

## Sake Production Process Flowchart



### Rice Polishing

Using a rice milling machine, sake rice is polished down to isolate just the starch in each grain.



### Washing/Soaking

Rice is then washed and soaked to begin introducing moisture into the grain and preparing the rice for steaming.



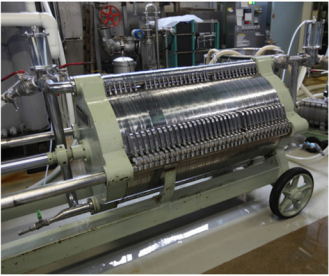
### Steaming

Rice is then steamed at about 100°C (212°F) for about 1 hour.



### Making Koji

Steamed rice is then sprinkled with koji mold spores. After 53 hours of attentive care, the result is molded Koji Rice.



### Filtering

Fresh sake is then filtered to remove any impurities and make it clear.



### Pressing

After about 30 days of brewing, the sake is ready to be pressed. This process separates the fresh sake from the unfermented rice solids known as "Kasu".



### Brewing

Next is preparation of the main mash or "Moromi". The yeast starter is combined in the main brewing tank with 3 additions of water, rice and koji rice.



### Yeast Starter

Over a 2 week period, yeast starter or "Shubo" is then made using water, rice, koji rice, yeast, and lactic acid.



### Pasteurization

Next, pasteurization quickly heats the sake to kill any remaining enzymes and bacteria.



### Maturing

The sake is then stored underground for a few months to mellow and smooth the flavor.



### Dilution/Bottling

Water is added to bring the alcohol to around 15% and then there is a second pasteurization followed by bottling.



### Finished Sake