

‘Whisky’s finest guru’
The Sunday Times

WHISKYPEDIA

AN INTRODUCTION TO
SCOTCH WHISKY

CHARLES MACLEAN

Maclean

Y SINGLE MALT
SKY
HABHAIN DISTILLERY
S OLD

‘Charles MacLean writes like no other expert on the subject. His prose is informed and highly entertaining.’

The Independent

‘Charles MacLean is a world authority on malt whisky.’

Barbara Mowlem, *Daily Telegraph*

‘Charles MacLean is, for my money, the most serious and scholarly writer on whisky today.’

Andrew Jefford, *London Evening Standard*

‘He is the doyen of whisky writers ... The fount of all knowledge on the subject.’

Tom Morton, BBC Scotland

‘... acknowledged in his industry as both a great lover and expert authority on Scotch whisky’

Al Horsford, *Essential Medical World*

‘MacLean, a moderately tall man of indeterminate age and stocky build, has an old world air about him -- if one were to get precise with such allegories -- of a former travelling minstrel, a sometime Smee-like pirate, now retired to the less precarious life of landed gentry. He has an impressive moustache of the Mark Twain/ Rudyard Kipling school of whisker-growth, and on his head a mop of hair with a distinguished recession at the temples. At the time we met, he wore a monocle that dangled from a string around his neck (apparently his wife hates it) and a pair of pink pants that did nothing to take away from his overall genial gruffness.’

Vinayak Varma, *New Indian Express*

Whiskypedia

An Introduction to Scotch Whisky

Charles MacLean



First published in 2009 by Birlinn Ltd, revised edition published in 2011.

This abridged digital edition published in 2012 by

Birlinn Ltd,
West Newington House
10 Newington Road
Edinburgh, EH9 1QS

www.birlinn.co.uk

Copyright © Charles MacLean 2009, 2011, 2012

The right of Charles MacLean to be identified as the author of this work has been asserted by him in accordance with the Copyright, Designs and Patents Acts 1988.

All rights reserved. No part of this publication may be reproduced, stored, or transmitted in any form, or by any means electronic, mechanical or photocopying, recording or otherwise, without the express written permission of the publisher.

eBook ISBN 978 0 85790 069 2

British Library Cataloguing-in-Publication Data

A catalogue record for this book is available on request from the British Library.

For Sheila MacLean

INTRODUCTION

‘At first I found my descriptive task beset with difficulties far exceeding what I had contemplated; but ... my interest grew with the work, making it easier for me; until, after a time, I acquired quite a zest for these distillery studies.’

Alfred Barnard,
The Whisky Distilleries of the United Kingdom, 1887

Welcome to the digital edition of *Whiskypedia*, which I hope will serve as an easy introduction to Scotch whisky. The focus of the material presented here is primarily on flavour. For a fuller description of each brand and for more information on their curiosities and for a greater overview of Scotch whisky, please see the print edition of *Whiskypedia*.

Each entry in this eBook includes the following information:

Biography: A short biography of each brand.

Style: This is the character of the new make spirit, prior to maturation.

Mature character: This will be largely determined by the kinds of cask the spirit has been matured in, and for how long, so is an approximate guide only, based on the whisky being around 12 years old.

Comparable to: A couple of suggestions for other whiskies with a broadly similar flavour profile.

Raw Materials: From a flavour perspective, the most important information here is whether the malt is peated or not. Peating, *i.e.* drying the green malt over a smoky peat fire, imparts a smoky flavour to the whisky, especially where the malt is ‘heavily peated’. Where possible, I have supplied the date on which the floor maltings at individual distilleries were closed. This date often coincides with other changes made at the distillery in the interests of efficiency and economy, and may signal a change in the flavour of the whisky made there, for

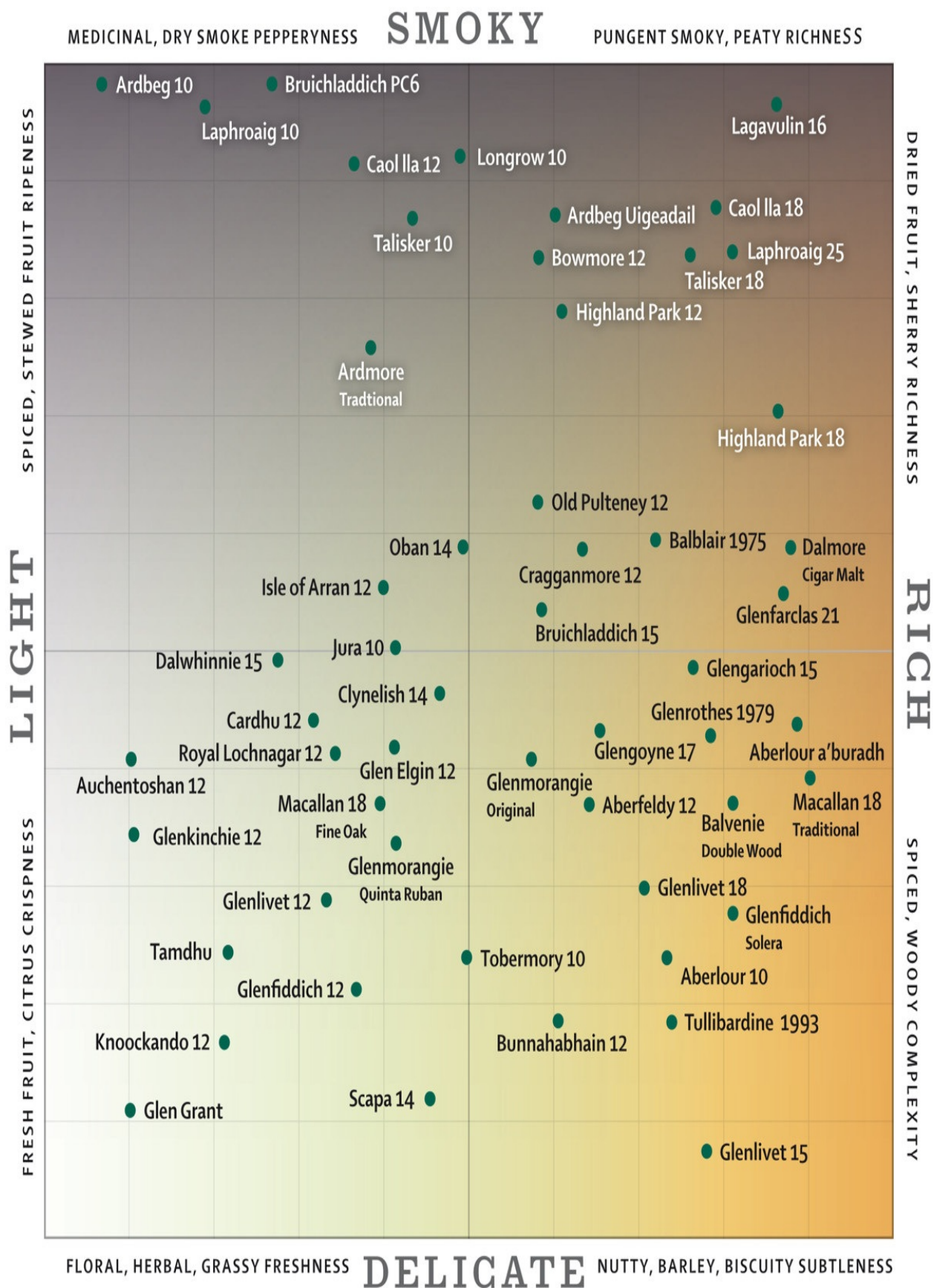
those of you who are interested in such matters!

Maturation: A note of the kinds of casks used. By law they must be made of oak, and around 90% of the casks are American oak (*quercus alba*), with 10% European oak (*q. robur*). The casks are invariably 'seasoned' prior to use, typically with bourbon or sherry, occasionally with other wines or spirits. Some bottlings use a mix of American and European oak casks.

Expressions: A list of current and recent bottlings released by the distillery owner. I have not included bottlings released by independent bottlers: it is impossible to keep track of these, and most sell out very quickly.

THE FLAVOUR MAP

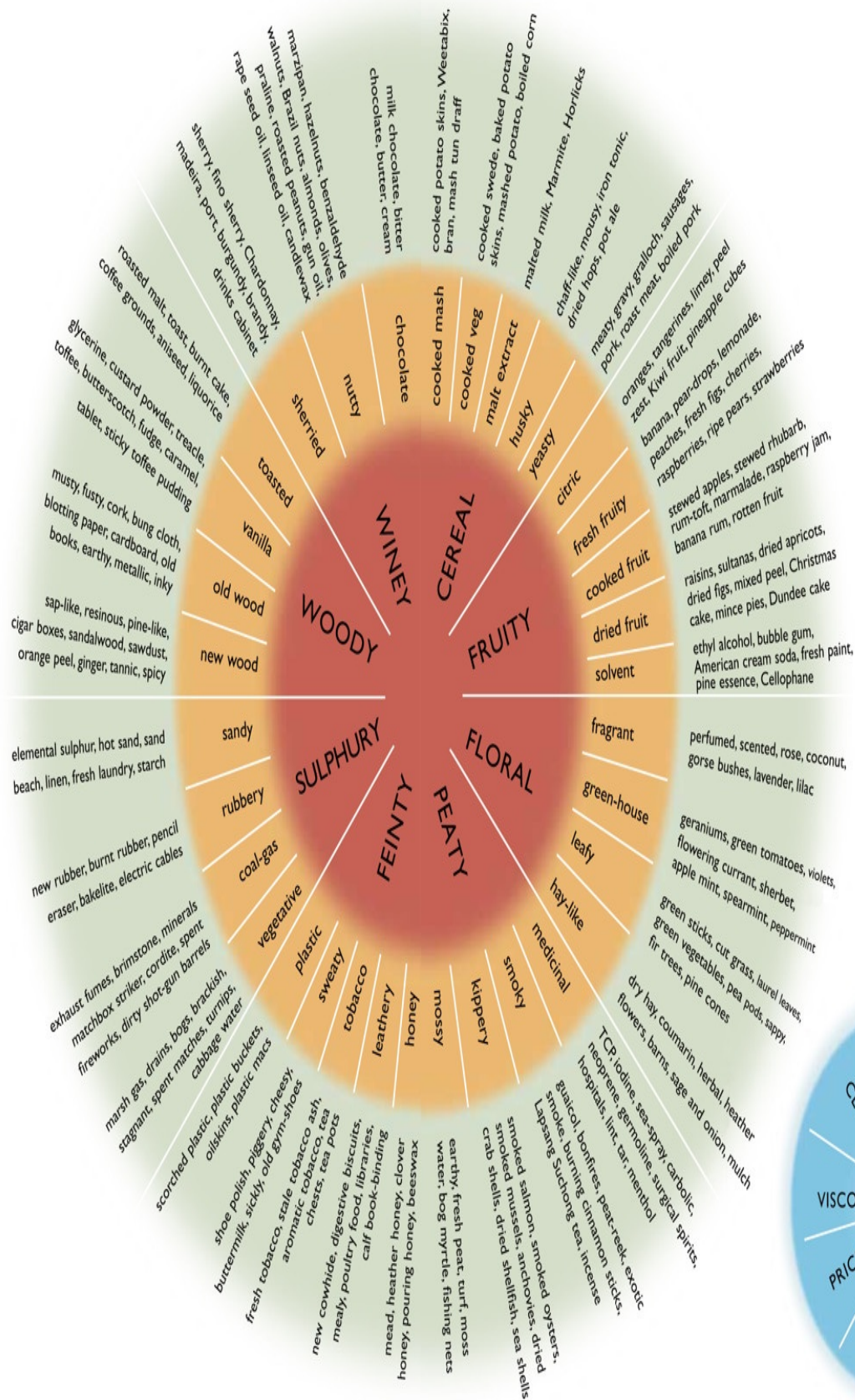
The Flavour Map was devised by some of Diageo's senior boffins and my friend and colleague, Dave Broom.



It sets out to plot malt whiskies on a simple matrix -- Smoky/Delicate; Light/Rich -- however, the positioning of the individual makes is not set in stone! Any of us might plot any of the whiskies slightly differently. But I think it is a useful tool.

THE FLAVOUR WHEEL

Flavour Wheels were first used by the wine and beer trades, and the first to be designed specifically for the evaluation of whisky was created by Messrs. Shortreed, Rickards, Swan and Burtles in 1979. I have simplified this wheel, and its successor (devised by the Scotch Whisky Research Institute).



TASTE AND MOUTH-FEEL



The hub of the wheel has eight segments, each of which describes a group of aromas commonly found in whisky, especially Scotch malt whisky.

In the next tier, these ‘cardinal aromas’ break down into more specific groups, and on the outer rim are the kinds of descriptors which might come to mind while nosing a sample.

As with the Flavour Map, the descriptors are not ‘set in stone’, nor are they exhaustive. They are designed to encourage you to develop your own vocabulary

Smells have an objective existence! They derive from volatile chemicals. But the words we use to describe them are generally allusive -- when we say “‘smells of apple’”, we are really saying “‘the smell reminds me of apple’”.

Taste, picked up by receptors on our tongues and soft palates, is less precise and evocative than smell. There are only five primary tastes: sweet, sour/acidic, salty, bitter and umami (loosely described as savoury).

Abstract terms such as bland, clean, coarse, dry, flat, fresh, green, hard, light, mellow, rich, round, sharp, smooth, soft, thin, etc), are also commonly used in describing flavour -- particularly when describing taste. These allude to an overall impression, rather than a specific smell or taste.

ABERFELDY



Aberfeldy distillery was built a quarter of a mile to the east of Aberfeldy village by the Dewar brothers, Tommy and John (Jnr), to supply fillings for their increasingly successful blends. Their father, John Dewar, had been born on a croft about two miles away. The distillery opened in 1898 and was built according to 'the most modern principles': barley went in one end of the distillery and whisky came out at the other. There was even a private railway line to Dewar's blending operation in Perth, to bring in grain and coal, and to carry away casks of whisky. The first-rate visitor centre, Dewar's World of Whisky, welcomes around 35,000 visitors a year.

Style: Sweet and estery; heather honey and Ogen melon.

Mature character: Smooth and creamy; heather-honey, pears, melon and bruised apples; light maltness. Taste is fresh, fruity and malty, predominantly sweet. Medium body.

Comparable to: Aberlour, Dalwhinnie

Raw materials: Unpeated malt from Simpson's, Berwick-upon-Tweed; water from the Pitilie Burn.

Maturation: Around 90% refill U.S. hogsheads, 10% refill European wood. All

Dewar's spirit filled and matured in Glasgow.

Expressions:

- First bottled 1991 (@ 15YO, Flora & Fauna series)
- In 2000 a 25YO @ 43% was released to mark the opening of the visitor centre.
- Aberfeldy 12YO @ 40%
- Aberfeldy 21YO @ 40% (introduced 2003)

Special single cask bottlings are released annually.

ABERLOUR



Today's Aberlour distillery was built in 1879/80 by local businessman James Fleming using stone from the quarry used by Thomas Telford for his famous bridge at Craigellachie. Sales of Aberlour single malt have increased dramatically since 2000, particularly in France, where it is the bestseller. A new visitor centre was opened in August 2002, offering an excellent two-hour tour. The name means 'the mouth of the chattering burn'.

Style: Sweet and fresh-fruity, medium bodied.

Mature character: Malty nose, with some fruits and spice. Viscous mouth feel. Honey, with a trace of nutmeg and a thread of smoke in the finish. Mediumbodied.

Comparable to: Aberfeldy, Strathisla

Raw materials: Unpeated malt from independent maltsters; own floor maltings closed in 1960. Process and reduction water from springs; cooling water from the Lour Burn.

Maturation: Approximately half is first and refill sherry butts, the remainder refill hogsheads. The whisky to be bottled as single is matured on site in one of six bonded warehouses (capacity 27,000 casks); the rest at other sites in the Highlands and Central Belt.

Expressions:

- Aberlour 10YO @ 40%
- Aberlour 10YO Sherry Finish @ 43%
- Aberlour a'bunadh NAS @ CS (introduced 2000)
- Aberlour 12YO @ 40% (Double cask matured)
- Aberlour 12YO @ 43% (Oloroso sherry matured)
- Aberlour 15YO @ 40% (Double cask matured)
- Aberlour 16YO @ 43% (Double cask matured)
- Aberlour 18YO @ 43% (introduced 2008)

ALLT-A-BHAINNE



Built by Seagram's in 1975, Allt-a-Bhainne Distillery looks like a compact fortress crouching on the northern slopes of Ben Rinnes, the mountain that dominates northern Speyside. The distillery itself is uncompromisingly modern, inside and out, and the whole operation was designed to be operated by one man, even in pre-computer days. The distillery looks out over Corriehabbie, the haunt of many illicit distillers in the past.

Style: Sweet and grassy.

Comparable to: Glendullan, Glen Grant

Raw materials: Unpeated malt from independent maltsters. Unusually, the distillery has a Buhler five-roller malt mill. Water from 20 springs on the sides of Ben Rinnes, via the Rowantree and Scurran Burns, is collected in a dam behind the distillery.

Maturation: Mainly refill U.S. hogsheads, matured off site.

Expressions: Never bottled by its owner. Very occasional independent bottlings only.

ARDBEG



Ardbeg has an old-fashioned, timeless atmosphere, with tasteful contemporary touches. The founders of the distillery were MacDougalls, tenant farmers in this part of Islay, and the first record of distilling on the site was in the 1790s. It was resurrected from the dead by Glenmorangie, after they bought the distillery in 1997. The Ardbeg Committee, a fan club founded in 2000, now has around 40,000 members.

Style: Peaty.

Mature character: Peaty, medicinal, salty, dry, but the taste is surprisingly sweet, followed by a blast of smoke, with some liquorice. Fullbodied.

Comparable to: Lagavulin, Laphroaig

Raw materials: Soft peaty water from Loch Arinambeist and Loch Uigeadail, three miles from distillery. Floor maltings until 1977 then heavily peated malt from Port Ellen Maltings (55ppm phenols).

Maturation: 98% bourbon barrels (first and second fill) and 2% sherry. 50% firstfill and 50% second fill used for single bottlings. Two dunnage and three racked warehouses on site (capacity 24,000 casks).

Expressions: Annual releases in small batches for the Ardbeg Committee are high sought after.

The current core list comprises:

- Ardbeg 10YO @ 46% (introduced 2000)
- Ardbeg Uigeadail @ 54.2% (introduced 2003)
- Ardbeg Araigh nam Beist 1990 @ 46% (introduced 2006)
- Ardbeg Corryvreckan @ 57.1% (introduced 2008)
- Ardbeg Blasda @ 40% (chillfiltered, introduced 2008)
- 1998 Renaissance @ 55.9% (introduced 2008)
- 1975 @ 54.2% (sherry butt; only available at the distillery, 2008)
- Supernova @ 60.1% (introduced 2009?)
- Ardbeg Alligator @ 51.2% (limited, introduced 2011)

ARDMORE



Ardmore is the heart malt of the Teacher's blends, and was built by Adam Teacher in 1897/8. The distillery stands deep in rural Aberdeenshire, between the historic villages of Spynie and Kennethmont, beside the main Inverness–Aberdeen railway line, off which the distillery had a siding (no longer used). The original steam engine, used to provide power, is still in situ and operational. The company's Scotch Whisky Director, Douglas Reid, was raised in one of the distillery cottages.

Style: Sweet and smoky, with spice in the finish.

Mature character: Creamy, sweet and smoky on the nose; mellow and buttery, sweet and malty; distinctly smoky to taste. Unusual. Robust.

Comparable to: BenRiach Curiositas, Edradour Ballechin

Raw materials: Soft process water from 15 springs on Knockandy Hill. Cooling water from local sources. Mediumpeated malt (12–14ppm phenols) from local independent maltsters.

Maturation: The majority of the spirit used for Teacher's is matured in European oak puncheons. The single malt is matured in exbourbon (Jim Beam) barrels, and finished in firstfill quarter casks.

Expressions: Only two bottlings have been done by the owner – the first now very rare.

- Ardmore Centenary 100th Anniversary Bottling 1977 21YO @ 43% (released 1999, exclusively for guests of the distillery)
- Ardmore Traditional Cask @ 46% (non-chill filtered, finished in quarter casks, introduced 2007)

ARRAN



Opened in 1995, the Isle of Arran Distillery stands above the picturesque village and sea loch of Lochranza. When the distillery opened in 1995 there was much speculation about which style of malt it would produce. Would it be Islay smoky, Campbeltown heavy or Lowland light? Owner Harold Currie, a Speyside distiller, opted for that style. Unlike most distilleries, you may buy the Arran malt by the cask, as a new-make spirit.

Style: Sweet and fruity, eau-de-vie.

Mature character: Speyside-like; pear drops, citric fruits, green apples. The taste is sweet, with some malt and citric acidity. Lightbodied.

Comparable to: Linkwood, Aultmore

Raw materials: Water from Loch na Davie, above the distillery via the Easan Biorach stream. 90% unpeated Scottish malt from Bairds (Black Isle). Each year a small amount of peated malt is taken in, for a peated expression.

Maturation: Two modern dunnage warehouses, one racked on site, holding 5,000 casks – 80% of the make. The remaining 20% is matured on the mainland.

Expressions: The first release was a 3YO in 1998; a 4YO followed. Since then the distillery has released occasional single casks at natural strength, a range of cask finished malts (usually at 14YO and 50%) and annual Icons of Arran bottlings. Since 2009, the distillery has also been releasing a peated expression,

Machrie Moor.

- The Arran Malt 10YO @ 46%
- The Arran Malt 12YO @ 46% (introduced 2008)
- The Arran Malt 100 Proof @ 57% (introduced 2008)
- The Arran Original @ 43% (limited markets)
- Robert Burns Malt @ 40%
- Robert Burns Malt 10YO 250th Anniversary @ 43% (limited release 2009)
- The Arran Malt 14YO @ 46% (released 2010, to replace 12YO)
- The Arran Westie @ 43% (i.e. West Highland terrier; limited release March 2011)
- Machrie Moor @ 46% (one bottling a year, since 2009)
- Machrie Moor 12YO @ CS (released September 2010)
- Machrie Moor Sleeping Warrior (limited release May 2011)

AUCHENTOSHAN



Auchentoshan's situation 20 minutes west of Glasgow makes it a popular place to visit, and the facilities here were refurbished in 2004 to enhance the experience. Auchentoshan is the sole remaining Lowland distillery employing triple distillation, which increases the delicacy of the whisky and its strength, and one of only four surviving malt distilleries in the Lowlands. It was founded by John Bulloch, corn merchant, in 1817 (as Duntocher).

Style: Delicate, fruity and zesty.

Mature character: Floral-fragrant, with lemon zest and light cereal. Smooth mouth feel, sweet then dry with roast almonds, fruits and a trace of butterscotch. Short finish. Lightbodied.

Comparable to: Glenkinchie, Bruichladdich

Raw materials: Soft process water from Loch Katrine and cooling water from the Kilpatrick Hills, via the bomb crater dam where it is recycled through a fountain. Unpeated malt from independent maltsters.

Maturation: Exbourbon barrels, exsherry casks (Oloroso and Pedro-Jimenez), remade hogsheads and butts. Each expression has its own mix of casks/wood formula. Three dunnage and two racked warehouses on site hold 20,000 casks.

Expressions: Current core expressions are:

- Auchentoshan Classic (no age statement) @ 40% (introduced 2008)
- Auchentoshan Select (no age statement) @ 40% (duty-free only, mid 1990s)
- Auchentoshan 12YO @ 40% (reintroduced 2005)
- Auchentoshan 18YO @ 43% (from American barrels, introduced 2008)
- Auchentoshan Three Wood @ 43% (a mix of exbourbon, ex-Oloroso and ex-Pedro Ximinez woods, introduced 1998)
- Auchentoshan 21YO @ 43% (limited edition; a mix of exbourbon and exsherry casks, mid 1990s)
- Occasional limited editions: 1976, 30YO @ 41.8%; 1965, 40YO @ 41.6%; 1957, 50YO @ 49.1% (all released 2007). Auchentoshan 1957, 50YO @ CS (released 2008).

AUCHROISK



Commissioned by Justerini & Brooks (J. & B.), building started at Auchroisk in 1972, on a site to the west of Keith with quantities of high-quality water available. The name comes from a nearby farm and means ‘the ford of the red stream’. The distillery was designed by Westminster Design Associates and won an award from the Angling Foundation for not interfering with the salmon’s progress upstream. Auchroisk is a large site and casks from other distilleries are matured here.

Style: Grassy.

Mature character: Sweet and lightly honeyed, with Sugar Puffs breakfast cereal. Cooked apples in the taste, with a whiff of smoke. Light-to mediumbodied.

Comparable to: Glenfiddich, Cardhu

Raw materials: Unpeated malt from Burghead. Soft process water from Dorie’s Well; cooling water from Mulben Burn.

Expressions: Auchroisk is not common as a single, since J. & B. Rare continues to prosper in global markets, currently standing at number two. It was first bottled as a single malt in 1986, as The Singleton. Bottlings were released from 1976, 1980 (named Particular, for the Japanese market), 1981 and 1983 all at 12YO .

- Auchroisk 10YO @ 43% (Flora & Fauna series)
- Auchroisk 1974 28YO @ 56.8% (Rare Malts series)
- 1989 20YO @ CS (Special Release 2011)

AULTMORE



Alexander Edward of Forres, who had inherited Benrinnes Distillery from his father and led the consortium that built Craigellachie Distillery, built Aultmore in 1895, just outside Keith on the road to Buckie. The site, known as the Foggie Moss, was abundant in springs and rich in peat, and had been a favourite haunt of smugglers in the early nineteenth century. Aultmore went into production in 1897. The make was not bottled by its owners as a single until 1996, although it has been ranked Top Class by blenders from the outset.

Style: Light and estery/fruity.

Mature character: Light and fragrant, with cut grass and green apples. The taste is sweet and floral – simple and easy. Lightbodied.

Comparable to: Glen Elgin, Cragganmore

Raw materials: Process water from Auchinderran Burn; cooling water from the Burn of Ryeriggs. Unpeated malt from Burghead.

Expressions: Apart from a limited Centenary Edition (16YO @ 63%, which achieved £960 at auction in 2000), Aultmore was not bottled by its owner until:

- Aultmore 12YO @ 43% (Flora & Fauna range, introduced 1996)
- Aultmore 1974 21YO @ 60.9% (Rare Malts series, bottled 1996)

Under John Dewar/Bacardi's ownership:

- Aultmore 12YO @ 40%

BALBLAIR



Founded in 1790, by John Ross, Balblair is among the oldest distilleries in Scotland, and one of the prettiest. Like many malts, the make was unknown beyond local farmers until relatively recently, but it is now – at last, for it deserves it – being nurtured and promoted as a brand by its owners. The present distillery stands some distance from the original, six miles outside Tain, with its back to the Dornoch Firth. It was built around 1872, and managed by members of the Ross family for just over a century. The distillery's location, Edderton, is reputed to have the cleanest air in Scotland; hence the brand name Elements.

Style: Fullbodied, waxy-oily, nutty, leathery, but also green apples, floral notes and a natural spiciness.

Mature character: Nutty and sweet, with a trace of smoke and an elusive maritime note. The taste is medium-sweet, with fruity, nutty and spicy notes and an attractive thick mouth feel. Medium to full-bodied.

Comparable to: Glenmorangie, Craigellachie

Raw materials: Process and cooling water from the Allt Dearg Burn in the Struie Hills, piped five miles from the distillery. Floor maltings until the early 1970s, now unpeated malt from Portgordon Maltings.

Maturation: Eight dunnage warehouses on site (one with a concrete floor installed by Norwegian troops during World War II, so it could be used as a canteen), with capacity for 28,500 casks. Mainly U.S. exbourbon hogsheads,

some European oak. All single malt matured on site.

Expressions: First bottled by its owner in the late 1990s, since 2007 Balblair has been bottled in limited edition 'vintages', with casks selected by current master blender, Stuart Harvey, by year, not age, but with a 'rolling core' of three vintages (at around 30, 20 and 10 years old) and occasional single cask bottlings. Currently the core vintages are:

- Balblair 1978 @ 46% (released 2010)
- Balblair 1989 @ 43% (released 2011)
- Balblair 2000 @ 43% (released 2010)
- Balblair 1991 @ 43% (U.S.A. only, released 2010)
- Balblair 1997 @ 43% (U.S.A. only, released 2010)
- Balblair 1990 @ 46% (travel retail exclusive, 2010)

BALMENACH



One of the earliest modern authorities on Scotch whisky is Sir Robert Bruce Lockhart (author of *Scotch*, 1951). His great-grandfather, James MacGregor, farmed at Balmenach and distilled illegally there until, in 1823, he received a warning from the local Excise officer and took out one of the first licences on Speyside. The make is ranked First Class by blenders. Balmenach was mothballed in 1993 and sold to Inver House Distillers in 1997. Production resumed the following year. The new owner acquired no stock, which is why this excellent malt is not (yet) more readily available.

Style: Meaty, vegetal, oily, full-bodied, some say slightly sulphury.

Mature character: The rich style of Balmenach makes it appropriate for European oak maturation, and the best bottlings have a dried fruit, sherried style, with a whiff of smoke. Medium-sweet, rich and dry in the finish. Fullbodied.

Comparable to: Mortlach, Benrinnes

Raw materials: Soft water from a private supply, via the Cromdale Burn. Saladin boxes were installed in 1964 and used until the 1980s; thereafter unpeated malt from independent maltsters.

Maturation: Mainly U.S. refill hogs; some Spanish oak.

Expressions: Balmenach was only available (and rarely) through independent bottlings until the early 1990s Flora & Fauna release. It is not currently bottled

by its owners.

BALVENIE



William Grant opened Glenfiddich Distillery in 1886, and, during the next decade, distillery building on Speyside was unprecedented. The Old Castle of Balvenie is a massive medieval keep that stands close by, its walls veiled by trees, and is well worth a visit. The new distillery, called Glen Gordon during its early months, went into production on 1 May 1893, with the old mansion house, which had lain empty and derelict for over 80 years, being converted into a maltings. Balvenie prides itself on doing everything in-house, growing its own barley and having its own floor maltings, coppersmiths and bottling facility.

Style: Fruity, full-bodied and honeyed.

Mature character: Rich and complex on the nose, with honeycomb, dried fruits (including orange peel) and some malt. Big mouth feel and a sweet taste, drying, with light acidity. Medium to full-bodied.

Comparable to: Strathisla, Dufftown

Raw materials: Soft water from springs in the Conval Hills, some barley from Mains of Balvenie and the rest from independent maltsters. Peat from Tomintoul.

Maturation: Forty-four warehouses on site. American and European oak, with some port casks. For the 10YO, sherrywood comprises 10% and exbourbon 90%.

Expressions: Balvenie Founder's Reserve was given a 10YO age statement in the early 1990s, when it was repackaged in the current dumpy bottle.

The current core range comprises:

- The Balvenie 12YO Doublewood @ 40% (introduced 1993)
- The Balvenie 12YO Signature @ 40% (introduced 2008, batches 1, 2, and 3 to date)
- The Balvenie 14YO Caribbean Cask @ 43% (U.S.A.)
- The Balvenie 14YO Cuban Cask @ 43% (France)
- The Balvenie 15YO Single Barrel @ 47.8% (introduced 1993)
- The Balvenie 21YO Portwood @ 40% (introduced 1996)

Old and Rare releases:

- Vintage Casks (numerous years)
- The Balvenie 30YO @ 47.3%
- The Balvenie 40YO @ 43.5% (introduced 2010 travel retail, globally 2011)
- The Balvenie Cask 191, 50YO single cask yielding 83 bottles, 45.1% (2002)

Recent Limited editions:

- The Balvenie 1989 PortWood @ 40% (editions in 2001, 2003 and 2005)
- The Balvenie 14YO RumWood (2005)
- The Balvenie 14YO Roasted Malt @ 47.1% (2006)
- The Balvenie 1992 Cask Selection @ 47.8% (2006)
- The Balvenie 17YO Islay Cask @ 43% (2001)
- The Balvenie 17YO New Wood @ 40% (2005)
- The Balvenie 17YO New Oak (2006)
- The Balvenie 17YO Sherry Oak @43% (2007)
- The Balvenie 17YO Rum Cask (2008)
- The Balvenie 17YO Madeira Cask (2009)
- The Balvenie 17YO Peated Cask @ 43% (2010)

Travel Retail:

- The Balvenie 14YO Golden Cask @ 47.8%
- The Balvenie 17YO and 21YO non-chill filtered and at @47.6%

Distillery Exclusives:

- The Balvenie 16YO Rose (introduced 2008, second edition 2009)
- The Balvenie Tun 1401 @ 48.1% (a marriage of six whiskies from 1966–88, released 2010)

BEN NEVIS



‘Long John’ Macdonald, the founder of the distillery, was a big man and proud, and perhaps on account of his size and strength was chosen by the Lochaber lairds to establish a legal distillery near Fort William in 1825, when he was 27 years old. The original distillery produced only 200 gallons a week, but the make’s reputation stretched even to Buckingham Palace, which accepted a cask in 1848, to be broached on the Prince of Wales’ 21st birthday in 1863. In 1941 the distillery was sold to the Canadian entrepreneur Joseph Hobbs, who made a fortune running Scotch into the United States during Prohibition. In 1989 the distillery was bought by Nikka Whisky Distilling Company of Japan, a company founded by Masataka Taketsuru, ‘the Father of Japanese Distilling’, who had trained in Scotland shortly after World War I.

Style: Malty and robust, with a hint of smoke.

Mature character: Aromatic, fruity (cooked fruits), malty, with dark chocolate notes. Mouth feel creamy; sweet start with vanilla and caramel, a trace of sulphury smoke. Medium to full-bodied.

Comparable to: Craigellachie, Blair Athol

Raw materials: Water from Allt a’Mhuilinn (Mill Burn), which flows from Coire Leis and Coire na’Ciste near the top of Ben Nevis itself. Unpeated malt from independent maltsters. Brewers yeast.

Maturation: A combination of exbourbon and exsherry casks, on site in five

traditional dunnage and one racked warehouse.

Expressions: Since the mid 1990s, there have been relatively frequent oneoff bottlings from 1966, 1967, 1968 and 1971–75, at cask strength and mainly at 26YO .

- Ben Nevis 10YO @ 46% (since 1996)
- Glencoe 8YO (blended malt, since 1992/93)
- Ben Nevis 40YO @ 40.6% (released 2004)
- Ben Nevis 14YO exsherry @ 46% 1992 (limited edition, introduced 2007)
- Ben Nevis 1984 24YO @ 55.4% (re-racked into sherry bath for 11 years (introduced 2010))

BENRIACH



Until 2004, BenRiach's fortunes were closely linked to its larger and more famous neighbour, Longmorn. It was built by the owner of that distillery, John Duff, in 1897, designed by Charles Doig. After several changes of ownership it became independent in 2004, since which time there has been a slew of bottlings! BenRiach was named Distillery of the Year in the 2007 Malt Advocate Whisky Awards.

Style: Sweet and fruity, Speyside style; sweet and smoky.

Mature character: (for the unpeated, un-finished malts) Fruity and estery, with apples and green bananas, some cereal notes. Sweet and creamy to taste, with vanilla and light caramel. Light-to mediumbodied.

Comparable to: Aberlour, Cragganmore

Raw materials: Process water from deep springs about half a mile away, known as Burnside, shared with Longmorn; cooling water from the Glen Burn (which also supplies Glen Elgin, Longmorn and Linkwood Distilleries). Currently peated (c. 35ppm phenols) and unpeated malt from independent maltsters.

Maturation: Now all filled into fresh exbourbon barrels for five to six years, then re-racked into refill hogsheads and butts.

Expressions: First bottled as a single by its owner @ 12YO in 1994. The new owner released a core range in August 2004 and has since added to it. Since then

there have been numerous annual limited and single cask releases.

- BenRiach Heart of Speyside @ 40% and 43%
- BenRiach 12YO @ 40% and 43%
- BenRiach 16YO @ 40% and 43%
- BenRiach 20YO @ 40% and 43%
- BenRiach 15YO @ 46% (in four different finishes: PX, Madeira, dark rum and tawny port, introduced 2006)
- BenRiach 25YO @ 46% (released 2006)
- BenRiach 30YO @ 50% (released 2007)
- BenRiach 40YO 1966 @ 50% (released 2007)
- BenRiach 10YO Curiositas @ 40%, 43% and 46% (peated)
- BenRiach 21YO Authenticus @ 46% (peated, introduced 2005)
- BenRiach 12YO Heredotas Fumosas @ 46% (peated, PX finished, introduced 2008)
- BenRiach 12YO Importanticus @ 46% (peated, finished in tawny port, introduced 2008)
- BenRiach 12YO Aromaticus Fumosas @ 46% (peated, finished in Jamaican dark rum barrels, introduced 2008)
- BenRiach 16YO @ 46% (Claret finish, 2010)
- BenRiach 17YO @ 46% (Burgundy finish, 2010)
- BenRiach 17YO @ 46% (Rioja finish, 2010)
- BenRiach 16YO @ 46% (Claret finish, 2010)

BENRINNES



A distillery was established 700 feet above sea level on the northern slopes of Ben Rinnes, at Whitehouse Farm, by one Peter McKenzie in 1826. It was destroyed by the Great Flood of Moray three years later and another distillery was built at Lyne of Ruthrie some distance away by John Innes. Eventually, the lease passed to Alexander Edward, who became a well-known distiller, founder of Aultmore, Dallas Dhu and Craigellachie Distilleries, part-owner of Oban and Yoker and supporter of Benromach, which was built on his estate near Forres. The distillery was rebuilt in 1955/56, and doubled in size to six stills ten years later. Benrinnes is ranked Top Class by blenders, and is extensively used in Diageo's blends.

Style: Heavy, meaty.

Mature character: Benrinnes has a famously big, robust character. The nose is rich with burnt caramel, dried fruits, sherry notes. The texture in the mouth is big, filling, velvety. The taste is sweet, then drying, with a long finish. Fullbodied.

Comparable to: Mortlach, Dailuaine

Raw materials: Floor maltings until 1964, then Saladin boxes until 1984. Unpeated malt now comes from Burghead and Roseisle. Process water from the Scurran and Rowantree Burns, which rise high up on Ben Rinnes itself.

Maturation: Mainly European oak and matured off site.

Expressions: Dewar Rattray, the independent bottler from Ayrshire, use Benrinnes for their 12YO single malt, Stronachie – named after a Perthshire distillery which closed in the 1920s and selected as the malt which was closest in style to that whisky.

- The first proprietary bottling was in 1991, at 15YO (Flora & Fauna series).
- Benrinnes 1974 21YO @ 60.4% (Rare Malts series, released 1996).
- Benrinnes 1985 23YO @ 58.8% (Special Release 2009).
- Benrinnes 1986 23YO @ CS (Special Release 2010).

BENROMACH



Benromach is the smallest working distillery on Speyside. It has had a chequered career, but is hopefully now on a sound footing. The Benromach Distillery Company was founded in 1898 by Duncan MacCallum (of Glen Nevis Distillery, Campbeltown) and F.W. Brickmann (spirit dealer, Leith), with the support of Alexander Edward, who rented them the site on the northern edge of his Sanquhar Estate, Forres. In 1993 it was sold to Gordon & Macphail, and carefully refurbished. The new distillery was opened by Prince Charles, Duke of Rothesay, on 14 October 1998; the visitor centre opened the following year. The distillery has a particularly good appearance, enhanced by the gardens laid out by the buccaneering Joseph Hobbs.

Style: Fruity, with body.

Mature character: Light Speyside in style, with more body than some. Fresh and fruity/floral on the nose; creamy to taste; sweet overall with some sweet cereal notes. Light-to mediumbodied.

Comparable to: Aberfeldy, Arran

Maturation: Mainly refill U.S. hogsheads, some refill European wood. Matured on site and in Elgin.

Expressions: Gordon & Macphail's original aim was to produce a light style of Speyside which could be enjoyed young. This has since been augmented by several older expressions.

- Benromach Traditional @ 40%
- Benromach 10YO @ 43%
- Benromach Organic @ 43% (certified by the Soil Association, special edition)
- Benromach Peat Smoke – Batch No. 4 @ 46%
- Benromach Origins Batch No. 1 @ 50% – Golden Promise (made from GP barley) 1999
- Benromach Origins Batch No. 2 @ 50% – Port Cask (matured in port pipes) 1999
- Benromach Origins Batch No. 3 @ 50% – Optic (made from Optic barley) 2000
- Benromach 25YO @ 43% (introduced 2004)
- Benromach Vintage 1968 @ 41.8% (released 2004)
- Benromach Classic 55YO @ 42.4% (very limited edition, released 2005)
- Benromach Pedro Ximinez Finish @ 45% (released 2010)
- Benromach Sassicaia Wood Finish @ 45% (released 2009)
- Benromach Hermitage Wood Finish @ 45% (released 2011)
- Benromach 30YO @ 43% (released 2011)
- Benromach Cask Strength 1981 @ 58.1% (released 2007)
- Benromach Cask Strength 2001 @ 59.9% (released 2011) raw materials: Malt from independent maltsters in Scotland, peated to around 10ppm phenols, with some experimental distillations at heavier and lighter peating. Process water from Chapelton Spring; cooling water from the Burn of Mosset, which rises on Romach Hill. Brewers yeast.

BLADNOCH



Bladnoch is the most southerly of Scottish distilleries, well off the beaten track on the Solway Firth. It was established as a farm distillery by the brothers Thomas and John McClelland in 1817. In 1994, it was bought by a developer from Banbridge, Northern Ireland. The original plan was to develop the site as holiday cottages, but the owners quickly realised what an important role the distillery had played in the local economy. Also, the distillery visitor centre was successful, yet without a distillery it would soon become pointless. Bladnoch went back into production in December 2000.

Style: Sweet, grassy, malty, mellow.

Mature character: Pastoral and floral; reminiscent of hedgerows, with lemony/citric notes and some cereal. The taste echoes this. The overall impression is light and appetising. Short finish.

Comparable to: Auchentoshan, Speyside

Raw materials: Process and cooling water (soft and peaty) from the River Bladnoch. Mainly unpeated malt from independent maltsters. Very occasional medium-peated (18ppm phenols) malt, usually once a year.

Maturation: Thirteen dunnage-style warehouses on site. 80% firstfill bourbon barrels (4 Roses and Heaven Hill), sherry butts and hogsheads, and occasional ex-wine casks. Unusually high levels of evaporation.

Expressions: Bladnoch was bottled by Bell's at 8YO, and by U.D. in their Flora & Fauna series at 12YO. Currently, the distillery bottles by hand in small batches and from single casks.

- Bladnoch 8YO @ 46%, 55% and 58.2 % (launched 2008)
- Bladnoch 18YO @ 55% (launched 2008)
- Bladnoch 18YO Sherry Matured @ 55% (single cask, launched 2008)
- Bladnoch 19YO @ 55% (launched 2009)
- Bladnoch 20YO @ 40% and 46% (launched 2010)
- Bladnoch Distillers Choice (a vatting of selected casks)

BLAIR ATHOL



Adjacent to the distillery's rustic stone buildings, thickly clad in Virginia creeper, flows the Allt Dour ('burn of the otter'), and this stream gave its name to the first distillery on the site, Aldour, founded in 1798. The name was changed to Blair Athol in 1825 when it was rebuilt and expanded. Mothballed between 1932 and 1949, it was then tastefully restored by Arthur Bell & Sons. Professor McDowell described it in the 1960s as 'almost a model distillery'. In 1985 it was subject to a hostile takeover by Guinness plc and soon after it became part of U.D. (now Diageo). Blair Athol is the heart-malt for the Bell's blends.

Style: Rich, nutty-spicy and cereal-like.

Mature character: Nutty and caramel-like on the nose, with rich maltiness, traces of leather and tobacco. A rich whisky, it takes European oak maturation well, adding to richness, with fruit cake, traces of wine and some sulphury notes. A curious mix of sweet and dry to taste, and not as long in the finish as the nose suggests. Medium-bodied.

Comparable to: Knockando, Macallan

Raw materials: Floor maltings until 1960s; now unpeated malt from Glen Ord. Water from the Allt Dour, which rises as a spring in the heights of Ben Vrackie ('the speckled hill'), above the snow line.

Maturation: Mainly exbourbon refills, some exsherry casks used in the

proprietary single malt bottlings. Mainly matured in the Central Belt.

Expressions: Not common, since required for Bell's. Blair Athol 12YO was released in the Flora & Fauna series in 1991 (decorated, appropriately, with an otter) since 1991; a 27YO (1975 @ 54.7%) was released as a Rare Malt in 2003.

BOWMORE



Bowmore is the oldest distillery on Islay, and one of the oldest in Scotland. The usual date ascribed to its foundation is 1779, but the distillery may have been established a decade before this, when the model village of Bowmore was built by Daniel Campbell of Shawfield. During World War II Bowmore was requisitioned by the Air Ministry to support Coastal Command's efforts to protect Atlantic convoys. In 1963, the Glasgow whisky broker, Stanley P. Morrison, bought the distillery for £117,000 and began modernising and expanding the site. Suntory bought a 35% stake in the company in 1989 and whole ownership in 1994. Bowmore whiskies are highly collectable.

Style: Smoky and floral.

Mature character: In a blind tasting, my identifier for Bowmore is 'lavender'. The character varies a lot, depending on cask selection (which varies from expression to expression). Behind the lavender/air-freshener note, it is sweet, rich, fruity (a combination of exotic fruits like mango, passionfruit and dried fruits), malty and scented – smoky on the nose. A good texture; sweet taste with a belt of smoke (especially in the younger expressions), and still this lingering perfume. Medium-bodied.

Comparable to: Springbank, Highland Park

Raw Materials: Soft peaty water from River Laggan, seven miles from the distillery, for process and cooling. Three malting floors produce 30% of the malt requirement; the remainder comes from Simpson's of Berwick, peated to 25ppm

phenols. 100% Scottish malt.

Maturation: Mix of firstfill American barrels and hogsheads, firstfill sherry butts and puncheons. Each expression has its own mix of cask-types. A three-floor dunnage warehouse on site, incorporating the ancient Bowmore Vaults on its ground floor, lies partly below sea level, and two warehouses (one dunnage, one racked) are on the Low Road outside Bowmore village. 27,000 casks in total.

Expressions: Bowmore's range is among the largest on the market. Limited expressions that have been released recently are:

- Bowmore 1989 16YO @ 53.8% (bourbon cask, released 2005)
- Bowmore 1968 37YO @ 43.4% (released 2006)
- Bowmore 1990 16YO @ 53.8% (sherrywood, released 2006)
- Bowmore 1991 16YO @ 53.1% (portwood, released 2007)

The core range comprises:

- Bowmore Legend @ 40%
- Bowmore Tempest 10YO @ 56%
- Bowmore 12YO @ 40%
- Bowmore Darkest 15YO @ 43%
- Bowmore 17YO @ 43%
- Bowmore 18YO @ 43%

Core range duty-free comprises:

- Bowmore Surf @ 40%
- Bowmore Enigma @ 40%
- Bowmore Mariner @ 43%
- Bowmore Cask Strength @ 56%

BRAEVAL



Braeval is the highest distillery in Scotland. Originally named Braes of Glenlivet, it was built by Seagram's in 1973 to produce fillings for the Chivas blends. At one time, 36 distilleries attached the suffix 'Glenlivet' – for example, Macallan-Glenlivet, Aberlour-Glenlivet – although there are only three distilleries in the glen of that name: The Glenlivet itself, Tamnavulin and Braeval. Like its sister, Allt-a-Bhainne, it is attractively laid out – uncompromisingly modern, but with traditional elements such as a pagoda roof. It is highly automated and can be run by one person.

Style: Sweet and grassy.

Mature character: Most of the independent bottlings of Braeval have come from exsherry butts, which cover the distillery character. The nose is sweet, with fruit cake, chocolate and sherry; the taste rich and full, with spicy notes. Bottlings from exbourbon refills, which retain the distillery character, are lighter and drier, with Speyside character and a sweet, fresh-fruity flavour. Medium-bodied.

Comparable to: Allt a'Bhainne, Glenlossie

Raw materials: Unpeated malt from independent maltsters. Water from the Preenie and Kate's Well Burns and the burn at Ladderfoot (once popular with smugglers).

Maturation: Mainly refill U.S. hogsheads, all at Mulben, near Keith.

Expressions: Never bottled by its owner.

BRUICHLADDICH



Bruichladdich (pronounced Brewickladdie) has enjoyed a renaissance since 2000, when it was bought by a private concern led by Mark Reynier, a London wine merchant. Bruichladdich was purpose-built from scratch in 1881 by the Harvey brothers (owners of Dundashill and Yoker distilleries in Glasgow) using the then new material, concrete, to bind beach pebbles. It is one of only three distilleries to bottle on site, and is a quirky and proudly independent operation. Invergordon took ownership in 1968.

Style: Malty, with peaty variations.

Mature character: ‘Traditional’ (i.e. unpeated) Bruichladdich is fresh, grassy and malty on the nose, with fragments of wild flower notes. The taste is sweet to start, with cereal and citric notes; dry and short in the finish. Lightbodied.

Comparable to: Jura, Bunnahabhain

Raw materials: Bruichladdich reservoir for process water (soft and acidic/peaty), Bruichladdich burn for the cooling water and James Brown’s spring (clear water) at Octomore for reduction water. Floor maltings closed 1961; then malt from Port Ellen; now malt from mainland maltings.

Maturation: 25% in firstfill and refill exsherry hogsheads, 65% in firstfill bourbon barrels, and other types of casks (rum and wine). Eight bonded warehouses on site and another four at Port Charlotte. Most are dunnage, with two racked; 35,000 casks in total. Bottling Hall named after the Harvey brothers,

opened May 2003. Cooperage opened May 2004.

Expressions: Until the current owners took over, Bruichladdich was bottled at 10YO; since then a bewildering number of limited edition bottlings (over 200!) have been released. A small amount of make is set aside each year for sale by the cask.

The current core range is:

- Bruichladdich Laddie Classic 01 @ 46%
- Bruichladdich Sherry Classic @ 46%
- Bruichladdich 12YO @ 46%
- Bruichladdich 15YO @ 46%
- Bruichladdich 18YO @ 46%
- Bruichladdich 20YO @ 46%
- Bruichladdich Rocks @ 46% (multi-vintage, lightly peated c. 3ppm phenols)
- Bruichladdich Waves @ 46% (multi-vintage, medium peated c. 15ppm phenols)
- Bruichladdich Peat @ 46% (multi-vintage, heavily peated c. 35ppm phenols)
- Bruichladdich Valinch Series (bottled by hand, only available at the distillery; single casks, at cask strength, from 1970, 1983, 1986, 1988, 1990)
- Bruichladdich Legacy Series @ CS (32, 33, 34, 35, 36 and 37YO)
- Bruichladdich Links Series @ 46% (a range of bottlings featuring Scottish golf courses, launched 2003)
- Bruichladdich Organic Edition 2.10 @ 46% (from Mid Coul Farm)
- Bruichladdich Organic 2003 @ 46% (Anns an t-Seann Doigh)
- Bruichladdich 7YO Resurrection @ 46% (the first make from the revived distillery, introduced 2008)
- Port Charlotte PC5 @ 63.5% (heavily peated, distilled 2001, bottled 2006)
- Port Charlotte PC6 @ 61.6% (heavily peated, distilled 2001, bottled 2007)

BUNNAHABHAIN



Bunnahabhain is Islay's most remote and northerly distillery. Over 250 ships have foundered off the coast of Islay, four of them within sight of Bunnahabhain. William Robertson of Robertson & Baxter, whisky blenders and brokers in Glasgow, founded Bunnahabhain Distillery in 1881, in partnership with the Greenlees Brothers from Campbeltown, and with the name Islay Distillers Company Ltd. The spirit first flowed in January 1883. Although its capacity was reported to be 3.4 million litres per annum in 1987, it was closed from 1982 to 2004, and production was down to 750,000 litres by 2002. Somewhat surprisingly, the distillery was sold by the Edrington Group to Burn Stewart Distillers in April 2003 for £10 million.

Style: Sweet and fruity, with a smoky batch each year, at 35–40ppm phenols (trialled in 1997; resumed 2003).

Mature character: 'Traditional' Bunnahabhain (i.e. unpeated) is sweet, lightly fruity and faintly maritime on the nose, sometimes with a whiff of peat smoke. The mouth feel is smooth, the taste mild, lightly sweet, then drying, with a hint of smoke. Light-to mediumbodied.

Comparable to: Jura, Bruichladdich

Raw materials: Very slightly peated and unusually hard process water from a spring in the Margadale Hills, piped from source so as to keep peat content down. Cooling water from Loch Staoinsha. 10% of malt from Port Ellen Maltings, the rest from Simpson's of Berwick. A portion peated to around

38ppm phenols; the majority unpeated.

Maturation: Mainly refill exbourbon hogsheads, with a percentage of 10% first- and second-fill sherry casks. Six dunnage and one racked warehouses on site; approximately 21,000 casks in total. All matured on site.

Expressions: First released by its owners in the late 1970s @ 12YO. Core range:

- Bunnahabhain 12YO @ 40% and 46.3%
- Bunnahabhain 18YO @ 43% and 46.3%
- Bunnahabhain 25YO @ 43% and 46.3%

CAMERONBRIDGE



Cameronbridge is the oldest grain whisky distillery, and the largest. It was also the first distillery in Scotland to produce grain whisky in column stills – prior to this many Lowland distilleries made grain spirit in pot stills. It was founded in 1824 by John Haig, a scion of the great Haig distilling dynasty. In 1989 the distillation of Gordon's, Booth's and Tanqueray London Dry Gins was transferred to Cameronbridge from Wandsworth. Today, around 70% of U.K. gin is made in Scotland, mainly at Cameronbridge.

Style: Light and clean, but fruity and flavourful.

Comparable to: Invergordon, Girvan

Raw materials: Wheat from the East Coast of Scotland; Wanderhaufen malting system on site until 1997, now dried malt from Burghead. Process water from bore-holes on site.

Maturation: Mainly firstfill and refill exbourbon casks; at Leven, nearby, and Blackgrange, Alloa, in racked warehouses.

Expressions: Choice Old Cameron Brig is one of only two proprietary bottled single grain whiskies available in the U.K., and one of only three available in the world.

CAOL ILA



The distillery takes its name (pronounced ‘Cull-eela’) from the strait between the islands of Islay and Jura, the Sound of Islay, and enjoys stunning views. The first distillery on this site – a small bay just north of the ferry point at Port Askaig – was built in 1846 by Hector Henderson who took advantage of copious water from Loch nam Ban. In 1972 the original distillery was demolished (apart from the large, three-storey warehouse, which is still in use) and replaced by a larger and more efficient building. The current Manager, Billy Stichell, is the fourth generation of his family to have worked there.

Style: Peaty, but with a lighter body than its sister Lagavulin.

Mature character: Sweet and lightly fruity on the nose, with smoked ham or smoked cheese, and some seaweed. The taste is sweet, with fragrant smoke and antiseptic cream. Medium length.

Comparable to: Lagavulin, Laphroaig

Raw materials: Heavily peated malt (30–35ppm phenols) from Port Ellen Maltings, and, for around four months of the year, unpeated malt from Port Ellen. Water from Loch nam Ban.

Maturation: Refill exbourbon hogsheads. Mainly matured in the Central Belt, some on site in the original warehouse.

Expressions: Caol Ila has always been a blending whisky, and continues to be

such, although since 1989, when a 15YO expression was released in the Flora & Fauna series, it has been bottled by its owner. Later it was bottled four times in the Rare Malts series: 1975 @ 20YO, 1975 @ 21YO, 1977 @ 20YO and 1977 @ 21YO.

Current proprietary bottlings:

- Caol Ila 12YO @ 43% (released in 2002)
- Caol Ila 18YO @ 43% (released in 2002)
- Caol Ila Cask Strength (NAS, but about 10YO, released in 2002)
- Caol Ila Distillers Edition 1993 @43% (finished in ex-Moscatel casks, introduced 2006)
- Caol Ila 1978 25YO @ 59.4% (Special Release 2004)
- Caol Ila 1979 25YO @ 58.4% (Special Release 2005)
- Caol Ila Unpeated; at 8–10YO @ cask strength (annual Special Release since 2006)
- Caol Ila Moch NAS @ 43% ('Moch' is 'Dawn' in Gaelic; limited to Friends of the Classic Malts, Spring 2011)

CARDHU



Like many others, Cardhu (the spelling was for many years Anglicised to Cardow, pronounced ‘Cardoo’) was a farm with a still. John Cumming, the son of a hill-farmer and grazier, became tenant here in 1811, and soon turned his hand to illicit whisky-making. He took out a licence in 1824; much of his make was taken by horse and cart to Burghead and shipped to Leith. In 1884 his daughter-in-law Elizabeth rebuilt the distillery. By 1888 her whisky was being sold as a single malt in London, proudly claiming to be the only whisky from Speyside that did not need to affix the name Glenlivet to its own. Cardhu stands among the top six bestselling malts in the world, and is so popular in Spain that there is not enough to supply demand.

Style: Floral.

Mature character: Fragrant and floral (Parma Violets, dried rose petals), and Speyside-fruity (pear drops, fresh apples) on the nose. Sweet and fresh to taste. Lightbodied.

Comparable to: Glenlossie, Glenburgie

Raw materials: Unpeated malt from Burghead Maltings. Soft water from springs on Mannoch Hill and from the Lynne Burn, both collected in a dam near the distillery.

Maturation: Refill exbourbon hogsheads.

Expressions:

- Cardhu 12YO @ 40% (relaunched 2005)
- Cardhu 1973 25YO @ 60.5% (Rare Malts series, released 1998)
- Cardhu 1973 27YO @ 60.02% (Rare Malts series, released 2000)
- Cardhu 22YO @ 57.8% (Special Release, 2005)
- Cardhu Special Cask Reserve @ 40% (released 2006)

CLYNELISH



The present-day Clynelish Distillery was built in 1967/68, close to the original Clynelish Distillery, which was renamed Brora, as part of D.C.L.'s expansion policy at that time. Architecturally, it bears a resemblance to Caol Ila, Mannochmore and Craigellachie – all of which were rebuilt at around the same time, in the so-called 'Waterloo Street' style. It is the third largest distillery in Diageo's estate.

Style: Waxy, with heather notes.

Mature character: An outstanding example of the 'Highland' style, Clynelish is scented with heather flowers and moorland herbs, candlewax and fragrant smoke. The texture in the mouth is waxy, teeth-coating; the taste creamy, lightly fruity and spicy, with tobacco notes. Medium-bodied. Complex.

Comparable to: Dalwhinnie, Glen Ord

Raw materials: Unpeated malt from Glen Ord. Soft water from the Clynemilton Burn.

Maturation: Mainly exbourbon refill casks, with some exsherry. Two dunnage warehouses on site (7,000 casks). Most matured in the Central Belt.

Expressions: Clynelish is highly prized by blenders, and forms a key component in the Johnnie Walker blends. As a result it has been uncommon as a single until recently: now it has been included in Diageo's extended Classic Malts series.

- Clynelish 14YO @ 43% (Flora & Fauna series, since 1991)
- Clynelish 14YO @ 43% (Hidden Malts series, released 2002)
- Clynelish 1972 22YO @ 58.95% (Rare Malts series)
- Clynelish 1972 24YO @ 61.3% (Rare Malts series)
- Clynelish 1972 23YO @ 57% (Rare Malts series)
- Clynelish 1974 23YO @ 59.1% (Rare Malts series)
- Clynelish 14YO @ 46% (extended Classic Malts of Scotland series, from 2006)

CRAGGANMORE



A distillery at Ballindalloch, deep in Speyside, was only made possible by the opening of the Strathspey railway in 1863. Its founder, John Smith, was acknowledged to be one of the most experienced distillers of his day, having formerly managed Macallan, Glenlivet, Glenfarclas and Wishaw Distilleries; he was also a keen railway enthusiast and a moving force behind the building of the Speyside line. The site he chose for his distillery was on Ballindalloch Estate. In 1965 S.M.D. took ownership.

Style: Big, rich and meaty.

Mature character: A multi-layered nose of polished leather and saddle-soap, green bananas, tobacco, nuts, dried fruits and herbs. The taste is dryish overall, with walnuts, hard toffee and dried fruits. Medium-bodied.

Comparable to: Benrinnes, Balvenie

Raw materials: Lightly peated malt from Roseisle. Hard process water from a spring on Craggan More Hill via the Craggan Burn; cooling water from the River Spey.

Maturation: A mix of refill exbourbon and exsherry casks.

Expressions:

- Cragganmore 12YO @ 40% (Classic Malts series, from 1987/88)
- Cragganmore Distillers Edition @ 40% (port cask finish)
- Cragganmore 1973 29YO @ 52.5% (Special Release, 2004)
- Cragganmore 1993 10YO @ 60.1% (Special Release, 2005)
- Cragganmore 1988 17YO @ 55.5% (Special Release, 2006)
- Cragganmore 1989 21YO @ CS (Special Release, 2011)

CRAIGELLACHIE



The original distillery was designed by Charles Doig and built in 1891 for a consortium of blenders and merchants. The distillery was lit by paraffin lamps until 1948, and a water wheel was used to drive the wash still rummager until 1964, when the distillery was completely rebuilt. In 1998 owner U.D.V. was obliged to sell Craigellachie, with three other distilleries, to Bacardi along with the Dewar's brands. Further expressions of Craigellachie are planned.

Style: A big-bodied and very slightly smoky Speyside style.

Mature character: Craigellachie is unusual as a Speyside in adding a thread of smoke to the familiar floral-fruity characteristic of the region. Sweet and creamy in the mouth, with citric notes, light acidity and a trace of smoke in the finish. Fullbodied.

Comparable to: Aberfeldy, Dalwhinnie

Raw materials: Floor maltings until 1964; thereafter lightly peated malt from Burghead. Soft process water from springs on Little Conval Hill; cooling water from the River Fiddich.

Maturation: Mainly refill exbourbon hogsheads, some exsherry butts; matured in the Central Belt.

Expressions:

- Craigellachie 14YO @ 43% (Flora & Fauna series)
- Craigellachie 1973 22YO @ 60.2% (Rare Malts series)
- Craigellachie 14YO @ 40% (introduced 2004 by John Dewar & Sons)

DAILUAINÉ



The distillery was built in 1851 by William Mackenzie, in a small wooded glen a mile off the main road, at the other (northern) end of Ballindalloch Estate from Cragganmore. Access to market was given a terrific boost 12 years later by the arrival of the Speyside Railway on the opposite bank of the river, at Carron, connected by a road bridge. The distillery was rebuilt in 1884 and was then one of the largest Highland distilleries. A major reconstruction took place in 1959/60, when the number of stills increased from four to six and mechanical coal-stoking was introduced. Always designed to be a blending whisky, Daluaine was not bottled as a single by its owners until 1991.

Style: Fullbodied, rich and meaty.

Mature character: The style of the new-make spirit makes it eminently suitable for sherrywood maturation, and these flavours emerge in the mature whisky. The nose is redolent of dried fruits and fruit cake, moist with sherry. A hint of rubber immediately after water is added. A thick, unctuous texture in the mouth, with a taste that starts sweet in the mouth and finishes slightly tannic, with dark chocolate. Fullbodied.

Comparable to: Mortlach, Benrinnes

Raw materials: Floor maltings until 1959 then Saladin boxes until 1983; thereafter unpeated malt from Burghead. Soft process water from Balliemullich Burn, flowing down from Ben Rinnes; cooling water from the Green Burn or the River Spey.

Maturation: Mainly refill exbourbon hogsheads, with some exsherry butts; all spirit now tankered for maturation in the Central Belt.

Expressions: The few proprietary bottlings are drawn from exsherry refills.

- Dailuaine 16YO @ 43% (Flora & Fauna series, introduced 1991)
- Dailuaine 22YO 1973 @ 60.92% (Rare Malts series)
- Dailuaine 16YO @ CS (released 1997)

DALMORE



Alexander Matheson, who founded Dalmore in 1839, was a partner in the famous Far East trading company, Jardine Matheson, established by the 'shogun' William Matheson who made a vast fortune out of trading opium from China. Ownership of Dalmore Distillery passed to the United Breweries Group of India in 2007, when that company acquired Whyte & Mackay. Dalmore is reputed to be the first single malt whisky exported to Australia (in 1870). One of a dozen bottles of Dalmore 62YO sold privately in April 2005 for £32,000 – the current world record. The purchaser opened and drank the bottle immediately, with friends.

Style: Heavy, oily and musky (from the smaller stills); lighter and more citric (from the larger still).

Mature character: The overall style of Dalmore new-make is appropriate for sherrywood maturation. The nose is rich and sherried, with sweet malt, fruit cake, orange peel and marzipan. Medium to full-bodied, the texture is mouthfilling and the taste sweet rather than dry. Long finish.

Comparable to: Blair Athol, Glendronach

Raw materials: Floor maltings until 1956, then converted to Saladin boxes until 1982. Now unpeated malt from Bairds, Inverness. Process water from Loch Kildermorie, on the slopes of Ben Wyvis; cooling water from River Averon or Alness.

Maturation: Mix of exsherry, exbourbon and refill hogsheads. Matured on site mainly in dunnage warehouses and in Leith.

Expressions: Until the mid-1990s, only the standard bottling at 12Yo was available (although a 20YO was bottled for Eduardo Giaccone in 1978). Since then a large number of limited and aged whiskies have been released.

Core expressions:

- 12, 15, 18, 21 YO @ 40%

Recent special releases include:

- Dalmore Gran Reserva @ 40% (replacing the popular Cigar Malt, introduced 2001)
- Dalmore King Alexander III @ 40% NAS (from a wide range of different wine casks, limited release 2010)
- Dalmore Mackenzie 1992 @ 46% 17YO (port finished, to raise money for Clan Mackenzie, limited release 2010)
- Dalmore Castle Leod 1995 @ 46% (Bordeaux finished, to raise money for Clan Mackenzie, limited release Feb 2011)
- Dalmore Rivers Collection (Dee, Spey, Tay, Tweed) @ 40% No Age Statement (limited, launched 2011)
- Dalmore Vintage 1995 Age of Exploration @ 45% (travel retail, released January 2011)
- Aurora 45YO @ 45% (200 bottles from an Oloroso cask, launched early 2011)
- Astrum 40YO @ 42% (500 bottles, launched early 2011)
- Candela 50YO @ 45% (77 bottles, launched late 2009)
- Selene 58YO 1951 @ 44% (30 bottles, launched late 2009)
- Eos 59YO 1951 @ 44% (20 bottles, launched 2010)
- Trinitas 64YO 1946 (3 bottles, launched October 2010)

DALWHINNIE



Dalwhinnie is ‘the meeting place’, the place where drove roads from the north and west met those coming out of Strathspey and headed south. It is a remote, wind-blasted site and it is not uncommon for the distillery to be snowbound for weeks. It was originally named Strathspey and was built in 1897 by three men from the neighbouring town of Kingussie. Dalwhinnie single malt became well known when it was selected by U.D. to represent the Highland style in the Classic Malts series.

Style: Fullbodied, sweet, heather-honey.

Mature character: Dalwhinnie is a remarkably viscous malt, with a big mouth feel. The nose is sweet, with heather pollen, even heather honey, and moorland scents. The taste is soft and smooth, starting sweet and drying out with a whiff of peat smoke. Mediumbodied.

Comparable to: Glen Ord, BenRiach

Raw materials: Floor maltings until 1968; now lightly peated malt from Roseisle. Soft water from Lochan an Doire-uaine (2,000 feet) via Allt an t’Sluie Burn.

Maturation: Mainly exbourbon refill casks, matured in the Central Belt.

Expressions:

- Dalwhinnie 15YO @ 43% (Classic Malts series since 1988)
- Dalwhinnie Distillers Edition @ 43% (re-racked into Oloroso sherry casks, introduced 1998)
- Dalwhinnie 36YO 1966 @ 47.2% (Special Release, 2002)
- Dalwhinnie 29YO 1973 @ 57.8% (Special Release, 2003)
- Dalwhinnie 20YO 1986 @ 56.8% (Special Release, 2006)

DEANSTON



Deanston Distillery was created within an historic cotton mill, designed in 1785 by Richard Arkwright (pioneer of steam-powered spinning). It is the classic example of a mill-distillery, of which there are several in Scotland, for the simple reason that both require copious supplies of fast-running pure water. It stands on the edge of the River Teith, near the picturesque Doune Castle, which was used in *Monty Python and the Holy Grail* (1974). The distillery was silent from 1982 to 1990, when it was sold to Burn Stewart Distillers for £2.1 million in cash and brought back into production. Burn Stewart was acquired in 2002 by C.L. World Brands, owners of Angostura Bitters, Hine Cognac and Rhum Rum.

Style: Waxy, light, fruity.

Mature character: Lightly oily on the nose, with cereal notes. The taste is malty and fruity and lightly nutty, starting sweetish and finishing dryish. Light-to mediumbodied.

Comparable to: Glen Ord, Ardmore

Raw materials: Unpeated malt from independent maltsters. Soft water from the River Teith.

Maturation: 40,000 casks on site in a former weaving shed known as Adelphi Mill; remainder at Airdrie.

Expressions: Around 15% of Deanston make is bottled as single malt, the rest

goes into Burn Stewart's blends, particularly Black Prince and Scottish Leader.
Current bottlings:

- Deanston 12YO @ 40% and 46.3%
- Deanston 17YO @ 40%
- Deanston 30YO @ 40% (released 2006)
- Deanston 35YO @ 50.7% (limited edition, released 2003)

DUFFTOWN



The distillery was converted from a meal mill in 1895/96. It is located just outside Dufftown in the Dullan Glen, and the site was chosen by Peter Mackenzie and Richard Stackpole, of P. Mackenzie & Company, wine and spirits brokers in Liverpool. Dufftown now falls within Diageo's estate and is their largest malt whisky distillery, with a capacity of 4.5 million litres of pure alcohol a year.

Style: Malty, nutty.

Mature character: The nose is Speyside-sweet, fruity and cereal-like (bruised apples, pears), with some butterscotch. The taste is predominantly sweet, with cereal notes and light toffee. Medium-bodied.

Comparable to: Milnong, Glendullan

Raw materials: Floor maltings until 1968, now unpeated malt from Burghead. Soft process water from Jock's Well in the Conval Hills (supplemented by the Convalley Springs), cooling water from the River Dullan.

Maturation: Exbourbon refills, with a small amount in exsherry refills.

Expressions: Some Dufftown was bottled as a single by Bell's. Since Guinness took over:

- Dufftown 15YO @ 43% (Flora & Fauna series, released 1990)
- Dufftown-Glenlivet 20YO @ 55.8% (Centenary Bottling, released 1996)
- Dufftown 21YO 1975 @ 54.8% (Rare Malts series, released 1997)

EDRADOUR



Edradour is a classic farm distillery, was the smallest in Scotland until 2005, and remains among the prettiest. It stands as a reminder of how many distilleries will have looked, and operated, during the nineteenth century. In all likelihood it was established by one Duncan Forbes in 1825 (named Glenforres), but the foundation on the present site was in 1837, when a group of farmers leased a strip of land beside the Edradour Burn from the Duke of Atholl. In July 2002, Edradour was bought for £5.4 million (£3 million of which was maturing stock) by Andrew Symington, owner of Signatory Vintage Malt Whisky Company. Many improvements have been made, on site, including the building of a bottling hall in 2007, and Edradour is one of the most popular distillery destinations in Scotland.

Style: Edradour fruity, pear-like, with a good body. Ballechin peaty.

Mature Character: Clean and fresh, with floral as well as fruity notes – almond blossom and dog roses, with cider apples and citric notes. Good texture, with a sweet start, slightly mouthcooling (minty), drying in the medium-length and lightly spicy finish.

Comparable to: Aberfeldy, Craigellachie

Raw Materials: Unpeated malt from Bairds, Edinburgh; peated malt from Inverness. Pre-1975 the malt was ground on site by mill-stones; between 2002 and 2007 it arrived ready milled. Soft process water from a spring on Moulin Moor, cooling water from Edradour Burn.

Maturation: Edradour is matured in a combination of refill U.S. oak hogsheads and European oak butts; around a dozen different kinds of first fill wine casks are also used, either for maturing or finishing. Ballechin is primarily matured in firstfill exbourbon barrels, with some first fill sherry and refill sherry. In both makes, no cask is used more than twice.

Expressions: The new owner has greatly increased the product range, including many wood finishes and limited editions. A smoky range (over 50ppm phenols), named Ballechin (after a local distillery which closed in 1927), was first released in 2006.

- Edradour 10YO @ 40% and unchill filtered.
- Edradour Straight From The Cask Range – Cask strength bottled by hand – (Typically 10–12 years old in 50cl bottles). Single sherry casks or wine finishes which have spent between 6 and 24 months in finishing cask. Wood finishes include Madeira, Sauternes, Chardonnay, Sassicaia, Burgundy, Bordeaux, Châteaneuf du Pape, Marsala, Barolo, Moscatel, Pedro Ximenez and Port wood)
- Edradour 10YO @ 46% (non-chill filtered, first released in 2002)
- Edradour Natural Cask Strength (12–14YO single sherry casks at cask strength)
- Edradour Caledonian Selection 12YO 1997 @ 46% (Oloroso finish)
- Edradour 2003 Port Cask @ 46% (matured in portwood throughout)
- Edradour 2003 Burgundy Cask @ 46% (matured in ex-Pinot Noir casks throughout) Ballechin Discovery series are limited releases from the various casks used to mature the peated version of the Edradour, each limited to 6,000 bottles:
 - Ballechin #1 @ 46% (from ex-Burgundy barrels, released 2006)
 - Ballechin #2 @ 46% (from Madeira casks, released 2007)
 - Ballechin #3 @ 46% (from Port casks, released 2008)
 - Ballechin #4 @ 46% (from Oloroso Sherry casks, released 2009)
 - Ballechin #5 @ 46% (from Marsala casks, 2010)

FETTERCAIRN



Fettercairn is in the heart of the fertile Mearns district, celebrated by the writer Lewis Grassic Gibbon (*Sunset Song* etc.). The distillery was established by the laird of Fasque, Sir Alexander Ramsay, in 1824. It is owned by the Indian brewer and distiller, U.B. Group. Some single cask bottlings on site are for sale exclusively through the visitor centre.

Style: Butterscotch, walnuts and spice.

Mature character: The nose is sweet and malty, with traces of damp wool and mixed nuts. The taste is sweetish to start, drying with nuts, biscuits and a whiff of smoke. Slightly oily.

Comparable to: Ardmore, Deanston

Raw materials: Floor maltings until 1960; now unpeated malt from independent maltsters, and, since 2005, heavily peated (55ppm phenols) for a couple of weeks a year for blending purposes. Process water from springs in the Grampian Hills which rise behind the town; cooling water from the Caulecotts Burn.

Maturation: Mix of exsherry, exbourbon and refill hogsheads. Matured mainly at Invergordon; some in dunnage warehouses on site, where there is capacity for 30,000 casks.

Expressions: In spite of the distillery's size, until recently Fettercairn has never been common, even in independent bottlings. Current proprietary bottlings

include:

- Fettercairn Fior NAS @ 42% (introduced 2010)
- Fettercairn 24YO 1984 @ 44.4% (limited, released 2010)
- Fettercairn 30YO 1978 @ 43.3%% (limited, released 2010)
- Fettercairn 40YO 1969 @ 40% (limited, released 2010)

GIRVAN



William Grant & Sons, owners of Glenfiddich and Balvenie Distilleries, and of the successful blend *Standfast*, built Girvan in 1963/64. Key reasons for choosing the small Ayrshire port of Girvan were the water supply, the availability of labour and access to both the sea and Lowland blending houses. It has an austere appearance, influenced by the Bauhaus design movement. Within a year Grant's had added a malt whisky distillery to the site, named Ladyburn (closed 1975). The dark-grains plant has the largest filter presses in the world.

Style: Clean, estery, sweet.

Comparable to: Caneronbridge, Invergordon

Raw materials: The cereal base is home-grown wheat and malted barley. Water from Penwhapple Loch.

Maturation: On site.

Expressions:

- Black Barrel Single Grain Whisky @ 40% (duty-free and export only)
- Girvan 1964 @ 48% (limited to 1,200 bottles, released 2000)

GLENALLACHIE



The ‘Glen of the Rocky Place’ (*Gleann Aleachaidh*) runs up behind Aberlour towards Edinville. It is not very rocky, although the mass of Ben Rinnes rises close beside the distillery, which draws its production water from springs on the mountainside. It was commissioned by Mackinlay-Macpherson (then a subsidiary of Scottish & Newcastle Breweries) in 1967, primarily to contribute Speyside fillings to the Mackinlay blend, which at that time was among the top five bestsellers in the U.K., and designed by William Delmé-Evans. After periods of mothballing and closure in recent decades it is now back in production under Chivas Brothers.

Style: Sweet, grassy and estery.

Mature character: Speyside sweetness, with fruity-floral notes. Some detect a whiff of smoke. Light and fresh. Similar to taste, starting very sweet, with vanilla and apples; clean and smooth, with a scented finish. Lightbodied.

Comparable to: Glenlossie, Braeval

Raw materials: Unpeated malt from independent maltsters. Water from springs on Ben Rinnes via two dammed streams flowing into the Lour Burn. Cooling water is collected in an attractive pond by the distillery.

Maturation: Mainly refill U.S. hogsheads, some firstfill. Twelve racked and two palletised warehouses on site, the rest matured at other Chivas sites.

Expressions: A small amount of Glenallachie was bottled as a single in 1982, for export.

- Glenallachie 1989 16YO @ 56.7% (from exsherry-wood, released 2005)

GLENBURGIE



Glenburgie bore the name Kilnflat, a place in the parish of Alves, between Elgin and Forres, until the 1870s. It was built in 1829 by William Paul, the son of a distinguished surgeon, who had formerly been involved in Grange Distillery (somewhere nearby and founded 1810, hence the foundation date adopted by Glenburgie). The giant Canadian distiller, Hiram Walker, bought 60% of the business in 1930 – Walker's first move into Scotch – and took full control in 1936, when they also bought Milnford Distillery. Glenburgie Distillery was demolished in 2004 and rebuilt on an adjacent site at a cost of £4.3 million. The new owners immediately installed an extra pair of stills and the distillery came into production in June 2005. The original distillery building of 1829 still stands, tastefully refurbished as a nosing room.

Style: Sweet, grassy and estery.

Mature character: The 15YO is light and grassy, with sweet vanilla sponge notes. The taste is sweet, with hints of vanilla, toffee and tinned pears, and a trace of smoke. Lightbodied.

Comparable to: Glenlossie, Glenfiddich

Raw materials: Unpeated malt from independent maltsters; own floor maltings removed 1958. Production water from springs on Burgie Hill; cooling water from a burn.

Maturation: Mainly refill U.S. hogsheads, some firstfill. Dunnage, racked and

palletised warehouses on site with capacity for 60,000 casks. The remainder matured at Mulben.

Expressions: Only bottled once by its owner (Allied) at 15 years old, in 2002. Not currently bottled by its owner as a single.

GLENCADAM



Situated about a mile outside the ancient Royal Burgh of Brechin, Glencadam (the name means ‘the glen of the wild goose’) was founded in 1825 by Messrs Thomas & Ruxton. Glencadam became the heart malt for Stewart’s Cream of the Barley. The distillery was mothballed by Allied in 2000, then purchased by Angus Dundee Ltd, a family firm of blenders, based in London, in 2003.

Style: Soft, light, boiled sweets, pear drops.

Mature character: The 15YO has a pleasant ‘peaches and cream’ nose, with almonds and vanilla. The taste is sweet and creamy, with nuts and a trace of malt. Some detect asparagus and aniseed. Mediumbodied.

Comparable to: Glenburgie, Allt a’ Bhainne

Raw materials: Unpeated malt from independent maltsters. Soft cooling and process water from Moorans water supply (a tributary of the North Esk), which used to supply the Royal Burgh of Brechin.

Maturation: All exbourbon barrels. 20,000 casks on site.

Expressions: A few independent bottlings only, until Angus Dundee took over.

- Glencadam 15YO @ 40% (released 2005; replaced at 46% in 2010)
- Glencadam 10YO @ 46% (released 2010, unchillfiltered natural colour)

- Glencadam 12YO Portwood Finish @ 46% (released 2010)
- Glencadam 14YO Oloroso Sherry Finish @ 46% (released 2010)
- Glencadam 21YO @ 46% (released 2010)

GLENDRONACH



Glendronach is one of the most charming and old-fashioned distilleries in Scotland. It was built in 1825 by a group of local farmers and businessmen, led by James Allardice, who so impressed the local laird, the Duke of Gordon, that he was introduced by the Duke to London society, among whom he established something of a reputation for his 'Guid Glendronach'. The make was a key filling for the Teacher's blends. On 25 July 2008, it was announced that the distillery had been sold to Billy Walker of BenRiach Distillers.

Style: Rich, sweet, creamy.

Mature character: Richly sherried in style, but also showing the contribution (sweetness, vanilla, trace of coconut) of American oak. The taste is both sweet (with dried fruits, malt and toffee) and tannic-dry. Full-to medium-bodied.

Comparable to: Cragganmore, Royal Lochnagar

Raw materials: Production water from Dronac Burn, which flows through the distillery. Lightly peated malt from independent maltsters; own floor maltings, but not used since 1996.

Maturation: Combination of exsherry and exbourbon casks.

Expressions: In 1991 Allied took the novel step of offering two versions of Glendronach 12YO : Traditional (from exsherry casks) and Original (from a mix of exsherry and exbourbon casks). These were included in their Caledonian

Malts series. Current proprietor's bottlings:

- Glendronach 12YO Original @ 43% (two kinds of cask maturation)
- Glendronach 15YO Revival @ 43% (Oloroso cask maturation)
- Glendronach 18YO Allardice @ 43% (Oloroso cask maturation)
- Glendronach 31YO Grandeur @ 45.8% (Oloroso puncheon, released 2010, limited)
- Glendronach 33YO @ 40% (Oloroso cask matured, released 2004, limited)
- Glendronach 31YO Grandeur @ 51.2% (Oloroso puncheon, released 2010, limited)
- Glendronach vintages from 1971, 1972, 1978, 1989, 1990, 1991, 1993, 1996 @ CS (all released 2010)
- Glendronach 14YO Virgin Oak Finish @ 46% (released 2010)
- Glendronach 14YO Sauternes Finish @ 46% (released 2010)
- Glendronach 15YO Moscatel Finish @ 46% (released 2010)
- Glendronach 20YO Port Finish @ 46% (released 2010)
- Glendronach 15YO Tawny Port Finish @ 46% (released 2011)

GLENDULLAN



Now Diageo's second largest distillery, Glendullan was founded in 1897 by William Williams & Sons, blenders in Aberdeen, in a wooded glen beside the River Fiddich. Water from the river drove all the machinery in the distillery, via a huge water wheel. It also shared a private railway siding with its neighbour, Mortlach. All supplies came by rail until 1968, when the branch line was closed. The distillery was very well-built, and most of the original plant was still being used in the 1930s. It was the seventh distillery built in Dufftown and gave rise to the rhyme: 'Rome was built on seven hills, but Dufftown stands on seven stills'.

Style: Floral/grassy.

Mature character: Typical light/medium-style Speyside. The nose is sweet and estery, with apples and pears and cut grass; the taste is sweet throughout with a smooth texture and light mouth feel. Medium to light bodied.

Comparable to: Glenlossie, Cardhu

Raw materials: Floor maltings until 1962, now unpeated malt from Burghead. Soft process water from springs in the Conval Hills; cooling water from the River Fiddich. Previously, Fiddich water was used for mashing as well – one of the reasons for choosing the site was its proximity to the river.

Maturation: Exbourbon refill hogsheads, some European oak (for The Singleton). Matured in the Central Belt.

Expressions:

- Glendullan 12YO @ 43% (Flora & Fauna series, since 1992)
- Glendullan 22YO 1972 @ 62.6% (Rare Malts series, released 1995)
- Glendullan 23YO 1972 @ 62.4% (Rare Malts series, released 1996)
- Glendullan 23YO 1973 @ 58.6% (Rare Malts series, released 1997)
- Glendullan 16YO 1982 @ 62.6% (Centenary Bottling, released 1998)
- Glendullan 23YO 1974 @ 63.1% (Rare Malts series, released 1999)
- Glendullan 26YO 1978 @ 56.6% (Rare Malts series, released 2005)
- The Singleton of Glendullan 12YO @ 40% (North America only, introduced 2007)

GLEN ELGIN



Charles Doig, the famous distillery architect who designed Glen Elgin, prophesised that it would be the last distillery to be built on Speyside for 50 years. He was spot on: the next was Glen Keith, which opened in 1958. Glen Elgin was founded by a former Manager at Glenfarclas, William Simpson, in partnership with a banker, James Carle. Until the 1950s the distillery was entirely operated and lit by paraffin; all machinery was driven by a paraffin engine and water turbine. Like other D.C.L. distilleries, Glen Elgin was extensively refurbished in 1964, and expanded from two stills to six. Glen Elgin is ranked Top Class by blenders, and it has been described as ‘the distillers’ dram of drams’.

Style: Fruity and full-bodied.

Mature character: Glen Elgin is subtle and complex. At first sight it is a typical Speysie – estery, fruity, grassy – but there is interesting depth to these aromas, traces of tangerine, light honey, vanilla, even a hint of cloves. Mediumbodied.

Comparable to: Glenlivet, Linkwood

Raw materials: Floor maltings until 1964, now unpeated malt from Burghead. Soft process water from springs near Millbuie Loch; cooling water from the Glen Burn.

Maturation: Mix of exbourbon and exsherry refill casks.

Expressions: A 12YO was introduced by White Horse Distillers as early as 1977, and the first distillery bottling (Flora & Fauna series) was introduced in the early 1990s. This was withdrawn in 2002 and replaced by the same whisky in the Hidden Malts series. In 2006, Glen Elgin became part of the extended Classic Malts series (12YO @ 43%).

- Glen Elgin 12YO @ 43% (Hidden Malts series, released 2002)
- Glen Elgin 32YO @ 42.3% (Special Edition, released 2003)
- Glen Elgin 16YO @ 58.2% (Special Edition, released 2008)

GLENFARCLAS



The distillery was not actually founded by the Grants of Glenfarclas: the first licence for the site was granted in 1836 to Robert Hay of Rechlerich Farm (there had been an unlicensed enterprise here since 1797), and when he died in 1865 his neighbour John Grant bought the distillery for £512. He leased it to John Smith, who had managed The Glenlivet Distillery, went on to build Cragganmore, and was reckoned one of the best distillers of the day. Glenfarclas has the largest stills on Speyside, and was the first to release a cask strength single malt, in 1968. In 2006 Glenfarclas was named Distiller of the Year in the Icons of Whisky Awards.

Style: Delicate, sweet and fruity – gains weight during maturation.

Mature character: Glenfarclas ages very well, especially in sherrywood. Above 15YO it develops complexity which is not apparent in the younger expressions – combining sherry, fruit cake and orange marmalade with sweet malt, nuts and tannic dryness, in a wholly satisfactory way, and rarely with the sulphury notes often associated with sherrywood.

Comparable to: Cragganmore, Balvenie

Raw materials: Floor maltings until 1972, now lightly peated malt from independent maltsters. Soft process and cooling water from springs above the snow line on Benrinnes.

Maturation: Now mainly Oloroso exsherry casks, used up to three times.

60,000 casks matured on site, with about a third refill bourbon (so-called 'plain' casks).

Expressions: A huge number of expressions have been released by Glenfarclas, particularly since the late 1990s, and the company is very touchy about allowing independents to use the distillery name.

- The core range: 8 and 10YO @ 40%; 15YO @ 46%; 12, 21, 25, 30 and 40YO all @ 43% and Glenfarclas 105 @ 60%.

The company also offers a range of vintages, at natural strength from 1952 to 1994 – 'The Family Casks'. This is being added to annually, and in some cases variations are available, for example, the 1990 expression is available at 46% from Oloroso firstfill, from Fino firstfill and from plain oak firstfill.

GLENFIDDICH



In the autumn of 1886 William Grant, son of a Dufftown tailor and Manager of Mortlach Distillery, bought distilling equipment from Elizabeth Cumming of Cardhu for £120 (including stills and a water mill). With his wife and nine children he set about carting stone from the bed of the River Fiddich and building his distillery on a site on the edge of the town named Glenfiddich, ‘the valley of the deer’. The first whisky ran from its stills on Christmas Day 1887. His family all joined William Grant in the enterprise, and the company is still controlled by his descendents, now the fifth generation. In 1963 the Directors of William Grant & Sons took the unprecedented step of bottling *Glenfiddich Pure Malt* (*Straight Malt* in the U.S.A.) and marketing it in the same way as blended Scotch had always been marketed; at first in England, then overseas. The venture was a huge success, export sales alone rising from 4,000 cases in 1964 to 119,500 cases in 1974. That year the company was granted the Queen’s Award for Export Achievement, the first whisky company to be so honoured. For many years Glenfiddich has been the bestselling single malt in the world, commanding around 18% of the market.

Style: Light Speyside. Floral and fruity.

Mature character: Classic Speyside style – light, fresh, fragrant, fruity. The nose adds cereal notes and a pine-sap dimension, and sometimes I detect a very light scent of coal smoke. The taste is sweet throughout, with

Comparable to: Glen Spey, Glenlossie

Raw materials: Floor maltings until 1958, now unpeated malt from

independents. Soft process water from the Robbie Dubh springs.

Maturation: On site, in a mix of American and European oak (15% European/85% American in Special Reserve).

Expressions: The core range comprises:

- Glenfiddich 12YO @ 40% (NAS prior to 2002)
- Glenfiddich 18YO @ 40% (introduced 1980s)
- Glenfiddich 15YO @ 40% (a mix of 4 wood types, introduced 1998)
- Glenfiddich 15YO Distillery Edition @ 51% (introduced 1990s)
- Glenfiddich 30YO @ 40% (introduced)
- Glenfiddich 40YO @ 45.3% (introduced)
- Glenfiddich 50YO @ 52.6% (introduced)
- Glenfiddich Gran Reserva 21YO @ 43.2% (finished in Jamaican rum casks, introduced 2002, repackaged 2011; travel retail and distillery shop only)
- Glenfiddich 14YO Rich Oak @ 40% (finished 12 weeks in new European oak and 6 weeks in new American oak, introduced 2010)
- Glenfiddich Snow Phoenix NAS (but casks 13–30YO) @ 47.6% (limited, introduced 2010)
- Glenfiddich Age of Discovery 19YO @ 40% (limited, Madeira finish, travel retail and distillery shop; introduced 2011)
- William Grant & Sons also release annual limited edition ‘Vintage Reserves’ (all single casks @ CS), which tend to sell quickly, including 1955 (50YO), six batches @ 40YO, 1965 (35YO), 1973 (33YO), 1973 (31YO), 1972 (31YO) and 1976 (33 and 31YO).

GLENGARIOCH



The Garioch (pronounced ‘Geery’) is the tract of arable land, 150 square miles in size, beginning 18 miles north-west of Aberdeen. It used to be known as ‘the granary of Aberdeenshire’. The market town of Oldmeldrum stands within it, and the current distillery was built here in 1797, possibly on the site of the earlier Meldrum Distillery which dates from before 1785. While Glengarioch has endured periods of closure since 1994 it is currently in production, and the opening of a visitor centre in January 2006 has been a great success. The whiskies were elegantly repackaged in 2009.

Style: Mediumbodied, slightly fruity/estery.

Mature character: Medium-rich in style, beefed up by the use of sherrywood. A curious lavender note on the nose, alongside sherry and malt, and a distinct whiff of smoke. Sometimes also ginger snaps. The taste combines toffee-sweetness with some tannic dryness and again a hint of smoke in the finish.

Comparable to: Balblair, Edradour

Raw materials: Floor maltings until 1993, supplying half the distillery’s requirement; now unpeated malt from Simpson’s of Berwick-upon-Tweed. Soft process water from Coutens Spring; cooling water from here and Meldrum Burn.

Maturation: Bourbon and sherry casks. Four dunnage warehouses on site, with a capacity of 12,000 casks.

Expressions:

- Glengarioch Founder's Reserve NAS @ 48% (unchillfiltered, introduced 2009)
- Glengarioch 12YO @ 48% (unchillfiltered, introduced 2010)
- Glengarioch 1978 30YO @ 57.8% (limited, introduced 2010)
- Glengarioch 1990 @ 54.6% (unchillfiltered, introduced 2009)
- Glengarioch 1991 @ 54.7% (limited, introduced 2010)
- Glengarioch 1994 @ 53.9% (limited, introduced 2011)

GLENGLASSAUGH



Glenglassaugh was built on the outskirts of the ancient burgh and harbour of Portsoy, on the Banffshire coast, in 1874 by an enterprising local businessman, James Moir, in partnership with two of his nephews and Thomas Wilson, coppersmith. Their intention was to sell most of their make as 'self' or single malt whisky, and they found a ready market for the surplus in Robertson & Baxter, brokers and blenders in Glasgow. Demand for Glenglassaugh dwindled after 1898; the distillery was silent from 1907 to 1960, when it was refurbished. It closed again in 1986, and, apart from a short period in production in 1998, it has remained silent. A restored distillery was opened in 2008.

Style: Fruity, sweet, with traces of smoke, and spice, and an unusually dry and salty finish

Mature character: Sweet, with orange juice and pears, light oil and sea salt. The taste sweet and salty. I have sometimes noted 'dried shellfish' in Glenglassaugh.

Comparable to: Oban, Glen Deveron

Raw materials: Medium-hard water from two deep wells in the vicinity of the Glassaugh Burn, which previously was softened on site prior to mashing. This softening process will not be used in future. Previously, malt supplied unpeated from Tamdhu malting; future supplies will be from commercial maltsters.

Maturation: Previously in a variety of exbourbon barrels, exsherry butts and

refill hogsheads, matured on a variety of sites.

Expressions:

- Glenglassaugh 26YO 1983 @ 46% (limited released 2010, to replace 21YO)
- Glenglassaugh 36YO 1972 @ 43% (released 2010, to replace 30YO)
- Glenglassaugh 41YO 1967 @ 44.6% (released 2010, to replace 40YO)
- The Spirit Drink That Dare Not Speak Its Name @ 50% (50cl, new make)
- The Spirit Drink That Blushes to Speak Its Name @ 50% (50cl, 6 months in American wine cask)
- The Spirit Drink Fledgling XB @ 50% (20cl, 1YO from exbourbon cask)
- The Peated Spirit Drink @ 50% (20cl, peated malt)
- Clearik @ 50% (20cl, new make)

GLENGOYNE



Glengoyne straddles the Highland Line (until the 1970s it was classified as a Lowland malt), with its warehouses below, and the distillery itself above. The name derives from 'Glen Guin', 'the glen of the wild geese'. The land hereabouts is owned by the Edmonstones of Duntreath, and it was a representative of this family who obtained a licence to distill in 1833, under the name 'Burnfoot'. The pretty site is indeed at the foot of the fast flowing Blairgar Burn, in a steep-sided wooded glen, covered in bluebells in spring. In 2003 Glengoyne Distillery was sold to Ian Macleod & Company, whisky blenders, of Broxburn.

Style: Light fruity, hint of vegetables and nuts.

Mature character: Glengoyne gains weight with age. The core bottlings are a mix of exsherry and exbourbon casks. The nose is malty with sherry notes and a bruised-pear fruitiness. The taste is well-balanced: light sweetness, some acidity, drying in the finish. Mediumbodied.

Comparable to: Balvenie, Glenfarclas

Raw materials: Soft water from Blairgar Burn which runs from the Campsie Hills. Floor maltings until 1910; now malt from Simpson's, Berwick-upon-Tweed.

Maturation: Sherry (around 40%) and refill casks. Matured on site in three dunnage warehouses (6,700 casks), with plans to build a further two racked

warehouses.

Expressions: Shortly before they sold the distillery R. & B. released a 16YO Scottish Oak Finish, which had been re-racked into oak-wood grown in Glenisla, Angus. A large number of single cask bottlings have been released recently, including nine casks selected by distillery operatives (in 2006 and 2007) and limited editions at 19, 32 and 37YO .

The core range comprises:

- Glengoyne 10YO @ 40% (relaunched 2006)
- Glengoyne 12YO @ 43% and CS (introduced 2004)
- Glengoyne 17YO @ 43% (repackaged 2006)
- Glengoyne 21YO @ 43% (ex-sherrywood, repackaged 2007)
- Glengoyne 40YO @ 45.9% (exsherry butt; limited, introduced 2009)
- Glengoyne 13YO Port Finished @ (introduced 2010)
- Glengoyne 14YO Heritage Gold @ 40% (travel retail only, introduced 2010)
- Glengoyne Burnfoot NAS @ (travel retail only, introduced 2010)

GLEN GRANT



When their lease at Aberlour expired in 1839 the brothers John and James Grant moved down the road to Rothes and built a new distillery (originally named Drumbain), the first distillery in this village. From the outset it was described as ‘one of the most extensive distilleries in the North’, although goods had to be transported by road until the arrival of the railway in 1858. By 1872 Glen Grant was already being sold as a single, described as ‘pure, mild and agreeable’. By 1887, the demand for Glen Grant was such that the Major built another distillery nearby. Glen Grant was bought by Campari of Milan in 2006, and it is Italy’s favourite malt.

Style: Sweet, grassy and fruity (green apples).

Mature character: The house style favours refill wood to produce a light-coloured, fresh, fruity and summery whisky. The taste is sweet and lightly lemony, with cereals and nuts, apples and pears. Lightbodied.

Comparable to: Cardhu, Caperdonich

Raw materials: Unpeated malt from independent maltsters (own maltings removed 1962). Water from the Caperdonich Springs and the Glen Grant Burn (formerly named the Black Burn).

Maturation: Mainly refill U.S. hogsheads, mostly on Chivas sites (especially at Mulben, near Keith).

Expressions:

- Glen Grant 5YO @ 40% (Italy only)
- Glen Grant NAS 'The Majors Reserve' @ 40%
- Glen Grant 1992 Cellar Reserve @ 46% (introduced 2009)
- Glen Grant 170th Anniversary @ 46% (introduced 2010)
- Glen Grant 10YO @ 40%
- Glen Grant 16YO @ CS (released 2008)

GLENGYLE



The original Glengyle Distillery operated from 1873 to 1925. It was built by William Mitchell & Company and remained in their ownership until 1919 when it was sold to West Highland Malt Distilleries Ltd. It was bought by J. & A. Mitchell Ltd, owner of Springbank Distillery, in November 2000; a new distillery was built and production commenced in March 2004. Currently production is only 50,000 litres per annum, because of arrangements with Springbank.

Maturation: Bonded warehouses at Springbank Distillery.

Style: Heavier than Springbank, oily, meaty, sweet with cereal notes.

Comparable to: Springbank, Ledaig

Raw materials: Water from Crosshills Loch. Lightly peated malt from Springbank Distillery maltings.

Expressions: Not yet generally available. Bottles may be filled at the distillery, from a cask in the tasting room, which is continually topped up.

- Kilkerran 'Christmas 2008' @ 46%
- Kilkerran 'Work in Progress 1' @ 46% (released May 2009)
- Kilkerran 'Work in Progress 2' @ 46% (released 2010)

GLEN KEITH



Glen Keith is situated on the opposite bank of the River Isla to Strathisla Distillery in the town of Keith. It was the first distillery to have been built on Speyside since 1900, and as Philip Morrice writes ‘an excellent job has been done in recreating the form and ambience of a turn-of-the-century Highland malt whisky distillery’. Although a modern unit, Glen Keith is traditional in design and partly built of dressed stone, including its pagoda-topped kiln. Seagram’s mothballed Glen Keith in 1999, and the company’s Scotch whisky interests were acquired by Pernod Ricard in 2001. There are currently no plans to bring Glen Keith back into production, although several of the distillery’s facilities, for example the boiler, are used by Strathisla Distillery nearby.

Style: Light, sweet, grassy.

Mature character: Speyside style, with apples and bananas, hedgerow flowers, lemongrass and vanilla. Sweet to taste, with dried fruits (figs, dates) and light almonds. Medium-bodied.

Comparable to: Tullibardine, Auchroisk

Raw materials: Own Saladin maltings until 1976; now unpeated malt from independent maltsters. Soft process and cooling water from Balloch Spring, augmented when required from Newmill Spring.

Maturation: Mainly refill casks, at various Chivas sites on Speyside and in the Central Belt.

Expressions: All but a small amount goes to Chivas blends, especially Passport. One official bottling at 10YO (introduced 1994 as part of Seagram's Heritage Selection).

GLENKINCHIE



The original distillery was called Milton, a typical farm distillery, established by the brothers John and George Rate in 1825 to make use of the surplus grains they produced after adopting the improved farming methods introduced by the Agricultural Revolution. In 1837 they moved to the present site and built a new distillery, but by 1852 they were bankrupt. In 1880 the site was bought by a consortium of brewers and whisky merchants in Edinburgh, and production resumed. In 1988 Glenkinchie was adopted by the recently founded United Distillers plc as the Lowland representative in their Classic Malts series.

Style: Heavy and meaty as new-make, the mature whisky is grassy and lemony.

Mature character: During maturation, the heavy style of Glenkinchie's new-make becomes fresh and fragrant, and it loses all traces of sulphur. The nose is 'rural' – meadows, hedgerows, with lemon notes and a thread of smoke. The taste is fresh, starts lightly sweet and finishes dry, and very short. Light in character, but with medium body.

Comparable to: Auchentoshan, Isle of Arran

Raw materials: Floor maltings until 1968; now lightly peated malt from Roseisle. Hard process water from a spring on site (formerly from Hopes Reservoir in the Lammermuir Hills); cooling water from the Kinchie Burn.

Maturation: Mainly exbourbon casks, matured on site and at Leven.

Expressions: Before its adoption as a Classic Malt, Glenkinchie was not bottled by its owners.

- Glenkinchie 10YO @ 43% (Classic Malts series, since 1989)
- Glenkinchie 12YO @ 43% (Classic Malts series, since 2007, to replace 10YO)
- Glenkinchie Distillers Edition 14YO @ 43% (Amontillado cask finished, since 1998)
- Glenkinchie 20YO @ 58.4% (limited edition, matured ten years in ex-Asbach brandy casks, released 2007)
- Glenkinchie 20YO @ 57.9% (Special Release, 2007)
- Glenkinchie 20YO (1990) @ CS (Special Release, 2011)

THE GLENLIVET



George Smith of Upper Drummin farm, on the Duke of Gordon's Glenlivet Estate, was the first in the district to apply for a licence under the 1823 Spirits Act. Prior to this, like his neighbours, he distilled illegally. When he 'went legal', his former colleagues saw this as an act of betrayal, and threatened to burn down his distillery – 'and him at the heart of it'. The pistols he carried for several years to ward off any such attempt are to be seen in the visitor centre today. By the mid 1820s his whisky had won a reputation beyond the Highlands, and Andrew Usher of Edinburgh became his agent. The fame of Glenlivet whisky was such that many distilleries, some of them over 20 miles from the place itself (giving rise to Glenlivet being 'the longest glen in Scotland'), began to use the appellation, until J.G. Smith obtained a court order granting him sole rights to the definite article, while others might use Glenlivet as a suffix only. By 1950 around 27 distilleries were doing this. His son, Bill Smith Grant, is the man who put malt whisky on the map of America. As soon as Prohibition ended in 1933 he began to look for business partners and shipped a few hundred cases; by 1939 shipments had increased ninefold. In the post-war period it enjoyed cult status, although there was an acute shortage of mature stock. Some cases were reserved for luxury transatlantic liners. In 2001 Chivas Brothers (Pernod Ricard) acquired The Glenlivet Distillery along with most of Seagram's other whisky interests. In June 2010 a new distillery within the existing distillery was opened, increasing capacity by 75%.

Style: Mediumbodied, complex Speyside, with fruits (pineapple, pears, apples) and floral notes.

Mature character: The Glenlivet is a complex malt, and develops depth and extra complexity with age. The younger expressions are soft, floral and fruity (apple, pineapple and peach). Some malty notes are apparent in both aroma and taste, and some vanilla from the American oak. The taste starts sweet, with a soft texture, and dries considerably in the finish. Mediumbodied.

Comparable to: Glen Elgin, Cragganmore

Raw materials: Mineral-rich, hard process water from Josie's Well; cooling water from bore-holes in the hills behind the distillery; reduction water from Blairfindy Spring. Own floor maltings until 1966, now unpeated malt from Crisp of Port Gordon, on the Moray Firth.

Maturation: Exbourbon casks for the 12YO, exsherry casks for the 18YO; the rest are a mix of bourbon, sherry and refill casks.

Expressions: Currently the make is bottled as single malt.

Coronation Glenlivet, distilled on the day of King George VI's coronation in 1937, and bottled to mark the coronation of his daughter, Queen Elizabeth II in 1953, is probably the first-ever commemorative bottling of any malt.

In 2004 Chivas Brothers embarked on a £6.5 million marketing campaign for The Glenlivet. The core expressions are:

- The Glenlivet 12YO @ 40%
- The Glenlivet 15YO French Oak Reserve @ 40%
- The Glenlivet 18YO @ 43%
- The Glenlivet 21YO Archive @ 43% (Gold Best in Class I.W.S.C. 2007)
- The Glenlivet XXV @ 43%
- The Glenlivet Cellar Collection (limited bottlings from 1959, 1964, 1967, 1969, American Oak Finish, 30YO (1971, 1972 and 1983)

The travel retail range adds:

- The Glenlivet 12YO Firstfill @ 43% (from firstfill exbourbon casks, introduced 2005)
- The Glenlivet 15YO @ 43%

- The Glenlivet 16YO Nadurra @ CS ('Nadurra' is Gaelic for 'natural', non chillfiltered from firstfill exbourbon casks, introduced 2005)

GLENLOSSIE



Glenlossie Distillery was built by a publican and a few friends in 1876. John Duff, tenant of the Fife Arms at Llanbryde and former Manager of Glendronach Distillery, in partnership with Alexander Grigor Allen (Procurator Fiscal of Morayshire, and after 1880 part owner of Talisker Distillery), H.M.S. Mackay (land agent and burgh surveyor of Elgin) and John Hopkins (a London-based blender, and owner from 1880 of Tobermory Distillery and of a well-known blend, *Old Mull*). A large dark-grains plant was built on the site (1968– 72), with a conspicuous white chimney which can be seen for miles around.

Style: Grassy.

Mature character: A fresh, light, Speyside nose, with cut grass, faint flowers and hair lacquer. The taste is sweet and perfumed. Lightbodied.

Comparable to: Glendullan, Cardhu

Raw materials: Process water from the Bardon Burn, which sources in the Mannoch Hills; cooling water from the Gedloch Burn and the Burn of Foths. Floor maltings until 1962; now unpeated malt from Burghead

Maturation: On site in traditional and raked warehouses, and in the Central Belt.

Expressions: Glenlossie has always been a blending malt. It is ranked Top Class and was not available as a single until 1990:

- Glenlossie 10YO @ 43% (Flora & Fauna series)

GLENMORANGIE



Glenmorangie has been the bestselling single malt in Scotland for over 20 years, standing number two in the U.K. and number three in world sales. The distillery stands near the ancient Royal Burgh of Tain, in Ross-shire, overlooking the Dornoch Firth, on Morangie Farm, a spot well-known to illicit distillers. It was established in 1843 by William and John Matheson. By 1849 production had reached 20,000 gallons. Glenmorangie was not promoted as a single until the late 1970s. In 1996 Glenmorangie became a public limited company; in 2004 it bought the Scotch Malt Whisky Society, the Macdonald family sold its shares, and both companies were acquired by the French luxury goods giant, Louis Vuitton Moët-Hennessy (L.V.M.H.).

Style: Light, floral, citric (tangerine).

Mature character: Glenmorangie is light in style, but complex in character. Keynotes are vanilla, almonds, mandarins, apples, roses, spices and hay. The mouth feel is soft and fresh, the taste lightly sweet, with some cereal and fresh fruit. Medium-bodied.

Comparable to: Balblair, Glen Elgin

Raw materials: The Tarlogie Spring – very hard, mineral-rich water. Floor maltings until 1977; now unpeated malt from independent maltsters.

Maturation: First-and second-fill exbourbon American white oak casks; some other woods for finishing. Fourteen bonded warehouses on site; ten traditional

dunnage, four racked to eleven casks high.

Expressions: Glenmorangie has bottled a wide range of expressions over the past 20 years. Finishing has been done in Fino and Oloroso sherrywood, portwood, Madeira-wood, Claret, Côtes du Rhône, Malaga, Côte de Beaune, Côte de Nuits, Meursault, Sauternes, white rum and blond rum.

A number of limited edition vintages and wood finishes have also been released in recent years. These include most recently the Artisan Cask, 1993 Truffle Oak Reserve and a 30YO Oloroso finish; vintages from 1975, 1987 and 1988.

The new core range, launched in 2007, is only lightly chillfiltered:

- Glenmorangie Original 10YO @ 40%
- Glenmorangie Nectar D'Or NAS @ 46% (finished in Sauternes barriques)
- Glenmorangie Lasanta 12YO @ 46% (finished in ex-Oloroso casks)
- Glenmorangie Quinta Ruban 12YO @ 46% (finished in ex-port pipes)
- Glenmorangie 18YO @ 43% (a portion of this re-racked for three years into sherrywood)
- Glenmorangie Quarter Century 25YO @ 40% (limited batches of 20 casks, some matured in exbourbon barrels, some exsherry and a portion ex-Burgundy barrels)
- Glenmorangie Signet NAS @ 46% (around 18YO, using a proportion of chocolate malt, launched autumn 2008)
- Glenmorangie Astar NAS @ 57.1% (matured in selected 'artisan' casks, introduced 2008)
- Glenmorangie Sonnalta PX NAS @ 46% (finished in Pedro Ximinez casks, launched 2009)
- Glenmorangie Finealta NAS @ 46% (part exsherry, part new American oak, the name means 'Elegance' in Gaelic, launched 2010)
- Glenmorangie Pride 1981 @ 56.7% (28YO finished for 10 years in Chateau d'Yquem casks, released 2011)

GLEN MORAY



Like several distilleries, Glen Moray was built on the site of an early nineteenth-century brewery to take advantage of a reliable water source. Unlike any other distillery, however, the grounds included the site of Elgin's gallows, on the edge of the town, beside the main road heading west; a grim warning to unruly Highlanders arriving in the city. The distillery was built by a local consortium, the Glen Moray-Glenlivet Distillery Company Ltd, in 1897, making use of some of the old West Brewery buildings and 'being equipped with electric light throughout'. In September 2008 L.V.M.H. sold Glen Moray to the French spirits company, La Martiniquaise.

Style: Fruity, floral, clean.

Mature character: Glen Moray is light in style, in its younger expressions, but elegantly balanced and 'well made'. The nose is floral and fruity, with butterscotch, vanilla and barley sugar. The taste is sweet, with nutty notes and a delicate fruitiness. Medium-bodied.

Comparable to: Glenmorangie, Glenburgie

Raw materials: Hard water from the River Lossie. Floor maltings until 1958 then Saladin box maltings until 1977; unpeated malt from independent maltsters.

Maturation: Mainly first and refill exbourbon casks. Small amount of exsherry casks. Mix of dunnage and palletised warehouses on site, holding 65,000 casks in total.

Expressions: Glen Moray is the bestselling malt in France. The core range comprises:

- Glen Moray Classic (no age statement)
- Glen Moray 12YO @ 40%
- Glen Moray 16YO @ 40%

Limited editions, 20-and 30-year-olds and several vintages have been released. A couple of new vintages were launched in 2006 – 1963 and 1964 – and a one-off limited edition, Mountain Oak, in 2007.

- Glen Moray Manager's Choice usually at around 15YO released annually.
- Glen Moray 1989 @ 57.6% (single bourbon cask bottled 2006, 240 bottles, only available at the distillery)

GLEN ORD



The distillery at Muir of Ord was established on a site which had formerly been much used by smugglers (over 40 illicit stills), and which was famous for whisky production, being near Ferintosh and the Black Isle. The museum displays several illicit stills dredged from lochs nearby. Ord Distillery was founded in 1838 by Thomas Mackenzie, the land-owner, and licensed to Robert Johnstone and Donald McLennan. The distillery was rebuilt and expanded in 1966, masterminded by Dr Charlie Potts, S.M.D.'s Chief Engineer. The visitor centre was opened in 1988, and today welcomes around 20,000 visitors a year.

Style: Described as 'the best representative of the "Highland" style'. Sweet and heathery, with distinct waxiness.

Mature character: 'The Singleton of Glen Ord', which will replace other expressions, retains the malt's characteristic waxy texture and light smokiness, while adding depth and complexity. A big, rich nose with fruity (nectarines and dried orange peel) and floral (old-fashioned perfume) notes, flaked almonds and sandalwood. Very smooth and chewy texture; sweet, slightly mouthcooling, with a long finish and a pleasant aftertaste of nougat. Mediumbodied.

Comparable to: Clynelish, Aberfeldy

Raw materials: Lightly peated malt from own maltings. 85% of barley grown locally. Water via Alt Fionnadh (the White Burn) from two lochs (the 'Loch of the Peats', Loch nam Bonnach, and the 'Loch of the Birds', Loch nan Eun).

Maturation: Approximately half first and refill sherry butts, and half refill hogsheads, for single malt bottlings. 12,500 casks matured on site in dunnage warehouse, the rest tankered to Cambus or to customers' own sites.

Expressions:

- Glen Ord 12YO @ 40% (first bottled 1993, Gold Medals I.W.S.C. 1994, 1995)
- Glen Ord 12YO @ 43% (Hidden Malts series, introduced in 2002)
- Glen Ord 1975 28YO @ 58.3% (Special Release 2003)
- Glen Ord 1978 25YO @ 58.3% (Special Release 2004)
- Glen Ord 30YO @ 58.7% (Special Release 2005)
- The Singleton of Glen Ord 12YO @ 40% (mix of American and European oak, released 2006, for S.E. Asia)
- The Singleton of Glen Ord 18YO @ 40% (mix of American and European oak, released 2006, for S.E. Asia)

GLENROTHES



In 1868, James Stuart, a ‘corn factor’ in Rothes village on Speyside and proprietor of the Mills of Rothes, took over Macallan Distillery nearby, in partnership with Robert Dick and William Grant (agents for the Caledonian Bank) and John Cruikshank (solicitor). Macallan prospered and three years later they decided to build a second and larger distillery upstream from Mills of Rothes. Glen Rothes was merged with Bunnahabhain Distillery in 1887 to form the Highland Distilleries Company. In 1987 Highland licensed *The Glenrothes* brand to Berry Brothers & Rudd, the old established London wine merchants, which also owned 50% of *Cutty Sark* (the other 50% being owned by Robertson & Baxter), and they released the first ‘official’ bottling that year, at 12 years old. In 2010 Edrington (owner of Robertson & Baxter) took 100% ownership of *Cutty Sark* and Berry Brothers 100% ownership of *The Glenrothes* brand. Until 1994 the distillery was named ‘Glen Rothes’, since then it has been ‘Glenrothes’.

Style: Sweet and fruity, but also heavy and rich.

Mature character: Glenrothes is a heavy style of malt, and takes sherrywood maturation well, and advanced age. The ‘Select Reserve’ best displays the distillery character: on the nose, nougat, dried fruits and nuts, caramel, vanilla sponge. Sweet to taste, with a soft texture, drying towards the end, with a nutty aftertaste and hints of chocolate. A useful combination of freshness and depth. Medium-bodied.

Comparable to: Balvenie, Glenfarclas

Raw materials: Water from the Ladies' Well and Ardcanny Spring. Lightly peated malt from Tamdhu Distillery maltings and from Simpson's.

Maturation: American oak casks (exsherry and exbourbon), European oak exsherry. Four racked and 12 dunnage warehouses are on site.

Expressions:

Glenrothes was repackaged in 1994, the design inspired by labels found on duty-paid samples in a blending room. The 'core expressions' are:

- Glenrothes Select Reserve NAS @ 43% (introduced 2005)
- Glenrothes Robur Reserve NAS @ 40% (European oak matured, travel retail only, introduced 2008)
- Glenrothes Alba Reserve NAS @ 40% (American oak matured, introduced 2009)
- Glenrothes Three Decades NAS @43% (containing whiskies from the 1970s, 80s and 90s, introduced 2009)

The rest are 'vintages', each a parcel of casks from the declared year and with its own personality behind the distillery character – very much a wine merchant's approach.

So far 'The Glenrothes Vintages' (all @43%) have included:

1971, 1972, 1973, 1974, 1975, 1978, 1979, 1981, 1982, 1984, 1985, 1989, 1991, 1992, 1994 and 1995. In addition, The Glenrothes is released in very occasional single casks (at natural strength). Only ten of these have been released to date, and they are highly sought after.

GLEN SCOTIA



Glen Scotia has had a patchy existence, but, unlike 30 other distilleries that once operated in Campbeltown, it has survived. The distillery was established in 1832, named simply Scotia, by Stewart, Galbraith & Company, which became a limited company in 1895 and sold to West Highland Malt Distilleries in 1919. From 1999 Glen Scotia has been in production for only a few weeks a year, operated by a team from Springbank Distillery, but since 2007 it has been in part-time production.

Style: Maritime and oily.

Mature character: Glen Scotia has a ‘maritime character’: seaweed, docks, briny, lightly peaty. The taste is somewhat oily and smooth, with cereal notes, nuts, light sweetness, distinct saltiness and some shoreline seaweed notes. Dry overall and medium-bodied. Variable.

Comparable to: Oban, Jura

Raw materials: Soft water from Crosshill Loch. Unpeated and lightly peated (four to five weeks per annum) from Greencore maltings, Buckie.

Maturation: Bourbon barrels mostly, with some sherry hogsheads and butts. Single racked warehouse on site holding 6,500 casks, all matured on site.

Expressions:

- Glen Scotia 12YO @ 40% (introduced 2005)
- Glen Scotia 17YO @ 40% (introduced 2006)
- Glen Scotia 6YO @ 40% (lightly peated, introduced 2006)

GLEN SPEY



Glen Spey is discreetly tucked in off the main street in Rothes, below a fragment of the outer wall of the once formidable Rothes Castle. James Stuart, grain merchant in Rothes, licensee (1868–86) then owner (1886–92) of Macallan Distillery, built Glen Spey (originally a corn mill, and named Mill of Rothes Distillery). He later sold it to W. & A. Gilbey, the London wine and spirits merchant. This was the first time an English company had bought a Scotch whisky distillery. They went on to build Knockando Distillery in 1904. Glen Spey was doubled in capacity in 1970, sold to Watney Mann (brewers) two years later, and acquired by Grand Metropolitan the same year. Grand Metropolitan merged with Guinness in 1997 to form U.D.V., now called Diageo. Glen Spey has long been a key filling for the *J&B*. blends. It was not bottled as a single by its owners until 2001.

Style: Nutty-spicy, light.

Mature character: A light style of malt, made for blending. The nutty, cereal character comes through on the nose, with a Speyside floral element. The taste is sweet, with a malty, grassy character. Some have identified roast chestnuts. Shortish finish. Innocuous. Medium to light bodied, all by design.

Comparable to: Glenfiddich, Miltonduff

Raw materials: Floor maltings until 1969, now unpeated malt from Burghead. Soft process water from the Doonie Spring; cooling water from the River Rothes.

Maturation: Refill exbourbon hogsheads. Mainly in the Central Belt.

Expressions:

- Glen Spey 12YO @ 43% (Flora & Fauna series, 2001)
- Glen Spey 22YO (1988) @ CS (Special Release 2011)

GLENTAUCHERS



Glentauchers was founded in 1897 by James Buchanan & Company (of Black & White fame) in partnership with their spirit supplier, W.P. Lowrie. The attractive buildings three miles outside Keith were designed by John Alcock, under the supervision of the legendary Charles Doig. It went into production in May 1898. During the general refurbishment of distilleries in the mid 1960s, Glentauchers was expanded from two to six stills. The two pagoda-topped Doig kilns and a single drum malting (from 1925) remain. In 2005, Pernod Ricard bought most of Allied's Scotch whisky interests, which included Glentauchers.

Style: Medium-bodied Speyside – sweet and fruity.

Mature character: Another malt which is principally made for blending. Broadly Speyside in style – sweet, fragrant, fruity, estery – Glentauchers adds a dash of coconut, almonds and cereal to the profile. Sweet to taste, with little body but a pleasant, summery impression. Light-bodied.

Comparable to: Aberlour, Benrinnes

Raw materials: Production water from two reservoirs fed by the Rosarie and Tauchers Burns; the former supplies process water and the latter cooling water. Maltings closed 1968, now unpeated malt from independent maltsters.

Maturation: Refill American oak casks.

Expressions: Glentauchers has always been a blending whisky, particularly for

Buchanan's blends, now a key component in Ballantine's.

- Glentauchers 15YO was issued by Allied (in their Special Distillery Bottling range) in 2000. Not currently bottled as a single.

GLENTURRET



There was an illicit farm distillery at The Hosh from 1775, and thus Glenturret claims to be the oldest distillery in Scotland. The first licence was granted to John Drummond in 1818. Its name changed from 'Hosh' to 'Glenturret' in 1875. Glenturret's revival was owing to James Fairlie, who bought the site in 1957 and reversed its decline – often using second-hand plant and integrating new buildings with the old – with a view to 'preserving the craft traditions of malt whisky distilling and developing its appreciation'. He opened to the public and arranged tours and tastings. In 2002, Edrington invested £2.2 million in further upgrading the visitor facilities, now named 'The Famous Grouse Experience', although the distillery had no previous connection to The Famous Grouse. The distillery's cat, Towser, who died in 1987 aged 24, dispatched 28,899 mice, and she is mentioned in *The Guinness Book of Records*.

Style: Fruity (orange), floral, slightly medicinal, with cereal notes.

Mature character: The younger expressions retain the distillery character well: floral, nutty, malty, with a hint of smoke. The taste is sweetish, with honey traces, nuts and cereal, and a thread of smoke. Mediumbodied.

Comparable to: Blair Athol, Aberfeldy

Raw materials: Soft water from Loch Turret. Lightly peated malt from Simpson's.

Maturation: Refill American and Spanish oak, six bonded warehouses on site.

Some goes to Buckley Bond, Bishopbriggs.

Expressions: Glenturret has a very small range (downsized from a wider range), including only one official bottling, the 10YO, and occasional limited or single cask releases.

- Glenturret 10YO @ 40% (introduced 2003, to replace a 12YO)
- Glenturret 1991 14YO @ 59.7% (single cask released 2007)
- Glenturret 1992 15YO @ 57.7% (single cask released 2007)
- Glenturret 1977 29YO @ 55.6% (single cask released 2007)
- Glenturret 1991 16YO @ 58.4% (single exsherry cask, released 2008)

HIGHLAND PARK



Highland Park Distillery stands on a hill overlooking Kirkwall, Orkney's main town – on an area of common land long known as the High Park of Rosebank. It proudly describes itself as 'The Northernmost Scotch Whisky Distillery in the World'. From 1798, illicit whisky had been made here by a local brewer named Mansie Eunson, described as 'the greatest and most accomplished smuggler in Orkney'. After the whisky boom of the 1890s turned to bust orders dropped from 60,000 to a mere 107 gallons in 1904/05. But the distillery remained in production throughout the First World War. Owners Highland Distilleries (now Edrington) began to promote Highland Park as a single malt in 1979 and installed a visitor centre in 1986, which was awarded five stars by VisitScotland in 2000.

Style: Malty, slightly smoky.

Mature character: The nose presents heather pollen and liquid honey, with caramelised oranges, sweet malt, a hint of oak and a drift of smouldering heather. The mouth feel is smooth, the taste sweet, slightly salty then dry, with toffee, traces of spice (cinnamon, ginger) and a twist of smoke. Medium-bodied.

Comparable to: Scapa, Springbank

Raw materials: Hard water pumped up to the distillery from the Crantit Lagoons and one spring. Own floor maltings produce 20% of requirements, peated at around 20ppm phenols; the rest is unpeated from Tamdhu maltings. Local peat from Hobbister Hill.

Maturation: 25% first fill exsherry, 60% refill exsherry, 15% refill hogsheads. Nineteen dunnage and four racked warehouses on site holding over 45,000 casks; a further 62 -63,000 casks matured elsewhere.

Expressions: The core range comprises the 12, 15, 18, 25, 30 and 40YO. The bottle was redressed in 2006. A number of limited editions and single cask bottlings have been released in recent years.

- Highland Park 12YO @ 40%
- Highland Park 15YO @ 40%
- Highland Park 18YO @ 43% (introduced 1997)
- Highland Park 25YO @ 50.7% (introduced 1997)
- Highland Park 30YO @ 48.1% (introduced 2007)
- Highland Park 40YO @ 48.3% (released 2008)
- Highland Park 50YO @ 44.8% (a vatting of 5 casks filled in 1960, released 2010)
- Highland Park St Magnus 15YO @ 55% (released 2009)
- Highland Park Earl Magnus 12YO @ 55% (released 2010)
- Highland Park King Hakon 18YO @ 55% (released 2011)

For travel retail:

- Highland Park 1973 @ 50.6% (released 2010)
- Highland Park 1990 Vintage @ 40% (released 2010)
- Highland Park 1994 Vintage @ 40% (released 2010)
- Highland Park 1998 @ 40% (released 2010)

INCHGOWER



Inchgower stands outside the fishing port of Buckie. The distillery was built in 1871 by Alexander Wilson & Company to replace their distillery at Tochineal nearby, which had become too small – and where the landlord had doubled the rent. In 1938 the distillery was sold for £3,000 to Arthur Bell & Sons. It supplied fillings for Bell's blends, and as the brand's popularity increased, the distillery was expanded to meet demand. From 1979 Bell's was the No. 1 bestselling Scotch in the U.K. (a position it holds to this day).

Style: Nutty-spicy, malty.

Mature character: The nose is malty, caramelised and lightly sherried, yet the overall impression is dry. There are some coffee and chocolate notes, and sometimes a whiff of smoke. The taste is sweet then dry, with a hint of salt; bruised apples and hazelnuts. Medium-bodied.

Comparable to: Dufftown, Tomintoul

Raw materials: Unpeated malt from Burghead. Water from springs in the Minduff Hills.

Maturation: Mainly refill American oak.

Expressions: Bell's bottled small amounts of Inchgower as a single from the early 1980s.

- Inchgower 14YO @ 43% (Flora & Fauna series, from 1991)
- Inchgower 27YO @ 55.6% (Rare Malts series, distilled 1976, released 2003)

INVERGORDON



The port of Invergordon stands on the north shore of the Cromarty Firth. It was named for Sir William Gordon, its owner in the late eighteenth century. Since World War II, several attempts had been made to bring industrial activity to the Highlands north of Inverness. One such was Invergordon Distillery, promoted strongly by James Grigor, Provost of Inverness, in the late 1950s. Communications by sea and road were excellent; it was on the edge of a notable barley-growing region, and the water was first-rate. The Invergordon Distillers Ltd was incorporated in March 1959 to build the first and only grain whisky distillery in the Highlands. Production commenced in July 1961. Invergordon Distillery is now under the ownership of United Distillers Group of India, part of the giant United Breweries Group.

Style: Light and sweet.

Mature character: Fresh and sweet, with pear drops and acetone. Clean and lightbodied, but somewhat onedimensional compared to malt whisky.

Comparable to: Cameronbridge, Girvan

Raw materials: Water from Loch Glass. Wheat from NE Scotland.

Maturation: American oak. On site.

Expressions: Invergordon Single Grain 10YO @ 40% (launched 1990)

JURA



Perhaps surprisingly for a place so remote from the Excise, Jura had a licensed distillery by 1810 – at Craighouse, the site of the present distillery and also of a previous, unlicensed still. The licensee was Archibald Campbell, the laird of Jura. Several tenants ran the distillery with little success. The first single malt bottling was released in 1974. The distillery was expanded by Dr Alan Rutherford (who went on to become Head of Production at U.D.) from 1976 to 1978. Invergordon Distillers acquired Mackinlay's and its distilleries in 1985, and were themselves bought by Whyte & Mackay ten years later. Jura has long been packaged in an unusual waisted bottle, elegant and even voluptuous!

Style: Oily, earthy-piney, with lemon notes.

Mature character: The oiliness apparent in the new-make comes through in the mature whisky, along with pine sap, orange zest and dry nuts. The taste is oily, with some maltiness; sweetish to start, becoming dry, with a dash of salt. Medium to light-bodied.

Comparable to: Bruichladdich, Glen Scotia

Raw materials: Unpeated malt from Port Ellen Maltings (also occasionally heavy peated malt for Superstition), Inverness, Aberdeen and Pencaitland. Water from the Market Loch.

Maturation: 27,000 casks matured on site in high racked warehouses (for single malt bottlings). 50% firstfill bourbon, 50% second-and third-fill; 5% sherry butts used in some expressions. 33% of the make bottled is as single malt.

Expressions:

Core expressions:

- Isle of Jura 10YO @ 40%
- Isle of Jura 16YO @ 40%
- Isle of Jura Superstition @ 43% (released 2002)
- Isle of Jura Prophecy @ 46% (released 2009)
- Isle of Jura Legacy @ 40% (French Exclusive)
- Isle of Jura 21YO @ 44% (limited edition 200th Anniversary Commemorative Bottling, finished in ex-Oloroso vintage 1963 butts, released 2010)
- Isle of Jura 30YO @ (travel retail limited edition, released 2007)
- Isle of Jura Elements: Air @ 46% (limited, released 2009)
- Isle of Jura Boutique Barrel Vintage 1993 @ 54% (limited release, cask strength, non-chill filtered, released 2010)
- Isle of Jura Boutique Barrel Vintage 1995 @ 56.5% (limited release, cask strength, non-chill filtered, released 2010)
- Isle of Jura Boutique Barrel Vintage 1999 @ 55% (limited release, cask strength, non-chill filtered, released 2010)

KILCHOMAN



Kilchoman's situation on the wild west coast of Islay, tucked in behind the sea cliffs and close to the wide white strand of Machir Bay, is striking. It is also historic. These lands were gifted by the Lords of the Isles to their physicians, the Beaton or MacBeatha family, who arrived in Scotland from Ireland in 1300, and may well have brought the secrets of distilling with them. The distillery was the brain-child of Anthony Wills, wine and spirits merchant, who moved to Islay in 2000, having married Cathy Wilks, an Illeach, some years earlier, and renovated some semi-derelict buildings at Rockside Farm, Kilchoman. The distillery was officially opened by the present writer on 3 June 2005, and went into production in December that year. It can make the proud claim to do everything on site – from growing the barley to bottling the whisky – and this is unique.

Style: Unusually sweet, fruity and smoky.

Mature Character: Even at 3–4 years old Kilchoman drinks very well, with more substance and character than many young whiskies. The nose is maritime, often with light dried fruit notes; the taste sweet to start, with some saltiness and acidity and a smoky finish.

Comparable to: Port Charlotte, Caol Ila

Raw materials: Soft peaty water from the Allt Glean Osmail Burn. Floor maltings on site, using barley grown on the farm and peat from Duich Moss (30ppm phenols) and the balance from Port Ellen Maltings (heavily peated at 50ppm phenols). Own grown malt accounts for 30–40% of production –

Maturation: 85% in fresh (currently from Buffalo Trace) and refill exbourbon barrels, and 15% in ex-Oloroso butts. All matured on site.

Expressions: Kilchoman's young whiskies have been very enthusiastically received. They favour maturation in first- (mainly) and re-fill ex Bourbon barrels, finished in active Oloroso sherry butts.

- Kilchoman Inaugural Release @ 46% (released September 2009)
- Kilchoman Autumn 2009 Release @ 46%
- Kilchoman Spring 2010 Release @ 46%
- Kilchoman Summer 2010 Release @ 46% (from 1st fill exBourbon barrels)
- Kilchoman Winter 2010 Release @ 46% (from 1st fill exBourbon barrels)
- Kilchoman Spring 2011 Release @ 46%
- Kilchoman 100% Islay %50 (barley grown on Islay and malted at the distillery; matured in 1st fill Bourbon, released June 2011)

KNOCKANDO



The distillery was designed by Charles Doig for John Tyler Thomson, chartered accountant and spirits broker in Elgin, who traded as the Knockando-Glenlivet Distillery Company. It is situated on the north bank of the Spey, and the Strathspey railway runs through the distillery; a dedicated siding was installed in 1905. The name is that of the parish, and comes from Cnoc-an-Dubh, ‘the dark hillock’. Production started in 1899, but the whisky industry went into recession shortly after and Knockando closed. It was sold in 1904 to W. & A. Gilbey, the London wine and spirits merchant, for £3,500. It is now owned by Diageo.

Style: Malty, cereal-like.

Mature character: The keynote breakfast cereal-style comes through in the standard 12YO expression, Sugar Puffs to be exact, with honey, walnuts and a trace of olive oil. The taste is sweet and simple, with cereal and nuts. Medium to light-bodied. A good breakfast malt.

Comparable to: Blair Athol, Glenturret

Raw materials: Soft process water from the Cardnach Spring; cooling water from the River Spey. Floor maltings until 1968; now lightly peated malt from Burghead.

Maturation: Refill exbourbon hogsheads.

Expressions: Until 2002, Knockando was bottled by ‘vintage’, displaying the year of distillation, not the age – although this was usually around 12YO and at

either 43% or 40% volume. 'Vintages' were declared in 1963 (bottled 1976), 1964, 1968 (bottled 1992), 1972, every year from 1975 to 1982, 1986, Master Reserve 21YO. Currently core range is:

- Knockando 12YO @ 40%
- Knockando 18YO @ 40%
- Knockando 1985 25YO @ CS (Special Release 2011)

KNOCKDHU



Situated three miles east of Keith, beneath the dark, rounded hump of Knock Hill, the distillery sits on the very edge of Speyside, and some classify the make as such. It was the first malt whisky distillery to be commissioned by D.C.L., which until then (1893/94) had confined its interests to grain whisky production. The site was chosen on account of the water quality from springs on the hill, close to ‘good barley country’ and near ‘an inexhaustible supply of excellent peats’; it also helped that the Great North of Scotland Railway line between Aberdeen and Elgin ran adjacent to the site. The make was used primarily in the Haig blends. Knockdhu was a casualty of the world recession of the early 1980s and closed in 1983. In 1988 Inver House bought the business and released the first single malt bottling in 1990, changing the brand name to *an Cnoc*.

Style: Speyside style – fruity-floral, estery, with lemon notes, but with added body from the worm tubs.

Mature character: A light Speyside style; sweet, floral (buttercups), cereal, lemony, with a suggestion of vanilla cream. The texture is light, the taste sweet, with cooked apples and lemon meringue pie.

Comparable to: Craigellachie, Tamdhu

Raw materials: Process water from springs on Knock Hill; cooling water from the Ternemny Burn. Malt from independent maltsters.

Maturation: Mainly U.S. exbourbon casks. Matured on site in four dunnage

warehouses and one racked warehouse for single malt bottlings, holding some 7,600 casks.

Expressions: Since 2004 the core range has comprised the 12YO with occasional limited editions and annual vintage bottlings, usually around 14YO .

- an Cnoc 12YO @ 40% introduced 2000)
- an Cnoc 30YO 1975 @ 50% (released 2005)
- an Cnoc 1991 @ 46% (released 2006)
- an Cnoc 1993 @ 46% (released 2007)
- an Cnoc 1994 @ 46% (released 2008)
- an Cnoc 16YO @ 46% (released 2008)
- an Cnoc 1995 @ 46% (released 2010)
- an Cnoc 1996 @ 46% (released 2011)

LAGAVULIN



Guarding the opening to Lagavulin Bay stand the crumbling remains of Dunyveg Castle, power-base of the Lords of the Isles and where the lords kept their galleys of war. There were illicit stills in this sheltered ‘hollow of the mill’ in the eighteenth century, but the first licensed operation was established in 1815 by John Johnston. In 1890, owner Peter Mackie created the blend *White Horse*; so successful was this that by 1908 Mackie & Company was named among the Big Five (with Walker’s, Dewar’s, Buchanan and Haig). In 1924, the company became White Horse Distillers. In 1927, it merged with D.C.L.

Style: Rich, sweet, peaty.

Mature character: Lagavulin is the richest and most complex of the Islay malts. The nose has berries, Lapsang Souchong tea, sherry, sweet seaweed, wax polish, camphor, carbolic and scented smoke. A big, rich mouth feel; very sweet to start, then a big blast of peat smoke in the finish and a long aftertaste. Fullbodied.

Comparable to: Laphroaig, Caol Ila

Raw materials: Floor maltings until 1974; now heavily peated malt (30–35ppm phenols) from Port Ellen. Dark, soft water from the Solum lochs.

Maturation: Mainly refill American, with some refill European. Some matured on site and at Port Ellen and Caol Ila Distilleries; mostly in the Central Belt.

Expressions: Lagavulin was bottled by D.C.L. at 12YO, but when it became the Islay representative of the Classic Malts in 1989 it was decided to bottle at 16YO. This advanced age combined with under-production during the 1980s and the phenomenal global success of the whisky made it difficult to buy in some markets.

- Lagavulin 25YO @ 57.2% (Special Release 2002)
- Lagavulin 30YO @ 52.6% (Special Release 2006)
- Lagavulin 21YO @ 56.5% (Special Release 2007)
- Since 2002 a 12YO Lagavulin has been released each year as a Special Release, @ CS

LAPHROAIG



Alexander and Donald Johnston, who were tenant farmers in Tallant and Kildalton by 1810, established the distillery at Laphroaig in 1815. Their forbears were MacIains from Glencoe ('MacIain' Anglicises to 'John-son'), who came to Islay in the late fifteenth century. Laphroaig labels still recall 'D. Johnston & Company', and the distillery remained in the family until the 1960s. (Laphroaig was possibly the first single malt Scotch to be promoted in the U.S.A., a loophole in the law allowing whisky to be sold 'for medicinal purposes' during Prohibition. By 1970 American distiller Schenley had complete ownership: the days of privately owned distilleries were over, and, like many other distilleries, Laphroaig became an item on a multi-national corporation's balance sheet. Prince Charles granted his Royal Warrant to Laphroaig in 1994. The new owners are proud of the distillery's heritage and can be relied upon to consolidate Laphroaig's position as a global brand.

Style: Sweet, spicy and peaty.

Mature character: Laphroaig positions itself as 'the definitive Islay malt' because it epitomises the classic Islay character. It also claims on the label to be 'the most richly flavoured of all Scotch whiskies'. This may once have been the case; modern expressions are less extreme. The nose is pungent and smoky (coal smoke), with coal tar soap and iodine. The taste is surprisingly sweet to start, then salty and dry, with billows of tarry smoke and medicinal, seaweed-like flavours. Fullbodied.

Comparable to: Lagavulin, Port Ellen

Raw materials: Soft peaty water from Kilbride Reservoir, with support from Loch na Beinne Brice. Own floor maltings supply around 15% of requirement; the rest from Port Ellen and mainland maltings (at 35–40ppm phenols). Peat from Machrie Moss, owned by the distillery and still cut by hand.

Maturation: Primarily firstfill exbourbon barrels from Maker's Mark Distillery; in the past a mix of American and European casks, and in recent years regular bottlings from quarter casks. Eight dunnage and racked warehouses on site with 55,000 casks in total. Five thousand casks at Ardbeg; 40% of production tankered to be matured in Glasgow; 65–70% of the current output of 2.6m L.P.A. is bottled as single malt.

Expressions:

The core range comprises:

- Laphroaig 10YO @ 40%
- Laphroaig 10YO @ CS (a different strength for each batch)
- Laphroaig 18YO @ 48% (introduced 2009)
- Laphroaig 25YO @ CS (introduced 2008)
- Laphroaig Quarter Cask NAS @ 48% (re-racked into 25L American oak casks for 7 months, introduced 2005)
- Annual limited editions, named 'Cairdeas' ('Friendship') are released for the Friends of Laphroaig

LINKWOOD



Linkwood was founded in 1821 by Peter Brown, factor of Linkwood Estate and agricultural improver, and commenced operation three years later. In 1932, the distillery was acquired by D.C.L. Major refurbishment took place in 1963, and in 1971 a new distillery was built next door, with four stills – an indication of the excellence of the make, which is ranked Top Class and is used as a ‘top dressing’ malt in several famous blends.

Style: Floral.

Mature character: A light Speyside style. Estery, with bubblegum, acetone, lemon sherbet, tea roses – clean, fresh and sweet. The taste also is sweet, with traces of white wine (Gewürztraminer grapes), lemon zest and sherbet. Lightbodied.

Comparable to: Cardhu, Glen Elgin

Raw materials: Floor maltings until 1963, now unpeated malt from Burghead. Process water from springs near Millbuies Loch; cooling water from the Burn of Linkwood and the Burn of Bogs.

Maturation: Mainly refill American hogshead, some refill European butts. Two thousand casks matured on site, mainly in the Central Belt.

Expressions: Such is the usefulness of Linkwood that for many years it was available as a single only through Gordon & Macphail.

- Linkwood 12YO @ 43% (Flora & Fauna series, from 1990)
- Linkwood 26YO @ 56.1% (Rare Malts series, 1975, released 2002)
- Linkwood 30YO @ 54.9% (Rare Malts series, 1974, released 2005)
- Linkwood 26YO ex-Port @ 56.9% (Special Release 2008)
- Linkwood 26YO ex-Rum @ 54.5% (Special Release 2008)
- Linkwood 26YO ex-Sweet Red Wine @ 55.5% (Special Release 2008)

LOCH LOMOND



Loch Lomond Distillery is a large and practical site, a production unit whose design owes little to aesthetics, without arrangements for visitors. It is situated in an industrial estate on the edge of Alexandria, about a mile and a half from Loch Lomond itself (the largest loch in the U.K. and a world-famous beauty spot since the eighteenth century). The distillery was constructed in 1965/66 by converting a former dye works. The job was done by American-born Duncan Thomas (owner of Littlemill Distillery), in partnership with Barton Brands of Chicago. Like many distilleries, Loch Lomond was mothballed in 1984, and then sold in 1985 to Inver House Distilleries, who sold it on the following year to Glen Catrine Bonded Warehouse Company Ltd.

Expressions: The distillery's website states: 'We produce a full range of malts from heavily peated (typical of Islay), to complex fruity (typical of Speyside), to full-bodied fruity (typical of Highland), and also soft and fruity (typical of Lowland).' They are generically bottled under the 'Distillery Select' label, and under the brand names Loch Lomond, Inchmurrin (designed to mature early), Croftengea, Inchmoan, Inchfad, Craiglodge and Glen Douglas. Confusingly, the brand names do not follow the style, 'peated', 'heavily peated' *etc.* or wood finishes.

Style: Light and estery.

Mature character: Loch Lomond Blue Label: a lightbodied whisky which might be mistaken for a Lowland. The nose is sweet and fruity/malty, with floral notes, and slightly minty. The taste is sweet then dry, with cereal and herbal

flavours.

Comparable to: Bunnahabhain, Deanston

Raw materials: Wheat from independent merchants. Water from bore-holes and Loch Lomond

Maturation: Mainly American oak exbourbon casks.

Expressions:

Core expressions:

- Loch Lomond Blue Label @ 40% (introduced 1999)
- Loch Lomond Black Label 21YO @ 40%
- Loch Lomond Single Blended @ 40% (both malt and grain fillings made on site)

Current Distillery Select bottlings include single batches and single casks from Croftengea, Inchmoan, Craiglodge, Glen Douglas and Inchmurrin.

LOCHSIDE



Lochside Distillery was established within a former Deuchar's brewery in 1957 in the pretty Angus port of Montrose. The brewery dated from 1781, but was rebuilt in the late nineteenth century and was 'far too big for a malt distillery'. Nevertheless, the bold Joseph Hobbs, owner of Ben Nevis Distillery, trading as MacNab Distilleries Ltd, was behind the conversion. His first intention was to make grain whisky, but when other larger grain distilleries were built (notably Invergordon in 1959) he installed four pot stills as well (in 1961), as he had done at Ben Nevis. Blending and bottling continued to be done on site, and at one time the blend *Sandy MacNab's* commanded a loyal following. In 1992, production ceased and when mature stocks were depleted by 1996 Lochside was closed and dismantled the following year. The bonded warehouse was demolished in 1999 and the rest demolished in March 2005, following a fire earlier that year.

Style: Fruity, with body.

Mature character: Longmorn is a rich whisky and benefits from long maturation in exsherry casks. Both the 15YO and the 16YO have discernible traces of sherry on the nose, backed by fruit (oranges, also dried figs) and some malt, and an interesting spicy note – cinnamon? nutmeg? The mouth feel is big and rounded, the taste sweet (fruit, caramel, malt) then drying slightly towards the finish, which is long and somewhat tannic. Mediumbodied.

Comparable to: Strathisla, Miltonduff

Raw materials: Production water from springs on Mannoch Hill. Own floor

maltings until 1970, now unpeated malt from independent maltsters.

Maturation: Refill American oak hogsheads and barrels, some European oak butts.

Expressions: Prior to 1993 when a 15YO was introduced (Seagram's Heritage Selection series; it won I.W.S.C. gold medals that year and in 1994) only occasional bottlings were released by Longmorn's owners, since it is a key filling for Chivas Regal 18YO and other blends.

- Longmorn 16YO @ 48% (introduced 2007 with stylish packaging to replace the 15YO)

MACALLAN



Originally named Elchies Distillery, Macallan took out a licence in 1824 – one of the first on Speyside to do so. It is likely that there was a farm distillery here before this, since the site is close to one of the few crossing points on the Spey used by cattle drovers. The founder was Alexander Reid. In 1967 Macallan-Glenlivet became a publicly quoted company. Macallan produced one million gallons for the first time in 1970, but 93% of that went for blending. Two years later sales of bottled Macallan doubled; the board decided to conserve mature stocks and increased production by 24%. The number of stills was increased in 1974 (to 18) and 1975 (to 21), but that year there was a dramatic drop in orders from blenders – ‘the worst downturn in the distillery’s history’ – encouraging the Directors to allocate further stock for bottling as a single malt. Promotion of The Macallan as a single malt began in 1980 and immediately resulted in increased sales: by 1984 it was No. 3 in Scotland and No. 5 in the world. In 1996 Highland Distilleries (now Edrington) combined its shareholding with that of Suntory to successfully mount a hostile takeover of the company. Edrington took Macallan out of public ownership in 2001.

Style: Rich, robust, oily, and fruity.

Mature character: The Macallan is the benchmark ‘sherried’ style of malt (although it is now bottled in a parallel range of non-sherried whiskies). The nose is rich and chocolatey, with dried orange peel, dried fruits, sherry, nuts and a trace of sulphur. The mouth feel is smooth and voluptuous; the taste sweetish to start, but tannic-dry overall, with sherry, Christmas cake (burnt edges),

caramel. Fullbodied.

Comparable to: (Traditional) Glendronach, Glenfarclas (Fine Oak) Glenlivet, Cragganmore

Raw materials: Soft water from bore-hole aquifers on site. Floor maltings closed late 1950s. Unpeated malt mainly from Simpson's of Berwick-upon-Tweed.

Maturation: Dry-Oloroso sherry, European and American oak first and refill butts and hogsheads for traditional Macallan. Mainly refill bourbon barrels and American oak sherry-seasoned casks for the Fine Oak range.

Expressions: The Macallan went to market with proprietary bottlings in 1980, beginning with the 10YO for the U.K. and 12YO for export markets, followed by the 18YO in 1983, the 25YO in 1987 and the 30YO in 1998. Prior to this, only limited amounts were bottled each year. Core Range:

Since then there have been numerous expressions. Traditional Macallan (branded 'Sherry Oak', matured in sherry seasoned Spanish oak casks) is bottled at 10, 12, 18, 25 and 30 years old @ 40% or 43%. In 2004 a parallel range using a combination of Spanish and American oak sherry casks, and bourbon casks, branded 'Fine Oak', was launched with bottlings at 10, 12, 15, 17, 18, 21, 25 and 30 years @ 40% or 43%.

Travel Retail (introduced April 2009):

- The 1824 Collection: Select Oak NAS @ 42.8%
- The 1824 Collection: Whisky Makers Edition NAS @ 42.8%
- The 1824 Collection: Estate Reserve NAS @ 45.7%
- The 1824 Collection: Limited Release NAS @ 48%

Limited Releases:

Macallan releases limited and single cask bottlings every year, some only available from the distillery. Current leading examples are:

- The Fine & Rare Collection: single casks @ CS from 1937–1980 (limited,

introduced 2002)

- The Macallan Masters of Photography 1: Rankin 30YO @ 43% (limited, 2009)
- The Macallan Masters of Photography 2: Albert Watson 20YO @ 43% (limited, 2010)
- The Macallan 55YO Lalique Decanter @ 41% (very limited, second edition 2010)

The Fine and Rare Collection is a range of vintage Macallan currently dating from 1926 to 1976. Exceptional single cask bottlings are available at the distillery.

MACDUFF



Macduff Distillery was a child of the Sixties. It was built in 1960 by a consortium, which included Brodie Hepburn (whisky blenders in Glasgow, with interests in the recently built Tullibardine and Deanston Distilleries), trading as Glen Deveron Distillers Ltd. It was designed by William Delmé-Evans and incorporated several novelties which have now become commonplace, such as indirect firing by steam coils, shell-and-tube condensers and a stainless steel mash tun. Unknown in the U.K., William Lawson's blended Scotch sells around 15 million bottles annually, especially in Southern Europe and Mexico. Almost all the make from Macduff goes into this and other blends. Ownership was transferred to John Dewar & Sons when Bacardi acquired that company from Diageo in 1998.

Style: Malty, nutty-spicy.

Mature character: Medium-rich and sweet on the nose, with malty and sherry notes. The taste is sweet, with apples and pears, and perhaps mangos and papayas, then drying into nuts and cereals. Medium length; medium-bodied.

Comparable to: Glenrothes, Tullibardine

Raw materials: Unpeated malt from independent maltsters. Soft process water from bore-holes on site and springs. Cooling water from the Gelly Burn.

Maturation: No filling on site since 2002; tankered to Coatbridge, matured in Central Belt. Mix of firstfill and refill hogsheads and butts.

Expressions: Proprietary bottling is always Glen Deveron; independent bottlings Macduff. William Lawson introduced an 8YO in the mid 1970s and a 12YO in the mid 1980s.

- Glen Deveron 10YO @ 40%
- Glen Deveron 5YO @ 40% (Italy only)

MANNOCHMORE



Mannochmore is another example of Scottish Malt Distillers' building frenzy during the 1960s/early 1970s. Like several of the distilleries built during this period, in what became known as the 'Waterloo Street' style, efficiency was everything. Its original purpose was to provide fillings for the Haig blends, which had been market leaders in the U.K. during the 1950s/1960s, but which were now in decline. In 1996 a famous expression of Mannochmore, 'Loch Dhu – the Black Whisky', was heavily tinted with spirit caramel and was designed to be mixed with Coca-Cola or Ginger Ale. It enjoyed popularity in Denmark but nowhere else and was soon discontinued.

Style: Grassy.

Mature character: The nose is light and floral, fresh and bright, with breakfast cereals. The taste is Speyside-sweet, with a creamy mouth feel, fresh fruits and a woody dryness in the short finish. Lightbodied.

Comparable to: Glenlossie, Speyside

Raw materials: Lightly peated malt from Burghead. Water from the Mannoch Hills via the Barden Burn.

Maturation: Refill American hogsheads. Matured mainly in the Central Belt.

Expressions:

- Mannochemore 12YO @ 43% (Flora & Fauna series, from 1990)
- Mannochemore 22YO @ 60.1% (Rare Malts series, released 1997)
- Mannochemore 1990 18YO @ 54.9% (Special Release, 2009)
- Mannochemore 1990 18YO @ CS (exbourbon, Special Release, 2010)
- Mannochemore 1990 18YO @ CS (exsherry American oak, Special Release, 2010)
- Mannochemore 1990 18YO @ CS (exsherry European oak, Special Release, 2010)

MILTONDUFF



The distillery was built six miles south-west of Elgin, in the grounds of Pluscarden Abbey, on account of the quality of the water source. Not surprisingly, many illicit distillers used the vicinity in the late eighteenth century – around 50, it is claimed – and the present distillery, founded in 1824, is on the site of one of them, Milton, where once stood the abbey’s meal mill. The name was changed when the Duff family bought the land, hence Milton of Duff. It retains an old water wheel. It was acquired by William Stuart (a co-proprietor of Highland Park Distillery) in 1866, and the distillery was extended in the mid 1890s, at which time it was producing over one million litres of alcohol. In 1974/75 ‘modernisation visited Miltonduff with a vengeance’, raising capacity to 5.24 million litres per annum – one of the largest distilleries in Scotland.

Style: Sweet, grassy and fragrant, with some spice.

Mature character: Miltonduff has always been a blending malt, and the few expressions that have appeared as singles reflect this. The nose is grainy and malty, with some honey notes and light floral scents. The taste is sweet, with some fruit and nuts. Mediumbodied.

Comparable to: Dufftown, Longmorn

Raw materials: Unpeated malt from Kilgours, Kirkcaldy; own floor maltings removed in the 1970s. Process water from a spring on site; cooling water from the Black Burn.

Maturation: Mainly refill U.S. hogsheads, some firstfill.

Expressions: An official 15YO @ 46% was released in 2002 and Chivas Brothers released a few bottles in the summer of 2006. Otherwise Gordon and MacPhail have bottled under licence. Not currently bottled by its owner as a single, the make goes into the Ballantine's and Chivas Regal blends.

MORTLATCH



Mortlach was first licensed in 1823 to James Findlater, who used a site that had been formerly used by smugglers on account of the excellent water from Highlander John's Well. By 1842 it was owned by J. & J. Grant, who were building Glen Grant Distillery at the time and removed the distillery plant to their new site in Rothes. The granary at Mortlach was used as a Free Church, until one was built in Dufftown. Dr Alexander Mitchell Cowie became a leading figure in the whisky industry in the late 1890s and over the next 30 years he built a high reputation for Mortlach (it is ranked Top Class by blenders), doubling the distillery's capacity (to six stills) in 1897, when a private railway spur, shared with Glendullan, was installed. Unlike most malt distilleries, Mortlach stayed open during World War II, except in 1944. Most of the distillery buildings were demolished and rebuilt in the early 1960s.

Style: Heavy, meaty.

Mature character: A big, rich whisky. Dry fruitcake, with burnt edges, moistened with Madeira. Soft, full-bodied texture; hint of allspice in the taste. Long finish.

Comparable to: Dailuaine, Benrinnes

Raw materials: Floor maltings until 1968, now unpeated malt from Burghead. Soft process water from Guidman's Knowe springs; cooling water from springs in the Conval Hills.

Maturation: For proprietary bottlings refill European casks are used. Some matured on site, the rest in the Central Belt.

Expressions:

- Mortlach 16YO @ 43% (Flora & Fauna series, since 1990)
- Mortlach 22YO 1972 @ CS% (Rare Malts series, released 1995)
- Mortlach 23YO 1972 @ 59.4% (Rare Malts series, released 1996)
- Mortlach 20YO 1978 @ 62.2% (Rare Malts series, released 1998)
- Mortlach 32YO 1991 @ 50.1% (Special Release 2004)

NORTH BRITISH



In 1885 a group of independent blenders and spirits merchants banded together to build a distillery in Edinburgh for the supply of grain whisky, in response to the monopoly of D.C.L., with its 'varying qualities and fluctuating prices'. Their goal was 'to check a great monopoly and maintain a uniformly low price'. Andrew Usher II was the first Chairman, John Crabbie Vice-Chairman and William Sanderson Managing Director. A greenfield site was chosen, to the north of Gorgie Road and west of Dalry (and the Caledonian Distillery). It was well connected by railway lines and supplied with ample water from the Union Canal, which passed close by. After a period during World War II where distilling ceased the 1950s were years of expansion and modernisation. In 1993, management of the North British was assumed by Lothian Distillers Ltd, a partnership between I.D.V. and Robertson & Baxter. R. & B. changed its name to Edrington in 1999.

Style: Robust.

Comparable to: Cameronbridge, Invergordon

Raw materials: Maize mainly from the South of France. Water from reservoirs in the Pentland Hills. Drum maltings until 1948, then Saladin boxes until 2007, now green malt from independent maltsters. Note: it is the only remaining distillery to use green malt. Mixed in proportion 1:4 – the highest malt content of any grain whisky.

Maturation: Mainly U.S. exbourbon firstfill and refill casks; filled and matured at Muirhall, West Calder.

Expressions:

- The N.B. Centenary Blend was released for staff in 1985.
- North British 1980 12YO @ 61.5% (released 1992)
- North British 18YO @ 60.3% (released 1998)

OBAN



Founded in 1794, Oban is among the earliest surviving malt whisky distilleries. Its founders were John and Hugh Stevenson, local worthies with interests in slate quarrying, house building and shipbuilding in and around Oban since 1778. The town of Oban grew up around the distillery, which is squashed between the main street and a high cliff. After the West Highland railway line, connecting Oban to Glasgow, was opened, the town became a popular tourist resort, and whisky could be sent direct to market in Glasgow. In 1923 Buchanan-Dewar took over Oban Distillery, and thus it joined D.C.L. in 1925. The make was chosen by U.D. to represent the West Highland style in their Classic Malts series (1988).

Style: Fruity, lightly maritime.

Mature character: The seaside location of the distillery somehow communicates itself to the flavour of the whisky, in spite of it being matured inland. The nose is fresh and maritime, with seaweed and salt behind fresh fruits and a hint of smoke behind that. The mouth feel is soft and slightly oily; the taste is sweet, with dried figs and light spiciness, a trace of salt and a thread of smoke. Medium-bodied.

Comparable to: Scapa, Old Pulteney

Raw materials: Floor maltings until 1968; now lightly peated malt from Roseisle. Soft water from Lochs Gleann a' Bearraidh.

Maturation: Refill American hogsheads. Matured mainly in the Central Belt.

Around 4,000 casks on site.

Expressions:

- Oban 14YO @ 43% (Classic Malts series, from 1989)
- Oban Distillers' Edition 14YO @ 43% (re-racked into Montilla fino casks, from 1998)
- Oban 32YO @ 55.1% (Special Release limited to 6,000 bottles, 2002)
- Oban 32YO 1969 @ 55.1% (Special Release 2002)
- Oban 20YO @ 57.9% (Special Release 2002)
- Oban 18YO @ 43% (limited to U.S. only, released late 2008)

PULTENEY



The awkwardly named Pulteneytown is the fishing port of Wick. It was built as a model village between 1800 and 1820 and was named after Sir William Pulteney, Director of the British Fisheries Society. Pulteneytown was designed by the leading civil engineer, Thomas Telford, over the Spey. By the mid nineteenth century it was the largest herring port in Europe (and in the world, by weight of catch). The most northerly distillery on mainland Scotland, Pulteney was built in 1826 by James Henderson, whose family continued to own it until 1920. Passing through several hands over the years, it was sold to Inver House in 1995.

Style: Fruity, oily (almond oil), malty, heavy, meaty – complex.

Mature character: Heavy as new-make, Pulteney becomes lighter and fresher as it matures. The nose is distinctly maritime, with oily notes, and light, fresh fruit. The taste is dry overall, and slightly salty, with traces of nuts. Medium - to lightbodied.

Comparable to: Oban, Craigellachie

Raw materials: Soft process water and cooling water from the Loch of Hempriggs via the longest lade in Europe: 5.5 miles long, stone built by Telford to supply water to Pulteneytown. Maltings removed 1958; unpeated malt from independent maltsters.

Maturation: Mainly bourbon and a small number of exsherry casks. All whisky

bottled as a single is matured on site in seven dunnage warehouses (30,000 casks capacity).

Expressions: The single malt coming from the distillery has long been named Old Pulteney.

- Old Pulteney 12YO @ 40% (introduced 1997)
- Old Pulteney 17YO @ 46% (introduced 2004)
- Old Pulteney 21YO @ 46% (introduced 2005, I.W.S.C. Gold 2007)
- Old Pulteney 23YO @ 46% (exbourbon, introduced 2006 for world duty-free)
- Old Pulteney 23YO @ 46% (exsherry, introduced 2006 for world duty-free)
- Old Pulteney 30YO @ 44% (introduced 2009)
- Old Pulteney WK 209 'Isabella Fortuna' NAS @ 52% (travel retail, introduced 2009)
- Old Pulteney WK 209 'Good Hope' NAS @ 46% (travel retail, introduced 2011)

ROYAL BRACKLA



A map of Cawdor Estate from 1773 shows a 'malt brewhouse' on the site where Brackla Distillery was built in 1812. The founder was Captain William Fraser of Brackla, an irascible and outspoken gentleman, who inveighed against smuggling in the district before the Parliamentary Commission of 1821 and was repeatedly fined by H.M. Customs & Excise during the 1830s and 1840s for unknown offences! Notwithstanding this, Fraser was granted a Royal Warrant by William IV in 1835, the first distiller to be so honoured. The distillery was sold to S.M.D. in 1943, and a major refurbishment took place in 1964/65. Royal Brackla was mothballed from 1985 to 1991, but resumed production that year and underwent a £2 million refurbishment in 1997 – in time for it to be sold to Bacardi, along with John Dewar & Sons the following year.

Style: Malty and fruity.

Mature character: Fresh, floral and grassy, with notes of cream and light coconut and a whiff of smoke. Smooth mouth feel, with vanilla cream; sweet taste to start, with malt, apples and pears, and sometimes spice. Medium-bodied.

Comparable to: BenRiach, Benromach

Raw materials: Floor maltings until 1966; unpeated malt from independent maltsters. Process water from Cawdor Burn and cooling water from a spring opened during World War II.

Maturation: Five bonded warehouses, some dunnage, some racked (built 1975).

Today all Dewar's own stock is tankered to Coatbridge and Glasgow for maturation in mainly refill American oak.

Expressions:

The first bottling of Royal Brackla in recent years was in U.D.'s Flora & Fauna series (@ 10YO released in 1993). The 20YO Rare Malts bottling in 1998 at 59.8% won Best Whisky at the I.W.S.C. that year. Until recently the core range comprised a 10YO and a limited edition 25YO. Neither of these is currently bottled, but Dewar's have plans to repackage and bottle further expressions in the near future.

ROYAL LOCHNAGAR



Royal Lochnagar is Diageo's smallest distillery, and its showcase 'Malts Brand Home' used for V.I.P. visits and training, on account of its charm and picturesque location. Deeside was long a hotbed of illicit distilling. John Begg built New Lochnagar Distillery in 1845, close to Balmoral Castle, which was finished three years later for Queen Victoria and Prince Albert, and whose name was later immortalised by the slogan for his blended whisky, 'Take a peg of John Begg'. After Prince Albert was invited to inspect his 'works' the award of a Royal Warrant followed. Before long the distillery was calling itself Royal Lochnagar. During World War I the Directors approached D.C.L., which acquired the family's shares in 1916.

Style: Light and grassy. Small stills and worm tubs should produce a heavy meaty malt, but the way they are operated (with air rests to cool the copper stills, and warm water in the worm tubs) achieves this specification.

Mature character: Light toffee and planed hardwood on the nose, with some piney notes, boat varnish and linseed oil; dry overall. Sweet to start, then acidic, with an attractive lingering sandalwood aftertaste. Medium-bodied.

Comparable to: Aberfeldy, Glen Elgin

Raw materials: Process water from springs in the foothills of Lochnagar;

cooling water from two reservoirs. Unpeated malt from Roseisle maltings.

Maturation: American and European oak puncheons and butts. One dunnage warehouse on site, holding 31,000 casks (formerly the distillery's maltings). The remainder stored at Glenlossie Distillery.

Expressions: Three bottlings were released in the Rare Malts series: 24YO from 1972 @ 55.7%, 23YO from 1972 @ 59.7% and 30YO from 1974 @ 56.2%. The core range comprises:

- Royal Lochnagar 12YO @ 40%
- Royal Lochnagar Selected Reserve @ 43% (a limited annual vatting of four specially chosen butts, two European and two American oak)
- Royal Lochnagar NAS @ 43% (Special Release 2007)

SCAPA



The distillery stands beside the Lingro Burn and overlooks the spacious anchorage of Scapa Flow, where the German High Seas Fleet scuppered itself in 1919. Scapa Distillery was built by John Townsend, a Glasgow blender, in 1885 and operated until 1919 when it was narrowly saved from total destruction by fire, thanks to sailors from the Grand Fleet forming a chain of buckets from the sea. It then passed through various hands, until it was bought by Hiram Walker in 1954. It was modernised in 1978, mothballed in 1994, and from 1997 production was sporadic. A major refurbishment was undertaken by Allied in 2004, and they launched the first proprietary bottling and established a fan club. In 2005 ownership passed to Pernod Ricard/Chivas Brothers, who resumed production in October 2005, 120 years after it opened.

Style: Heather pollen, honey and light spice.

Mature character: Scapa has a maritime character, with faint saltiness on the nose, together with floral/grassy notes and some scented wood. The taste is dryish and lightly spicy, with some vanilla and toffee notes. Medium-bodied.

Comparable to: Highland Park, Dalwhinnie

Raw materials: Unpeated malt from Kilgours, Kirkcaldy; own floor maltings removed 1962. Cooling water from the Lingro Burn; process water from springs and the Coltland Burn.

Maturation: Mainly refill U.S. hogsheads, some firstfill.

Expressions: Independent bottlings only until 2004 when Allied introduced a 14YO @ 40%.

- Scapa 14YO @ 40% (reintroduced in 2006)

SPEYBURN



Speyburn is a picturesque distillery tucked snugly into a steep wooded glen just outside Rothes. It was designed for John Hopkins & Company (owners of Tobermory Distillery) by the leading distillery architect, Charles Doig of Elgin, and built from stones quarried from the adjacent riverbed. It opened in 1897. Speyburn is little known in most markets, but it is in the top six bestselling malts in the U.S.A., and No. 1 in Finland!

Style: Speyside: estery, floral, grassy, citric, but with a meaty note.

Mature character: A lightweight Speyside style: fresh and floral/fruity on the nose, with cereal notes. Predominantly sweet to taste, with green apples, pear drops and herbalheathery notes. Lightbodied.

Comparable to: Aberlour, Milntown

Raw materials: Own drum maltings until the 1967; now unpeated malt from independent maltsters. Soft process water from the Granty Burn, a tributary of the River Spey; cooling water from the Broad Burn.

Maturation: Mainly exbourbon casks, some European. 80% of spirit tankered and filled into cask at Airdrie; casks for bottling as a single matured on site in a two-floored warehouse, racked three high.

Expressions: U.D. bottled Speyburn as a 12YO in their Flora & Fauna series. Inver House now offer:

- Speyburn 10YO @ 40% (since 1992)
- Speyburn 25YO Solera @ 58.5% (introduced 2005)
- Speyburn Bradan Orach NAS @ 40% (the name means 'golden salmon', introduced 2009)

SPEYSIDE



In 1955 partners George Christie and Sandy Grant founded the Speyside Distillery & Bonding Company, and next year bought Old Milton Estate, Glen Tromie, three miles from Kingussie. In particular Christie was interested in Tromie Mills, a barley mill dating back to the eighteenth century, which had been run for generations by a local family, and continued until 1965. When restoration of the building commenced in 1967, the mill and water wheel were retained, and are still in working order. The first spirit ran on 12 December 1990. George Christie also founded Strathmore Distillery at Cambus, Alloa, in 1957. The company's HQ is in Rutherglen, Glasgow, where most of the make is matured, blended and bottled.

Style: Light, soft, sweet, vanilla, hint of liquorice.

Mature character: A light style of Speyside: predominantly cereal-like, with fresh apples and pears, and faint floral notes. The taste is sweet, with cereal and fruity notes. Lightbodied.

Comparable to: Arran, Tamdhu

Raw materials: Soft process and cooling water from the River Tromie, via the former mill lade. Traditionally unpeated malt from independent maltsters, with small annual matches of heavily peated malt.

Maturation: Mix of American barrels and remade hogsheads, with a small number of sherry casks. No bonded warehouses on site; matured in Rutherglen,

Glasgow, where the bottling plant is located.

Expressions: As well as its single malts, Speyside produces around 20 blended whiskies and Glentromie blended malt. It also bottles single casks from other distilleries, selected by its (now retired) Master Blender, Robert Scott, under the Scott's Selection label (at cask strength) and Private Cellar (at 43%).

- Drumguish (no age statement, introduced 1993)
- The Speyside 12YO @ 40% (introduced 2003)
- The Speyside 15YO @ 40% (introduced 2007)

SPRINGBANK



Springbank is the most traditional distillery in Scotland, and the only one, established in the nineteenth century, which is still in the ownership of its founding family. In all likelihood it was originally called Longrow Street Distillery (too easily confused with Longrow Distillery next door, it soon became Springbank), and is said to have been founded in 1828 by one William Reid. Springbank closed from 1926 to 1933, during the Great Depression, but was one of only three Campbeltown distilleries to survive the 1920s, when 17 distilleries closed in the town. Springbank currently makes around 150,000 litres of spirit per annum, and has no plans to increase this, owing to the fact that for periods of the year the staff devote themselves to malting and to distilling at Glengyle. In 2007 Springbank introduced a whisky school for enthusiasts.

Style: Springbank: light peatiness, oily, sweet and heavy. Longrow: heavy, sweet and distinctly peaty. Hazelburn: light, sweet, with hay and malt notes.

Mature character: Springbank needs long aging, and takes it superlatively well. At 10–15YO it only has ‘potential’: hints of strawberries and cherries and bananas on the nose, with distinct smokiness. A creamy mouth feel, with some butterscotch and mint, some sweet malt, a light smokiness. Mediumbodied, becoming fuller with age.

Comparable to: Highland Park, Bowmore

Raw materials: Soft water from Crosshills Loch. Own floor maltings; Springbank malt dried for six hours over peat (cut from near Campbeltown

Airport) and then for 18–24 hours over hot air. Longrow malt is dried over peat for around 27 hours, then hot air. Hazelburn malt has no peating.

Maturation: Mainly firstfill exbourbon barrels, followed by firstfill exsherry; around 20% refill casks; also Madeira, port and Demerara Rum casks. Six bonded warehouses on site; four traditional dunnage, two racked seven high. The entire make is matured on site.

Expressions: Many proprietary bottlings have appeared in recent years, including a number of limited edition ‘vintages’ (Springbank 21YO, 25YO and 32YO; Longrow 1989, 1990, 1991, 1992, 1993, 1994, 1995, mostly at 10YO), and since 2002 a series of Wood Expressions (finished in ex-port, sherry, rum, Tokaji and Barolo casks). The core expressions are:

- Springbank 10YO @ 46%
- Springbank 10YO @ 57% (100³ proof)
- Springbank 15YO @ 46%
- Longrow 10YO @ 46%
- Longrow 10YO @ 57% (100³ proof)
- Longrow 14YO @ 46% (sherry matured)
- Hazelburn 8YO @ 46%

STRATHISLA



Strathisla is the oldest working distillery in the Highlands, and is one of the most attractive in Scotland, tastefully restored in 1995 and a listed building. The distillery was founded in 1786 by a local worthy, George Taylor (flax-dresser, postmaster, banker), in partnership with the Duke of Gordon's factor, with a single 40-gallon still. Originally the distillery was named Milltown, which became Milton after 1825 (although the make was called 'Strathisla'), and in 1830 it came into the hands of William Longmore, banker and grain merchant. Most of the shares were subscribed by local people. It is interesting to note that Sir Robert Burnett & Company of London (the gin makers) were bottling 'Longmore's Strathisla' as a single in the 1880s, in 'immense quantities'. In 1950, Strathisla was sequestrated and bought for £71,000 by James Barclay, who immediately sold to the Seagram Company. Thenceforward the distillery was named Strathisla, after its product.

Style: Sweet, fruity and estery.

Mature character: Strathisla is a rich malt at its best, with deep fruity scents, including apricots and plums, sweet malt, sandalwood and even a whiff of smoke. It has a pleasant, full texture in the mouth and a sweet, sherried taste, becoming tannic/dry towards the end. Medium-long finish. Medium-bodied.

Comparable to: Glenrothes, Balvenie

Raw materials: Floor maltings until 1961; now unpeated malt from Paul's, Buckie. Production water from Fons Bulliens Well, which, it is believed, was

used by monks for brewing beer in the thirteenth century.

Maturation: Mainly refill U.S. hogsheads, some firstfill.

Expressions: Most bottlings (and there are some very old and fine ones) come from Gordon & Macphail.

- Strathisla 12YO @ 43% (reintroduced 2002)
- Strathisla 1991 15YO @ 55.4% (exbourbon cask, released 2004)

STRATHMILL



Strathmill began life in 1891 as Glenisla-Glenlivet, within a converted flour mill, itself built in 1823 and called Strathisla Mills. Its name was changed four years later when it was bought by the London gin distillers, W. & A. Gilbey (who already owned Glenspey Distillery and would later buy Knockando Distillery). It was from here that the first whisky tanker was used to carry spirit to the blenders. The tanker was named *Whisky Galore*, which probably dates it to the 1950s. In 1966 Strathmill was expanded to four stills, and purifiers were added to increase reflux and lighten the spirit.

Style: Light, grassy, malty.

Mature character: A light Speyside style, designed for blending (principally the J. & B. blends). The nose is sweet and estery, with floral and fresh-fruity notes (reminiscent of tangerine, oranges and sweet apples). The taste is also sweet, with fruity notes. Medium to light bodied.

Comparable to: Isle of Arran, Tamdhu

Raw materials: Process water drawn from a spring on site; cooling water from the Isla Burn. Non-peated malt from Burghead in Elgin.

Maturation: Sherry butts and refill hogsheads; six warehouses on site.

Expressions: Except for the two butts (25YO s) which were bottled in 1992 to celebrate the distillery's centenary, there are no official bottlings apart from:

- Strathmill 12YO @ 43% (Flora & Fauna series, introduced 2001)

TALISKER



Founded in 1830 by Hugh and Kenneth MacAskill, tacksmen (substantial tenant farmers), who had acquired the lease of Talisker House and its associated estate from Macleod of Macleod. Importing barley and coal and exporting whisky, all by sea, was costly. The MacAskills sold to the North of Scotland Bank in 1848, and two subsequent licensees went bankrupt before the distillery was bought by Roderick Kemp in 1879. Robert Louis Stevenson famously remarked in 1887: ‘The King o’ drinks as I conceive it – Talisker, Islay or Glenlivet.’ The distillery was extended in 1900 and the pier and cottages built. Until the stillhouse was rebuilt in 1961/62, following a devastating fire, Talisker was triple-distilled. A unique characteristic of Talisker is the peppery ‘catch’ as you swallow. No one knows where it comes from.

Style: Smoky and spicy, with maritime notes and high pungency. Its keynote flavour (for me) is chilli-pepper in the back of the throat.

Mature character: Talisker is always bottled at slightly higher strength than other whiskies, which enhances its pungency. It is elemental and maritime. Beaches, seaweed, salt spray, with spice, dried fruits and distant bonfires. The taste is sweeter than expected, with rich fruits, fragrant smoke and chilli pepper. Fullbodied.

Comparable to: Caol Ila, Highland Park

Raw materials: Mediumpeated malt (18–25ppm phenols) from Glen Ord Maltings (7–8 in final spirit). Production water from a burn rising on Cnoc nan

Speireag (Hawkhill) behind the distillery; process water from Carbost Burn.

Maturation: Mainly refill U.S. hogsheads; a small amount of refill European wood. 4,500 casks on site; remainder filled and matured in Central Scotland.

Expressions: Talisker is one of only a handful of malts bottled as singles in the early twentieth century. Until it was selected as a Classic Malt in 1988 it was bottled at 8YO, thereafter at 10YO. An oddity of the make is that it is traditionally bottled at slightly higher than standard strength. Very few independent bottlings have been done, since the malt is extensively used in the Johnnie Walker blends.

- Talisker 10YO @ 45.8%
- Talisker Distillers Edition @ 45.8% (finished in Amoroso sherrywood)
- Talisker 20YO @ CS (limited releases 2001, 2003)
- Talisker 25YO 1979 @ CS (limited releases 2001, 2004, 2005, 2006, 2007, 2008, 2009)
- Talisker 28YO 1973 @ 43.3% (limited release 2001)
- Talisker 57° North @ 57% (released 2008)
- Talisker 30YO @ CS (limited releases 2003, 2006, 2007, 2008, 2009, 2010)

TAMDHU



In 1896 three distilleries were planned for Knockando parish: Tamdhu, Knockando and Imperial. The moving force behind Tamdhu was William Grant, a Director of Highland Distilleries and agent for the Caledonian Bank in Elgin. The place he chose beside the Knockando Burn was well supplied with pure water from springs, and according to local tradition had been used by illicit distillers in days gone by. As important, it was adjacent to the Strathspey railway. Charles Doig was appointed to design it. According to Alfred Barnard, who visited two years later, it was one of the ‘most modern of distilleries’. The distillery went into production in mid July 1897. With the onset of the Great Depression, it closed in 1928, and remained so until 1948. Tamdhu was doubled in size (to four stills) in 1972, and two more stills were added in 1975. It was mothballed in 2010.

Style: Fresh honeyed apple, with a light smokiness. Good depth.

Mature character: Tamdhu is a ‘well-mannered’ malt, wellmade and displaying all the virtues of Speyside. The nose is sweet and estery, with fresh fruits (including Ogen melon), nail varnish remover and a hint of smoke. The mouth feel is voluptuous, the taste sweet and fruity, with a trace of peat. Mediumbodied.

Comparable to: Aberlour, Cardhu

Raw materials: Soft water from bore-holes on site and a spring beneath the distillery. Saladin box maltings since 1950, producing lightly peated malt, from

locally sourced peat.

Maturation: Exsherry, exbourbon, refill hogsheads and butts.

Expressions: Tamdhu was first launched as a single in 1976 (at 8YO); this became 10YO in 1979. The only available proprietary bottling today bears no age statement.

TAMNAVULIN



Tamnavulin was built by the Tamnavulin-Glenlivet Distillery Company, a subsidiary of Invergordon Distillers Ltd, in 1965/66. At the time it was one of only two distilleries in Glenlivet (the other being The Glenlivet; in 1973/74 they were joined by Braeval, originally named Braes of Glenlivet). It was equipped with six stills, reflecting the demand for Scotch at that time. It is utilitarian in design, although it enjoys an attractive situation in a steep glen carved by the River Livet. It is currently in full production, the malt being almost entirely used for blending.

Style: Light, sweet, slightly peppery and grassy.

Mature character: The label on the 12YO states 'Naturally Light' and this sums it up. The nose is fresh and herbal, with dried parsley, green vegetables, lemongrass, even a hint of camphor. The latter comes through in the mouth feel, which is cooling, even minty, with lemon meringue and camomile tea in the taste. Lightbodied.

Comparable to: Strathmill, Glen Spey

Raw materials: Unpeated malt from independent maltsters. Process water from springs in the Easterton surrounding hills; cooling water from the River Livet or Allt a' Choire.

Maturation: Mix of exsherry, exbourbon and refill hogsheads. Matured on site in racked warehouses.

Expressions: A number of limited edition Stillman's Drams have appeared, aged from 21 to 30 years, and there was an OB @ 12yo, now discontinued.

TEANINICH



The district around Alness, where stands Teaninich (pronounced ‘Chee-an-in-ick’), is Munro country. ‘Teaninich’ comes from ‘Taigh an Aonaich’ meaning ‘the house on the hill’. Captain Hugh Munro, who lost his sight owing to an injury sustained during the Napoleonic War, owned the Teaninich estate and built the distillery here in 1817. He was encouraged by the local lairds who were determined to stamp out the widespread illicit distilling in the county and wanted to provide farmers with an alternative legal outlet for their barley crop. It was closed from 1939 to 1946, as a result of wartime restrictions on barley supply, but otherwise has been in continuous production throughout its long life (except for 1985–1990). In the mid 1970s Teaninich was the largest of S.M.D.’s distilleries, with a capacity of 6m L.P.A.

Style: Grassy, oily.

Mature character: Teaninich is a robust malt, in the North Highland style. The nose is sweet and slightly waxy, with dandelion, green leaves, green apples and gooseberry notes. The mouth feel is smooth and mouthfilling, and the taste lightly sweet with citric hints and a thread of smoke. Mediumbodied.

Comparable to: Balblair, Glenmoangie

Raw materials: Process and cooling water from the Dairywell Spring. Unpeated malt from Glen Ord Maltings.

Maturation: Mainly refill exbourbon hogsheads, some ex sherry butts. New

make tankered to Menstrie for cask filling and maturation.

Expressions:

Three bottlings were released in Diageo's Rare Malts series:

- Teaninich 1972 23YO @ 64.9% (Rare Malts series, released 1995)
- Teaninich 1972 27YO @ 64.2% (Rare Malts series, released 1999)
- Teaninich 1973 23YO @ 57.1% (Rare Malts series, released 1996)

TOBERMORY



Tobermory Distillery has had a chequered history. Like Pulteney, the village itself was planned in the 1780s to be a ‘fishing station’ by the landlord, the fifth Duke of Argyll, with the encouragement of the British Fisheries Society, but one way or another Tobermory never became a serious fishing port. However, the distillery’s situation on the sheltered shore at the mouth of the fast-flowing Tobermory River met all supply requirements: water, barley, fuel and shipping of casks. The distillery may have been founded during this period – 1795 or 1798 – by John Sinclair Esq., ‘merchant’ and proprietor of Lochaline in Morvern, although he did not receive a charter to the land until 1823, and there is no sign of a distillery on the site in William Daniell’s engraving of Tobermory in 1813. It was originally named ‘Ledaig’. Tobermory Distillery was eventually sold to Burn Stewart Distillers for £600,000 (plus £200,000 for stock) in 1993.

Style: Malty and smoky.

Mature character: Historically, Tobermory has been variable. The ‘Standard’ 10YO is somewhat maritime and somewhat industrial (in the faint, oily smokiness); cereal notes abound, with light fruitiness. The mouth feel is soft and the taste dryish, with nuts and apple brandy, and a hint of smoke. Lightbodied.

Comparable to: Bruichladdich, Aultmore

Raw materials: Soft peaty water from Gearr a’Bkimm lochan above the distillery. Unpeated malt from Greencore and heavily peated malt (35ppm phenols) from Port Ellen maltings.

Maturation: Primarily firstfill and refill bourbon casks, with some exsherry casks. Small number of casks on site; rest matured at Deanston Distillery.

Expressions:

- Tobermory 10YO @ 40%
- Tobermory 1972 32YO @ 50.1% (Oloroso sherry cask, bottled 2005)
- Tobermory 15YO @ 43% (limited edition, released 2008)
- Ledaig Original @ 40%
- Ledaig 10YO @ 40%
- Ledaig Sherry Finish @ 40%

TOMATIN



Tomatin means ‘the hillock of the juniper’ (in Gaelic ‘tom – aiteann’), and at over 1,000 feet this is no mean hillock! The first distillery here, just off the A9 some ten miles south of Inverness, was built in 1897 by a group of local businessmen trading as the Tomatin Spey District Distillery Company Ltd. In the mid 1970s, with 23 stills, Tomatin had the greatest capacity of any malt whisky distillery – 12m L.P.A. per annum – and operated to capacity, consuming 600 tonnes of malt a week. It was the first distillery to introduce the Lauter mash tun from the German brewing industry (1974). Production was dramatically cut in the 1980s, and 11 stills were removed in 1997/98. Tomatin Distillers was sold to Takara Shuzo Company and Okura & Company of Japan, both long-standing customers – the first time a Japanese company had entered the Scotch whisky industry.

Style: Mediumbodied, but fresh and grassy.

Mature character: The nose is sweet, malty and aromatic with vegetal notes. The taste is sweet to start, with cereal flavours supported by caramelised fruits (orange especially) and assorted nuts. A very faint smokiness. Mediumbodied.

Comparable to: Fettercairn, Tomintoul

Raw materials: Water from Allt-na-Frithe, ‘the free burn’. Floor maltings until 1973. Unpeated and peated malt (2–5ppm phenols) from Simpson’s and Greencore.

Maturation: Mainly refill hogsheads; also sherry hogs, bourbon barrels and a small amount of new hogs from Speyside Cooperage. Finish in Spanish exsherry for about nine months to a year. 14 bonded warehouses on site with a capacity of c.197,000 casks.

Expressions: Usually classified as a Speyside, Tomatin describes itself on its label as Single Highland Malt. Vintages from 1967, 1975, 1980 and 1990 in 2007 and from 1973, 1982, 1997 and 1999 in 2009. Further vintages are released each year. The core range is:

- Tomatin 12YO @ 40% (which succeeded the 10YO in 2004)
- Tomatin 15YO @ 43% (introduced 2009)
- Tomatin 18YO @ 46% (introduced 2006)
- Tomatin 21YO @ 52% (introduced 2009)
- Tomatin 25YO @ 43% (limited release, introduced 2005)
- Tomatin 30YO @ 49.3% (limited release, introduced 2008)
- Tomatin 40YO @ 42.9% (limited release, introduced 2008)

TOMINTOUL



This functional-looking distillery was built in 1964/65 by two firms of whisky brokers and blenders in Glasgow (Hay Macleod Ltd and W. & S. Strong Ltd). The London-based blenders Angus Dundee Ltd took ownership in 2000.

Style: Light, fragrant, floral, fruity. Speyside, now also with a peaty variant.

Mature character: The bottle describes Tomintoul as ‘The Gentle Dram’. The style is light and delicate; the nose grassy, perfumed, lemony; the taste sweet, with breakfast cereal and nuts and a shortish finish. Lightbodied.

Comparable to: Tomatin, an Cnoc

Raw materials: Water from Ballantruan Spring. Malt from independent maltsters, usually unpeated.

Maturation: Mainly refill hogsheads; some firstfill and some Oloroso sherry butts. Six high racked warehouses on site (holding 114,000 casks in total). Many other sites used.

Expressions: First bottled as a single in 1974. Since Angus Dundee acquired the distillery they have released:

- Tomintoul 10YO @ 40% (in 2002)
- Tomintoul 16YO @ 40% (in 2003)

- Tomintoul 27YO @ 40% (in 2004)
- Old Ballantruan N/A (no age) @ 50% (in 2005, a peaty malt distilled in 2001)
- Tomintoul 1976 23YO decanter (bottled 2000)
- Tomintoul 12YO @ 40% (from ex-Oloroso wood, limited edition released 2007)

TORMORE



Tormore was one of several distilleries built to satisfy the post-World War II thirst for whisky, and the first to be raised from scratch on a greenfield site. It was built between 1958 and 1960 by Schenley International, U.S. agents for Dewar's. The design for the distillery was commissioned from Sir Albert Richardson, past President of the Royal Academy. A contemporary described it as 'a masterpiece of distillery architecture' and whisky writer Michael Jackson compared it to 'a spa offering a mountain-water cure'!

Style: Sweet, fruity and estery.

Mature character: Tormore's label describes it as 'The Pearl of Strathspey'; reflecting the whisky's 'brilliant appearance and honouring the freshwater pearl mussels flourishing in the pure clean waters of the River Spey'. A firm Speyside character with a malty, nutty (almonds, coconuts) nose. A pleasant, smooth texture and a sweet, honeyed taste, drying in the relatively short finish. Medium bodied.

Comparable to: Aberlour, Glenrothes

Raw materials: Unpeated malt from independent maltsters. Soft water from Achvockie Burn.

Maturation: Mainly refill U.S. hogsheads; some firstfill.

Expressions: Tormore was being promoted in North America by the early

1980s, and in 1991 Allied introduced its Caledonian Malts range (Miltonduff, Glendronach, Laphroaig and Tormore – the latter later replaced by Scapa). Previous proprietary bottlings were at 5, 10 and 15 years. Currently the official bottling is:

- Tormore 12 years old @ 40% (introduced 2004)

TULLIBARDINE



The distillery was designed and built by William Delmé-Evans in 1949 (the first ‘stand alone’ distillery – that is, not within another distillery – to be built since 1900, presaging the boom of the 1950s and 1960s). He went on to design Jura and Glenallachie distilleries. It was sold to Brodie Hepburn (whisky blenders in Glasgow) in 1953. In 2003 a consortium of whisky men bought the distillery and resumed production, having devised a cunning scheme to develop part of the site as an up-market retail centre – Tullibardine stands beside the main road (the A9) from Glasgow to the Highlands. Scotland’s most famous hotel and the first ‘country club’ hotel in the U.K., Gleneagles, is a neighbour.

Style: Sweet, fruity and malty.

Mature character: Tullibardine is remarkably consistent in its make. The key flavour is malt, balanced by a zesty fruitiness. The nose is all of this, and some peach and melon notes. The taste is sweet to start, then drying, with biscuits and light caramel in the middle. Mediumbodied.

Comparable to: Knockando, Dufftown

Raw materials: Soft water from the Danny Burn, with its source in the Ochil Hills, where the brewery water came from. Unpeated malt from Greencore Maltings, Carnoustie.

Maturation: Predominantly exbourbon barrels, with some Oloroso sherry and Pedro Ximinez hogsheads and butts. Racked warehouse on site.

Expressions: Small amounts of Tullibardine were bottled at 10YO by Invergordon and its successor, but never promoted. The new owner has released a number of single cask bottlings each year, at natural strength, including casks from 1964, 1965, 1966, 1968 and 1975. The core range comprises:

- Tullibardine 1993 @ 40% (since 2004)
- Tullibardine 1992 @ 46% (non chillfiltered, predominantly firstfill exbourbon casks)
- Tullibardine 1988 @ 46% (non chillfiltered, predominantly exsherry casks)

Also a wood-finished range @ 46%, mainly from 1993:

Currently portwood, Marsala-wood, sherrywood, Moscatelwood, Sauternes-wood, rum-wood.

- John Black 10YO blended malt @ 46% (peated style, introduced 2008)
- John Black 8YO blended malt @ 46% (honeyed style, introduced 2008)

Table of Contents

[Whiskypedia](#)

[INTRODUCTION](#)

[THE FLAVOUR MAP](#)

[THE FLAVOUR WHEEL](#)

[ABERFELDY](#)

[ABERLOUR](#)

[ALLT-A-BHAINNE](#)

[ARDBEG](#)

[ARDMORE](#)

[ARRAN](#)

[AUCHENTOSHAN](#)

[AUCHROISK](#)

[AULTMORE](#)

[BALBLAIR](#)

[BALMENACH](#)

[BALVENIE](#)

[BEN NEVIS](#)

[BENRIACH](#)

[BENRINNES](#)

[BENROMACH](#)

[BLADNOCH](#)

[BLAIR ATHOL](#)

[BOWMORE](#)

[BRAEVAL](#)

[BRUICHLADDICH](#)

[BUNNAHABHAIN](#)

[CAMERONBRIDGE](#)

[CAOL ILA](#)

[CARDHU](#)

[CLYNELISH](#)

[CRAGGANMORE](#)

[CRAIGELLACHIE](#)

[DAILUAINE](#)

[DALMORE](#)

[DALWHINNIE](#)

[DEANSTON](#)
[DUFFTOWN](#)
[EDRADOUR](#)
[FETTERCAIRN](#)
[GIRVAN](#)
[GLENALLACHIE](#)
[GLENBURGIE](#)
[GLENCADAM](#)
[GLENDRONACH](#)
[GLENDULLAN](#)
[GLEN ELGIN](#)
[GLENFARCLAS](#)
[GLENFIDDICH](#)
[GLENGARIOCH](#)
[GLENGLASSAUGH](#)
[GLENGOYNE](#)
[GLEN GRANT](#)
[GLENGYLE](#)
[GLEN KEITH](#)
[GLENKINCHIE](#)
[THE GLENLIVET](#)
[GLENLOSSIE](#)
[GLENMORANGIE](#)
[GLEN MORAY](#)
[GLEN ORD](#)
[GLENROTHES](#)
[GLEN SCOTIA](#)
[GLEN SPEY](#)
[GLENTAUCHERS](#)
[GLENTURRET](#)
[HIGHLAND PARK](#)
[INCHGOWER](#)
[INVERGORDON](#)
[JURA](#)
[KILCHOMAN](#)
[KNOCKANDO](#)
[KNOCKDHU](#)
[LAGAVULIN](#)
[LAPHROAIG](#)

[LINKWOOD](#)
[LOCH LOMOND](#)
[LOCHSIDE](#)
[MACALLAN](#)
[MACDUFF](#)
[MANNOCHMORE](#)
[MILTONDUFF](#)
[MORTLATCH](#)
[NORTH BRITISH](#)
[OBAN](#)
[PULTENEY](#)
[ROYAL BRACKLA](#)
[ROYAL LOCHNAGAR](#)
[SCAPA](#)
[SPEYBURN](#)
[SPEYSIDE](#)
[SPRINGBANK](#)
[STRATHISLA](#)
[STRATHMILL](#)
[TALISKER](#)
[TAMDHU](#)
[TAMNAVULIN](#)
[TEANINICH](#)
[TOBERMORY](#)
[TOMATIN](#)
[TOMINTOUL](#)
[TORMORE](#)
[TULLIBARDINE](#)