

separate distillations and two separate condensations in copper worms.

In making Bourbon steam whisky the mash is prepared and yeasted as in steam copper houses. In the distillation the American still is used, in which the beer is boiled by steam and the vapor, instead of passing directly to and through a copper worm, passes into a wooden doubler in which is a sufficient quantity of lowwines to condense the vapor, and the whisky passes from the wooden doubler to the worm. Only one worm is used, no singlings run and no copper still or doubler employed. This trade constitutes the bulk of Bourbon County whisky. Highwines or raw whisky is made by precisely the same process as Bourbon steam. The American still is used in both modes, and the only difference consists in the superior quality of grain used in making Bourbon steam, and in the quality of rye, only one distillation and one condensation take place. The highwines are not reduced with water to a strength near proof, as the Bourbon steam is, and is generally drawn off into tubs or barrels. The construction of Bourbon steam-houses is very similar, and either grade of whisky can be alternately made in either class of houses. Many distilleries operate with slight variations from the methods we have described, but as the slightest departure from the regular process gives a different result the tendency is to adhere closely to established grades.

KENTUCKY WHISKY.

The Different Methods of Distillation— The Processes Described.

From the Louisville Commercial, March 14.

The manufacture of whisky in Kentucky is a most important branch of homestead industry. Millions of dollars are invested in the working of our distilleries, and their product has world-wide reputation. The methods by which it is produced are known to but few persons outside of a limited number of practical distillers, even dealers in the article being generally ignorant of the different processes by which it is made. There are six modes of distillation practiced in this State, and the result is six classes of whisky, known to the initiated as "sour mash, pure copper," "sour mash, log and copper," "sweet mash, pure copper," "steam copper," "Bourbon, steam," and "highwines." Sour mash, pure copper, is made as follows: One to two bushels of corn-meal is mashed in small tubs, by hand, with slop, and without the use of steam. (Slop is the spent beer from the still.) A sufficient amount of this slop, boiling-hot from the still, is mixed with the fresh meal to heat the same to proper temperature. The mash then stands undisturbed from twenty-four to thirty-six hours, according to the weather, no artificial means of cooling being used for this period. When the mash has cooled to about 110 degrees a very small quantity of rye-meal and malt is added, after which the same is diluted with water to the proper temperature. Then, in the different small tubs, or in one large one into which the small ones are discharged, the mash is yeasted with yeast, or rather a small quantity of mash previously mashed and in a state of fermentation. After fermentation ceases the beer is boiled in a copper still over the fire, the vapor passing to and through a copper worm and condensing into what is known as singlings. The singlings are doubled in a copper still over the fire, and the vapor again passes through a copper worm, condensing into whisky. The highwines, or high-proof spirit, is reduced with the lowwines to the strength at which it is barreled. The yield by this process is from two to two and a half gallons.

In making "sour mash log-and-copper" whisky, the process differs from that described above in the substitution of a wooden beer-still for the copper, and the introduction of steam into the beer. Most of the sour mash whisky in the State is made on this plan.

Sweet mash pure copper is made by mashing as before described, but with water, instead of slop. The mash stands only a few hours, when it is cooled down and yeasted. The distillation is the same as for sour mash.

In the manufacture of steam copper the mash is made in one tub by a rake driven by steam. The mash, having been mixed with water, is scalded by steam introduced directly into the mash-tub. From one-fourth to one-fifth of the mash is rye-meal, with a proper quantity of malt. Sweet hop-yeast is generally used to start fermentation. The beer is boiled in a wooden still by steam thrown into it. The vapor, just as in the old-fashioned pure copper distilleries, passes through a copper worm, and is condensed into singlings. The singlings are doubled in a copper still over the fire, and the vapor passes through a second worm. Thus whisky is the result of two