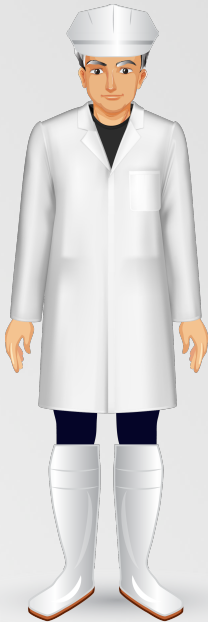


Sake Brewery Workers

Traditional Sake Breweries Have a Staff Hierarchy



Toji

The Master Brewer. The role of Toji is the head of all production in the sake brewery. They require mastery of all production steps as well as the ability to problem solve, manage teams and lead the entire brewery production staff. Though not required, many Toji have an affiliation with a regional Toji guild.



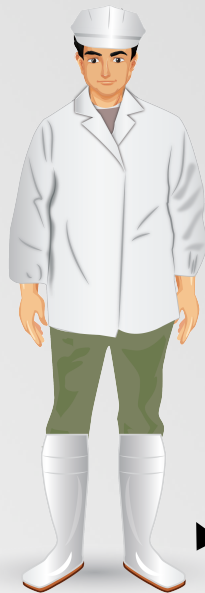
Kuramoto

The Sake Brewery President. Sake Breweries are usually family-run businesses and the Kuramoto is the brewery president and owner. Traditionally, they focus more on sales, marketing and promoting the sake rather than hands-on work in the brewery, although there are exceptions.

Kojiya

This is a senior brewer who is in charge of the koji making process.

Along with the Toji and Kashira, it is viewed as one of the most important jobs in the brewery.



Kashira

Kashira means "head" and is the 2nd in command of production at the brewery. This role could be likened to an assistant production manager and the Kashira will take direction directly from the Toji and relay instructions to all the brewers.

Sanyaku

Sanyaku is the term for the top 3 senior brewers - often the Kashira, Kojiya and Motoya.

Motoya

This is a senior brewer who is in charge of the Shubo or Moto (fermentation starter) production.



Kurabito

Kurabito means "brewery person" and it is a term used for people who work in a sake brewery. Rank and file kurabito are the main labor force and report to the more senior brewers and ultimately the Toji. These workers may be assigned to general work such as washing and cleaning or department specific jobs such as assisting in the koji room.