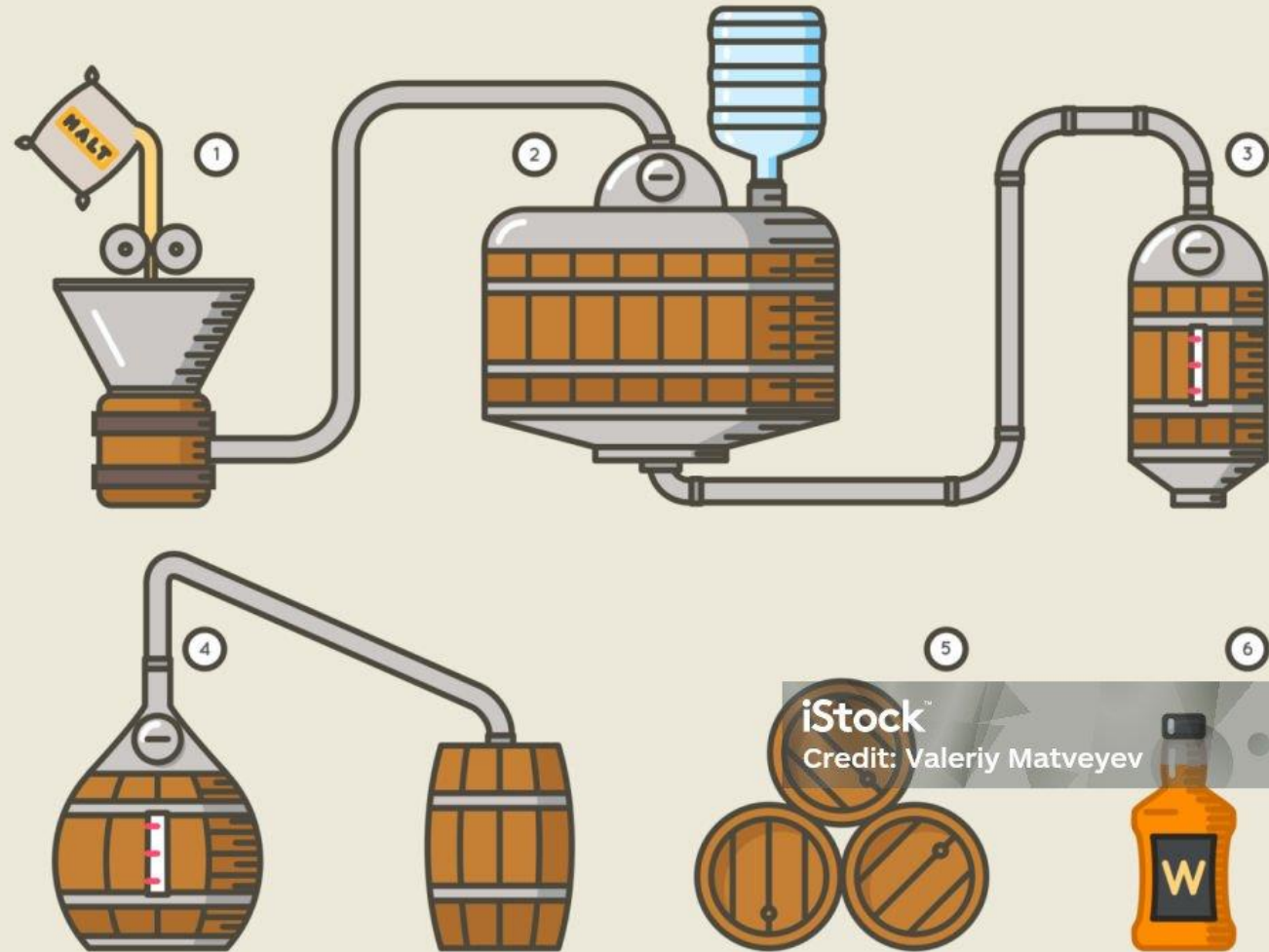


Is it Scotch or Whisky or Whiskey?



WHISKEY PRODUCTION PROCESS



1 PREPARATION

2 MARSHING

3 FERMENTING

4 DISTILLING

5 AGING

6 BOTTLING



Whiskey (or whisky) can be any of a variety of distilled liquors that are made from a fermented mash of cereal grains and aged in wooden containers, which are usually constructed of oak. Commonly used grains are corn, barley malt, rye, and wheat.

WHISKY



WHISKEY



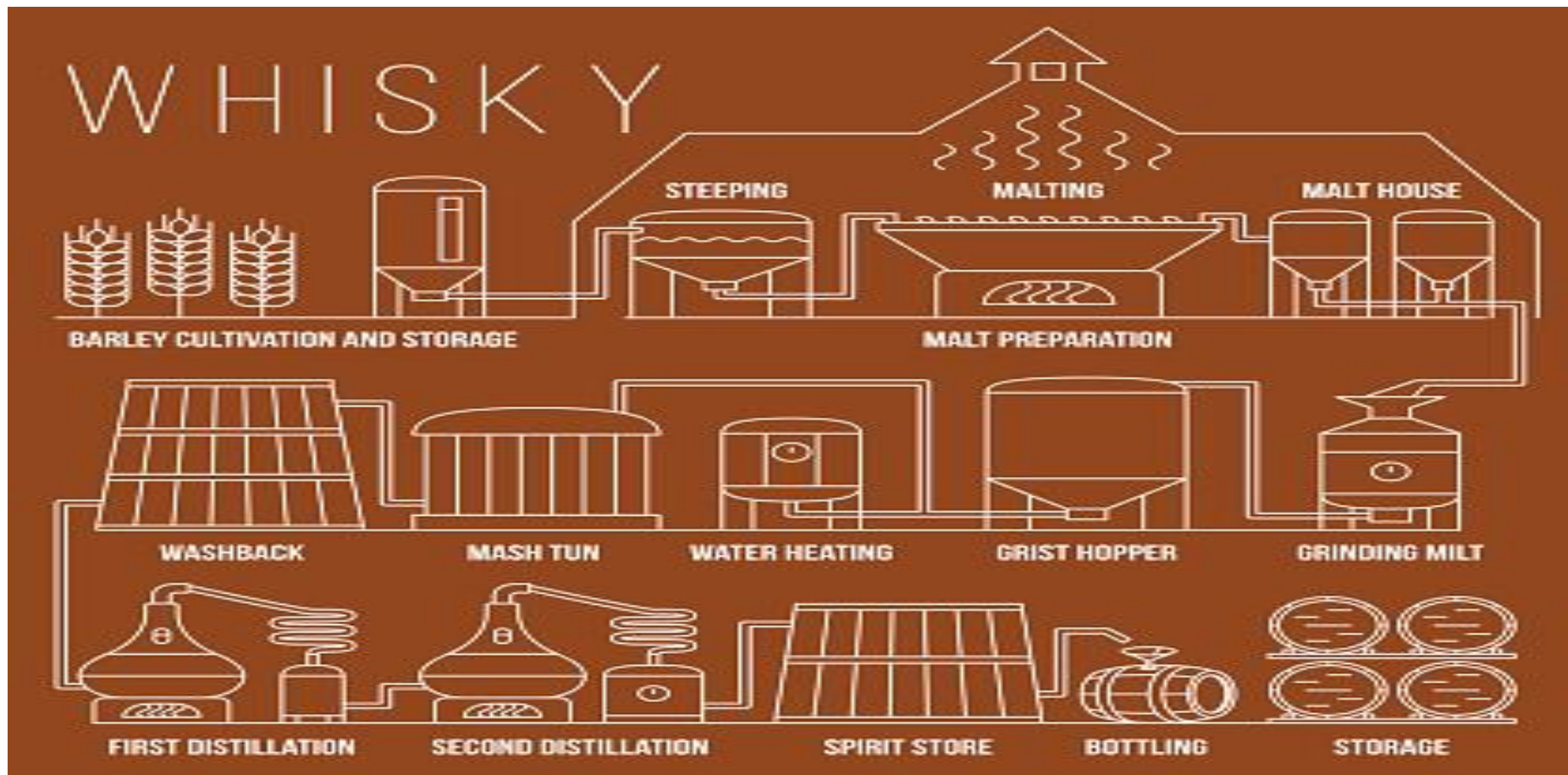
WHISKY

- **WHISKY** is the drink made in Japan, Canada, or Scotland.
- Plural forms: whiskies



WHISKEY

- **WHISKEY** refers to the beverage from the United States and Ireland.
- Plural forms: whiskeys



Scotch is a whisky (no e) that gets its distinctive smoky flavor from the process in which it is made: the grain, primarily barley, is malted and then heated over a peat fire. A whisky cannot be called Scotch unless it is entirely produced and bottled in Scotland.



Scotch whisky must be matured for a minimum of three years.

If a bottle of Scotch whisky shows an age statement, e.g. "12 Years Old" means that the youngest whisky in the bottle is at least 12 years old.

Scotch is bottled at a variety of ages, from 3 years to 50 years.

Be aware of "No Age Statement" Scotch

How about Blended Whisky?

Grain whisky is most often used between 3 and 5 years old in blended whisky brands. It is also in demand at various other ages in blends: 5, 8, 12 years and older.

Johnnie Walker Black Label and Chivas Regal 12 are both 12 year old blends whose combined case sales are over 10 million cases, or 10% of the total market. These two brands alone require high volumes of 12 year old grain whisky.

Malt whisky is used in blends from any age over 3 years old, but typically would be between 5 and 10 years old as malt matures more slowly than grain.





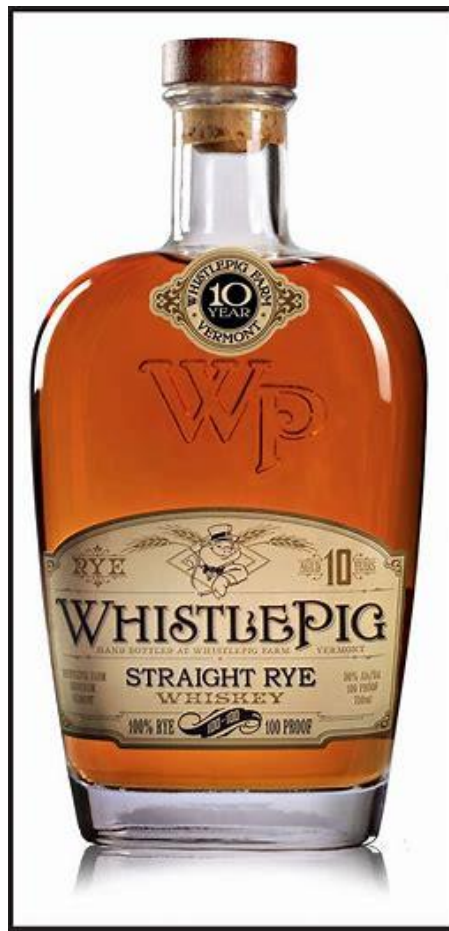
Bourbon, a whiskey that was first produced in Kentucky, U.S., uses at least 51 percent mash from corn in its production. It also uses a sour mash process — that is, the mash is fermented with yeast and includes a portion from a mash that has already been fermented. U.S. regulations specify that in order for a whiskey to be called bourbon, it must be made in the United States.

In order to be classified as bourbon, a whiskey needs to be distilled from a mixture of grains, or mash, that's at least 51% corn. That corn gives bourbon its distinctive sweet flavor.

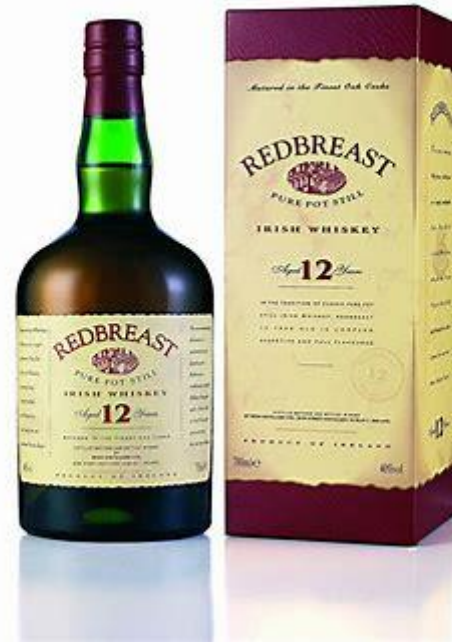
Bourbon also must be aged in new charred oak barrels, and cannot include any additives or colorings. Other whiskeys can be aged in barrels previously used to age other spirits, and they don't necessarily need to be whiskey barrels — port, [sherry](#), and rum casks are used in the aging process for non-bourbon whiskeys. To be designated "straight bourbon whiskey," bourbon has to have been aged in new charred oak barrels for a minimum of two years.

The mash must be distilled at 160 proof (or 80% alcohol by volume) or less, and aged in barrels until it is no more than 125 proof (62.5% alcohol by volume) or less. Before bottling, bourbon is filtered and diluted down to no less than 80 proof (40% alcohol by volume)

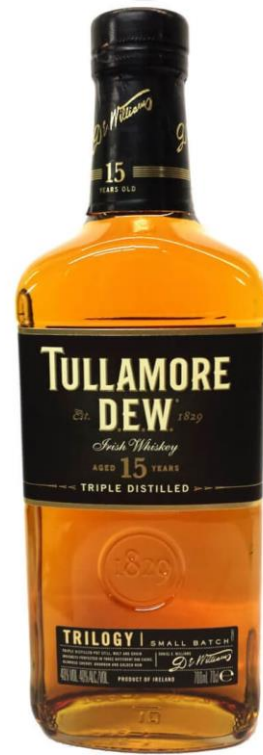
You may have heard that in order to be a bourbon, the whiskey has to be from Kentucky. That's not quite true — bourbon can be made outside that state. But to be designated a "Kentucky bourbon," the spirit has to be both distilled and aged in Kentucky. The name "bourbon" even comes from old Bourbon, what is now Bourbon County, Kentucky.



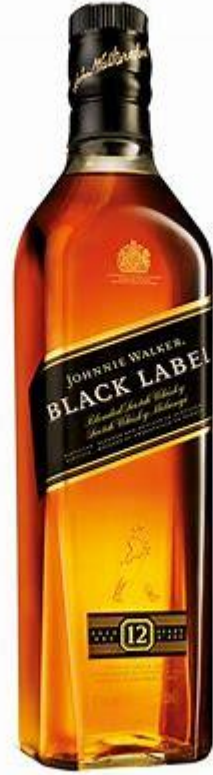
And **rye whiskey**? It's a whiskey that uses a rye mash or a rye and malt mash. In the United States, regulations stipulate that the mash must be at least 51 percent rye in order for it to be called rye whiskey. In Canada, regulations do not specify a minimum percentage of rye.



The tippie the Irish were famous for back then was a far cry from the smooth spirit Irish whiskey is perceived to be nowadays. [Single pot still whiskey](#), or pure pot still as it was called back then, is a mixed mash bill whiskey made from both malted and unmalted barley. It's produced in giant, bulbous pot stills, sometimes with a capacity of over 35,000 gallons. Known for its oily and thick texture, single pot still whiskey is surprisingly spicy, and often displays an abundance of dried red fruits.



That fact is not withstanding that triple distillation was a widespread technique in late 19th century Ireland. However, distillers didn't necessarily do this to achieve a smooth, easy-drinking result. In many cases, a third round of distilling was needed to extract more alcohol from the generally lower-yielding mash of malted and unmalted barley. Generally speaking, even after three merry-go-rounds in one of those big Irish pot stills, a pure pot still whiskey is in essence often quite heavier than an average double distilled malt whiskey.



This myth is still perpetuated to this day as a marketing strategy. At the [Jameson Bow Street Experience](#) in Dublin for example. More than 350,000 people visited the attraction in 2017, and all were invited to try an Irish ([Jameson](#)), a scotch ([Johnnie Walker Black](#)), and an American ([Jack Daniel's](#)) whiskey. The message this tactic tries to convey is this: Scotch whisky is peated, American whiskey is sweet, and Irish whiskey is smooth and most accessible.