-polishing Ratio*: 40%
- ◆ Volume: 720 ml
- ◆ Alcohol Content: 16%
- ◆ Domestic Sales Price (excl. tax): 5,000 yen

Dishes that go very well with this product: Please enjoy this sake with fresh seafood and other healthy dishes.



Miho IMADA

Master Brewer's Point of Pride

Akitsu-cho, where our company is located, is the hometown of Hiroshima's master brewers. Inheriting the passion of Senzaburo MIURA, who was the first in Japan to develop a fermenting technique using soft water, we brew sake using locally produced rice and water.

⑫ Hakuko Junmai Ginjo Blue Bottle

Company Name Morikawa Shuzo Co., Ltd

Address: 44 Harahata, Yasuura-cho, Kure-shi, Hiroshima Prefecture 737-2506

URL: <http://morikawa-shuzo.com/>

E-mail: info@morikawa-shuzo.com

Contact Person: Tomonori MORIKAWA TEL: 81-823-84-2002



Characteristics

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.

- ◆ Specific Class Name: Junmai Ginjo
- ◆ Main Ingredients: rice, malted rice
- ◆ Rice-polishing Ratio*: 60%
- ◆ Volume: 300 ml
- ◆ Alcohol Content: 15.0-15.9%
- ◆ Domestic Sales Price (excl. tax): open

Dishes that go very well with this product: Marinated salmon, chicken pot-au-feu, escabeche with oil



Motoharu MORIKAWA

Master Brewer's Point of Pride

My sense of "Hakuko-like sake" is "a sake with a taste can continue to be enjoyed without becoming boring," "a sake that without realization washes down smoothly glass after glass," and "a sake with a strength within softness." This is the kind of sake I am aiming for.

*The ratio of the weight of polished rice to that of the weight before polishing

⑬ Kirei Daiginjo So

Company Name Kirei Shuzo Co., Ltd

Address: 8-18 Saijo-Honmachi, Higashiroshima-shi, Hiroshima Prefecture 739-0011

E-mail: kirei@r5.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.

- ◆ Specific Class Name: Daiginjo
- ◆ Main Ingredients: rice, malted rice, distilled alcohol
- ◆ Rice-polishing Ratio*: 45%
- ◆ Volume: 720 ml
- ◆ Alcohol Content: 16.5%
- ◆ Domestic Sales Price (excl. tax): 2,500 yen

Dishes that go very well with this product Whitefish sashimi, anago-no-shirayaki (a conger eel grilled without seasoning)



Masahiro NISHIGAKI

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.

⑭ 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).

- ◆ Specific Class Name: Junmai Daiginjo
- ◆ Main Ingredients: rice, malted rice
- ◆ Rice-polishing Ratio*: 50%
- ◆ Volume: 720 ml
- ◆ Alcohol Content: 17%
- ◆ Domestic Sales Price (excl. tax): 2,727 yen

Dishes that go very well with this product Sukiyaki, tuna sashimi



Masao FUJII

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.

⑮ Kamoizumi Junmai Ginjo Shusen Honjikomi

Company Name Kamoizumi Shuzo Co., Ltd

Address: 2-4 Saijo-Kamiichicho, Higashiroshima-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.

- ◆ Specific Class Name: Junmai Ginjo
- ◆ Main Ingredients: rice, malted rice
- ◆ Rice-polishing Ratio*: 58%
- ◆ Volume: 1800 ml
- ◆ Alcohol Content: 16%
- ◆ Domestic Sales Price (excl. tax): 2,566 yen

Dishes that go very well with this product Red flesh fish sashimi, oyster dotenabe, grilled eel



Toshiyuki SHINTANI

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 especial care with our rice malt production to ensure the sweetness of the rice is liberally extracted.

⑯ Junmai Ginjo “Suishin Inaho”

Company Name Suishin Yamane Honten Co., Ltd

Address: 1-5-58 Higashi-machi, Mihara-shi, Hiroshima Prefecture 723-0011

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.

- ◆ Specific Class Name: Junmai Ginjo
- ◆ Main Ingredients: rice, malted rice
- ◆ Rice-polishing Ratio*: 60%
- ◆ Volume: 720 ml
- ◆ Alcohol Content: 15.0-15.9%
- ◆ Domestic Sales Price (excl. tax): 1,335 yen

Dishes that go very well with this product Whitefish terrine, wild vegetable tempura, boiled shrimps or crabs, asparagus sautéed with butter, steamed chicken



Terushige HIRA

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”.

⑰ Special Junmai Hattan Nishiki

Company Name Tenpoichi Co.,Ltd

Address:660 Kawakita, Kannabe-cho, Fukuyama-shi, Hiroshima Prefecture 720-2123

URL: <http://www.tenpo1.co.jp/>

E-mail: tenpoichi@tenpo1.co.jp

Contact Person:Yasuhisa MURAKAMI TEL:81-84-962-0033



Characteristics

This sake is characterized by its sophisticated Hattan Nishiki rice flavor, clarity, and sharpness.

- ◆ 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

Dishes that go very well with this product Fish dishes and dishes using cream (without too much garlic)

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 brewing our sake so that those who drink our products can experience happiness.

⑱ Hibabijin Junmai Genshu

Company Name Hibabijin Shuzo Co., Ltd

Address:232-1 Mikkaichi-cho, Shobara-shi, Hiroshima Prefecture 727-0021

E-mail: bijin-2@piano.ocn.ne.jp

Contact Person: Toru HAYASHI TEL: 81-824-72-0589



Characteristics

Obtaining the inherent flavor passed down from ancient times required excellent quality rice (home-grown) and rice malt, yeast, and water, as well as the spirit of the master brewer. Try tasting the soft aroma and velvety taste of this sake.

- ◆ 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

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

Master Brewer's Point of Pride



Kyoso SUKEHIRO

We handle the rice very carefully as it is washed and steamed to make good-quality rice malt in order to produce sake that is delicious to drink and taste with a sense of the (1) rice malt, (2) traditional methods, and (3) brewing.

⑲ Zuikan Junmai Yamahaijokomi Aigamomai Kamenoo

Company Name Yamaoka Shuzo Co., Ltd

Address:489-1 Nishino, Konu-cho, Miyoshi-shi, Hiroshima Prefecture 729-4102

URL: <http://wp1.fuchu.jp/~zuikan/>

Contact Person: Katsumi YAMAOKA TEL: 81-847-67-2302



Characteristics

The rice used to produce this sake is 100% Aigamonohomai Kamenoo. The natural flavor of rice is preserved in the rich flavor of this Junmai through the use of traditional Yamahaishikomi brewing methods and small-batch production.

- ◆ Specific Class Name: Junmai
- ◆ Main Ingredients: rice, malted rice
- ◆ Rice-polishing Ratio*: 65%
- ◆ Volume: 720 ml
- ◆ Alcohol Content: 16.5%
- ◆ Domestic Sales Price (excl. tax): 1,450 yen

Dishes that go very well with this product Oyster dishes, meat dishes, smoked foods

Master Brewer's Point of Pride



Uji HATANAKA

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.

⑳ Junmai Diginjo Ugo no Tsuki

Company Name Aihara Shuzo Co., Ltd

Address:1-25-15 Nigata-honmachi, Kure, Hiroshima Prefecture 737-0152

URL: <http://www.ugonotsuki.com/>

E-mail: aihara@urban.ne.jp

Contact Person: JUNICHIRO AIHARA TEL: 81-823-79-5008



Characteristics

This sake is brewed using the legendary "Omachi" rice harvested in Akaiwa 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.

- ◆ 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

Dishes that go very well with this product Whitefish sashimi, itawasa, tempura (with salt), fish soup

Master Brewer's Point of Pride



Atsushi HORIMOTO

In order to create the taste of "Ugo-no-tsuki" that reminds you of elegant and beautiful scenery lit with clear moonlight, this sake is brewed in the same method as *daiginjo*. Both unrefined sake and finished products are slowly matured under refrigeration before shipping.

*The ratio of the weight of polished rice to that of the weight before polishing

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.



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.

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.

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.

STEP ①
Rice Milling

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.

STEP ②
Washing and Soaking

STEP ③
Rice Steaming

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.

STEP ④
Koji Making

STEP ⑤
Moto Making

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.

STEP ⑥
Shikomi





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.



STEP⑨
Bottling



STEP⑧
Pasteurization



STEP⑦
Squeezing

⑦ Squeezing

Fermented *moromi* is put into bags and pressed to be divided into fresh sake and lees (called *sake-kasu*).

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



【Production/Compilation】

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【Cooperation】

Hiroshima Sake Brewers Association

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