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EDITOR'S THOUGHTS

A Faith ful Fireside Whiskey in the Autumn air



ust when we were getting comfortable in our summer sandals, along comes fall. And with it, change. We feel the cold start to whisper a change of season. The colours turn and we start to add layers on our outings. The air changes and we sit awhile by the fireside. The wardrobe changes, an update here, a donation there, and the tastebuds change. Time for something new in the collection, don't you think? Change is good, after all, as they say.

In this spirit of change, we introduce you to our fall issue. Have you noticed? Women like whisky too! And, they know their stuff. The remarkable Cara Laing takes us back in history 75 years to tell us about the legacy that is Douglas Laing & Co. in our cover feature. Blue Run Spirit's, whiskey director, Shaylyn Gammon sits down with us to tell us all about this playful inventive brand. Nc'Nean Spirits, an organic distillery, teaches us, the environment can be considered and cared for in the whisky world. Even from the remote coastal Scottish highlands. And many more stories await. Best of all, the community of whisky enthusiasts can meet this season at the annual Ottawa Whisky show, as well as new locations in Oakville and Calgary.

It's an exciting time to pour a glass and savour the season. Enjoy our whisky pages and allow your senses to be overtaken. With a glass in hand, we begin our adventure.

total which we

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FALL 2023 PUBLISHED QUARTERLY ISSUE 32

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Find all the answers, if you need them, here







lue Run Spirits was launched in 2020 by Mike Montgomery. Soon Montgomery had some top-notch talent on his team, including Jim Rutledge, who serves as his "liquid advisor," and Shaylyn Gammon, the brand's Whiskey Director. The brand is currently sourcing barrels but has recently announced plans to build a brand-new distillery in Kentucky. We recently caught up with Shaylyn Gammon to learn more about the brand and her role at the company.

MK: Did you always know that you wanted to work in the Bourbon industry?

SG: I had a serendipitous "field trip" during college to a major alcohol company and fell in love with sensory science, specifically - something I didn't quite realize existed within the alcohol space. I found the science matched with traditional craftmanship to be utterly fascinating. That trip planted in me a seed of determination to one day work in this aspirational industry.

MK: You've worked with some legends in the industry, including Jimmy Russell and Jim Rutledge. What has that been like?

SG: Working with Bourbon Hall of Famers like Jim Rutledge, Jimmy Russell and Eddie Russell has been nothing short of amazing. I can even count the legendary Peggy Noe Stevens as one of my mentors. I started working with the Russells when I was 24, largely and blissfully unaware



of my good fortune. As I spent more and more time with them, I began to realize the magnitude and specialness of their mentorship. I've, of course, gone on to apprentice under Jim Rutledge and have learned more than I thought was possible in such a short time. What impresses me the most about all these talented individuals is their open willingness to share their knowledge. They are so proud of what they do that they proactively share it with anyone who is interested. To me, that is the sign of a true master craftsman - someone who wants to pass their knowledge down to the next generation.

MK: As someone with a technical background in food science, do you think it's necessary to have that technical background to work in the distilled spirits industry?

SG: It depends on what position one is in. If you're entering Quality, R&D, Distillery Operations, etc. then yes, it is vital. Although you will undoubtedly go on to receive a "secondary education" on the job. I would argue a technical background is helpful in any position beyond even those listed above as it gives a more wholistic understanding of how things work.



Even with my experience in innovation at Campari, I learned much more beyond just creating a product. I learned how it is marketed and sold to the consumer. There are so many aspects of how to bring a product to market, that while general instincts and super taster senses are great to have, there are technical aspects of the job that really help to lift a product to the next level.

MK: What is your day-to-day like as the Whiskey Director for Blue Run Spirits?

SG: A typical day at Blue Run has a good amount of variety — just the way I like it. Some days are spent entirely on the computer, planning and reconciling inventory, while many other days are spent in the lab assessing samples, blending, planning, and creating. Still other days, I am out in production at a distillery watching our runs, dumps, and bottling and helping to ensure quality. I will say this: there is never a dull day when you are making whiskey!

MK: What are you most excited about with the new distillery Blue Run is building?

SG: Creating something as tangible as an amazing distillery, it's thrilling to think about being able to share our vision of the brand with the public. It takes some of the mystery out of how Blue Run is created, which I think is great. I am a big fan of transparency when crafting a whiskey. Having your own distillery allows people to see, hear, touch, smell, and taste Blue Run as we intend it to be experienced. It also allows us to meet our customers face to face, which is invaluable. I love hearing what people like about our





whiskeys and what they think we might improve upon. I also look forward to having my own space to create, dream, and share.

MK: What can Blue Run fans expect to see when they get that first chance to visit the Blue Run Distillery?

SG: I can't reveal anything right now, but I can tell you what is planned is unlike anything folks have seen in the past, in keeping with how Blue Run has approached its entire business.

MK: Do you have any favorites among Blue Run's products?

SG: Asking a whiskey maker to pick their favorite whiskey is like asking a mother to pick her favorite child! If I have to pick, I would say High Rye Bourbon stands as a tried and true, and the Flights Microblends from last fall are more of a favorite creative expression.

MK: For readers who may not be familiar with Blue Run, what would you like them to know about the brand?

SG: Great question! At Blue Run, we value inclusivity, playful/youthfulness, and innovation. We want you to feel these company and brand values when you partake in any of our products.

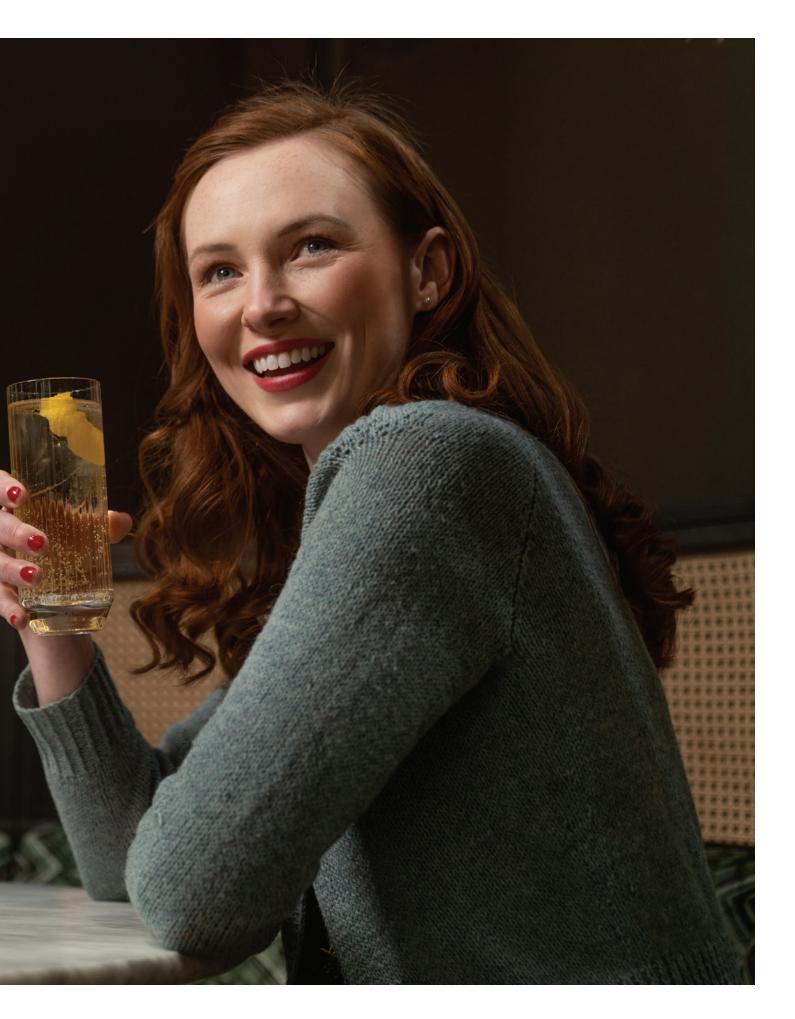
MK: How does Blue Run choose grains for its products?

SG: For all of our own distilled product that will be coming of age in the upcoming year, our grains come from only a handful of known, trusted sources. All of these grains are non-GMO.

MK: What's next for Blue Run Spirits?

SG: Next up for Blue Run is a great mix of new, innovative products as well as some reappearances from past favorites, in the form of new batches. You can look for blends, some age-stated products, and plenty more!







Conducted in June 2023, the SIP
Consumer Insights: Canadian Whisky
Survey sought quantitative and qualitative feedback from 831 Canadians, of
which more than 500 of the respondents
were women. The survey found that
over 67.7 percent of female respondents
were fans of Canadian whisky with an
additional 20.3 percent noting they were
'sometimes a fan' but it depended largely
on which brands and how the whisky
was served. Only 15 percent of female
respondents noted that they flat out did
not like Canadian Whisky.

Further to this, women also selected 'whisky' as the second most preferred alcohol category in comparison to wine, beer, and other spirits.

In fact, a majority of respondents, both male and female, preferred whisky in comparison to other alcohol categories, however, the specific types of Canadian whisky and methods by which to enjoy it, were quite varied between the sexes.

Canadian Whisky Isn't Trendy, It's For Everyone

Despite the majority of Canadian women noting that they had an appetite for Canadian whisky, it was not seen as top quality in comparison to other countries' whiskies, nor was it seen as trendy.

When asked where female respondents thought Canadian whisky sat in relation to other styles of whisky, such as bourbon or American whiskey, Irish whiskey, Japanese whisky and Scotch, only 5.0 percent noted that they 'see it as the best' whereas a majority noted that they either 'prefer other whiskies over Canadian whisky' or it was 'just okay' in comparison to other whiskies. Similarly, when asked if there was a certain image associated with Canadian whisky, only 5.1 percent of respondents thought it was 'trendy.'

One of the main reasons that respondents thought Canadian whisky was

not perceived as 'trendy' or 'the best' was attributed to how Canadian whisky as an industry is advertised. One respondent noted, "I think [Canadian whisky] is understated and poorly marketed so it is left on the shelf to many due to that." Along similar lines, another respondent mentioned that "Canada has generally done a poor job promoting their whisky."

Julie Federman, an Ontario-based whisky reviewer and the creator of Red Lip Whisky Diary believes that "the industry is emerging, maturing, and full of anticipation, but still commonly misunderstood."

About a third of survey respondents, both men and women, believed that Canadian whisky still has a perceived image as a 'cheap mixing whisky.' Cheap doesn't necessarily mean it's considered 'bad' in the minds of consumers, rather, it's actually perceived as approachable. Only 8.2 percent of women thought that Canadian whisky was intimidating for



new drinkers and 36.9 percent agreed that Canadian whisky does not have a certain image associated with it, rather, it's 'something for everyone.'

Flavour Profile Preferences

In April 2023, two in-person blind whisky tastings were conducted by SIP Spirits Consulting in Vancouver, BC, for 75 participants total. The attendees were made up of 55 percent women and 45 percent men. During these 90 minute sessions, participants blind tasted and ranked eight Canadian whiskies on a nine-point hedonic scale ranging from '1', which meant they disliked the sample extremely, to '9', which meant they liked the sample extremely.

The eight samples included two corn-predominant whiskies (Wisers 10 Year and Bearface 7 Year Triple Oak), three high-rye whiskies (Reifel Rye, Dillons Rye, and Lot 40 Dark Oak), and three single malt whiskies (Shelter Point Evans Family Reserve, Two Brewers Batch 39, and Macaloney Island Distillery's Invernahaven).

For participating women, the top three whiskies based on their highest average scores were Bearface 7 Year Triple Oak, Lot 40 Dark Oak, and Reifel Rye. In comparison, Lot 40 Dark Oak, Two Brewers Release 39, and Shelter Point Evans Family Reserve were the top three choices for men.

Regardless of their relative rankings, looking at the averaged blind tasting

scores of each whisky and comparing the scores between men and women, women scored the corn-predominant whiskies higher on average in comparison to men, whereas men scored the rye and single malt whiskies much higher, on average, than women. For example, the average score for Bearface 7 Year Triple Oak was 6.33 for women, and only 5.78 for men (out of 9.0). Conversely, the average score for Two Brewers Release 39 was 6.91 for men, and only 5.8 for women.

These in-person results seem to have similarities to the findings from the online survey (SIP Spirits, 2023). When asked which Canadian whisky distilleries and/or specific bottles respondents would recommend a friend purchase, the top recommendations by women were Crown Royal Deluxe, Forty Creek (Distillery), Canadian Club 1858, Lot 40, and Wisers (Distillery), whereas the top recommendations from men were

Shelter Point (Distillery), Lot 40, Two Brewers (Distillery), Bearface 7 Year, and Alberta Premium.

Does this mean that women, in general, don't like single malt whiskies? Perhaps not. It could simply be that they haven't had the opportunity to try any yet. 77.7 percent of men were aware that some Canadian distilleries produced single malt whiskies, whereas only 56.8 percent of women were aware of this.





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The Perfect Serve

While more than 50 percent of men surveyed said that they prefer to drink Canadian whisky 'neat', only 22 percent of women preferred it served that way. Instead, more than 50 percent of women preferred to drink Canadian whisky in a cocktail and 33 percent also preferred to drink it with a mixer.

In addition, when asked 'what would make you try a new Canadian whisky,'



the majority of both men and women noted that a referral from a friend and high reviews from a trusted source would influence their purchase decisions. Most interestingly though, 58 percent of women noted that 'suggestions on how to enjoy the whisky (i.e. cocktail recipes)' would influence their decision to purchase, but only 27 percent of men felt the same way.

Which cocktails and mixers do women prefer specifically? Overwhelmingly, the Whisky Sour was the top choice by women with the Old Fashioned and Manhattan trailing significantly behind to round out the top three preferences. Ginger Ale, Coca Cola, and Ginger Beer were the top mixers that women preferred.

The Future is Female

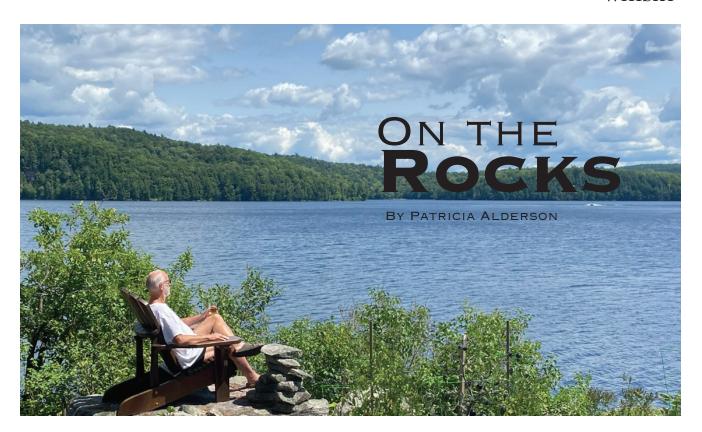
Based on these findings, there is an enormous opportunity for Canadian whisky brands to appeal to female consumers via cocktail recipes, canned cocktails, and highballs. The market for canned vodka sodas is booming, however, it has become saturated. On the other hand, there are only a handful of whisky brands that have entered Canadian markets with ready-to-drink alcoholic canned beverages.

The canned beverage format is particularly appealing for off-premise occasions. Fortunately for brands, more than 60 percent of women noted that they were most likely to drink Canadian whisky either at home or at a social gathering, versus just 25.9 percent who would most likely drink it at a pub/bar and just 9.6 percent that would drink it at a restaurant.

Canadian distilleries looking to tap into the female consumer market need to place a greater emphasis on cocktail programs at bars/pubs, as well as cocktail suggestion neck tags, cocktail co-packs, bottled cocktails, and ready-to-drink cans in retail. And in terms of trial-by-taste, while whisky tastings and in-store sampling will always be essential activations, branded cocktail masterclasses could be a complementary offering that would appeal to a large number of Canadian whisky-loving women.







hil Dangerfield does some of his best thinking on the rocky shore at his Haliburton Lake property in Ontario. Reflecting on the success of Whisky Ottawa one evening, the answer to a nagging issue became as clear as the crystal of his favourite whisky glass. It was finally time to expand.

Whisky aficionados from across Canada joined locals at Whisky Ottawa each year but voiced their wishes for the same expertly produced event closer to home. The pandemic knocked back Phil's initial plans to grow, but now that people were ready to mingle again, the inauguration of Whisky Canada Events moved from the back burner to Phil's ASAP list. The result? This fall, the same high-quality experience will reach whisky enthusiasts in Ottawa, Oakville, and Calgary.

As Executive Director of Knowledgeable Consumption, the corporate, not-for-profit organization behind Whisky Canada Events, Phil knows the same educational focus followed in Ottawa is the right approach for Oakville

and Calgary. All three locations will strengthen the quality and value of annual whisky events by showcasing whisky brands to an increasingly informed consumer. "It's often said, the educated consumer is our best customer - we believe if we're not educating people, we're limiting their opportunity to appreciate the wide selection and sophistication level

offered by Canada and the world's whisky industry, "says Phil.

"Raising awareness and building knowledge about the family of whiskies is our goal," says Phil. "We had a guest comment after last year's Ottawa event that he now has a better understanding of what Canada brings to the whisky front, and that whisky in Canada is so



diverse, it reflects Canada itself - that is so true!"

While the Grand Hall tasting experiences are always popular and a great experience, Phil notes the rise in popularity of a Masterclass series. "These always sell out and are a fantastic way to learn the science behind whisky development and what makes each unique. It's an incredible learning opportunity we're thrilled to offer at all three locations this year."

"This expansion would not be possible without the staunch support of the whisky industry. Vendors and producers understand the value an educated consumer brings to their business, and an annual experience where clients and consumers talk whisky directly with makers, sample their selections, and participate in masterclasses helps grow knowledgeable product enthusiasts."









Phil emphasizes it's not just the attendees who enjoy the event. "We get amazing feedback from vendors. They love the one-on-one and chance to nerd out with whisky fans! Vendors appreciate the chance to share their expertise, as the more individual whisky fans learn, the more they appreciate a particular brand and whisky in general. That's the opportunity in a new show like Whisky Oakville or Whisky Calgary - it's a chance to build your customer base."

Meticulous planning and production means Whisky Canada's expansion offers an experience not to be missed. Phil promises not to show up in his cottage country attire and will happily share his thoughts on how listening to loons on a calm summer lake leads to big things. ◆





A fter that first impression, you also might pick up a little ripe stone fruit, bright orange and vanilla in this exceptionally easy-drinking limited-release single malt from Nc'nean, an organic distillery in a remote coastal region of the Scottish Highlands. Released in autumn 2022, "Lorna" is only the second bottling in the Quiet Rebel series, a project that sees blender Matt Hastings craft a bespoke whisky reflective of the taste of one member of the team that works in the distillery.

The first Quiet Rebel was Annabel, a blend designed for Annabel Thomas, CEO and founder of the Nc'nean, named after Neachneohain, the Gaelic goddess known for being a protector of nature, walking her own path and, to boot, being the "Queen of Spirits."

The second bottling honours Lorna Davidson, a distiller and the first person to sign on to work at Nc'nean, before there was even a proper facility. "Matt will sit down with the person with loads of whiskies to try, to try and figure out what it is they really like," explained Thomas. "And then he picks a cask from the warehouse or he starts sourcing finishing casks that fit what they're trying to do.

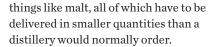




"There are these sweet donut-like things in Marks and Spencer called Yum Yums that are basically all sugar and Lorna was like, 'that's my favourite thing'." So there's a distinct powdered sugar note to be found in Quiet Rebel Lorna. And, if this release seems surprising, consider that it's a well-deserved reward for Davidson who, Thomas recalled, "heroically" catered food for everyone during the build stage, since they had to stay on site, at a spot that's way too far away from anything for Uber Eats to work.

That's an indication of just how remote Nc'nean is. And, this isolation has presented numerous logistical challenges, starting, of course, with the build, but not, by any means, ending with that. It was quite a feat, for instance, getting a "massive" biomass steam boiler down a very narrow single-track road, but that road has to be factored into every delivery, including regular shipments of





This begs the question: "Why set up shop in such a far-flung region?" Well, the obvious part of the answer is that this is where Thomas' family farm is located and, for years, the clan had dreamed of opening up a whisky distillery there. There's more to it than that, though. "Part of the reason we've done this is because we wanted to create long-term, sustainable, skilled employment in a very remote area," she explained. "And if we had set up a distillery in the city, we wouldn't need to create that employment."

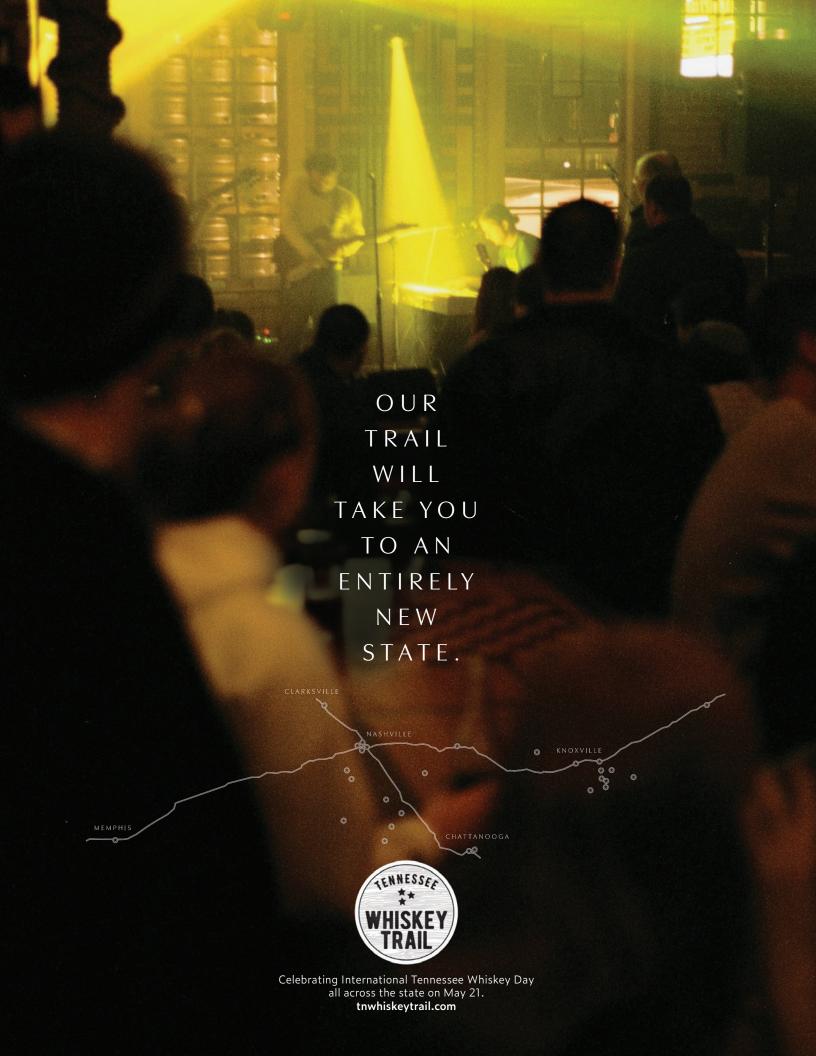
Thomas, herself, had what people in the United Kingdom call a "city job" as a





strategy consultant back then but, roughly a decade ago, decided it was time for a change. Her vision, though, was far more ambitious than a run-of-the-mill farm distillery. When it opened in 2017, it was Scotland's first organic distillery, and is now only one of two Scottish distilleries to be certified as a B-Corp—a "benefit corporation" that balances shareholder profits with social and environmental good. (The other is Bruichladdich.)





Thomas has been asked to speak about sustainability more times than she can count, including at the 2022 World Whisky Forum held at the Stauning distillery in Denmark and, that same year, in Glasgow at the United Nations Climate Change Conference. Nc'nean has become a prominent leader when it comes to sustainability and transparency in a short period of time but, she added, it's not just her. The industry—and the zeitgeist—has changed a lot over that decade as well. "It's really interesting to look at how quickly this has changed because, when we were fundraising, I had a number of conversations with potential investors about things like the biomass boiler which cost over half a million pounds to install," she recalled. "Compared with an oil-burning boiler, in pure monetary



terms on a spreadsheet, it didn't really make financial sense, but it was the right thing to do. "You would never have that conversation now," she added. "Even if they were thinking it, they wouldn't dare say it, so for that to have changed so radically in eight years is really interesting."

Boilers are one thing. Sourcing organic and sustainably grown grain is another. Thomas recalled that, at the outset, when she asked a maltster about sourcing biodynamic barley, he looked at her like she was "off her rocker." At the time, a lot of people also told her that organic barley was an expensive waste of time.



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taste like Yum Yums-or any confectiondespite the name. Instead, it's a complex spirit with pronounced bright herbal notes and a creamy mouthfeel. Neither of the two whiskies, perfectly match their names this year. There's one name, though, that couldn't be more on-point, namely, Nc'nean, which perfectly describes this nature-protecting and fiercely independent "Queen of Spirits" that promises to change the way we talk about sustainability in the industry. Even more than it already has. ♦



"It's true that it's expensive, but we chose to be organic because, again, we felt that it was the right thing to do," she said. "Having made the whisky, what we discovered is that we feel like the organic grain brings a beautiful texture, sort of a lovely, oily, buttery quality to the whisky, which I feel is like karma."

Indeed, the flagship Organic Single Malt has a bit of a buttered toast note, which

balances out the warm spicy notes on the palate perfectly. All the whisky made at Nc'nean is organic, though, whether it's the core single malt, the Quiet Rebel expressions or the limited-edition Huntress series, a very small release of about 5,000 bottles that comes out every spring. (Nc'nean is new to Canada, but I had a chance to taste samples of releases that are no longer available. The Organic will be available soon, as will future



MILLSTONE DUTCH SINGLE MALT WHISKY







ometimes you savour a whisky slowly, not paying attention to the label, noticing the symphony of flavours and the way they harmonize on your palette. You return to the whisky and are surprised that it's different from your go-to. It's better. What makes a whisky worth savouring like that?

Whisky snobs might judge a whisky's worth on age and origin. True whisky lovers understand a whisky worth savouring is personal. For the coowners of Bridgeland Distillery, Daniel Plenzik and Jacques Tremblay, a good

whisky is no accident. Personal preference, local ingredients, and attention to detail are the winning ticket.

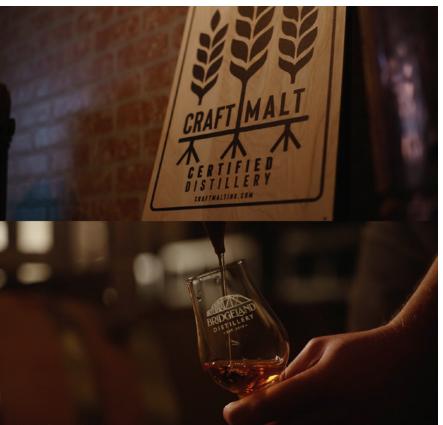
It starts with terroir. Often associated with wine, whisky labels also reference the geographical location. Daniel and Jacques believe Alberta can be put on the whisky map. Although traditionally not a whisky region, the terroir is ideal for growing grain. Bridgeland drinkers can trace their whisky back to the precise fields of Penhold, Alberta. Where, after the barley is malted on the farm, it's transported

100 kilometres to the heart of Calgary.

The fermentation, distillation, and aging process flows with the local climate — the high-pressure chinooks, dry summers, and cold winters. The result is a whisky that showcases the freshness of local ingredients. "When our farmers declare, 'I can taste my fields,' that's precisely what we strive to share with the world," Jacques mentions.

The foundation of local ingredients intertwines with tradition. Bridgeland uses pot stills and similar Scotch whisky







process that's old-fashioned - the concept of small-batch distilling and the connection to the land is a story as old as time.

Being traditional doesn't take away from innovation. New barrels impart a richness rarely found in single malt whiskies around the world.

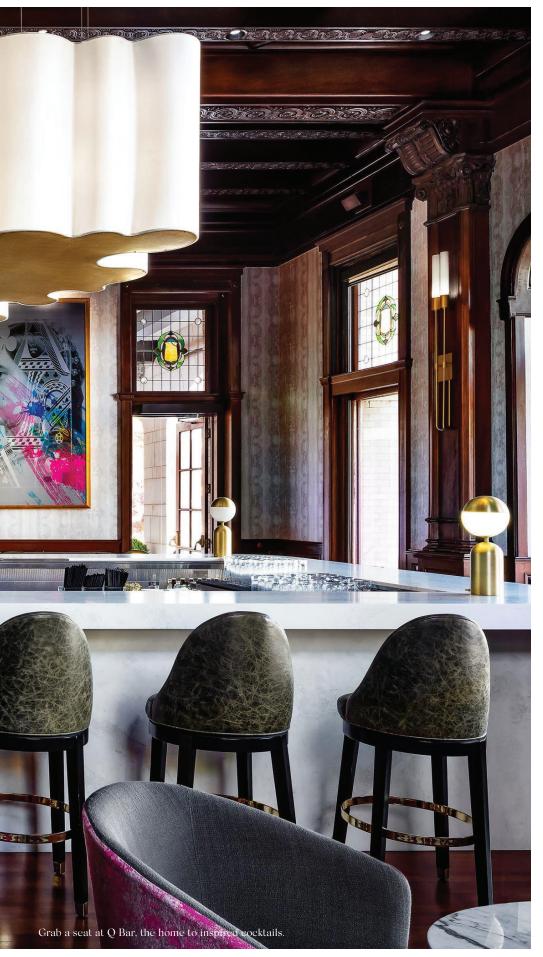
The intriguing yet comforting result is seen in The Artisan's Collection. The Wheat Whisky with Moscato Brandy Finish nods to the terroir, being different without being too unusual. Daniel notes, "It all comes together when you pick up a bottle and you pour it for a friend. Their eyes light up and they say, 'wow, what an incredible whisky."

While the approach may seem novel, Jacques and Daniel believe it's the path to creating exceptional whisky. Whisky critics seem to agree. Since Bridgeland Distillery was founded five years ago, their whiskies have won many awards. Most recently, Glenbow Single Malt won a silver medal at the 2023 London Spirits Competition.

Daniel and Jacques are proving that while age and origin are important, they're only part of what makes a good whisky. The experience is what brings it all together. Bridgeland Distillery welcomes visitors to learn the history of the beverage with behind-the-scenes tours and grain-to-glass tastings in

In this way, creating a good whisky is like baking a cake. While a family recipe is a starting point, the goodness lies in quality ingredients, personal touch, and the memories around it. This dedication creates a whisky worth savouring. ◆

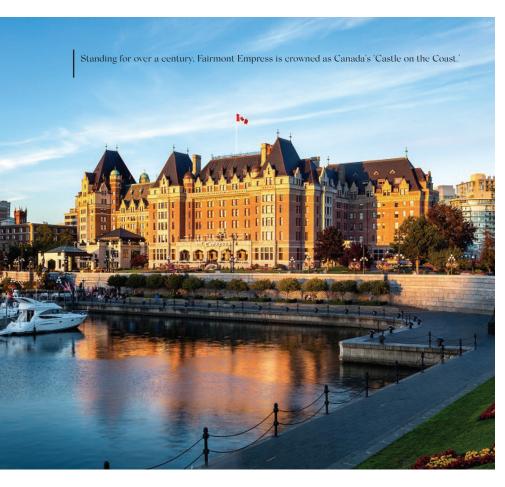




Indulge in the Allure of Whisky Cocktails: A Luxurious Fall Experience

By Fairmont Empress

s the crisp autumn air settles in there is no better way to embrace the season's charm than by savouring an exquisite drab of whisky on the west coast. Nestled in the heart of Victoria. BC, stands the historic Fairmont Empress, a prestigious luxury hotel with unparalleled views of the city's Inner Harbour and an inviting ambiance that exudes warmth even on the chilliest of fall days. In extending a warm welcome, the hotel has a new selection of whisky comforts that await your arrival.



The internationally acclaimed Fairmont Empress, crowned as Canada's 'Castle on the Coast,' is celebrating its 115 anniversary and welcoming those near and far to come and stay—and try their new fall drink menu. With a focus on pleasing even the most refined palates, the fall concoctions promise to deliver an unforgettable experience for spirit connoisseurs and enthusiasts alike.

To create an enriching west coast experience, the hotel is offering guests the opportunity to cozy up and unwind with a peaty drink by a crackling fire at the hotel's Veranda restaurant. Fairmont Empress has thoughtfully designed an authentic whisky tasting experience that immerses all guests in the natural beauty that is found on the Pacific West Coast. Guests can try any cocktail of their choosing to have by their side while watching the oscillating waves and enjoying the comforting glow of the flames.

One may order a whisky flight if they wish to be totally surrounded in a gentle cast of warmth by the fire. The Aging Up Flight includes Dalmore 12, 15, and 18. It is available on the Veranda or in the comfort of Q Bar's warm wood interiors. It offers a variety of rich and complex flavours to compare and

discover, providing a unique opportunity to savour the nuances of each expression.

An Aging Up Flight can deliver a memorable experience for you and yours, while deepening your appreciation for the art of the whisky. The hotel's mixologists have also re-imagined classic whisky cocktails to allure guests into a world of indulgence. New this fall is "Into the Woods", a delicious twist on the classic Old Fashioned. The cocktail features Woodford Reserve Bourbon Whiskey, spruce tip syrup, hickory and rootside Cascadian Bitters-and suits a smoky and woodsy palette. It is finished with a tableside smoke infusion which perfectly pairs with the fireside setting on the hotel's Veranda.

Contrasting the Into the Woods cocktail is a captivating new libation called Naughty & Nice. The drink is designed to leave a fresh and balanced flavour on the palate for those who step inside the posh setting of the Q Bar. The cocktail strikes a perfect balance between fiery and refreshing elements, intertwining elements of sweetness, spice, and effervescence in perfect harmony. The tantalizing libation combines the rich and distinct flavours of Calvados and Hennessy VS with the zesty kick of lemon and the

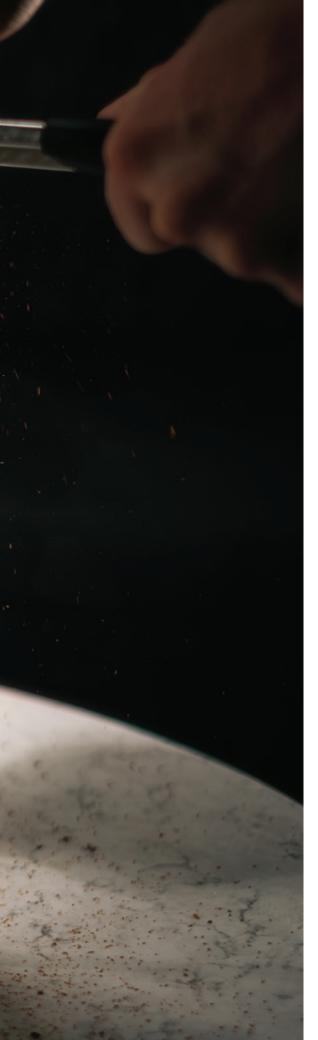




Naughty & Nice Fresh & Balanced

- 1 oz Calvados
- 0.5 Hennessy VS
- 0.5 Lemon
- 0.5 oz Cinnamon habanero syrup Fresh apple slice Top with Prosecco





intriguing warmth of cinnamon habanero syrup. The drink pairs very well with the crispy wild boar belly on the Q Bar menu for those looking for a late night snack.

For those looking for a tranquil place to rest their head after a night cap, experience the epitome of solace at Fairmont Empress. The awardwinning hotel has 431 well-appointed rooms and suites featuring classic details with modern touches and offering magnificent views of the harbour, city and gardens, ensuring your stay in Victoria is unforgettable.

Earlier this year, Fairmont Empress completed a multimilliondollar renovation of the Fairmont Gold Floor experience, including expanding the Fairmont Gold lounge and adding 22 guestrooms and suites. The Fairmont Gold experience begins upon arrival and includes exclusive food and beverage offerings and a rooftop terrace that provides sweeping views of the Inner Harbour accompanied by outdoor fireplaces.

As temperatures begin to cool across Canada, things are only starting to heat up on the Fairmont Gold Terrace. Guests can relax by the flickering flames as they relax under a blanket of stars.

If you're seeking seclusion, privacy and an escape from every day, the Fairmont Gold experience will not disappoint. The VIP offering comes with the highest level of personalized service to each Fairmont Gold guest. It will feel like a luxurious home away from home.

So when embracing the shifts of the season, consider dropping by or staying overnight at Fairmont Empress, where you are encouraged to cozy up, take it easy, and sip your favourite whisky cocktail. Come raise a glass, and let the warmth of fall envelop you in pure luxury.



To learn more or book a stay, please visit: www.fairmont-empress.com









An experience is a staple feature for every bottle of Okanagan spirits. This rye transports your olfactory senses into the spacious valley neighbouring the Vernon, British Columbia, distillery. The experience is in the valley's rich agriculture, native trees and wildflower-edged slopes set against blue skies, sunshine and grain fields waiting patiently to be milled, fermented and distilled into this straight-up rye. The nose is expressive, vibrant and assertive with herbal dill, mint, vanilla, honey and maple with medicinal accents. Vanilla and rye baking spices steer the cooked grain profile with drops of toasted oak, malty undertones and a waxy honeycomb note on the finish. Rye fans rejoice. This is rye whisky at its core with a splash of the wild west.



LAWS Four Grain Straight Bourbon Whiskey (47.5%)

This sweet and full-bodied four-grain whiskey is all about the grains grown on two Colorado family farms with a mash bill of 60% heritage corn, 20% heirloom wheat, 10% heirloom malted barley and 10% heirloom rye. The mash is allowed to ferment in the open air, which adds what the distillery describes as adding soulful complexity. This soulfulness treats the palate with baskets of citrus fruit mingled with orchard fruits covered in a blanket of charred oak. The usual suspects of vanilla, baking spices and caramel hit the palate, but the underlying drier grain structure wakes up the mouth with malty-cooked cereals that soar a mile high.



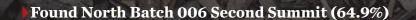


Two Brewers are masters at integrating peat into a single malt without shadowing complex and delicate subtleties that balance the whisky. The peated, smoky high notes compliment the sweet malty tones with light spices, steady oak and tropical fruits that never drift from the malt's beautiful smoky core. To develop the whisky's profile, the distillery blended a large portion of 11-year-old peated whisky with smaller volumes of whiskies aged in new oak, ex-bourbon and second-fill ex-bourbon.



Three Chord Tennessee Straight Whiskey (42.5%)

Guitarist Neil Giraldo and the band at Three Chord travel to Tennessee for the soulful sounds of this straight whiskey. 80% corn, 10% rye and 10% malted barley are distilled and aged for at least three years before flowing through a traditional Tennessee maple charcoal filtration process. An approachable nose features vanilla, tropical fruits and a crick of charred smoke that runs through the middle. Caramel, toasted sugars, spice and a power chord of oak form the whiskey's Graceland. Easy going and easy drinking.



What do you do with a freshly emptied 500-litre Pedro Ximenez sherry butt? If you're Found North, you refill it immediately with a blend of 18 to 26-year-old Canadian whiskies and allow it to take an eight-month sabbatical in the Spanish goodness. Sweet butter cookies, stewed orchard fruits, sweet figs, maple, citrus and a medley of spices highlight a flavour treasure chest brimming with subtle herbal notes, exotic wood and a nuttiness that balances the integrated structure of this beautiful blend.



Found North Batch 007 (65.9%)

Batch 007 doesn't rely on Bond-like gadgets for building flavour. Instead, it's made by a blending team that appreciates the art of blending and understands that blending defines Canadian whisky. A Generation Z corn whisky from 1998 forms the whisky's centrepiece, along with a pair of 22-year-old corn whiskies aged in ex-bourbon and new American oak. Some 2004 rye whisky resting in Hungarian oak adds layers to the blend. This buttery whisky packs loads of flavours into a cohesive beast. It's got everything: blistering rye and oak spices, cinnamon hearts, chocolate, torched sugars, lumber, oak tannins, sweet biscuits and fruits. The chest-warming finish was still going at the time of publishing.

QBAR

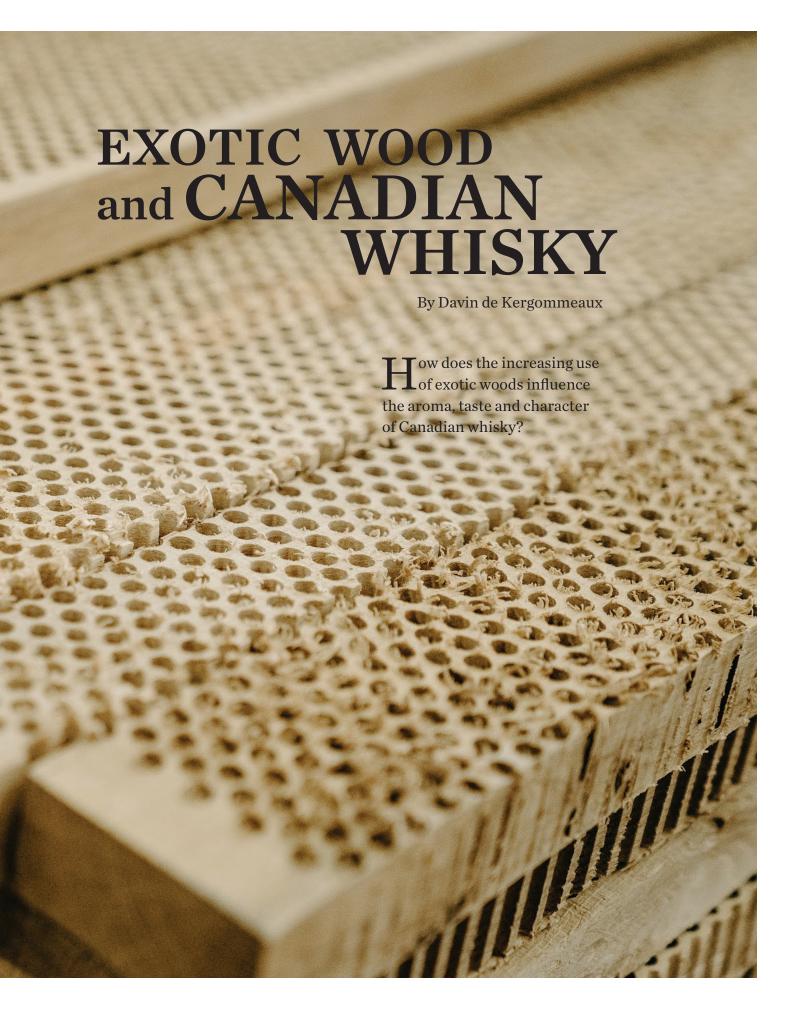
AT FAIRMONT EMPRESS

Home to inspired cocktails, artisan beers, locally crafted Empress 1908 Gin and the best BC Martini on the coast. Q Bar is the place to see and be seen in Victoria.











In 2010, Fortune Brands created a new bourbon simply by placing French oak staves inside bourbon barrels and re-filling them with mature Maker's Mark whisky. The French oak, carefully toasted, added new flavour tones and boosted sales of an already popular whisky. Not surprisingly, most people learned of this little-known finishing possibility only when Maker's applied it to bourbon.

Although the vast range of American whisky styles offers US producers tremendous flexibility, regulations restrict them to maturing bourbon in new American white oak barrels. Among other things, this regulation is what makes bourbon instantly recognizable in the glass, with its sweet oak caramels, rich floral vanillins and brisk rising tannins. However, until Maker's Mark 46 came along, it seemed the regulation denied bourbon makers access to flavours found in other woods.

With no substantial oak forests in Canada, so no oak-timber industry to protect, Canada's regulations state only that Canadian whisky must mature in "small wood." Specifying oak would be redundant since its unique properties make oak barrels the only ones that don't leak. Still, where there are regulations, there

are lawyers, and where there are lawyers, there are loopholes. To them, the words "small wood" were an opportunity, not a constraint.

But another regulation says that Canadian whisky must possess the aroma, taste and character generally attributed to Canadian whisky. So, when aged or finished in the presence of exotic wood, it must retain the sensory qualities unique to Canadian whisky. Otherwise, it becomes a whisky infusion – flavoured whisky.

There is, for example, a strong argument that Canadian whisky matured or finished in peated Scotch barrels no longer qualifies as Canadian whisky. However, that argument remains moot until someone challenges a peated Canadian whisky in court. Fortunately, for those who enjoy such things, Canadians tend not to be a litigious lot.

The early days

In 2011, Collingwood became the first Canadian whisky to use non-oak wood for finishing. As the whisky approached maturity, blenders rested it in vats containing toasted hard-maple staves. Although hints of Cherry Blossom chocolate bar soon emerged to enhance the palate, the final whisky smelled like, tasted like and exhibited the character of Canadian whisky. More than a decade later it's still going strong.

Not long after, Odd Society Spirits in Vancouver began experimenting with wooden inserts in oak whisky barrels. The practice was becoming popular with small distillers in the US, and Odd Society, following their lead, imported a selection of exotic wood "staves" from Black Swan Cooperage in Minnesota. Black Swan had developed and patented a so-called "Honey Comb®" stave, which they perforated with a matrix of small holes that significantly increased the surface area, allowing much more rapid flavour extraction.

According to Odd Society distiller Gordon Glanz, "Honey Comb® staves definitely add more intense flavours, no question. I do believe they can be a useful tool, especially for blending. They add more intense color and rich flavours. However, if





you leave them too long, you get too much wood!" According to Black Swan, extraction is essentially complete within about six weeks.

More recently, Forty Creek and Wiser's have begun experimenting with non-traditional ways to add new dimensions to finished whiskies and blending stock. Forty Creek started conservatively with a gentle infusion of locally foraged plants they called The Forager and labelled as "botanical whisky." It got excellent reviews and appears to have encouraged whisky makers in some other countries to do the same.

Meanwhile, behind the scenes, Forty Creek master blender Bill Ashburn was quietly working away in his lab with a sample pack of Black Swan staves that included hickory, red oak, cherrywood, hard maple, sassafras, yellow birch and white ash.

When Wiser's began sampling similar whiskies at the fall whisky shows in

2022, reactions were also generally favourable. JP Wiser's Hickory is in stores right now and whisky lovers looking to expand their tasting data banks would be well advised to try it if only to learn its flavours.

However, your best bet to experience the complementarity of some exotic wood in Canadian whisky is the new Forty Creek Cherrywood Reserve. Not only does it exude the aroma, taste and character generally attributed to Canadian whisky, somehow, Ashburn has managed to retain the Forty Creek house style as well while adding new fruity, floral and woody overtones.

Of seven kinds of wood sampled for Relish and Whisky magazine, cherry was by far the most expressive, most complex and the most whisky-like. Cherrywood Reserve, this year's special release from Forty Creek, will be available for Forty Creek Weekend in September.

Tasting exotic wood whiskies

Collingwood presents rich toffee notes with vanillas, dark fruit, Cherry Blossom-like maraschino notes and floral tones. Fresh-cut lumber, hints of leather and cooked corn cobs round it out.

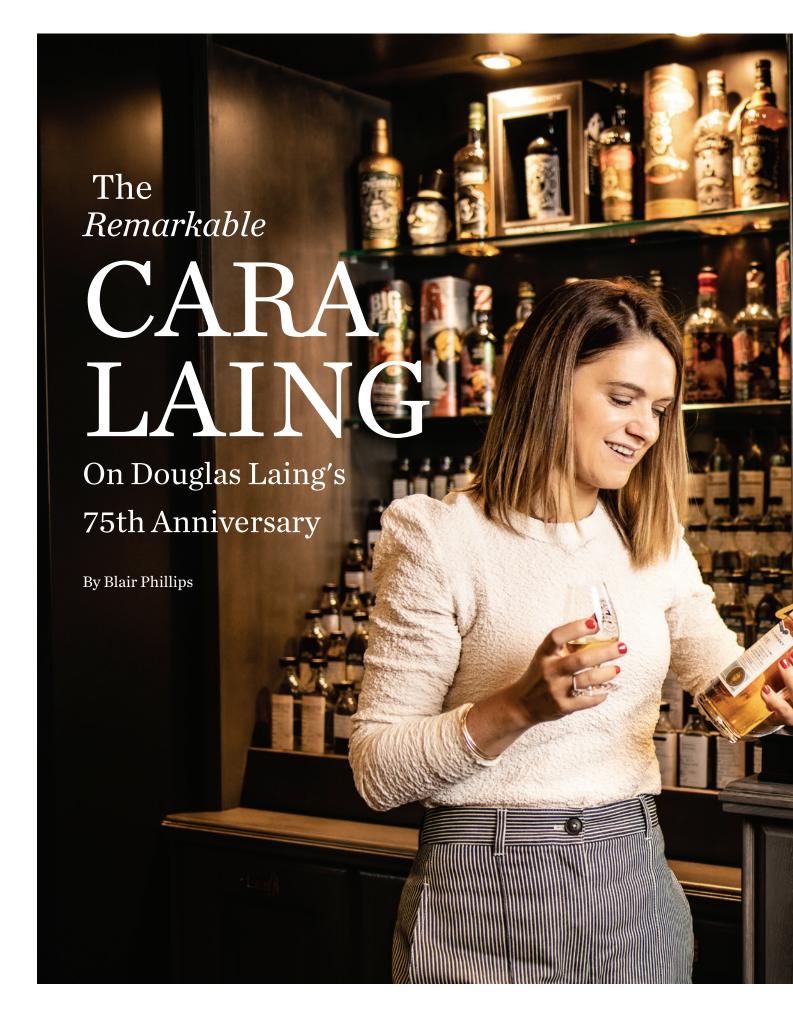
JP Wiser's Hickory starts very sweet with searing peppers and lovely woody tones. The wood influence grows while staying clean with hints of pecan shells, a cold fireplace and just-snuffed charcoal.

Forty Creek Cherrywood Reserve shows the typical complex Forty Creek character, with firm bracing peppers, a lovely tannic pull, doused hardwood campfire, fruitiness, floral tones, hints of grapes, sweeter fruit, and, on the finish, fresh rain.

On the other hand, Sassafras, a wood once used to make root beer, definitely fails the authenticity test. Its sweet, powerful sensory elements depart wildly from the aroma and taste of Canadian whisky, skidding heels down into medicinal, pop-like Prime drinks, with artificially flavoured candy or gum and best summarized as "kind of disgusting."

Still, overall, there is no doubt that used judiciously, some non-oak woods complement Canadian whisky's aroma, flavour and texture without detracting from its authentic Canadian-ness.

But wood finishing is not a free-for-all. If you are tempted to put a piece of non-oak wood in your home mini barrel and see what happens, please do a little research first. Some common woods contain allergins and other toxic chemicals and some, such as Sassafras, are so displeasing that no one will ever mistake spirits finished with them for whisky.





lashback to 1948. Television was taking a foothold with Milton Berle and Ed Sullivan making their small screen debuts. The Andrews Sisters were on the radio, and The Three Musketeers on the silver screen - all golden oldies. In Scotland, they were in the hangover of a whisky shortage partially caused by a war effort where barley stocks meant for whisky were diverted for food. It wouldn't be until the 1950s that distilleries rebounded.

But that year, no shortage would hinder Fred Douglas Laing from getting into the whisky business. What began as pioneering straightforward blends snowballed into a flavourful lineup of blended malts featuring Scotland's six whisky regions. When Fred Sr. passed the reigns to his son Fred Laing, a man with the "it factor" for blending, he took the business to the next level, growing the scope of their whisky portfolio.

Now in its third generation, Cara Laing is ushering Douglas Laing & Company into its 75th year. Instead of gathering around a birthday cake ablaze with candles, they continue to up their game. This special birthday will include a lineup of anniversary expressions such as Extra Old Particular and a 50-year-old expression of their flagship, King of Scots, along with others. We should be giving Douglas Laing a birthday present. Instead, Cara Laing has given us an early loot bag by sitting down to reminisce about their 75-year legacy and why their flavourful whiskies have remained relevant from generation to generation.

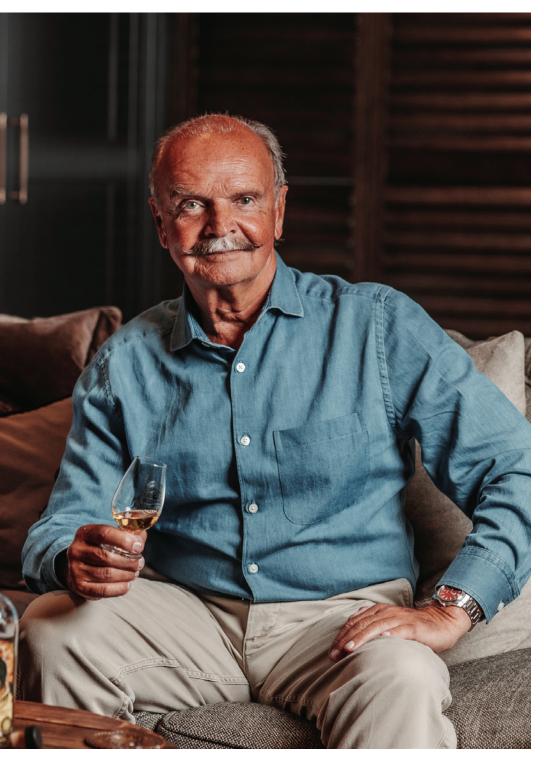


What inspired your grandfather to get into the whisky business? What were those first releases like?

My grandfather - Fred Douglas Laing - had a long-standing love and appreciation for Scotch Whisky but worked in shipping before World War Two. After the War, he decided to apply his knowledge of shipping goods around the globe to whisky and established Douglas Laing & Co. in 1948. He acquired the King of Scots brand and started building stocks

of whisky. And so it all began. I wish I could try some of those early releases, but I have never managed to lay my hands on any of our earliest bottlings. From what I remember and know of my grandfather, he was big on quality and loved a Port Ellen, so I expect our early bottlings were pretty smoky in style and with quality at its core.

What were some challenges or obstacles to starting a whisky business in 1948?



He was essentially a one-man band. Building a post-War business from scratch would have been tough when people weren't enjoying an expendable income. Obtaining casks and building a stock inventory wouldn't have been straightforward, either. However, Fred Douglas Laing was an absolute character and very charming, so I suspect his sales skills helped to establish Douglas Laing. He also had a great work ethic and placed a huge emphasis on hard graft. I often think he'd be stunned at where his

little business, which he started with a couple of casks, a brand and a secretary, is today 75 years on.

The company would have witnessed several shifts and ups and downs in the whisky industry as tastes changed and trends came and went. How did Douglas Laing have to adapt through the years?

We've had to evolve and innovate many times over our 75 years in the whisky industry - there's never a dull moment! We only ventured into the Single Cask territory in the 1990s. Before that, we were entirely focused on Blended Scotch. We were even awarded the Queen's Award for Export Achievement due to our Blended Scotch business. Then Asia Pacific faced a huge economic downturn and literally stopped ordering Blended Scotch from us overnight. Fred - our Chairman and my father - had to do fancy footwork. He looked at our stocks and realized that the Bowmore, Macallan, and Port Ellen casks we used for our aged Blended Scotch brands could stand on their own two feet, so we began releasing Single Cask bottlings. Bizarrely our business today has taken us back to our blending routes with our range of Blended Malts like Big Peat and Scallywag.

A lot of other whisky makers have come and gone or have been snatched up and disappeared. Is there something particular that you can attribute to the whisky's survival through the years?

I think we have recognized when we've needed to evolve and adapt to market conditions - and at times, relished that challenge. Beyond that, I think our agility and ability to react quickly to opportunities greatly helped us. We like to innovate, trial things, and respond quickly to what our distributor partners ask of us.

When blending a whisky, is there something specific you want to capture that gives a whisky the Douglas Laing stamp?

Quality. We believe it's very easy to sell a bottle once, but we want the consumer to enjoy that first bottle so much that they return for a second or third bottle. My father or I approve each and every batch of our Regional Malts - to us, every small batch release of our Malts must be tasted by a family member and signed off by a family member as our name is on the bottle. We are small enough that we can do this. Beyond the quality aspect - but linked to it - we work based on releasing our whisky "as natural as it gets,"

meaning we bottle at a high alcohol strength and without chill-filtering or adding colouring.

As Director of Whisky, you approve cask samples and write tasting notes. When did you realize you had a palate for whisky, and how did you develop it?

When I went to Whyte and Mackay in 2006, up until then, I actively disliked whisky and dreaded getting a cold, as Fred would prescribe endless hot toddies. Then I joined Whyte and Mackay, hoping to work on their vodka brands, but I was assigned to Jura's Marketing team. This allowed Fred to educate me and help develop my palate in conjunction with some great tuition and input from Richard Paterson. My appreciation and understanding of whisky just started to develop. I now drink whisky every day and have a genuine love of it.

When you are tasting cask samples, what is your process? Are you tasting them looking for specific profiles or with a blend/category already in mind?

We are ultimately looking for quality. We do, from time to time, reject samples and - if it's a Single Cask, the spirit is reracked and into a new cask. If we negate one of our Blended Malt batches, it creates a lot of hassle as we have to start moving casks and rebalancing the vatting. We are also looking for the whisky to reflect the region - that's a huge focus for our Regional Malts. We are also checking to make sure the whisky still tastes like whisky and the wood hasn't dominated so that the true character and flavour of the whisky is lost.

Your whiskies cover a broad scope of expressions and styles. Could you tell us about the core areas?

We have three core areas within Douglas Laing:

Regional Malts, where the focus is on marrying the finest Single Cask and Single Malts from specific regions, ultimately distilling that respective region. Scallywag, for example, is a marriage of Malts only from Speyside, so, in our mind, that delivers the ultimate taste of





Speyside style.

Single Casks, where we are fortunate that many of my grandfather's filling agreements still stand and allow us to access some exceptional whiskies.

Strathearn Highland Single Malt, where the focus is on delivering the most special, genuinely hand-crafted Single Malt. At Strathearn, we are obsessed with quality - volumes are tiny, but the spirit quality is incredible.

discovered?

We have filling programs with many lead distillers - meaning we fill our casks with their spirit at zero hours of age. We then move the casks into warehouses and allow them to age up. After that, we have the fun job of tasting them. We must keep a constant eye on how they are maturing. Sometimes you can over-age, and the whisky becomes too woody. So we're regularly trying whiskies and establishing what to do with them.

Instinctively we know the older Whiskies are destined for XOP Single Casks bottlings, but when we come across a batch of super smoky, particularly peated Islay Single Malts, we earmark them for Big Peat.

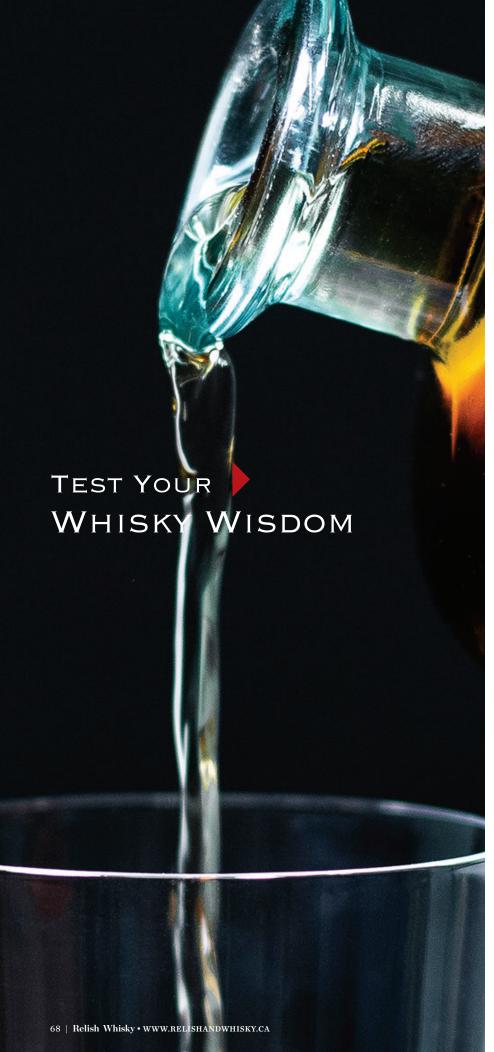
How many countries can you find Douglas Laing whiskies?

Our brands, through our extensive and valued import partners, are currently available in 72 countries - that we know of.

I say that because, over our 75-year history, we have been extremely lucky to have the support of many incredibly passionate whisky enthusiasts that have often introduced our brands to wherever their travels have taken them. We are regularly surprised and humbled to be told about our brands being in markets, bottle shops and bars that we simply can't explain.

What excites me is that the future still holds many more opportunities to expand our global distribution network into new markets. So, if someone were to ask my grandson or daughter this question in another 75 years, who knows what the answer might be? •







Caitlin Bartlemay, *Head Distiller, Clear Creek Distillery*

Q-1: McCarthy's is the first American Single Malt, in which year was it first released?

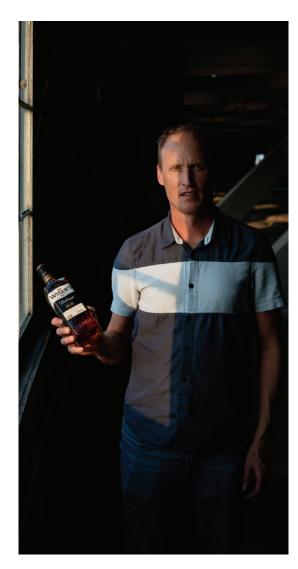
Q-2: McCarthy's is a peated American Single Malt, what other defining characteristic sets this whiskey apart?

Jesse Parker

Master Blender, Doc Swinson's

Q-1: Have you heard of Garryana Oak? Where does it come from? What flavors does it contribute to whiskey? Q-2: What does the term "Barrel Proof" or "Cask Strength" mean according to the TTB?





Don Livermore

Master Blender

Q-1: The whisky industry is closely connected to the agriculture community. We purchase grain such as corn, rye, wheat, or barley from farmers, but also at the same time we sell our co-products after distillation back to the agriculture community as feed. We can sell in a dried or wet format. What do we call these co-products?

Q-2: Fermentation is the heartbeat to a distillery. Yeast not only makes the all important ethanol, it also contributes many of the flavour compounds such as the fruity or floral notes that we enjoy in our whisky. Name three parameters in fermentation that are essential for brewers\distillers to control to make consistent whisky.

Lisa Wicker,

Distiller & Owner Saints & Monsters Distilling Consulting

Q-1: In the US, "fake whiskey" flooded the market in the 19th century. Bottledin-Bond was passed in 1897 and became a symbol of purity and quality, a guarantee of what was in the bottle. The Pure Food and Drug act was passed in 1906 as a protection for food being altered in the US at the time. Both of these were still not enough to keep "rot gut" whiskey from being sold. What year and US President were responsible for "defining" whiskey in the US? Q-2: Whiskey production being produced in the US has lots of folklore about when it all started. The accounts of who, when and where vary widely. One theory is whiskey production started when the British government passed the Molasses Act. It imposed a tax on any non-British molasses. Most of the molasses was from French and Spanish islands at the time, it was less expensive. This theory believes distillers began to use what was available domestically, rye and corn to produce their spirits when they chose not to buy and pay duty on British molasses. What year was the Molasses Act passed? ◆











It didn't matter because Don DiMonte at the neighbouring Last Straw Distillery didn't have a height restriction for grain. All grain varieties get to skip the line and experience the thrills, chills and spills of Last Straw's fermenters and stills.

This was the case a few years ago when Mark Hayhoe, who owned K2 Milling then, specialized in acquiring noteworthy grains to mill for bakeries. "He had a request for a long grain Argentinian rice flour, brought it in, and for whatever reason, the customer no longer required it," says DiMonte. "So instead of sending it off as livestock feed, he called and asked me if I could do anything. I had no idea, but I was willing to try."

DiMonte treated it like he would with any other grain. It was a whiteknuckle mash, fermented with an American whisky yeast, it disappeared in the water, and as if fermented, the rice aggressively bubbled up like giant soap

bubbles. The yield from distilling the rice created enough sublime spirit to fill a single barrel with leftovers to fill a second re-charred American Oak barrel partially. DiMonte blended in some rye spirit to top off the second barrel, then set it down to rest for four years and nine months.

"I didn't know much about the rice. Afterwards, I started asking questions. This rice is grown on the hillside of a small farm cooperative in Córdoba, Argentina," says DiMonte He also





learned that the Argentinian farm didn't use pesticides or till the land. Instead, it was all harvested by hand. It had a story.

The resulting whisky produced 204 bottles following a familiar Last Straw theme. As important as the ageing process is, the ingredients that go into making a Last Straw whisky play a critical role in making whisky that stands out. And DiMonte doesn't release a whisky for the sake of doing something different or shocking. His whiskies are released if they taste good.

This Rice and Rye whisky pulls some serious G's. Not the g-forces experienced on a roller coaster that sucks the eyes to the back of your head, but a grain-force that is just as exhilarating. G's are achieved with the rice grain creating a foundation through the whisky-making process. The fresh grain notes on the nose climb slowly to a peak with orchard fruits and cinnamon. A distinct Armagnac-like stylishness brings dried fruits, sweet spices and candied fruits with grassy rye, light hints of citrus and sweet bread. This depth carries over to the palate, where the rice and rye whisky twists with butterscotch into a searing rye spice dive drop. And by mid-palate, those rye notes scream through the finish. The oak influence is indirect compared with Last Straw's other whiskies, but the side effect of the mellower wood is that it allows the star of the show - the grains - to shine bright. Bursting spices flare and sizzle, then quickly fade on the finish back to toffee and those electrifying Armagnac notes.

But, it wasn't the rice and rye aged barrel that got DiMonte thinking about releasing this whisky. It was the barrel containing 100% rice spirit. At two years old, it was already developing into something special. The rice spirit was allowed to age longer, not because it wasn't ready, but because the distillery didn't want to slam the shelves with too

many releases at once. "When we were moving casks around, the rice and rye was out of sight and out of mind. We pulled it down, drew a sample and thought, this is something completely different. It was like a hybrid whisky. I think we should release this."

The Last Straw team has carved their innovative niche into Canada's distilling landscape, raising its bar by working directly with small local family farms that practice regenerative agriculture, organic farming and growing heritage grains. The whiskies produced tell the story of the season, land and the farmers that grow these grains for maximum flavours. Last Straw synergizes with the farming community, evolving grain curiosity to flavours.

"No" is not a word in DiMonte's vocabulary, so if opportunity knocks with a chance to try something new, he's willing to take a risk and see what happens. It has paid off with Rice and Rye.

"When I take on these experiments and trust me, there have been some really bad ones. Only the good ones are released because I am its author, "

says DiMonte modestly. But there is a reason why interesting grains show up at his door. He has repeatedly proven that he can take grain on an exhilerating ride with thrills and chills that you sip instead of spill. ♦

Answers for page 68 Test Your Whisky Wisdom

Caitlin Bartlemay

A-1: McCarthy's first released in 1996.

A-2: McCarthy's is aged 100% in Garryana Oak (Oregon Oak).

Jesse Parker

A-1: Quercus Garryana is a species of white oak that only grows on the Pacific Seaboard from southern British Columbia to Northern California, it is not commonly used for barrels due to its availability, and difficulty to cooper but when used properly for finishing whiskey such as Doc Swinson's "Garryana Cask Finished Bourbon" we find a richer profile than in a typical bourbon, caramels turn to molasses cookies, cinnamon turns to cloves and there's a subtle smoke that enriches the bourbon profile.

A-2: The term "barrel proof" or "cask strength" may be used to refer to distilled spirits stored in wood barrels only when the bottling proof is not more than two degrees lower than the proof of the spirits when the spirits are dumped from the barrels.

Don Livermore

A-1: Distillers dried grains with solubles (DDGS) is a combination of the leftovers of corn, rye, barley, and wheat. Yeast will use the starch in fermentation leaving a residue rich in crude protein, fat, fiber, vitamins, and minerals. It is currently used as aquaculture, livestock, and poultry feeds. DDGS is dried to 10% - 12% moisture and is very stable with almost an indefinite shelf life. This allows it to be shipped to any market regardless of proximity to the distillery. The downside is that its energy intensive to make DDGS. Another option is to produce wet distillers grains (WDG). This is essentially the unfermented residue after the distillation process. Typical moisture content of WDG is 70%, which means the production is less energy intensive and less carbon footprint to produce. The downside to WDG is its shelf life is four to five days. It is only practical to ship WDG within a 200 km radius of the distillery.

Interestingly, JP Wiser's purchased a distillery in 1857 for the primary purpose of raising livestock. At one point he had over fifty thousand head of cattle and he was the first to ship cattle to the UK. He understood cattle nutrition in the 1850s. He was one of Canada's agriculture experts and a pioneer in the field of agriculture science.

A-2: Temperature. The maximum temperature brewing yeast can tolerate is about 32 degrees Celsius. pH. Typical whole grain fermentation pH starts at 5.5 and finishes around 4.0. Brix. This is a measure of starting solids content. This correlates with the concentration of sugar. If the sugar content starts too high, this can shock the yeast and

fermentation will be sluggish.

Nutrients. Yeast is dependent on oxygen, nitrogen, or vitamins to support growth. Yeast strain. Distillers need to be consistent with pitch (dose) rate, health, and genetics. Processing aids. The mash or wort requires commercial enzymes or malt to convert starch to sugar. Other processing aids could be hops or sour mash to control bacterial infections.

Lisa Wicker

A-1: President Taft approved the legal definition of whiskey in 1909.

A-2: 1733. There are accounts of grain distillation far ahead of this, but rum was the primary distillate. It does predate many of the other theories and folklore of who "invented" grain distillation in the US. ◆



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