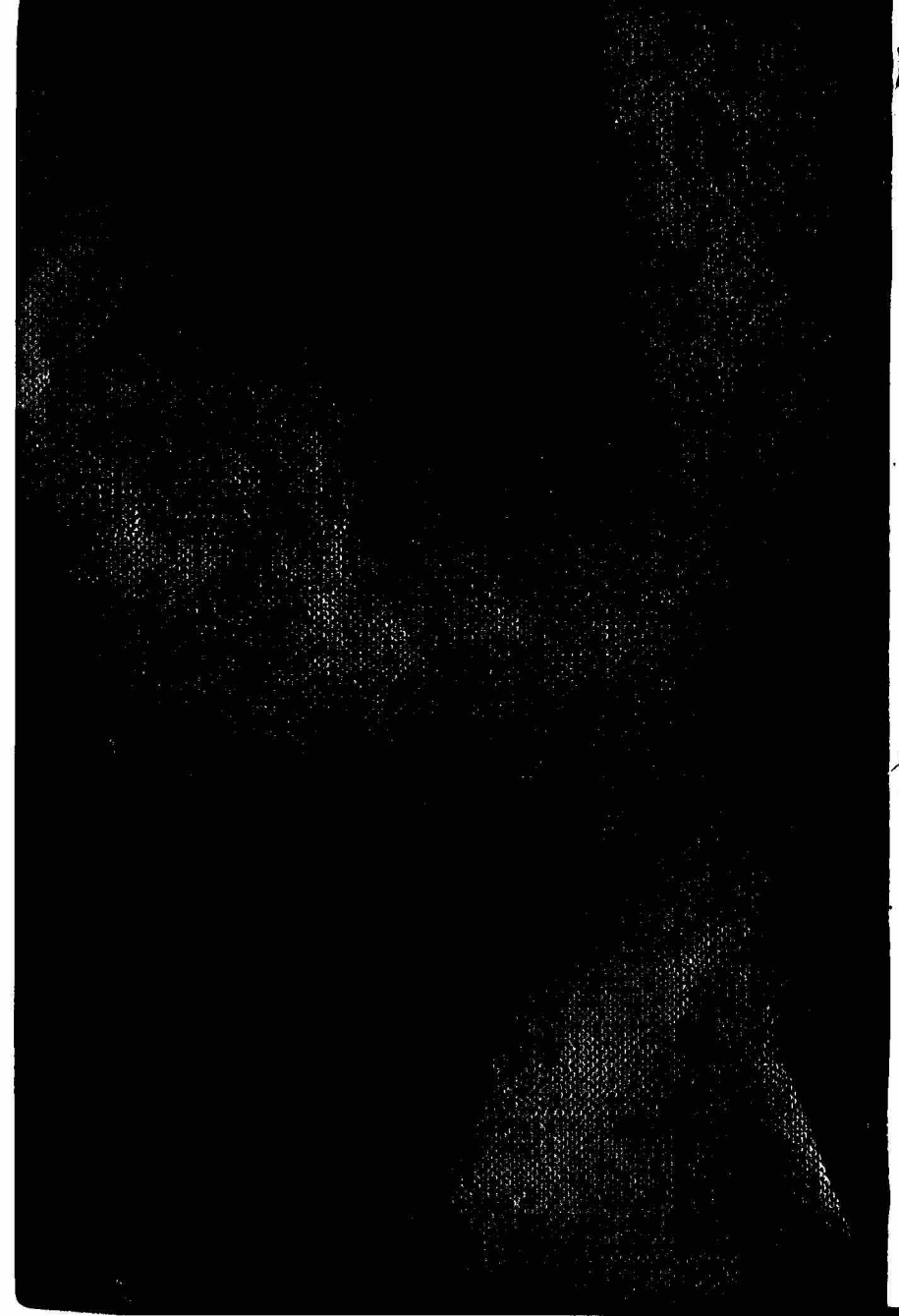

SCOTCH WHISKY

QUESTIONS AND ANSWERS

Published for the Scotch Whisky Association by Philip Gee

First published 1953

MADE AND PRINTED IN GREAT BRITAIN BY
JAMES TURNER AND COMPANY, EDINBURGH

FOREWORD

THIS book is intended as a handy reference work for those whose interests bring them in touch with the subject of Scotch Whisky

Scotch Whisky is itself a straightforward product and one, it might be thought, which could give rise to no great problems or misunderstandings. Nevertheless, experience has shown the need for some publication such as this, to provide a readily available answer to queries which constantly arise.

The time-lag in maturing Scotch Whisky occasions frequent confusion, for instance, among those whose daily work lies outside the Scotch Whisky industry It is not always appreciated that it is impossible, because of the time-lag, to relate production figures for any given year to consumption figures in the same year The distiller in making whisky, and the blender in laying it down, are thinking not of consumer demand that year or the next, but are endeavouring to forecast demand as much as a decade ahead. Maturing, in fact, posits problems, including financial problems, which are unique to the Scotch Whisky industry , no other product of these isles has such a gap between the creation and consumption of its product.

In compiling this volume the assistance of the experts, most qualified in their own fields, has been freely given. So many have co-operated that it would be invidious to mention names.

THE PUBLIC RELATIONS COMMITTEE,
SCOTCH WHISKY ASSOCIATION
EDINBURGH, 1953.

CONTENTS

SECTION I

WHISKY IN THE MAKING

1. *What are the main types of Scotch Whisky and their characteristics ?*
2. *How is Scotch Whisky made ?*
3. *What gives Scotch Whisky its characteristic flavour and bouquet ?*
4. *Why do not Patent-Still, or grain, whiskies have the range of variety of flavour and bouquet of Pot-Still, or malt, whiskies ?*
5. *What is blending ? What is its object ?*
6. *When was blending first introduced ?*
7. *What is the percentage of grain whisky in Scotch Whisky blends ?*
8. *What sizes of casks are used for bulk whisky and what are their respective capacities ?*

Question No. 1

WHAT ARE THE MAIN TYPES OF SCOTCH WHISKY AND THEIR CHARACTERISTICS?

Answer

The main types of Scotch Whisky are Malt Whisky and Grain Whisky There are also four recognised types of malt whisky These are

1. Highland Malt Whisky, made north of an imaginary line from Dundee on the east to Greenock on the west. This can be subdivided into Glenlivets and Highlands.
2. The Lowland Malt Whiskies, made south of the line.
3. Islays, from the island of that name.
4. Campbeltowns, from the town of that name in the Mull of Kintyre. Production now small.

Malt whiskies, which all differ among themselves according to the distillery from which they come, have a more pronounced bouquet and flavour than the grain whiskies.

Question No. 2

HOW IS SCOTCH WHISKY MADE?

Answer

1. RAW MATERIALS Whisky may be distilled from any of the following

(*a*) Malted barley;
(*b*) Unmalted barley,
(*c*) Maize;
(*d*) Rye,

and from many mixtures of two or more of the above materials.

Scotch Malt Whisky is made from malted barley only

Scotch Grain Whisky is normally made from unmalted barley with an admixture of maize or rye, in varying proportions, but in any case mashed with malted barely, whatever the mixture adopted.

2. MANUFACTURING PROCESS. There are two different processes of distillation used in the manufacture of Scotch Whisky, viz., the pot-still process and the patent- (or Coffey-) still process.

The product of the former is known as Malt Whisky, and of the latter as Grain Whisky Both are true whiskies and neither is in any sense a neutral spirit.

3. THE POT-STILL PROCESS Scotch Malt Whisky

(*a*) *Cleaning*. The barley is screened to remove any foreign matter.

(*b*) *Malting* · The clean barley is steeped for two or three days in tanks of water, called " steeps," after which it is spread out on a concrete floor, known as the " malting floor," to germinate under conditions of warmth and moisture. This may occupy from eight to twelve days, during which time the starch is modified by the enzyme cytase, and the enzyme diastase is secreted. Diastase later in the process converts the starch into a sugar—maltose. At the appropriate moment the action is stopped when the malted barley, or " green-malt," is removed to the kilns for drying.

(*c*) *Drying and Grinding* · The green-malt is then dried, in the case of Highland malt whiskies over a fire of peat and coke, the peat imparting its characteristic flavour and aroma to the sprouting grains. The dried malt is then ground ready for the next stage.

(*d*) *Mashing:* The ground malt, or " grist," is then mixed in mash tuns with hot water, which, aided by

the enzyme diastase, converts and dissolves the modified starch of malt as maltose. This sweet liquid, technically known as " the wort," is drawn off and the remaining husks, or " draff," are removed for use as cattle food.

(*e*) *Fermentation* After cooling, the wort is passed to vessels containing anything from 2,000 to 10,000 gallons, where it is fermented by yeast. The living, growing yeast attacks the sugar and converts it into crude alcohol. Simultaneously and later, other subsidiary fermentations take place which are responsible for many of the flavours of the whisky characteristic of each particular distillery

Fermentation occupies about forty-eight hours and results in a liquid known as " wash " which contains yeast, crude alcohol of low strength, some unfermentable matter, and the by-products of fermentation and bacterial action.

(*f*) *Distillation*. Distillation is carried out in a pot-still, and malt whisky is distilled twice first in the Wash Still, secondly in the Spirit Still.

The first distillation separates the crude alcohol from the fermented liquid and eliminates the residue of yeast and unfermentable matter In this first distillation a " cooking " of the secondary constituents takes place within the still, which, it is believed, develops the principal character and flavour found in each particular pot-still product.

The second distillation is carried out in a separate still in order to separate the desirable, potable portion of the distillate from the first and last runnings, which are not considered potable and are returned to the process. In deciding when to begin and end the collection of the potable spirit, the skill and experience of the stillman are of paramount importance.

The process of distillation is to heat the liquid to a point at which the alcohol, which has a lower boiling-point than water, becomes vapour. The vapourised

alcohol rises from the liquid and is driven off towards the cooling plant, where it is condensed to the liquid state and finally runs into the receiver.

Pot-still distillation is an intermittent process. The fermented wash is fed into the still, distilled, the residue rejected, and the still recharged.

(g) *Maturation* When distillation is completed, the new whisky, which has been collected in the Receiving Vat, is filled into casks made of wood. Most of these are of American oak, and a much smaller number are former sherry casks. Scotch Whisky must be left to mature in wooden casks because the wood, being permeable, allows air—oxygen—to pass inwards and evaporated spirit and undesirable coarser flavouring materials, or secondary products, to pass outwards. Crude whisky kept in casks becomes, after a sufficient number of years, a pleasant, mellow, mild spirit, having lost all its coarse, undesirable fiery characteristics. A pot-still whisky may be left as many as fifteen years to mature and will improve continuously, but there is a danger that after, say, twenty years from the time when it was distilled, it may acquire traces of " woodiness." Maturation is also influenced by the size of the cask, the strength at which the spirit is stored, and the temperature and atmosphere of the vault or warehouse.

4. The Patent-Still Process This process uses a mixture of unmalted barley and other cereals and a small proportion of malted barley, in contrast to the pot-still process, which relies entirely on barley malt to provide the wort. The unmalted cereals are first partly cooked.

Only one distillation takes place, in a continuous action which will carry on so long as the wash is fed into the still—unlike the pot-still, which is filled, emptied, and filled again.

The patent-still, different in design and method of operation from the pot-still, has a rectifying action which deprives the distillate of fusel oil and certain other secondary

constituents. This being so, the spirit distilled by this method, and known as Grain Whisky, does not require as long to mature as pot-still malt whisky, nor does it possess the pronounced characteristics of pot-still whisky It is, in fact, a true whisky of light body

5. Blending After maturing, the different whiskies —and no two are the same—are forwarded to the blending warehouses, where they are blended. Practice varies, but as a rule the blended whisky is then left for a period of months in casks to " marry " before bottling.

6. Bottling Now mechanical, and follows the reduction in strength of the whisky by adding soft water. For sealing the bottle, cork has now been extensively replaced by a metal cap containing a layer of cork which provides a cushion between the cap and the bottle and makes a liquid-tight joint possible. The cork is insulated from the whisky by a layer of pure tin, which it has been found does not affect whisky and is not affected by it.

7 Packing and Despatch Most Scotch Whiskies are marketed at home and abroad in branded bottles, so jealous are the established firms of the integrity and reputation of their product. This is an expensive method of marketing overseas, because of the weight of the bottles, the amount of packaging materials, such as wooden cases, required, but there appears no practical alternative.

Question No. 3

WHAT GIVES SCOTCH WHISKY ITS CHARACTERISTIC FLAVOUR AND BOUQUET?

Answer

This is one of the mysteries of the Industry and a secret which imitators of Scotch Whisky the world over would give a fortune to know

Many are the theories and partial explanations which have been advanced. There is no accepted solution.

Water is probably the most important single factor in deciding character and flavour The water best loved of distillers is soft and from red-granite streams. Certainly they guard their water supplies most jealously, and as the water supplies vary in the north of Scotland so do the whiskies with them. Adjoining distilleries with water supplies very close to each other are known to produce two quite different whiskies, and it is a commonplace of daily life that water from different areas can make all the difference in the world in even so simple a process as making tea.

The origin of the barley has no influence on the characteristics of the whisky, for distillers have used barley from all over the world with no variation in their product.

The peat used in drying the malt certainly affects the character of the whisky It is customary to remark the "peaty" or "smoky" bouquet and flavour of Scotch Whisky The explanation given is that the peaty emanations with which the malt becomes impregnated during drying pass through the operations in a more or less chemically unchanged condition, thus imparting distinctive characters to the whiskies. This is especially so when the usual forms of pot-stills are used for distillation.

The most likely explanation is that, besides the water and ethyl alcohol which are the main constituents of Scotch Whisky, there are small but variable amounts of other constituents and it is these which impart the characteristic flavours and aroma to the spirit. These constituents are rarely more than one-half per cent. of the ethyl alcohol and they are best described as secondary products.

When the wort is prepared, other substances besides the sugar are obtained in solution and from these the secondary constituents are derived, both directly and indirectly The exact nature of these is not fully understood, but it is argued that they are some of the essential oils naturally existing in the malt and other cereals, together with the

peaty bodies incorporated during the drying. The volatile secondary products pass over with the alcohol into the Low Wines Receiver on the distillation of the wash, although a portion escapes with the Spent Lees. The extent to which the secondary constituents may be retained, and thus affect the character of the whisky, largely depends on the variety of pot-still used and the manner of its operation.

The patent-still retains fewer of these secondary constituents. As a result, grain whiskies are relatively mild in flavour and aroma. (The feints received from the patent-still yield fusel oil in sufficient quantities for it to be sold for use in arts and manufactures.)

The flavour and bouquet do not originate in the still, they are dependent on such factors as the water and the secondary products. But if the wash be distilled in a still heated by, say, steam, the same intensity of character and quality is not obtained. The reason is believed to be the cooking process, already referred to, which takes place in the Wash Still.

The Scottish climate, too, plays its part in producing the characteristic flavour and bouquet of Scotch Whisky, and achieves its greatest influence during the maturing process. Then the pure fresh air of the Highlands, permeating the casks in the warehouse, works on the whisky, helping to mature it, and bears off undesirable secondary constituents at just that rate which ensures the smooth mellow qualities expected in Scotch Whisky The climate also is important during the earlier stages of manufacture, and even during the temperate Scottish summer distilling stops, temperatures then being too high for successful operation of the plant. The period from autumn to late spring or early summer constitutes the distilling season when climatic conditions are most suitable for distilling.

Finally, in leading to differences between Scotch and other "whiskies," must be mentioned the skill and experience of the men engaged in the manufacture of Scotch Whisky The production of Scotch is much more an art

than a manufacturing process, and an art which requires above all a certain quality of water found only in parts of Scotland.

Question No. 4

WHY DO NOT PATENT-STILL, OR GRAIN, WHISKIES HAVE THE RANGE OF VARIETY OF FLAVOUR AND BOUQUET OF POT-STILL, OR MALT, WHISKIES?

Answer

First, there are many more pot-still distilleries than patent-still distilleries—about ninety of the former and less than a dozen of the latter If only because of this numerical disparity, there cannot be anything like a comparable variety among grain whiskies as among malt whiskies. Each distillery aims to keep its product as uniform as possible and does not cultivate diversity for its own sake.

Secondly, differences arise from the different methods of manufacture and different materials used.

Among the factors contributing to the distinctive flavour of pot-still malt whiskies is the cooking process which takes place in the wash still. This process does not take place in the operation of the patent-still, which includes instead an element of rectification in its operation. Thus pot-still malt whisky contains a greater total of secondary products than grain whisky This is true of each of the constituents, but the most marked differences are in the higher alcohols, esters and furfurol. Grain whisky contains no furfurol when new, though after maturing it may contain traces, and higher alcohols and secondary constituents are always present in lower amounts in grain whisky than malt whisky.

Malt whisky is made, moreover, entirely from malted barley whereas grain whisky uses unmalted cereals in addition to malted barley This makes for a further difference in secondary constituents.

Finally, being a lighter spirit, with fewer secondary constituents, grain whisky does not require as long a maturing period as pot-still malt whisky

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Question No. 5

WHAT IS BLENDING? WHAT IS ITS OBJECT?

Answer

Blending is the admixture of any two or more different whiskies, whether malt or grain whiskies.

As practised to-day it is not a haphazard mixture of any malts with any grains, but a great art. Each individual blender carefully follows a formula of his own with a definite standard of quality and character in mind. He decides the quantities of each whisky to be mixed.

The mixing itself may be done mechanically or, more usual to-day, by compressed air. The blended product is then kept in vats for a period of months before it is ready for bottling. This process is known as " marrying ", it allows the constituents of the blend to become intimately united.

Some firms prefer to blend their malts and their grains separately, leaving them to marry in separate vats, and only bringing the two together for bottling.

There is no common formula throughout the Industry Each firm keeps secret the proportions of its blend.

Blending is necessitated by the fact that no two whiskies are exactly alike, even when made at the same distillery The blender's aim is therefore to produce a whisky for sale to the public which is uniform year after year Lacking precise uniformity in the single whiskies, the blender must

work to a standard, and it is only his art that enables him to reproduce this annually

Blending has further purposes besides offering the consumer a recognisable and uniform whisky on which he can rely. The pot-still malt whisky by itself is apt to be too strongly flavoured for most people in sedentary occupations, and the demand for something milder in flavour and more suited to conditions of life to-day can only be met by blending malt whisky with grain whisky, which has less pronounced characteristics.

Finally, blending is in no sense a dilution. On the contrary, the malts and the grains combine to bring out the respective flavours of each in a harmonious whole.

Question No. 6

WHEN WAS BLENDING FIRST INTRODUCED?

Answer

Blending of Scotch Whisky on a large scale began between 1860 and 1870, since when the practice has gone on increasing. It has undoubtedly done much to popularise Scotch Whisky in the home and foreign markets for which it was initiated.

Question No. 7

WHAT IS THE PERCENTAGE OF GRAIN WHISKY IN SCOTCH WHISKY BLENDS?

Answer

There is no fixed percentage and the proportion differs from one blender to another No firm is willing to reveal the proportions of the different whiskies it uses, but a good average figure would probably be about 50 per cent. of malt whisky and 50 per cent. of grain whisky.

Question No. 8

WHAT SIZES OF CASKS ARE USED FOR BULK WHISKY AND WHAT ARE THEIR RESPECTIVE CAPACITIES?

Answer

Cask	*Approximate content in gallons*
Butt	110
Hogshead	50–65
Quarter	28–35
Octave	10–15

SECTION II

THE WHISKY INDUSTRY

9. *What whisky trade associations are there?*
10. *How much Scotch Whisky is made annually? How much Scotch Whisky is sold at home annually? How much Scotch Whisky is exported annually?*
11. *How are annual releases of Scotch Whisky regulated?*
12. *Did Scotch Whisky make any contribution to the war effort?*
13. *What effect did the war-time restrictions on distilling and the export drive have on the stocks of Scotch Whisky in this country?*
14. *Has Scotch Whisky done anything to help the export drive since the end of the war?*
15. *What has been the value of these exports?*
16. *What stocks of Scotch Whisky are there in the country at present?*
17 *How many distilleries are there?*
18. *How much Scotch Whisky can be made from a ton of barley?*
19. *What is the present rate of distribution for the Home Trade?*
20. *Does this quota apply to the individual or to the House?*

Question No. 9

WHAT WHISKY TRADE ASSOCIATIONS ARE THERE?

Answer

The trade associations are

(1) *The Scotch Whisky Association.* This is an association of all the principal firms of distillers and blenders (but not retailers) engaged in the Scotch Whisky Industry, and has about 145 members. The President is Sir James C. Calder, C.B.E.; Chairman, Sir Henry J. Ross, Secretary, Mr. P. J Woodhouse. The headquarters address is

77a George Street, Edinburgh, 2.

(2) *The Pot Still Malt Distillers' Association of Scotland.* (Formerly "North of Scotland Malt Distillers' Association.") The President is Mr. D. Mackessack, the Secretary, Mr A. F Black. The headquarters address is

1 North Street, Elgin, Morayshire.

In general the members of this Association are also members of the Scotch Whisky Association.

Question No. 10

HOW MUCH SCOTCH WHISKY IS MADE ANNUALLY?

HOW MUCH SCOTCH WHISKY IS SOLD AT HOME ANNUALLY?

HOW MUCH SCOTCH WHISKY IS EXPORTED ANNUALLY?

Answer

It is only since 1949 that distillation of Scotch Whisky has reverted to normal volume after the interruptions of the war and post-war restrictions.

Recent figures are

PRODUCTION

Year ended 30th Sept.	*Quantity in proof gallons*
1948	20,922,113
1949	27,672,270
1950	29,156,407
1951	27,062,800
1952	30,091,989

RELEASES FOR THE HOME MARKET

Year ended 31st March	*Quantity in proof gallons*
1948	3,200,000
1949	2,500,000
1950	3,000,000
1951	3,800,000
1952	3,500,000

EXPORTS

Year ended 31st March	*Quantity in proof gallons*
1948	7,438,308
1949	8,112,901
1950	8,581,904
1951	9,944,962
1952	11,200,000

Question No. 11

HOW ARE ANNUAL RELEASES OF SCOTCH WHISKY REGULATED?

Answer

The present procedure is that an arrangement is made annually between the Ministry of Food, the Board of Trade, and the Scotch Whisky Association for each calendar year. The arrangement provides that a certain gallonage is to be sold for export and a certain gallonage for the home market.

The figures for 1953 are :

11,000,000 proof gallons for export.

2,750,000 proof gallons for the home market.

At the time of the agreement, the Government specify priorities among the overseas markets. The dollar area remains the most important market. These priorities are decided upon in the light of the balance of payments' position and are liable to alteration.

Question No. 12

DID SCOTCH WHISKY MAKE ANY CONTRIBUTION TO THE WAR EFFORT?

Answer

Yes, Scotch Whisky made an important contribution to the foreign exchange earnings of the United Kingdom during the war, when it formed a staple return cargo in ships which had brought in food, raw materials and munitions. It was the only British manufacture to be

exported without interruption (except for enemy action) throughout the war years. Its contribution was especially important during the "Cash and Carry" period of our war-trading with the U.S.A.

In 1940, Scotch Whisky sales to the U.S.A. amounted to £10,470,000 out of sales to all overseas markets of £16,200,000.

The following table shows the Industry's achievement in the remaining war years.

Calendar Year	*Value of exports to the U.S.A.*	*Value of exports to all overseas markets*
1941	£8,150,000	£13,580,000
1942	£6,240,000	£9,700,000
1943	£6,100,000	£9,340,000
1944	£4,750,000	£8,110,000
1945	£3,940,000	£8,620,000

Exports of Scotch Whisky declined somewhat after their peak of 1940 because, following the introduction of Lend-Lease, there was not the same urgent need to pay for imports by exports, and account had to be taken of the fact that stocks of mature whisky were rapidly being run down.

Question No. 13

WHAT EFFECT DID THE WAR-TIME RESTRICTIONS ON DISTILLING AND THE EXPORT DRIVE HAVE ON THE STOCKS OF SCOTCH WHISKY IN THIS COUNTRY?

Answer

The effect was to reduce stocks drastically. In the six years of war stocks fell by 60 million proof gallons, from

144 million gallons at the outbreak of war to 84 million gallons in 1945. The Industry is only now just catching up on this war-time depletion.

The stock position has been as follows.

Year ended 31st March	*Million proof gallons*
1939	144·25
1940	142·63
1941	129·64
1942	113·98
1943	103·68
1944	92·04
1945	84·79

Moreover, these figures represent *original* proof gallons, that is, the gallonage laid down at the time of distillation, and they do not take account of losses by evaporation during maturing. The actual, or "regauge," gallonage in 1945 would have been much lower, probably not much over 70 million proof gallons.

Question No. 14

HAS SCOTCH WHISKY DONE ANYTHING TO HELP THE EXPORT DRIVE SINCE THE END OF THE WAR?

Answer

Yes, Scotch Whisky is Britain's biggest single dollar-earning export and its rate of export to other overseas markets has been as high as possible in relation to stocks available and the capacity of the importing country For this reason, the Industry has also had to restrict

releases to the home market. The priorities for the overseas markets have all been agreed with the Government so as to accord with the foreign-exchange needs of this country During 1951–52, 11,200,000 proof gallons of whisky went abroad and only 3,500,000 gallons went to the home market. That is, out of the total whisky consumed that year, 76·2 per cent. was exported and only 23·8 per cent. was retained for consumption in Britain. By way of comparison, in 1938–39 only 52·8 per cent. was exported and 47·2 per cent. was released for home.

The following table shows the dramatic part played by the Industry in the export drive

Year ended 31st March	*Whisky consumed at home*		*Whisky exported*	
	Quantity in proof gallons	*Percentage of total*	*Quantity in proof gallons*	*Percentage of total*
1946	4,700,000	40·8	4,996,601	59·2
1947	4,700,000	45·3	5,667,735	54·7
1948	3,200,000	30·1	7,438,308	69·9
1949	2,500,000	23·6	8,112,901	76·4
1950	3,000,000	25·9	8,581,904	74·1
1951	3,800,000	27·6	9,944,962	72·4
1952	3,500,000	23·8	11,200,000	76·2

In 1950–51 there were abnormally heavy clearances from bond in anticipation of an increase in duty in the 1951 budget.

The home releases over the last few years are in excess of the releases agreed between the Government and the Scotch Whisky Association because of whiskies outside the control of the Scotch Whisky Association.

Question No. 15

WHAT HAS BEEN THE VALUE OF THESE EXPORTS?

Answer

During the year 1952, the latest figures available, Scotch Whisky exports to the U.S.A. earned us £18,600,000 and in all overseas markets £33,026,966. This is far more than Scotch Whisky ever earned before abroad. For the U.S.A. market it is more than two and a half times what was earned in 1939, and for world markets as a whole more than twice as much as in 1939.

The table below shows the overseas earnings of Scotch Whisky since the end of the war.

Calendar Year	*Value of exports to the U.S.A.*	*Value of exports to all overseas markets*
1946	£5,270,000	£10,830,000
1947	£8,000,000	£13,569,816
1948	£9,542,000	£16,189,562
1949	£11,000,000	£18,738,003
1950	£17,019,000	£26,270,788
1951	£18,209,973	£29,594,474
1952	£18,600,000	£33,026,966

Question No. 16

WHAT STOCKS OF SCOTCH WHISKY ARE THERE IN THE COUNTRY AT PRESENT?

Answer

The latest figures available show that at 31st March 1953 there were some 150,600,000 proof gallons of whisky as stocks in bonded warehouses. This figure is, however, of original proof gallons, and a certain amount, perhaps as much as 15 per cent., must be subtracted to allow for evaporation during maturing.

Although stocks are at present above pre-war level, they are very unbalanced in respect of age. This will correct itself in time.

Stocks in March 1939 were 144,250,000 original proof gallons.

STOCKS OF SCOTCH WHISKY

Date	*Original proof gallons*
1953. 30th Sept.	
1954. 31st March	
30th Sept.	
1955. 31st March	
30th Sept.	
1956. 31st March	
30th Sept.	
1957 31st March	
30th Sept.	
1958. 31st March	
30th Sept.	
1959. 31st March	
30th Sept.	

Question No. 17

HOW MANY DISTILLERIES ARE THERE?

Answer

The number of distilleries working in Scotland varies slightly from year to year, but at present there are between eighty-five and ninety malt pot-still distilleries, and up to nine grain, or patent-still, distilleries producing whisky.

Question No. 18

HOW MUCH SCOTCH WHISKY CAN BE MADE FROM A TON OF BARLEY?

Answer

A ton of barley produces 105 original proof gallons of Scotch Whisky. Thus a normal year's output of some 27 million proof gallons requires some 257,000 tons of barley

The economic value of the industry is shown by the fact that 105 gallons of Scotch Whisky sold to the U.S.A. are worth £301 17s. 6d. The price of barley varies from season to season and is not by any means the only cost incurred in producing whisky. In the 1952–53 season barley averaged about £6 a quarter, or £30 a ton. Early in the previous season, 1951–52, it was as much as £9 10s. a quarter, a price which fell to about £6 a quarter at the end of the season.

The moisture content of the barley has a definite bearing on production. A moisture content of below 4 per cent. is considered satisfactory and the 105 original proof gallons mentioned comes from barley of this specification.

Question No. 19

WHAT IS THE PRESENT RATE OF DISTRIBUTION FOR THE HOME TRADE?

Answer

Since rationing of the home market was introduced on 1st March, 1940, the percentage of supplies released has been based on the purchases made by any customer during the year ending 29th February, 1940, which is regarded as the standard.

From	*To*	
1st March 1939	29th Feb. 1940	100 per cent.
1st March 1940	28th Feb. 1941	80 ,, ,,
1st March 1941	31st July 1941	65 ,, ,,
1st Aug. 1941	31st Dec. 1946	50 ,, ,,
1st Jan. 1947	30th April 1947	45 ,, ,,
1st May 1947	30th April 1948	25 ,, ,,
1st May 1948	30th April 1950	20 ,, ,,
1st May 1950	(See note below)	25 ,, ,,

From 1st January, 1953, the quota was very slightly increased, when the allocation for the home market for the year was raised by 150,000 proof gallons to a total of 2,750,000 proof gallons.

Question No. 20

DOES THIS QUOTA APPLY TO THE INDIVIDUAL OR TO THE HOUSE?

Answer

This quota applies to the House and is intended to serve the requirements of the customers of that House. In the same way in the case of Off-Licence Premises, the quota goes with the shop.

SECTION III

WHISKY AND THE LAW

21. *When was whisky first the subject of legislation?*
22. *What is the difference between "Customs duty" and "Excise duty"?*
23. *What records does a distiller keep of whisky in his distillery warehouses?*
24. *How may a private individual become a distiller of of whisky?*
25. *What precautionary method is adopted in the case of Under Bond sales for home consumption?*
26. *What is the history of charging duty on whisky?*
27. *What is the U.K. duty on* (a) *a case of whisky, and* (b) *a bottle?*
28. *How does the rate of duty on Scotch Whisky compare with that on other alcoholic liquors?*
29. *Why is whisky duty-free at sea?*
30. *To what extent is duty charged or duty recoverable on whisky which is lost to consumption by accident or other circumstances outside the control of the owner, and apart from allowances for ullage in bonded warehouse?*
31. *What official Customs documents are required in connection with sales of spirits?*
32. *The answer to the preceding question deals with the official Customs documents required in connection with sales of spirits. What is the rule governing the private individual who wishes to remove spirits from one place to another for purely private reasons?*

33. *What are the Excise allowances in case of loss of whisky*
    (a) *in maturing in warehouse,*
    (b) *in the blending process,*
    (c) *in the bottling process?*
34. *What is the rule about claims for loss or breakage other than by evaporation during maturing?*
35. *What is the liability of a seller of whisky in cask if the whisky is found, subsequent to sale, to be unfit for use?*
36. *Is it legal to sell whisky which is less than three years old for immediate consumption in this country?*
37 *Can a mixture of Scotch Whisky and Irish Whiskey be properly described as "Scotch Whisky"?*
38. *What are the different types of licence authorising the sale of spirits and what quantities of spirits may be supplied by the holders of such licences?*
39. *Can a shop which is licensed to sell a minimum of half a bottle of spirits sell two quarter-bottles of the same brand?*
40. *In Questions Nos.* 38 *and* 39 *what does "of the same denomination" mean?*
41. *Can liquor for off-consumption be served to children?*
42. *Is a licence needed to sell whisky by auction?*

Question No. 21

WHEN WAS WHISKY FIRST THE SUBJECT OF LEGISLATION?

Answer

Historians seem to be at variance on the matter. In 1505 the exclusive privilege of making and selling "aqua-vitæ" was granted by the City of Edinburgh to the Guild of Surgeon Barbers. This was ratified by King James IV in the following year, but some doubt exists whether the aqua-vitæ in this case was whisky. Some authorities allege that it was a strong proof spirit made with herbs and spirits.

An Act of the Scottish Parliament of 1555 forbade the export of victuals generally, but made this exception

> "It salbe leiffull to the inhabitantis of the burrowis of Air, Irvin, Glasgow, Dumbertane and uthers our Soverane Ladyis liegis dwelland at the west seyis to have [i.e. send] bakin breid, browin aill and aqua vite to the Ilis to bertour with uther merchandice."

An Act of 1579 "Anent the making of aquavitie," says

> "Undirstanding that thair is ane greit quantitie of malt consumit in the haill partis of this realme be making of aquavitie quhilk is ane greit occasioune of the derth within the samin,"

the brewing and distilling of aquavitie is forbidden from 1st December next till 1st October, 1580, except to noblemen, barons, and gentlemen, who may brew and distil from their own malt for their own and their friends' use. This clearly applies to the whole country and also, equally clearly, to whisky

Question No. 22

WHAT IS THE DIFFERENCE BETWEEN " CUSTOMS DUTY " AND " EXCISE DUTY " ?

Answer

Customs Duty is a duty or tax levied on goods imported from an overseas country or from Eire. Excise Duty is a duty or tax charged on home-manufactured goods during manufacture or before sale to home consumers. Commissioners of Customs were first appointed in 1671. The Excise Department was formerly under the Inland Revenue Department and was amalgamated with the Customs Department on 1st April, 1909.

Question No. 23

WHAT RECORDS DOES A DISTILLER KEEP OF WHISKY IN HIS DISTILLERY WAREHOUSES ?

Answer

The distiller keeps a complete record of the history of every cask while it remains under his care in his bonded warehouse. The book used for this purpose is called the Bond Book. It contains the following particulars ·

(1) The original date of warehousing of the cask, after its being filled with new whisky.

(2) The number of the warehouse in which it is stored.

(3) The Excise number of the cask.

(4) The liquid contents of the cask.

(5) The strength of the whisky.

(6) The content in proof gallons.

(7) The kind of cask (i.e. whether " sherry," " plain," etc.).

(8) The owner of the cask.

As a rule these original particulars remain unaltered, the cask not being again " gauged " until the day of its removal from the distillery warehouse, when the distiller writes it off his book, showing the date of despatch and the destination to which it was sent.

Should, however, a cask be found leaking through faulty wood, or other cause, the regauge particulars, in the event of the loss being excessive, are recorded beside the original particulars of the cask, for guidance when the cask is finally regauged for removal. This assumes that the cask is capable of repair Where this is not so, the whisky remaining in the faulty cask is transferred into a sound cask—the distiller writing off the old cask and substituting particulars of the new cask, exactly similar to those given above.

The distiller also notes opposite each cask whether any samples have been drawn and the dates of any such drawing.

Finally, the distillers' Bond Book shows the history of the ownership of each cask, if it has passed through various hands, and the dates of the changes. In this connection it should be stated that the distiller, as giver of the Bond for the safe custody of the goods in the warehouse, is the only " Trader " recognised by the Excise authorities.

Question No. 24

HOW MAY A PRIVATE INDIVIDUAL BECOME A DISTILLER OF WHISKY?

Answer

Anyone may become a distiller of whisky by applying for a licence as follows:

(*a*) To distil not exceeding 50,000 proof gallons per annum . .	£10	0	0
(*b*) To distil exceeding 50,000 p.g. For first 50,000 .	£10	0	0
For each further 25,000 or fraction thereof . additional	£10	0	0

Having acquired a licence to distil, he must construct premises approved by the Excise authorities before he may commence operations.

The law does not, however, provide for the case of a "private individual" in the ordinary sense of the term. The distillery premises and plant must be of commercial size. A householder would not be permitted to distil spirits in his own home.

Question No. 25

WHAT PRECAUTIONARY METHOD IS ADOPTED IN THE CASE OF UNDER BOND SALES FOR HOME CONSUMPTION?

Answer

All customers who request supplies to be made to them Under Bond are required to sign an undertaking to the effect that they will not ·

(*a*) Transfer any such whisky to any purchaser Under Bond, or

(*b*) re-sell or relinquish possession of any such whisky until the duty thereon has been paid.

Question No. 26

WHAT IS THE HISTORY OF CHARGING DUTY ON WHISKY?

Answer

In Scotland the manufacture and use of whisky was very limited until the latter part of 1700 and most of the whisky was drunk on the homesteads where it was made. Public distilleries were not long in being set up, and in the Inverness area a flourishing new trade was soon established. In 1707 the Board of Excise was set up. From 1709 to 1742 the duty on whisky was 3d. and 6d. a gallon. It rose gradually to 3s. 11¾d. in 1784, and by 1814 it was around £7 16s. per gallon of a still's content. This occasioned an increase in illicit distilling and by 1823 the duty had to be reduced to 2s. 3d. a gallon. However, the duty soon

began to increase again and the subsequent history is shown in the following table:

Date	*Additions*			*Amount of duty per gallon*	
	s.	d.		s.	d.
1st May 1840				3	4
15th May 1840		4		3	8
31st April 1853	1	0		4	8
8th March 1854	1	0		5	8
26th May 1854		4		6	0
20th April 1855	1	10		7	10
1st Oct. 1855		2		8	0
29th Feb. 1856		1		8	1
17th July 1860	1	11		10	0
1st May 1885	2	0		12	0
9th June 1885	1	0	off	11	0
10th June 1885	1	0	off	10	0
April 1890		6		10	6
17th April 1894		6		11	0
1st July 1895		6	off	10	6
5th March 1900		6		11	0
29th April 1909	3	9		14	9
22nd April 1918	15	3		30	0
30th April 1919	20	0		50	0
19th April 1920	22	6		72	6
28th Sept. 1939	10	0		82	6
24th April 1940	15	0		97	6
15th April 1942	40	0		137	6
13th April 1943	20	0		157	6
12th Nov. 1947	33	4		190	10
6th April 1948	20	0		210	10

A Scottish "Act for Excyse" of 1644 imposed a duty of 2s. 8d. "one everie pynt of aquavytie or strong watteris sold within the country" At that time in Scotland 34 "pynts" were equivalent to approximately 12 gallons English. The rate of duty was therefore about 7s. 6d. per English gallon.

Question No. 27

WHAT IS THE U.K. DUTY ON (A) *A CASE OF WHISKY, AND* (B) *A BOTTLE?*

Answer

As a case of twelve bottles at 70° proof contains 1·4 proof gallons of whisky, the duty at 210s. 10d. per proof gallon amounts to 295s. 2d. a case. The duty on one bottle is one-twelfth of this, viz. 24s. 7·2d.

Question No. 28

HOW DOES THE RATE OF DUTY ON SCOTCH WHISKY COMPARE WITH THAT ON OTHER ALCOHOLIC LIQUORS?

Answer

1. BRITISH SPIRITS (i.e. Spirits made in Britain):

	Per proof gallon
(*a*) Scotch Whisky, like other British Spirits warehoused for 3 years or more, pays . . .	£10 10 10
(*b*) British Spirits, e.g. gin, which are not warehoused or are warehoused less than 2 years, pay . .	£10 12 4

2. IMPORTED SPIRITS pay at the following rates

	Proof gallons *Foreign* £ s. d.	*Empire* £ s. d.
(*a*) Brandy and rum in cask	10 13 8	10 11 2
(*b*) U U Spirits in cask or bottle	10 13 9	10 11 3
(*c*) Liqueurs in bottle (tested) . .	10 15 3	10 12 6

That is, there is very little difference in the rate of duty between British spirits, including Scotch Whisky, and foreign-made spirits.

3. IMPORTED WINES :

(*a*) *Light wines*, i.e. not exceeding 25° proof if Foreign or 27° proof if Empire, pay

Foreign . . 13s. per gallon.
Empire 11s. per gallon.

Taking these at strength of 25° proof they pay at the rate :

Foreign . . £2 12s. per proof gallon.
Empire . £2 4s. per proof gallon.

(*b*) *Other wines*, i.e. fortified wines, not exceeding 42° proof, pay

Foreign £2 10s. per gallon.
Empire . . . £2 per gallon.

These wines mostly sell at an average strength of 35° proof. At their rate of duty they would pay at 70° proof

Foreign £5 per gallon.
Empire . . . £4 per gallon.

Scotch Whisky at this strength, i.e. 70° proof, pays £7 7s. 7d. per gallon.

(*c*) *Examples :*

(i) *Claret* This can be taken as 23° proof for a fair average of the market strength.

At this strength Foreign claret pays 13s. per gallon duty,
Empire claret pays 11s. per gallon duty

Duty per degree of proof strength per gallon

Foreign claret . . 6·7d.
Empire claret . 5·7d.
Scotch Whisky . 2s. 1·3d.

A bottle of Foreign claret at 23° proof pays 2s. 2d. duty.

A bottle of Empire claret at 23° proof pays 1s. 10d. duty

A bottle of Scotch Whisky at 70° proof pays 24s. 7d. duty.

At 23° proof a bottle of claret contains the same quantity of alcohol as 8·7 fluid ounces of Scotch Whisky, or four doubles, and this amount of Scotch Whisky pays 8s. 8·4d. duty, i.e. four times as much as a bottle of Foreign claret and more than four times as much as a bottle of Empire claret.

(ii) *Champagne* · This can be taken as 23° proof for a fair average of the market strength.

At this strength Foreign champagne pays £1 17s. 6d. per gallon duty,
Empire champagne pays £1 15s. 6d. per gallon duty

Duty per degree of proof strength per gallon :

Foreign champagne . . 1s. 7·5d.
Empire champagne . . . 1s. 6·5d.
Scotch Whisky . . 2s. 1·3d.

A bottle of foreign champagne at 23° proof pays 6s. 3d. duty.

A bottle of Empire champagne at 23° proof pays 5s. 11d. duty.

A bottle of Scotch Whisky at 70° proof pays 24s. 7d. duty.

At 23° proof a bottle of champagne contains the same quantity of alcohol as 8·7 fluid ounces of Scotch Whisky, or about four doubles, and this amount of Scotch Whisky pays 8s. 8·4d. duty

(iii) *Port and sherry* · These can be taken as 35° proof for a fair average of the market strength. At this strength : Foreign port and sherry pay £2 10s. per gallon duty; Empire port and sherry pay £2 per gallon duty

Duty per degree of proof strength :

Foreign port and sherry . .	1s. 5d.
Empire port and sherry . . .	1s. 1·5d.
Scotch Whisky . . .	2s. 1·3d.

A bottle of foreign port or sherry at 35° proof pays 8s. 4d. duty.

A bottle of Empire port or sherry at 35° proof pays 6s. 8d. duty.

A bottle of Scotch Whisky at 70° proof pays 24s. 7d. duty

At 35° proof a bottle of port or sherry contains the same quantity of alcohol as a half-bottle of Scotch Whisky and this half-bottle of whisky pays 12s. 3·6d. duty That is, half as much again as the foreign port or sherry and very nearly double the Empire port or sherry.

(iv) *Beers :*

A pale ale, original gravity 1055, may be taken to contain 5·1 per cent. of alcohol by volume and to be 9° proof strength. It pays duty then of 8s. 11d. per gallon.

If it paid duty at the same rate per degree of proof strength as Scotch Whisky (i.e. 2s. 1·3d. per degree) it would pay 18s. 11·7d. per gallon. That is, more than twice as much as at present.

A mild ale, original gravity 1038, may be taken to contain 2·7 per cent. of alcohol by

weight and to be 5·7° proof. It pays duty then of 5s. 9½d. per gallon.

If it paid duty at the same rate per degree of proof strength as Scotch Whisky (i.e. 2s. 1·3d. per degree) it would pay 12s. 0·2d. per gallon. That is, more than twice as much as at present.

Duty on these two beers is approximately at the rate of 1s. per degree of proof strength. They therefore pay duty at the rate of 100s. per proof gallon, whereas Scotch Whisky pays 210s. 10d. per proof gallon.

Question No. 29

WHY IS WHISKY DUTY-FREE AT SEA?

Answer

Whisky for the consumption of crew and passengers (if any) on board ships at sea is " ship's stores," which means goods of any kind (whether dutiable or non-dutiable, and whether of British manufacture or imported) taken on board an outward-bound ship for the officers, crew and passengers during the voyage. " Outward-bound " means bound for " an eventual destination outside the United Kingdom." Ship's stores have from time immemorial been relieved of duty, just as goods exported as cargo to countries overseas are. The theory is that the stores are in effect exports, in that they are consumed outside United Kingdom territory, and that the Treasury cannot expect to collect the duty they would bear if consumed at home. Whisky after distillation is stored (without paying duty) in a bonded warehouse to mature, and whisky shipped as stores or exported goes direct from the bonded warehouse to the ship. H.M. ships are included in these regulations.

" Coasting ships," which ply from port to port round the coast, and vessels which ply on rivers or other inland waters, are not " outward bound " and do *not* get whisky or any other stores duty-free.

Question No. 30

TO WHAT EXTENT IS DUTY CHARGED OR DUTY RECOVERABLE ON WHISKY WHICH IS LOST TO CONSUMPTION BY ACCIDENT OR OTHER CIRCUMSTANCES OUTSIDE THE CONTROL OF THE OWNER, AND APART FROM ALLOWANCES FOR "ULLAGE" IN BONDED WAREHOUSE?

Answer

The answer to this question depends upon the circumstances. The duty is remissible (i.e. not payable) if it is *shown to the satisfaction of the Commissioners of Customs and Excise* that the whisky has been "lost or destroyed by unavoidable accident," provided the whisky was in the distillery where it was made, or in a bonded warehouse where it was deposited to mature, or in course of being moved under bond (i.e. duty not having been paid) to another bonded warehouse or to a ship for export or ship's stores.

The duty must be paid to the Customs and Excise before goods are cleared from a bonded warehouse for home consumption, and the case may occur where duty has been paid, but the whisky is lost or destroyed by unavoidable accident before it is actually removed out of the warehouse. In such a case the duty paid is repayable.

On the other hand, once the duty has been paid, *and* the whisky has been removed out of the bonded warehouse, the duty cannot be repaid. There is no remedy (except the obvious one of insurance for duty as well as for ex-duty value) if whisky is lost or destroyed by accident when it is in the duty-paid stock of a wholesale dealer or in a public house, an off-licence shop, or a club. Likewise, a householder cannot claim repayment of the duty if he breaks a bottle in his house.

Question No. 31

WHAT OFFICIAL CUSTOMS DOCUMENTS ARE REQUIRED IN CONNECTION WITH SALES OF SPIRITS?

Answer

There are two kinds of documents, the "permit" and the "certificate." A permit is required when spirits are sent out from a distillery or bonded warehouse. Spirits sent out from the stock of a *wholesale dealer* must be accompanied by a certificate, except in the case of a quantity not exceeding one gallon sold by the dealer under a retailer's licence to a person who is neither a dealer in nor a retailer of spirits (i.e. a private individual).

Spirits sent out from the stock of a retailer must be accompanied by a certificate, except in the case of spirits not exceeding in quantity one gallon of the same denomination at a time for any one person.

The procedure is as follows

(*a*) *Under Bond Sales* · A Warrant and Permit are filled in by the merchant and passed by the Customs. The Permit goes forward with the goods and a separate despatch is forwarded by the Issuing Bond Customs Officer to the Customs Officer of the Receiving Bond, notifying him of the removal of the goods.

(*b*) *Duty Paid Sales* In the case of Duty Paid Sales an Excise Certificate has to be filled in by the seller, and this Certificate must accompany the goods when they are delivered to the purchaser The customer must retain his Certificate for production, on request, to the Customs and Excise authorities.

Question No. 32

THE ANSWER TO THE PRECEDING QUESTION DEALS WITH THE OFFICIAL CUSTOMS DOCUMENTS REQUIRED IN CONNECTION WITH SALES OF SPIRITS. WHAT IS THE RULE GOVERNING THE PRIVATE INDIVIDUAL WHO WISHES TO REMOVE SPIRITS FROM ONE PLACE TO ANOTHER FOR PURELY PRIVATE REASONS?

Answer

The law is that, *apart from* spirits sent out from the premises of a licensed trader, a distillery, or a bonded warehouse—" no such spirits exceeding in quantity one gallon of the same denomination at a time for any one person shall be removed from any place in the United Kingdom to any other such place unless accompanied by a permit."

One gallon is six reputed quart bottles. As to " of the same denomination " see Question No. 40. If a person removes from his house to another and wishes to take with him, say, ten bottles of whisky, he should see the local Excise Officer and ask for a permit. Similarly, if he buys a case of whisky (twelve bottles, or two gallons), properly accompanied by a certificate when it is delivered at his house by the licensed dealer or retailer, and takes it by car as a gift to another person, he ought to see the Officer first.

Question No. 33

WHAT ARE THE EXCISE ALLOWANCES IN CASE OF LOSS OF WHISKY:

(A) *IN MATURING IN WAREHOUSES;*

(B) *IN THE BLENDING PROCESS;*

(C) *IN THE BOTTLING PROCESS?*

Answer

Duty is chargeable on the quantity of proof whisky contained in a cask (or other container) at the time of delivery from warehouse, but if this quantity is less than the quantity originally warehoused duty is chargeable on the latter quantity unless the Customs are satisfied that no part of the deficiency is due to fraudulent abstraction.

In administration, the local Customs and Excise Officers are given discretion to allow deficiencies if they are satisfied that they are due to natural causes, or to causes such as the process of bottling, but there are no fixed or published scales of allowances.

Allowances are based on proof spirit content and not on bulk.

The customary Excise allowance for losses by evaporation during maturing is 2 per cent. per annum for each year or part of a year, plus 2 per cent. for whisky stored in butts and 3 per cent. for whisky stored in hogsheads. The formula is, accordingly, twice the number of years plus 2 or 3, depending whether the cask be a butt or hogshead. For example, for an eight-year-old whisky stored in a hogshead the allowance would be $8\times2+3=$ 19 per cent. decrease.

The customary allowance for losses during bottling is 2 per cent. and for losses during vatting, blending and reducing with water is 1 per cent.

Question No. 34

WHAT IS THE RULE ABOUT CLAIMS FOR LOSS OR BREAKAGE OTHER THAN BY EVAPORATION DURING MATURING?

Answer

As in other instances of loss or damage of goods, whisky sent by rail is sent at Carrying Company's risk and must be examined at the time of delivery in the presence of the carrier's carmen, and if there is any loss, the delivery sheet should be signed accordingly. Loss must be notified to the carriers immediately, and advice sent to the firm within three days. In the event of non-delivery no claims can be entertained unless advice is received within ten days of date of despatch. (See notes on the invoice.)

Question No. 35

WHAT IS THE LIABILITY OF A SELLER OF WHISKY IN CASK IF THE WHISKY IS FOUND, SUBSEQUENT TO SALE, TO BE UNFIT FOR USE?

Answer

The onus is on the *buyer*, who can either demand a sample prior to sale being completed or make an arrangement with the seller to draw a sample after delivery of the parcel and to confirm the sale only if the sample proves satisfactory Such sample is free, and duty free, or on payment, according to whether a sample has already been taken from the cask.

It is not, however, always customary in the trade to demand such a sample.

Question No. 36

IS IT LEGAL TO SELL WHISKY WHICH IS LESS THAN THREE YEARS OLD FOR IMMEDIATE CONSUMPTION IN THIS COUNTRY?

Answer

No. The Customs and Excise Act, 1952, prohibits the delivery for home consumption of British or foreign spirits that have not been warehoused for at least three years. The only exceptions to this are British compounds, gin, liqueurs, and perfumed spirits.

(See also answer to Question No. 82, What is Scotch Whisky?)

Question No. 37

CAN A MIXTURE OF SCOTCH WHISKY AND IRISH WHISKEY BE PROPERLY DESCRIBED AS "SCOTCH WHISKY"?

Answer

No. This question has been decided in the Courts, and it is illegal to label a mixture of Scotch Whisky and Irish Whiskey as "Scotch Whisky."

Question No. 38

WHAT ARE THE DIFFERENT TYPES OF LICENCE AUTHORISING THE SALE OF SPIRITS AND WHAT QUANTITIES OF SPIRITS MAY BE SUPPLIED BY THE HOLDERS OF SUCH LICENCES?

Answer

1. ENGLAND:

(*a*) Wholesale Dealer's Licence This authorises the sale to one person at one time of any spirits in any quantity not less than two gallons.

(*b*) Retailer's Off-Licence This authorises the holder to sell for consumption off the premises any quantity of spirits not exceeding two gallons at a time, but subject to the proviso that the minimum quantity permissible to be sold by itself is either (i) the equivalent of one reputed quart bottle (the quantity may be made up of two or more smaller bottles of the same denomination) or (ii) a reputed pint (half) bottle, but this must be in a single " vessel," i.e. all in one bottle. The law on this subject is somewhat confusing, but the following table sets forth the position.

Question	*Answer*
Can one half-bottle of spirits be sold ?	Yes
Can two half-bottles of spirit be sold ?	Yes
Can one half-bottle and one quarter-bottle of spirits be sold ?	No
Can one half-bottle and two quarter-bottles of spirits of the same denomination be sold ?	Yes
Can four quarter-bottles or fourteen two-ounce miniatures of spirits of the same denomination be sold ?	Yes
Can one reputed quart bottle and one quarter-bottle of spirits be sold ?	Yes

Can one half-bottle of whisky and two quarter-bottles of other spirits be sold at the same time ?	No
Because the spirits are not of the same denomination.	
Can two quarter-bottles of whisky and two quarter-bottles of other spirits be sold at the same time ?	No
Because the spirits are not of the same denomination.	
Can one bottle of whisky and one quarter-bottle of other spirits be sold at the same time ?	Yes
Can one bottle of whisky and one miniature of other spirits be sold at the same time ?	Yes

Note: The basic principle involved is that having sold the equivalent of one bottle of spirits of one denomination, it is permissible at the same time for the retailer to sell a smaller quantity of any kind of spirits.

(*c*) Full On-Licence Hotel, restaurant, or public house. This enables the sale of any quantity of spirits not exceeding two gallons—even one miniature—during permitted hours, for consumption either on or off the premises.

(*d*) Beer and Wine Licence: This does not permit the sale of spirits.

2. SCOTLAND:

(*a*) Wholesale Dealer's Licence Same as in England.

(*b*) Grocer's or Off-Licence This authorises the sale of any quantity of spirits less than two gallons.

(*c*) Hotel or Public House Licence. Same as in England.

Question No. 39

CAN A SHOP WHICH IS LICENSED TO SELL A MINIMUM OF HALF A BOTTLE OF SPIRITS SELL TWO QUARTER-BOTTLES OF THE SAME BRAND?

Answer

No. Off-Licencees holding a justices' licence are allowed to sell a minimum of a half-bottle of spirits provided the spirits are sold in the one bottle. It would be illegal to sell two quarter-bottles of the same denomination, or a half-bottle of whisky and a quarter-bottle of any other spirits. A quart, however, can be made up of smaller bottles of the same denomination, and once you have sold a quart of the same kind of spirits you can always add a smaller quantity to it as part of the same transaction.

This does not apply to Scotland. See preceding question, 2 (*b*).

Question No. 40

IN QUESTIONS NOS. 38 AND 39 WHAT DOES "OF THE SAME DENOMINATION" MEAN?

Answer

It means that the spirits which make up the equivalent of "a reputed quart bottle" must be of the same *tariff denomination*.

As regards *imported* spirits, the different tariff denominations are. (1) brandy, (2) rum, (3) "Geneva," "Hollands," or gin, (4) unenumerated unsweetened spirits, which includes spirits of the whisky type, and (5) liqueurs. The reputed quart may be made up of, say, a half-bottle of French brandy, and a half-bottle of Spanish or South African brandy, or of an assortment of small bottles of foreign liqueurs aggregating a reputed quart. On the other hand,

it *cannot* be made up of a half-bottle of brandy and a half-bottle of rum, nor of a half-bottle of Canadian whisky plus a half-bottle of foreign liqueurs.

As regards *British* spirits, the two different denominations are (1) whisky, legally styled "plain spirits," and (2) "compounds," such as gin and British liqueurs. Two half- or four quarter-bottles of Scotch Whiskies of different brands can be sold, but not a half-bottle of whisky with a half-bottle of gin.

In no case can imported and British spirits together make up the reputed quart. A half-bottle of Scotch or Northern Irish Whiskey and a half-bottle of Jamaica rum (nor even a half-bottle of whiskey from Eire) do *not* meet the requirement.

Question No. 41

CAN LIQUOR FOR OFF-CONSUMPTION BE SERVED TO CHILDREN?

Answer

There is no limit to the age of children acting as messengers to whom alcoholic liquor may be supplied provided it is in properly corked and sealed vessels, and in quantities not less than one reputed pint. If the liquor is supplied to any child under fourteen in a container which is not sealed as well as corked, the penalty is 40s. for the first offence, and £5 for any subsequent offence.

Question No. 42

IS A LICENCE NEEDED TO SELL WHISKY BY AUCTION?

Answer

A Ministry of Food licence is no longer necessary for the sale of Scotch Whisky by auction.

SECTION IV

WHISKY AND THE DRINKER

43. *What right has a consumer on licensed premises*
    (*a*) *to see the bottle out of which his drink is poured ?*
    (*b*) *to a fixed quantity for his order ?*
    (*c*) *to receive a whisky of the strength stated on the bottle ?*
44. *Can Scotch Whisky be manufactured only in Scotland ?*
45. *If you could duplicate exactly a Scotch Whisky plant in, say, Australia, could you produce Scotch ?*
46. *Why is Scotch Whisky still so scarce on the home market ?*
47 *What has been the effect on the home market of restricting releases for home consumption ?*
48. *What are the rules regarding retail prices ?*
49. *What action is taken if any firm or individual is found to be selling the brands of member-firms of the Scotch Whisky Association at prices in excess of the prices fixed by the Association ?*
50. *How many brands of whisky are there ?*
51. *How old should the best Scotch be ?*
52. *What causes whisky to lose its brightness ?*
53. *Some Scotch Whisky has a " smoky " flavour. What causes this ?*
54. *Are the well-known brands of Scotch Whisky commonly offered for sale, single whiskies ?*
55. *What are the best blends ?*
56. *Is it possible to tell the difference between one brand of Scotch Whisky and another by smell alone ?*
57 *What is the difference in strength between present day Scotch Whisky and pre-war ?*

58. *Why is Scotch Whisky now so dear in this country compared with pre-war ?*

59. *What is the usual strength at which proprietary brands of Scotch Whisky are sold for consumption in the home market ?*

60. *At what strength is whisky sold for export ?*

61. *What is the average liquid content of the bottles as used for Scotch Whisky in the home trade ?*

62. *What is the measure at which Scotch Whisky is generally sold across the counter ?*

63. *Does Scotch Whisky improve in a bottle which is kept corked ?*

64. *Does Scotch Whisky in a bottle lose its strength with age ?*

65. *What is the difference between Scotch Whisky and gin ?*

66. *Why is whisky coloured brown or golden while gin remains water white ?*

67 *What is the alcoholic strength of Scotch Whisky ?*

68. *What are the usual alcoholic strengths of (a) Whisky, (b) Gin, (c) Rum, (d) Sherry; (e) Port, (f) Madeira, (g) Bordeaux, (h) Burgundy, (i) Champagne; (j) Claret; (k) Ginger Wine, (l) Beer, as drunk in the U.K. ?*

69. *At what temperature is whisky best served ?*

70. *Does it spoil or improve the flavour of Scotch Whisky to put ice into it as a drink ?*

71. *What is the best shape of whisky glass ?*

72. *Is the bouquet of Scotch Whisky improved by warming slightly ?*

73. *What is the medicinal value of whisky ?*

74. *Why do some people turn a new bottle of Scotch upside down before opening ?*

75. *Is it injurious to drink whisky with oysters or other shell-fish ?*

76. *What are some drinks which may be made with Scotch Whisky ?*

Question No. 43

WHAT RIGHT HAS A CONSUMER ON LICENSED PREMISES :

(A) *TO SEE THE BOTTLE OUT OF WHICH HIS DRINK IS POURED ?*

(B) *TO A FIXED QUANTITY FOR HIS ORDER ?*

(C) *TO RECEIVE A WHISKY OF THE STRENGTH STATED ON THE BOTTLE ?*

Answer

(*a*) Customers have no *right* to see the bottle.

(*b*) No obligation to supply a fixed quantity rests on the proprietors if an order is merely for " a whisky " or " a Scotch." The obligation exists only if the order is for a specified quantity such as " a gill," " a half-gill," etc., and a licensee is not under legal compulsion to undertake to supply a specified measure.

(*c*) Where whisky has been bottled in Bond, at any strength whatsoever, it is an offence to dilute it before sale to the customer Moreover, a Ministry of Food Order requires the strength to be stated on the label (e.g., " 70 per cent. proof spirit "), and it would be an offence to sell spirits so labelled if they were diluted to less than the stated strength.

Question No. 44

CAN SCOTCH WHISKY BE MANUFACTURED ONLY IN SCOTLAND?

Answer

Yes. Unlike many other products which were originally manufactured only in a particular locality but which have lost their geographical significance and can now be manufactured anywhere, the word "Scotch" as applied to whisky has retained its geographical significance. All attempts to copy its unique flavour have failed. This is generally admitted throughout the world and is recognised by law An example of the type of article which has lost its geographical significance and become generic is "Bath Buns," now made anywhere.

Question No. 45

IF YOU COULD DUPLICATE EXACTLY A SCOTCH WHISKY PLANT IN, SAY, AUSTRALIA, COULD YOU PRODUCE SCOTCH?

Answer

No, it is not possible to produce Scotch Whisky in Australia or anywhere else other than Scotland.

The experiment has been tried in Australia. The resulting product merits consideration but does not rival the Scottish-made spirit.

It has also been tried in Japan.

Question No. 46

WHY IS SCOTCH WHISKY STILL SO SCARCE ON THE HOME MARKET?

Answer

Scotch Whisky is (1953) scarce on the home market because of the needs of the export drive and because from 1940 to 1945 the Government were able to allocate only trifling quantities of cereals for distillation. In fact, no distilling at all took place in the seasons 1942–43 and 1943–44.

The total Scotch Whisky production for the six years of war, some 32·5 million gallons, was only equal to about one year's production pre-war, and it is whiskies made during the war years which would normally be coming on the market now (1953).

Distilling did not return to normal immediately after the end of the war, because the Government was unable to allocate any barley, there was no distilling whatsoever from the summer of 1946 to the spring of 1947 Full distillation was not permitted until 1949. During the twelve-year period from 1938–39 to 1949–50 inclusive, the total whisky distilled was rather less than the total output for five normal pre-war years.

Thus only a very limited amount is available for distribution at present and most of this is sent to export markets at the direct request of the Government.

Scotch Whisky is now being made in ample quantities but, because of the necessary maturing time-lag, it will not be ready for sale for some years.

Question No. 47

WHAT HAS BEEN THE EFFECT ON THE HOME MARKET OF RESTRICTING RELEASES FOR HOME CONSUMPTION?

Answer

The effect has been to encourage the consumption of other forms of spirit, particularly of gin, rum and brandy It has also led to the importation of foreign-made " whiskies "—even into Scotland.

The following table shows what has happened

Spirit	*Million Proof Gallons*			
	1938–39	1949–50	1950–51	1951–52
Whisky	6·9	3·0	3·8	3·5
Gin	1·8	3·5	3·8	3·0
Rum	·58	1·5	1·7	1·2

In 1950–51 there were abnormally heavy clearances from bond in anticipation of an increase in duty in the 1951 budget.

The home consumption of whisky has been halved, the consumption of gin has doubled and that of rum has more than doubled. But whisky has now overtaken gin and is reverting to its former position as the most popular spirit drink.

Question No. 48

WHAT ARE THE RULES REGARDING RETAIL PRICES?

Answer

All home-trade invoices bear a statement as follows

Our bottled whiskies are sold on the express conditions that they will not be re-sold

(1) Except in or from our bottles, and exactly as supplied by us.

(2) At more than the following prices as fixed by the Scotch Whisky Association—if sold retail

	Standard brand	*De luxe brand*
In bottles	35s. 0d.	37s. 0d.
In half-bottles	18s. 3d.	19s. 3d.
In quarter-bottles	9s. 6d.	—
In miniatures	3s. 8d.	4s. 2d.

Question No. 49

WHAT ACTION IS TAKEN IF ANY FIRM OR INDIVIDUAL IS FOUND TO BE SELLING THE BRANDS OF MEMBER-FIRMS OF THE SCOTCH WHISKY ASSOCIATION AT PRICES IN EXCESS OF THE PRICES FIXED BY THE ASSOCIATION?

Answer

The offence is reported to the Scotch Whisky Association, and the firm in question is thereafter invited to attend before a Committee of the Association and later, if necessary,

before the Council, and, if the offence is proved, their name may be published in the trade papers on a Stop List—the effect of which is that supplies of Scotch Whisky are withheld from them. The name of any such firm may be removed from the Stop List at such time as the Council of the Association think fit.

Question No. 50

HOW MANY BRANDS OF WHISKY ARE THERE?

Answer

There are about 100 main brands on the home market, and many more exported, but it would be impossible to count every brand of whisky marketed. Many of them are sold only locally or to private clubs, etc.

Question No. 51

HOW OLD SHOULD THE BEST SCOTCH BE?

Answer

No precise period of time can be laid down as the standard age for securing the best Scotch Whisky Generally speaking, malt whiskies require longer to mature fully than grain whiskies. The law insists that whisky shall be at least three years old before sale for consumption in Britain and most overseas countries have similar provisos. It is the practice of the trade to mature for much longer than the legal minimum, however Malt whiskies are matured for seven, ten, or twelve years or even longer.

Question No. 52

WHAT CAUSES WHISKY TO LOSE ITS BRIGHTNESS?

Answer

30° U.P is considered the lowest safe strength to bottle whisky in order to maintain brightness. The reason for cloudiness is that the essential oils cannot be absorbed by the alcohol when the strength is reduced below a certain level and come out of solution and into suspension, thereby causing a cloudiness or turbidity

If the whisky is reduced to a low temperature or stored in very cold conditions it will become cloudy, but this cloudiness will disappear when the whisky is brought back to a normal temperature. It has been found that when whisky is actually chilled to temperatures below freezing-point the cloud formed becomes a deposit; and if this is filtered off, the whisky will then retain its brightness under all conditions of temperature. Unfortunately, the removal of the deposit produced by very low temperature may entail also the removal of some of the flavour

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Question No. 53

SOME SCOTCH WHISKY HAS A "SMOKY" FLAVOUR. WHAT CAUSES THIS?

Answer

The "smoky" flavour of certain Scotch Whiskies originates from the peat-fire over which the green malt is dried prior to grinding and mashing.

Question No. 54

ARE THE WELL-KNOWN BRANDS OF SCOTCH WHISKY COMMONLY OFFERED FOR SALE SINGLE WHISKIES?

Answer

No. They are blends, i.e. they contain various whiskies, both malt and grain, distilled at different distilleries. Each company has its own individual blending formula. Single whiskies are sometimes sold locally

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Question No. 55

WHAT ARE THE BEST BLENDS?

Answer

This is entirely a matter of taste. The well-known standard brands on the market are blended by experts who have had years of experience, and the consumer can rest assured that in drinking their product he is drinking a whisky blended to bring out best the characteristics of the malt and grain whiskies of which it is composed. A good average blend is of about 50 per cent. of malt whiskies and 50 per cent. of grain whiskies.

Question No. 56

IS IT POSSIBLE TO TELL THE DIFFERENCE BETWEEN ONE BRAND OF SCOTCH WHISKY AND ANOTHER BY SMELL ALONE?

Answer

Yes, it is possible to differentiate between different well-known established brands of Scotch Whisky by smell alone if one is sufficiently expert and experienced. The blenders employed by the standard bottling and blending firms, who blend the dozen or more different whiskies which go to make the customary brands, are guided by smell alone in producing a uniform product over the years. At the most they moisten their hands with a little of the spirit. Usually it is enough to smell the whisky in a glass. For the drinker who is not a professional blender, the only thing is to go on experimenting until practice makes perfect.

Question No. 57

WHAT IS THE DIFFERENCE IN STRENGTH BETWEEN PRESENT-DAY SCOTCH WHISKY AND PRE-WAR?

Answer

None. There is no difference in strength between present-day and pre-war Scotch Whisky of the established brands. It is still retailed at 70° Proof for the home market. For practically all overseas markets it is usually sold at 75° or 76° Proof.

Question No. 58

WHY IS SCOTCH WHISKY NOW SO DEAR IN THIS COUNTRY COMPARED WITH PRE-WAR?

Answer

Because the rate of duty is now very nearly three times what it was at the outbreak of war Then a bottle of Scotch Whisky sold at 12s. 6d., of which 8s. 5½d. was duty. Now it sells at 35s. a bottle, of which 24s. 7d. is duty

The cost of the bottle of Scotch Whisky, including manufacturing and storage costs, transport, advertising, selling, administration expenses, and wholesale and retail profits, has only gone up therefore from 4s. 0½d. to 10s. 5d. over that period.

Question No. 59

WHAT IS THE USUAL STRENGTH AT WHICH PROPRIETARY BRANDS OF SCOTCH WHISKY ARE SOLD FOR CONSUMPTION IN THE HOME MARKET?

Answer

The usual strength at which proprietary brands are sold for consumption at home is 30° Under Proof. On the label this is expressed as 70° Proof—this statement being required by the Labelling Regulations of the Ministry of Food. The reason for the almost standardised strength of 70° Proof is because it is the most economic under the heavy duty rate.

In this connection it may be noted that (although it is

not actually provided in the Order) an understanding exists with the Ministry of Food to the effect that no proceedings will be taken in any case where the strength of the spirit is not more than 0·5° less than stated on the label—this being referred to as the " margin of tolerance."

Scotch Whisky can be sold at any strength, but the law is to the effect that spirits must not be sold at a strength below 35° Under Proof (or 65° Proof) unless clear notice is given to the customer that the strength is, in point of fact, below 35° Under Proof. In the case of whisky below 35° Under Proof the bottle must bear on the label a statement as follows : " Diluted with water to not less than " (Ministry of Food Labelling Order, 1946.)

In addition, however, to the above, where whisky is bottled in bond, at any strength whatsoever, it is an offence to dilute same before sale to the customer.

Question No. 60

AT WHAT STRENGTH IS WHISKY SOLD FOR EXPORT?

Answer

A strength of 75° Proof, or 25° Under Proof, is normally inferred for export markets, though it is a custom of the trade to bottle up to 1° on the strong side, i.e., 76° Proof, or 24° Under Proof.

Canada and Ship Stores are exceptions, requiring whisky at 70° Proof, or 30° Under Proof.

Question No. 61

WHAT IS THE AVERAGE LIQUID CONTENT OF THE BOTTLES AS USED FOR SCOTCH WHISKY IN THE HOME TRADE?

Answer

Bottle	26⅔ oz. (or ⅛ gallon)
Half-bottle	13⅓ oz.
Quarter-bottle	6⅔ oz.
Miniature	2 oz.

Question No. 62

WHAT IS THE MEASURE AT WHICH SCOTCH WHISKY IS GENERALLY SOLD ACROSS THE COUNTER?

Answer

Whilst there is no standard measure, the most common one in England is known as " six out," meaning that six drinks are obtained from one gill. As one gill equals 5 oz. this means that on the basis of " six out," a bottle will produce approximately thirty-two drinks. In Scotland the " five out " measure is more usual. This represents approximately twenty-six drinks per bottle. The " four out " measure is also served. (See also previous question.)

Legislation to standardise measures is proposed.

Question No. 63

DOES SCOTCH WHISKY IMPROVE IN A BOTTLE WHICH IS KEPT CORKED?

Answer

No. There is no change in a whisky once it has been bottled and securely sealed. As oxygen in the air cannot get to the whisky there is no further maturing, unlike wines which continue to mature in the bottle.

Question No. 64

DOES SCOTCH WHISKY IN A BOTTLE LOSE ITS STRENGTH WITH AGE?

Answer

Once bottled, whisky should not lose its strength. " Loss of strength " is only another way of describing evaporation, which does not occur in a sealed bottle.

Question No. 65

WHAT IS THE DIFFERENCE BETWEEN SCOTCH WHISKY AND GIN?

Answer

Both are potable spirits but differ in their methods of manufacture and the ingredients used. Their characters, flavour, and content of secondary constituents are very different.

Gin, unlike Scotch Whisky, is a rectified spirit. The basis of good English (or "London") Gin is a potable spirit obtained by the patent-still process of distillation from a mash of maize, malted barley and other cereals in the right proportions. This spirit is then rectified and the juniper and other flavouring materials added. Practice differs according to the manufacturer, the spirit is often doubly rectified and frequently the rectified spirit is distilled with the juniper berries and other flavouring materials, the distillation in that case taking place in a steam-heated pot-still with a long rectifying head. In some cases the flavouring materials are separately distilled and added to the alcohol afterwards. That is, the distinctive characteristics of gin arise from a special process and separate elements intended to produce just those characteristics for addition to the alcohol, for the spirit base of gin is flavourless.

The aroma and flavour of Scotch Whisky are inherent within the spirit itself and depend chiefly on the water and method of distillation used. The secondary constituents are subsidiary, though important, products of the manufacturing process itself. They are native to the whisky and inseparable from it.

Gin does not materially change with age—unlike Scotch Whisky—and can be cleared for immediate consumption without having to remain in bond for even three years.

Question No. 66

WHY IS WHISKY COLOURED BROWN OR GOLDEN, WHILE GIN REMAINS WATER WHITE?

Answer

Whisky derives its colour in the first place from the casks in which it is matured. When it leaves the condenser unit after its second distillation, the whisky is colourless.

That which is matured in former sherry casks is usually, after maturation, a darker colour than that which is matured in American oak casks. The blender, who aims at uniformity in his product year after year, brings his whisky to a definite standard colour by adding, if necessary, a small quantity of colouring solution prepared from caramelised sugar. In relation to the volume of whisky involved, the amount of colouring matter is infinitesimal and does not affect the flavour or strength of the whisky.

Gin, a rectified spirit, usually reaches the consumer in the form in which it issues from the still and without colour

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Question No. 67

WHAT IS THE ALCOHOLIC STRENGTH OF SCOTCH WHISKY?

Answer

When distilled it is reduced for filling into casks at a strength of 11° Over Proof (63·4 per cent. of alcohol by volume).

After maturing, according to the age of maturity, the strength may be anything from 6° O.P (60·5 per cent. of alcohol by volume) at around seven years of age, to Proof (57·1 per cent. of alcohol by volume) at around twelve years of age.

At bottling the strength is normally 30° U.P (40 per cent. of alcohol by volume) for home-trade sale, and 25° U.P. (42·9 per cent. of alcohol by volume) for export sale, but with occasional variations from that strength as ordered.

Question No. 68

WHAT ARE THE USUAL ALCOHOLIC STRENGTHS OF: (A) *WHISKY;* (B) *GIN;* (C) *RUM;* (D) *SHERRY;* (E) *PORT;* (F) *MADEIRA;* (G) *BORDEAUX;* (H) *BURGUNDY;* (I) *CHAMPAGNE;* (J) *CLARET;* (K) *GINGER WINE;* (L) *BEER, AS DRUNK IN THE U.K.?*

Answer

	Percentage of alcohol content by volume	*Percentage or degree of proof spirit (Sikes)*
Whisky	40	70·0°
Gin	40	70·0°
Rum	40	70·0°
Sherry	20	35·0°
Port	20	35·0°
Madeira	20	35·0°
Bordeaux	14	24·5°
Burgundy	14	24·5°
Champagne	13·1	23·0°
Claret	13·1	23·0°
Ginger wine	14·2	25·0°

(Not all ginger wines are as strong as this.)

BEERS: The general descriptions in use are not indications of the relative strength but of the characteristics of the beer Draught milds and bitters are to be found brewed at gravities ranging from 1030° of gravity into the higher 1040's. Similarly with bottled beers, the brown ales, pale ales, stouts and lagers are to be bought at gravities from 1030° upwards—brown ales well into the 1040's, stouts up to about 1050 or more, pale ales up to 1060 where they merge into the strong ale class. These are merely general indications and do not exclude examples of higher strength being encountered.

BEER

Original gravity	*Percentage of alcohol content by volume*	*Percentage or degree of proof spirit (Sikes)*
1034·5°	3·13	5.48°
1041·5°	3·85	6·74°
1055°	5·18	9·03°

A beer containing 8·8 per cent. of alcohol by volume, i.e., 15·38° proof, would be a very strong beer.

Question No. 69

AT WHAT TEMPERATURE IS WHISKY BEST SERVED?

Answer

This is entirely a matter of personal choice and no rules, such as icing for certain wines, can be laid down. In this country it is usually served at room temperature, but in some overseas countries the convention has grown up of putting ice in the glass. Under climatic conditions of extreme heat and cold it would be advisable to cool or warm slightly, as appropriate, the whisky before serving. In extreme cold, whisky may become cloudy in appearance because of the precipitation of some of its secondary constituents.

Question No. 70

DOES IT SPOIL OR IMPROVE THE FLAVOUR OF SCOTCH WHISKY TO PUT ICE INTO IT AS A DRINK?

Answer

This is entirely a matter of personal taste. The ice can have no effect on the whisky itself, although whisky which is subjected to very low temperatures will become cloudy This cloudiness will disappear when the whisky returns to normal temperature. Similarly with soda water To mix this with Scotch Whisky has no effect on the whisky itself. Most connoisseurs prefer, in this country, to drink their whisky neat or with no more than an equal quantity of water

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Question No. 71

WHAT IS THE BEST SHAPE OF WHISKY GLASS?

Answer

A tumbler-shaped glass or a goblet is probably the most convenient shape, but whisky does not require any specific shape to enhance its delights and no rigid convention has grown up in this connection.

Question No. 72

IS THE BOUQUET OF SCOTCH WHISKY IMPROVED BY WARMING SLIGHTLY?

Answer

The bouquet of Scotch Whisky cannot be improved by warming. The effect of such warming would only be to increase the rate of evaporation of the spirit, thus speeding up the release of the aroma.

Question No. 73

WHAT IS THE MEDICINAL VALUE OF WHISKY?

Answer

Whisky is universally recognised for its tonic and restorative qualities. Its efficacy as a preventive and remedy for colds and influenza is generally acknowledged. It is also an admirable stimulant to the appetite.

Some recent medical opinion, including the Bethel Hospital, Brooklyn, U.S.A., considers Scotch Whisky an important item in treating hardening of the arteries and some other diseases.

Question No. 74

WHY DO SOME PEOPLE TURN A NEW BOTTLE OF SCOTCH UPSIDE DOWN BEFORE OPENING?

Answer

This is quite unnecessary and can do nothing to improve the whisky, which does not need to be turned upside down or shaken. It is quite erroneous to think that the essential constituents settle at the bottom. No origin is known for this peculiar habit unless it be possibly due to the advice on medicine bottles to " shake before taking."

Question No. 75

IS IT INJURIOUS TO DRINK WHISKY WITH OYSTERS OR OTHER SHELL-FISH?

Answer

No. This is an ancient superstition for which there is no foundation. A personal experiment will furnish the proof.

Question No. 76

WHAT ARE SOME DRINKS WHICH MAY BE MADE WITH SCOTCH WHISKY?

Answer

1. WHISKY TOM COLLINS

   5–6 dashes of gomme syrup.
   1 large glass of Scotch.
   2 or 3 lumps of ice.
   Pour into a large glass and fill with soda.

2. SCOTCH HORSE'S NECK

   Lemon juice. Scotch.
   Angostura. Ginger ale.

3. " WHISPER "

   2 glasses of whisky
   2 glasses of French Vermouth.
   2 glasses of Italian Vermouth.
   Cracked ice.

4. Whisky and soda to taste.

5. Whisky and dry ginger to taste.

6. WHISKY NEGUS or WHISKY TODDY.

   Hot whisky and lemon.

7 Whisky and hot milk.

8. ROB ROY

   ½ Italian Vermouth.
   ½ Scotch.
   Dash of Angostura.

9. WHISKY SPECIAL

   3 glasses of whisky
   2 glasses of French Vermouth.
   ½ glass of orange juice.
   Add a little nutmeg after mixing.

10. MINT COOLER

    1 glass of Scotch.
    3 dashes of Crème de menthe.
    1 lump of ice.
    Fill up glass with soda.

11. SCOTCH RICKEY

    1 lump of ice.
    Juice of half a lime.
    Juice of a quarter of a lemon.
    1 glass of Scotch.
    Soda.

12. DERBY FIZZ

    5 dashes of lemon juice.
    1 teaspoonful of powdered sugar
    1 egg.
    3 dashes of Curacao.
    1 glass of Scotch.
    Soda water.

13. HIGHLAND COOLER

    1 teaspoonful of powdered sugar.
    Juice of half a lemon.
    2 dashes of Angostura.
    1 glass of Scotch.
    1 lump of ice.
    Ginger ale.

14. EARTHQUAKE COCKTAIL

One third gin.
One third whisky.
One third absinthe.

15. FLYING SCOTSMAN COCKTAIL

2½ glasses Italian Vermouth.
3 glasses Scotch.
1 tablespoonful bitters.
1 tablespoonful sugar syrup.

16. HOOTS MON COCKTAIL

¼ Lillet.
¼ Italian Vermouth.
½ Scotch.

17 HOT TODDY Place a spoonful of sugar in a warm glass and add enough boiling water to dissolve the sugar. Add a generous measure of whisky and stir with a silver spoon ; pour in more boiling water and top up with more whisky Stir well.

18. ATHOLL BROSE Mix an equal quantity of honey (preferably heather honey) and fine oatmeal in a little cold water. Add the whisky and stir until frothy Bottle and keep for two days before serving. Two pints of whisky will be needed for a half-pound of honey and a half-pound of oatmeal.

19. WHISKY SOUR To a double whisky add the juice of half a lemon and half a teaspoonful of sugar Shake with ice and serve with a squirt of soda water.

SECTION V

MISCELLANEOUS

77 *What is the origin of the name " Whisky " ?*

78. *Why is it sometimes spelt " whisky " and sometimes " whiskey " ?*

79. *How does the consumption of Scotch Whisky in Scotland compare with that in the rest of the United Kingdom ?*

80. *Was whisky distilling ever prohibited in Great Britain ? If so, when ?*

81. *When is the earliest reference to the manufacture of Scotch Whisky in the Highlands ?*

Question No. 77

WHAT IS THE ORIGIN OF THE NAME "WHISKY"?

Answer

The term "whisky" derives originally from the Gaelic "usquebaugh," or "uisge beatha," meaning "water of life," Gaelic being that branch of Celtic spoken in the Highlands of Scotland.

Question No. 78

WHY IS IT SOMETIMES SPELT "WHISKY" AND SOMETIMES "WHISKEY"?

Answer

Most well-known dictionaries give both spellings. The *Oxford English Dictionary* points out that "in modern trade usage, Scotch Whisky and Irish Whiskey are thus distinguished in spelling." American-made whiskey is usually spelt as printed here.

The most that can be said with any certainty is that it is a convention that has grown up as spellings, which were for a long time very variable, have become stabilised. In the Report of the Royal Commission on "Whiskey and other Potable Spirits" (1909), the spelling "whiskey" is used throughout of both the Scotch and Irish products.

Question No. 79

HOW DOES THE CONSUMPTION OF SCOTCH WHISKY IN SCOTLAND COMPARE WITH THAT IN THE REST OF THE UNITED KINGDOM?

Answer

Customs and Excise monthly figures of releases from bond give no guide as to the amount of whisky consumed in Scotland itself, but from inquiries within the Trade, it would appear that between 15 and 20 per cent. of the total home consumption is drunk in Scotland.

Taking the population of Scotland as being about one-tenth of the total population of the United Kingdom, the average consumption of whisky in Scotland per head of the population is higher than over the remainder of Britain.

Question No. 80

WAS WHISKY DISTILLING EVER PROHIBITED IN GREAT BRITAIN? IF SO, WHEN?

Answer

It was first prohibited in 1802 during the Napoleonic Wars when all grain was reserved for food. It was again prohibited in World War II during the distilling seasons 1942–43 and 1943–44 and after the war from the summer of 1946 to the spring of 1947, by the Government's withholding allocations of barley and other cereals.

An Act of the Scottish Parliament, 1579, severely limited distillation and brewing, on which, see the answer to Question No. 21.

Question No. 81

WHEN IS THE EARLIEST REFERENCE TO THE MANUFACTURE OF SCOTCH WHISKY IN THE HIGHLANDS?

Answer

The earliest reference to the manufacture of Scotch Whisky in the Highlands is uncertain and a matter for debate among the authorities. When King James IV was in Inverness during September 1506, his Treasurer's Accounts have entries for the 15th and 17th of the month respectively. "For aqua vite to the King iiis" and "For ane flacat of aqua vite to the King vs." It is very probable that the aqua-vitæ in this case was spirit for drinking.

Mr. J. Marshall Robb, in his book *Scotch Whisky*, says: "The oldest reference to whisky occurs in the Scottish Exchequer Rolls for 1494, where there is an entry of 'eight bolls of malt to Friar John Cor wherewith to make aquavitae.'"

Sir Robert Bruce Lockhart, K.C.M.G., in his book *Scotch. The Whisky of Scotland in Fact and Story*, states that "it is a fact that for centuries a spirit distilled from a fermented barley mash has been made all over the Highlands."

The earliest reference to a distillery in the Acts of the Scottish Parliament is not earlier than 1699, and the reference is to the famous Ferintosh distillery owned by Duncan Forbes of Culloden.

There is also a definite reference to distilling in a private house in the parish of Gamrie in Banffshire in 1614. This occurs in the Register of the Privy Council, where a man accused of the crime of breaking into a private house, combined with assault, was said to have knocked over some "aquavitie."

One of the earliest references to " uiskie " occurs in the funeral account of a Highland laird about 1618.

An unpublished letter of February, 1622, written by Sir Duncan Campbell of Glenorchy to the Earl of Mar, reports that certain officers sent to Glenorchy by the King have been given the best entertainment that the season and the country allow—" For they wantit not wine or aquavite." This " aquavite " was no doubt locally distilled whisky.

Another writer affirms that aqua-vitæ occasionally formed part of the rent paid for Highland farms, at any rate in Perthshire, but no actual date is given for this practice.

Professor David Masson, in his introduction to Volume XII of the Register of the Privy Council, says in reference to the period 1622–25 : " Although whisky was well enough known in the Highlands, neither that nor any other form of aqua-vitæ was as yet familiar in the Lowlands." Some authorities consider his statement questionable in both parts, and see answer to Question 21 on the 1505 grant to the Edinburgh Guild of Surgeon Barbers.

Miss I. F Grant, in *The Social and Economical Development of Scotland before* 1603, says that the Highlanders cannot have made whisky, because it is known that they imported aqua-vitæ. This, again, is considered to be disproved by such references as that already given to King James IV's obtaining aqua-vitæ in Inverness.

SECTION VI

DEFINITIONS

82. *What is Scotch Whisky ?*
83. *What is the difference between Scotch, Irish, Rye, Bourbon, etc. ?*
84. *What are Spirits ?*
85. *What is meant by " Proof Spirit " ?*
86. *What is a Single Whisky ?*
87 *What is the distilling year ?*
88. *What is meant by " Original " and " Regauge " gallonage and by " Ullage " ?*
89. *What is meant by " Under Bond " and " Duty Paid " sales respectively ?*
90. *What is meant by " saccharify " in the Industry ?*
91. *What is Diastase ?*
92. *What is Wort ?*
93. *What is Wash ?*
94. *What is a Pot-Still ?*
95. *What is a Patent-Still ?*
96. *What is the Worm ?*
97 *What are Low Wines ?*
98. *What is Pot Ale ?*
99. *What are Foreshots ?*
100. *What are Feints ?*
101. *What are Spent Lees ?*
102. *What is Draff ?*

Question No. 82

WHAT IS SCOTCH WHISKY?

Answer

" Spirits described as Scotch Whisky shall not be deemed to correspond to that description unless they have been obtained by distillation in Scotland from a mash of cereal grain saccharified by the diastase of malt and have been matured in warehouse in cask for a period of at least three years." (Customs and Excise Act, 1952, Clause 243 (1) (*b*).)

The word " Scotch " is, in this connection, of geographical, not generic, significance.

Question No. 83

WHAT IS THE DIFFERENCE BETWEEN SCOTCH, IRISH, RYE, BOURBON, ETC.?

Answer

The difference arises from variations in the methods of manufacture, including blending, and among the materials used, particularly the quality of the water.

Scotch Whisky is made in Scotland chiefly from malted and unmalted barley and a smaller proportion of other cereals by distillation in pot-stills or patent-stills. The usual retail brands are blends of several Scotch whiskies, both pot- and patent-still whiskies.

Irish Whiskey is made by similar processes, but Irish distillers favour three distillations, as against two in Scotland, in the case of pot-still whiskies, and the range of cereals used is rather wider. The best-known retail

Irish Whiskies are usually unblended, that is, they are single pot-still whiskies.

Rye and Bourbon Whiskies are made in the U.S.A. and Canada, the former, as its name indicates, from rye, and the latter from maize. They are mostly produced by the patent-still process of distillation.

" Scotch Type " is a description applied in the U.S.A. to blended whisky composed of 20 per cent. or more of malt whisky (whether domestic or imported) and 80 per cent. or less of neutral spirits. There is no such thing as " Scotch Type Whisky " in Scotland, where whisky is either " Scotch Whisky " or not.

Question No. 84

WHAT ARE SPIRITS?

Answer

The term " Spirits " describes the product of distillation, whatever the raw materials, or whether it be in a pure state or contaminated by impurities normally present in any distillate. Generally, the word refers to any volatile inflammable liquid obtained by distillation.

Spirits for human consumption, or potable spirits, are the distillates of alcoholic liquids, the alcohol in which has been formed by the fermentation of sugar as contained in grape-juice, sugar-cane, etc., or in saccharified materials such as specially prepared cereals, e.g., malted barley

For Excise purposes, the term " Spirits " is applied to any liquid containing spirit, presumably distilled alcohol, and to all mixtures, compounds and preparations made with spirits.

In " The Attorney-General *versus* William Bailey " (1947, 1, Exch. 281 with reference to 6 George IV, c. lxxx), " Spirits " was really defined as an intoxicating beverage

requiring a licence for its sale. It was argued that as there is no statutory definition of the word " Spirits," it must be assumed that the Excise Acts use it in the same sense as it bears in common parlance. That is, nothing can be taken to be spirits which cannot come under the definition of an inflammable liquid produced by distillation, either pure or mixed with ingredients which do not convert it into some other article of commerce not generally known as " Spirits." Further, in common parlance the word " Spirits " does not include a liquid such as " Sweet Spirits of Nitre " nor any liquid usually known as spirits but not adopted for ordinary use as an intoxicating beverage so as to need a licence for its sale.

In the Excise regulations under the Spirit Act of 1880 it is stated that when spirits are conveyed into a Feints Receiver, they are Feints, and that when spirits of the first extraction are conveyed into a Low Wines Receiver, they are Low Wines, notwithstanding that when these Low Wines are re-distilled the product is spirits if passed to the Spirit Receiver, but Feints if passed to the Feints Receiver, but still all subject to Excise duty as spirits.

The Spirit Act further says that " British Spirits " means spirits liable to duty of Excise, and therefore includes Low Wines and Feints, but if such spirits are to be designated *Plain Spirits* they must be " British Spirits " as defined above (*except Low Wines and Feints*) which have not had any flavour communicated thereto, or ingredients or material mixed therewith.

Consistently, the flavours, although such are *present* in Feints (and they are intense flavours), not having been *communicated* to the liquid but acquired congenitally, exclude such liquids from the dignity of the description Plain British Spirits.

Question No. 85

WHAT IS MEANT BY "PROOF SPIRIT"?

Answer

The short, rough answer to this question is that proof spirit is a mixture of absolute alcohol and water in equal measure.

Technically, the expression "proof" represents a standard, and "proof spirit" relates to a standard of alcoholic content, or strength. Early methods of verifying this standard of spirit consisted of rough and ready tests such as smell and taste, inflammability, or igniting a mixture of gunpowder and spirit.

The Customs and Excise Act of 1952 defined spirits of proof strength as follows.

"Spirits shall be deemed to be at proof if the volume of the ethyl alcohol contained therein made up to the volume of the spirits with distilled water has a weight equal to that of twelve-thirteenths of a volume of distilled water equal to the volume of the spirits, the volume of each liquid being computed as at fifty-one degrees Fahrenheit." (Clause 172 (2).)

That is, spirit of proof strength is that which, at the temperature of 51° F., weighs exactly twelve-thirteenths of an equal measure of distilled water.

Proof spirit is thus a solution of alcohol in water in the concentration arising from mixing at 51° F., 100 measures of alcohol of the specific gravity of 0·79381 (i.e., absolute alcohol) with 81.82 measures of water, the bulk of the resulting mixture being 175·25 and not 181·82 measures.

Whisky of proof strength means whisky consisting of 100 per cent. of proof spirit, as defined above, i.e., a mixture of whisky and water containing 57·06 per cent. by volume of alcohol, or 48·24 per cent. by weight of alcohol at 51° F.

Nowadays a temperature of 60° F. has been found more convenient, in which case the mixture contains 49·28 per cent. of alcohol by weight, and 57·10 per cent. of alcohol by volume. Its specific gravity is then 0·91976.

A whisky containing a higher proportion of alcohol than 57·10 per cent. is described as "Over Proof," whilst a lower alcoholic content makes it "Under Proof."

For example, if the mixture contains 70 per cent. of proof spirit as defined above, its strength is defined as 70° Proof or 30° Under Proof (30° U.P.). It then consists of 39·97 per cent. of alcohol by volume, or 33·3 per cent. of alcohol by weight, and its specific gravity is 0·9523.

Similarly, if it contains, say, 10 per cent. more of alcohol than is needed to make it 100 per cent. of proof spirit, it is defined as 10 per cent. Over Proof (or 110° Proof). Actually 10 per cent. O.P. is a whisky containing 62·79 per cent. of alcohol by volume, or 54·94 per cent. by weight, and its specific gravity is 0·9071 at 60° F

The measurement of proof strength is carried out by an instrument known, after its inventor, as the Sikes's Hydrometer It is made of brass and consists of a hollow globular body which is topped by a vertical scaled stem, graduated in ten divisions, reading downwards. The globular body is underhung by a thin spindle ending in a bulb-like equipoise. Nine flat brass weights, marked from 10 to 90, to correspond with the ten graduations on the stem, also form part of the apparatus. The instrument is placed in the liquid to be tested after recording the temperature by an accurate thermometer Any necessary weights are added to float the hydrometer, which is then read at the level of liquid. The reading is then converted, with the aid of the tables provided, into proof strength.

There is a special hydrometer for high-strength spirits.

Question No. 86

WHAT IS A SINGLE WHISKY?

Answer

A Single Whisky is the product of one particular distillery, either grain or malt.

Question No. 87

WHAT IS THE DISTILLING YEAR?

Answer

The distilling year for Scotch Whisky (used for statistical purposes only) runs from 1st October, the opening of the distilling season, to 30th September.

The malt whisky distilling season runs approximately from 1st October to 30th June, and the three months of hot weather are known as the " silent period."

The grain distillers work to the calendar year.

Question No. 88

WHAT IS MEANT BY " ORIGINAL " AND " REGAUGE " GALLONAGE AND BY " ULLAGE "?

Answer

Original gallonage is the actual gallonage at which the whisky is filled into casks when it is distilled. Regauge is the gallonage which remains in the casks at any time thereafter. The regauge gallonage is smaller than the original gallonage by reason of the evaporation which has taken place during the years which elapse while the whisky is maturing. Ullage is the difference between the original and the regauge gallonage, or, in other words, the amount of loss which has taken place.

For all stocks maturing in Scotland it is estimated that the loss is around 3,000,000 proof gallons in a normal year.

The word " ullage," meaning what a cask lacks of being full, derives from the Old French *eullage* or *œillage*, meaning the amount required to fill the cask to the eye or bung, deriving from the French *œil* (Latin *oculus*, eye), in the sense of bung-hole.

Question No. 89

WHAT IS MEANT BY " UNDER BOND " AND " DUTY PAID " SALES RESPECTIVELY?

Answer

(*a*) Sales Under Bond are sales to customers of goods on which the Excise Duty has not been paid, and the goods are, of course, consigned to a bonded duty-free warehouse.

(*b*) Sales Duty Paid are sales to customers of goods on which the Excise Duty of 210s. 10d. per proof gallon has already been paid.

The literal meaning of " under bond " is that the trader has given a bond or guarantee to H.M. Customs and Excise against the duty involved to deliver the goods into the custody of another Crown warehouse.

See also Section III, Legal.

Question No. 90

WHAT IS MEANT BY " SACCHARIFY " IN THE INDUSTRY?

Answer

To saccharify means to convert to sugar. It is applied in the Industry to the process which takes place during the malting and mash-tun stages by which the enzyme diastase turns the starch in the cereals into sugar ready for the fermenting action of the yeast.

Question No. 91

WHAT IS DIASTASE?

Answer

Diastase is a substance which forms in the grain of barley during the malting process and turns the starch in the grain into a kind of sugar—maltose.

Each grain of barley consists of a small plant enclosed in a skin and packed into a further outer skin or skins along with a storehouse of starch. When conditions of warmth and moisture favour germination the corn secretes the enzyme diastase, and during malting another enzyme and this diastase act upon the line separating the starch from the embryo plant. At malting, the growth of the plant is allowed to proceed until it has the maximum development or secretion of diastase and the minimum loss of sugar by absorption into the embryo. The action is then stopped by drying.

Question No. 92

WHAT IS WORT?

Answer

Wort is the liquid drawn off from the mash-tun in which the malted and unmalted cereals have been mashed with hot water. Wort contains all the sugars of the malt and certain secondary constituents. After cooling, it is passed to the fermenting vats.

In Malt Distilleries the cereals are all malted, in Grain Distilleries a proportion only is malted, the remainder being unmalted.

Question No. 93

WHAT IS WASH?

Answer

"Wash" is the term applied to the liquid obtained by fermenting wort with yeast. It is the wash which forms the raw material of the first distillation in the pot-still process and of the only distillation in the patent-still process.

Question No. 94

WHAT IS A POT-STILL?

Answer

A pot-still is a large copper vessel used in the distillation of malt whisky

The fermented liquid, or wash, containing yeast, crude alcohol, some unfermentable matter, and the by-products of fermentation, is put into the pot-still, consequently called the "Wash Still," and heated directly over a coal fire, or in some few instances by steam.

In appearance the still is like a copper kettle with the top extended, turned down, and taken out through the wall of the building, where it is attached to the "Worm." This is a coiled copper pipe of decreasing diameter enclosed in a water-jacket through which cold water circulates, thus condensing the vapours within the worm.

Inside the Wash Still is an apparatus known as the Rummager, consisting of four rotating arms which control a copper chain mesh which is dragged around the bottom of the still. This prevents the Wash, the contents of which are not in complete solution, from burning on the bottom of the still.

During this process of boiling the Wash over a naked fire, changes take place in the constituents of the Wash

which are vital to the flavour and character of the whisky It is maintained that the open fire cooks some of the organic substances in the Wash by the local super-heating of parts of the still bottom and flue-plates.

Distillation is continued in the Wash Still until all the alcohol is driven off and collected in one distillate, known as the " Low Wines." The liquor remaining in the still is termed " pot ale " or " burnt ale," and is usually run to waste.

The Low Wines are placed in another pot-still, the Spirit Still, similar in appearance and construction to the Wash Still but without the Rummager, and smaller, because the bulk of liquid to be dealt with is less. Three fractions are obtained from the distillation in the Spirit Still. The first is termed " Foreshots," the second constitutes the Potable Spirit, and the third is called " Feints." The Foreshots and Feints are returned to the process and redistilled in the Spirit Still with the succeeding charge of Low Wines. The residue in the still, called " Spent Lees," is run to waste like the pot ale.

In the case of the Spirit Still, the design of the still, the height of the head (or top) of the still, and the angle of the wide-diameter pipe, or " Lyne Arm," connecting the head to the condensing unit are all very important and have an effect on the distillate.

The pot-still has changed little in general design over the centuries.

Question No. 95

WHAT IS A PATENT-STILL?

Answer

A patent-still is a continuously working still used for the distillation of grain whisky. It is sometimes known as the Coffey-Still, after Æneas Coffey, who invented it in 1831.

The still consists of two columns, the analyser and the rectifier. Both columns are subdivided horizontally into chambers, each of which is fitted with a perforated copper plate as a base and a drip pipe into the chamber below.

Steam enters the base of the analyser, and when both columns are filled with steam, the Wash is introduced near the top of the rectifier in a pipe whence it passes to the bottom of the column. By then it is nearly at boiling-point. It is next carried to the top of the analyser, where it is discharged on to the perforated plate forming the base of the top chamber. The rising steam, being under pressure, prevents the Wash passing through the perforations, and the Wash cannot pass on to the next chamber until it has reached the top of the drip pipe, about an inch above the plate. This process is repeated in each chamber and by the time the Wash reaches the base of the analyser it has been deprived of its volatile elements by the ascending steam and is practically free from alcohol.

The alcohol has, in short, been vapourised by the steam. The alcoholic vapours mixed with the steam are led to the base of the rectifier, and as they pass from chamber to chamber up that column are cooled by the descending Wash in its pipe. At a certain point in the rectifier a temperature prevails which is roughly that of the condensation temperature of strong ethyl alcohol. In this region a stout copper sheet, or " spirit plate," pierced by a fairly wide pipe replaces the perforated plate, and pipes are fitted to drain all the liquid condensing or falling back on the spirit plate. Under normal working conditions the greater part of the ethyl alcohol condenses on or above the spirit plate and once the pure spirit commences to be collected it runs continuously until the close of distillation.

This still represents a saving of fuel and water · the vapours heat the Wash, and the Wash condenses the vapours.

Because of the rectifying element present in this process, the distillate lacks many of those secondary constituents found in malt whisky It consequently has a milder character and requires less time to mature.

Question No. 96

WHAT IS THE WORM?

Answer

The Worm and its surrounding bath of cold running water, or " worm-tub," form together the condenser unit of the pot-still process of manufacture. The Worm itself is a coiled copper tube of decreasing diameter attached to the head of the pot-still and kept continuously cold by running water. In it the vapours from the still condense. Fed by the still, it in turn feeds the receiving vessel with the condensed distillate.

The Worm is gradually being replaced by the more modern tubular condenser.

Question No. 97

WHAT ARE LOW WINES?

Answer

This is the name given to the product of the first distillation in the pot-still process of manufacture. It is the distillate received from the Wash and contains all the alcohol and secondary constituents and some water. It forms the raw material of the second distillation, that which is carried out in the Spirit Still. The Feints and Foreshots are added to the Low Wines when the Spirit Still is charged, but the entire contents are still termed Low Wines.

Question No. 98

WHAT IS POT ALE?

Answer

Pot Ale, alternatively " Burnt Ale," is the liquor left in the Wash Still after the first distillation in the pot-still process, i.e., it is the residue of the Wash after the extraction by distillation of the Low Wines.

Question No. 99

WHAT ARE " FORESHOTS " ?

Answer

" Foreshots " is the term applied to the first fraction of the distillate received during the distillation of the Low Wines in the Spirit Still used in the pot-still process of manufacture. They form the first raw runnings of this second distillation and their collection is terminated by the judgment of the stillman. The following fraction of the distillate is the potable spirit.

The Foreshots are returned to the still, together with the Feints.

Question No. 100

WHAT ARE FEINTS?

Answer

" Feints " is the name given to the third fraction of the distillate received from the second distillation in the pot-still process. They form the undesirable last runnings of

the distillation. As noted above, they are returned with the Foreshots to the Spirit Still when it is recharged with Low Wines.

The term is also applied to the first and last runnings from the patent-still, in which process they are returned to the Wash for re-distillation.

The Feints and Foreshots from the last distillation of the season are kept for adding to the first Low Wines of the succeeding season.

Question No. 101

WHAT ARE SPENT LEES?

Answer

Spent Lees are the residue in the Spirit Still after the distillation of the Foreshots, Potable Spirits, and Feints. They are usually run to waste.

Question No. 102

WHAT IS DRAFF?

Answer

Draff is the substance left in the mash-tun after the liquor, Wort, has been drawn off. It represents, as a rule, about 25 per cent. of the malt and unmalted cereals, if any, put into the mash-tun.

Draff enjoys a large market as a cattle food.

INDEX

Unless otherwise stated, references are to Question numbers.

NOTES

NOTES