

これからの酒。



ほしほし

The Start and the Future of Sake.

奈良県酒造組合

Nara Sake Brewers Association

奈良県酒造協同組合

Nara Sake Brewers Joint Association

2-33 Saiwai-cho, Yamatotakada, Nara Prefecture, 635-0015

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Nara sake specialist shop authenticated by the Nara Sake Brewers Association

Mobile phones smartphones

なら泉勇齋
Nara izumi yusai

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Hours: 11:00 - 20:00 / Closed: Thursdays



Tales of Nara and Sake ① Shoryakuji Temple, "Birthplace of Sake"



The birthplace of Japanese sake

Alcohol has always been a part of human history and culture, and each country around the world has its own unique alcoholic drinks. The unique alcohol of each country is usually made from that country's main crop, and which suggests that each type of alcohol was first made a very long time ago. Today, alcohol from around the world is drunk in Japan, but nevertheless, there is one drink that people immediately associate with Japan, and that is sake, made from rice. Japanese and sake have an intimate history together that goes back to the dawn of the country's history.

From the court to temples

Sake has been enjoyed in a range of ways since classical times. The Engishiki, a work compiled in the Heian period, lists some 14 types of sake. Wooden tablets recording such varieties of sake as "sumisake" (clear sake), "shiroki" (white sake), "kuroki" (black sake), and medicinal sake have been excavated from the site of Heijokyo, the old capital. Other wooden tablets have been found that seem to show the roots of Nara pickles. The term "sumisake" used by these tablets refers to the clear sake obtained by filtering through silk.

To be able to create the refined, clear sake drunk today had to wait until the Middle Ages, when the center of political power shifted from the court nobles to the warrior class, the samurai. This was also the period when sake-brewing shifted from the court to temples. Nara, with its many great temples, was where culture from the continent ended up. Here a type of sake called "bozu-sake" (priest sake) made from the rice grown in the temple estates was very common. The brew made by the Shoryakuji Temple on the outskirts of Nara was epoch-making.

The origins of the various styles of sake brewing come from the Nara style

Shoryakuji Temple is today a quiet temple, almost lost among the rural hills. But at its height in the Muromachi period, it was a huge temple with 86 sub-temples on its grounds, and large amounts of bozu-sake were brewed there. They used the three-step brewing technique, where the ingredients are added in three parts, the "moro-haku" method where white rice is used for both koji (malt) and kake-mai, and "bodaimoto," the original sake starter. In addition, they also used a version of pasteurization about 300 years before the French microbiologist Louis Pasteur discovered heat-treating wine to prevent it going bad. With these methods, the temple priests established the basics of modern brewing. In addition, the development of carpentry tools at this time also made it possible to make large barrels for brewing sake in, rather than the pots or urns that were used before. This era saw dramatic leaps in the quality and quantity of sake, as well as its production techniques. In particular, Nara sake and moro-haku sake are synonymous with high-class sake, and almost all the terms related to sake in the Japanese-Portuguese dictionary compiled around that time were related to Nara sake. Even in Edo, after the Tokugawa shogunate started its rule, Nara sake was considered a rare treat. As it was shipped from Nara to Edo, it was known as "kudari-sake" or "down-sake," having come from up in the capital region. As this historical background shows, Nara can be called the birthplace of Japanese sake.



Fukuju-in, Bodaisan Shoryakuji Temple

Tales of Nara and Sake ② Omiwa Shrine, home to the god of sake-brewing

The Omiwa Shrine, in Miwa, Sakurai, Nara Prefecture, is where brewers from around the country go to worship Omononushi, the god of brewing. The grounds also house the Ikuhi Shrine, which enshrines Takahashi-Ikuhi-no-Mikoto, considered to be the ancestor of brew-masters. In addition, a stock word used in poetry related to Miwa is "umasake" (tasty sake), once again showing how Nara and sake have such a deep relationship.

Miwa, the mystical home of sake-brewing

Japan's oldest Omiwa Shrine, built to worship sacred Mt. Miwa, has a long connection with sake. Miwa's Omononushi is the god of sake-brewing, and in ancient times, brewers would devote much worship to the god of Miwa. Omiwa Shrine's sub-shrine, Ikuhi Shrine, houses the ancestor god of brew-masters. Regarding its god, Ikuhi-no-Mikoto, the Emperor Sujin records of the Nihon Shoki chronicle note how the great god of Miwa was worshiped when pestilence stalked the land and chaos reigned. Along with Ikuhi-no-Mikoto being the ancestor god of brew-masters, this shows how there has been someone responsible for brewing sacred sake at Omiwa Shrine for over a millennium.

The "Sugitama Sign"



The Sakae-ko is an assembly of brewing houses from around the country to praise the god of Omiwa and the divine virtues of the ancestor god of brew-masters. The Festival to Pray for Safety in Brewing (the Sake Festival) is held here on November 14 each year. The assembled people all pledge to strive to brew new sake with renewed hearts, and are blessed by the gods' virtue and influence. The Umasake Miwa Dance, a poem written when Ikuhi-no-Mikoto gifted sacred sake to the emperor and turned into a kagura court dance, is presented at the festival by shrine maidens in a solemn yet gorgeous performance.

During this festival, the shrine grants a sugitama, a ball of sugi (Japanese cedar) made from sacred trees from Mt. Miwa: this is the "Sugitama Sign." Also known as a "sakabayashi" (sake forest), they are commonly seen hanging from the eaves of a sake brewery. They are a sign that fresh sake has been brewed using that year's rice harvest. They became standard from around the middle of the Edo period. The Miwa sugitama is also a symbol of the spirit of joining the brewers and the gods of Miwa.



Worship Hall of Miwa Shrine during the Sake Festival

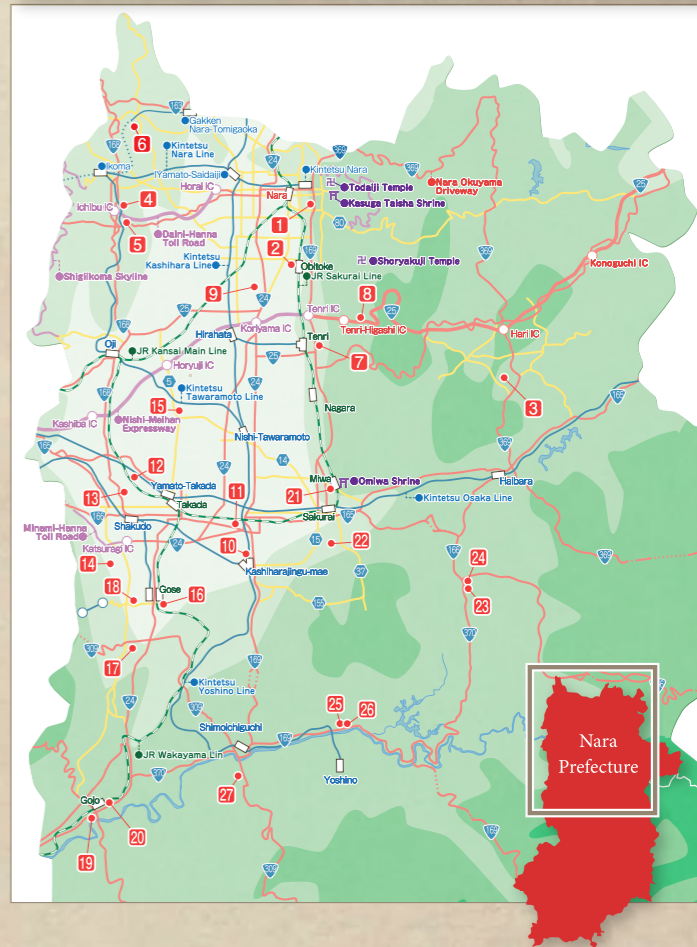
Sake as Japanese culture

Recently, younger people in particular are taking a fresh look at traditional Japanese culture. We in the sake-brewing trade also feel that now is the time we should return to our roots, once more meditating on the stories of the Miwa god, of Ikuhi-no-Mikoto as we revisit the role of sake in religious rituals, and in Japanese culture.

Once, Japanese saw the divine spirit within the life energy of rice. This symbol, its essence, was the mochi rice cakes and the sake so indispensable for rites. The first offering to the gods at the Omiwa Festival was sake, and sake was considered something sacred that bound the gods and men together. So we should think more deeply about the modern significance of sake-brewing and the relationship between the gods and sake in the old days as we set ourselves to our brewing. And at the same time, we should strive to have people know about the original taste of sake.

Sake as Japanese culture is something that has been fostered and cared for by the climate and land of Japan since the days of myth before the first emperor. We feel that this is a key word for considering the future of the Japanese sake industry. We, the sake brewers of Nara Prefecture, shall continue moving forwards with pride in brewing sake here in Nara.

Map of Nara Breweries



Nara Sake Brewers Association

Brewery name	Typical labels	Address	Telephone
1 株式会社今西清兵衛商店 S. Imanishi Co., Ltd.	春鹿 Harushika	24-1 Fukuchiin-cho, Nara	0742-23-2255
2 奈良豊澤酒造株式会社 Naratoyosawa Shuzo Co., Ltd.	豊祝 Hoshuku	405 Imaichi-cho, Nara	0742-61-7636
3 倉本酒造株式会社 Kuramoto Sake Brewery Co., Ltd.	金蔵 Kingaku	2501 Tsughayama-cho, Nara	0743-82-0008
4 上田酒造株式会社 Ueda Sake Brew Co., Ltd.	嬉長 Kicho	866 Ichibu-cho, Ikoma	0743-77-8122
5 菊司醸造株式会社 Kikutsukasa Sake Brewery Co., Ltd.	菊司 Kikutsukasa	555 Oze-cho, Ikoma	0743-77-8005
6 株式会社中本酒造店 Nakamoto Sake Brewery Co., Ltd.	山鶴 Yamatsuru	1067 Kami-machi, Ikoma	0743-78-0005
7 稲田酒造合名会社 Inada Sake Brewery Co.	黒松稲天 Kuroatsu Inaten	379 Mishima-cho, Tenri	0743-62-0040
8 増田酒造株式会社 Masuda Sake Brewery Co., Ltd.	都姫 Miyakohime	42 Iwaya-cho, Tenri	0743-65-0002
9 中谷酒造株式会社 Nakatani Brewing Co., Ltd.	大和郡山中谷 Yamato Koriyama Nakatani	561 Banryo, Yamato-Koriyama	0743-56-2296
10 喜多酒造株式会社 Kitashuzo Co., Ltd.	御代菊 Miyokiku	8 Gobo-cho, Kashihara	0744-22-2419
11 河合酒造株式会社 Kawai Sake Brewery Co., Ltd.	出世男 Shusse Otoko	1-7-8 Imai-cho, Kashihara	0744-22-2154
12 澤田酒造株式会社 Sawada Syuzo Co., Ltd.	歡喜光 Kankiko	6-167 Goido, Kashiba	0745-78-1221
13 株式会社大倉本家 Ookurahonke Co., Ltd.	金鼓 Kinko	692 Kamada, Kashiba	0745-52-2018
14 梅乃宿酒造株式会社 Umenoyado Brewery Co., Ltd.	梅乃宿 Umenoyado	27-1 Teraguchi, Katsuragi	0745-69-2121
15 長瀬酒造株式会社 Choryo Shuzo Co., Ltd.	吉野杉の樽酒 Yoshinosugi-no-Tarusake	4 Minami, Koryo-cho, Kitakatsuragi-gun	0745-56-2026
16 浦長酒造株式会社 Yucho Shuzo Co., Ltd.	風の森 Kaze no Mori	1160 Gose	0745-62-2047
17 葛城酒造株式会社 Katsuragi Brewery Co., Ltd.	百間門 Hyakurakumon	347-2 Nagara, Gose	0745-66-1141
18 千代酒造株式会社 Chiyooshuzo Co., Ltd.	御羅 Kujira	621 Kujira, Gose	0745-62-2301
19 株式会社山本本家 Yamamoto Honke Co., Ltd.	松の友 Matsunotomo	1-2-19 Gojo, Gojo	0747-22-1331
20 五福酒造株式会社 Gojoshuzo Co., Ltd.	五福 Goshin	1-1-31 Imai, Gojo	0747-22-2079
21 今西酒造株式会社 Imanishi Shuzo Co., Ltd.	みちの杉 Mimurosugi	510 Miwa, Sakurai	0744-42-6022
22 西内酒造 Nishiuichishuzo	談山 Tanzan	3 Shimo, Sakurai	0744-42-2284
23 芳村酒造株式会社 Yoshimura Shuzo Co., Ltd.	千代乃松 Chiyanomatsu	1797 Oudamanroku, Uda	0745-83-2231
24 株式会社久保本家酒造 Kubohonke Sake Brewery Limited	藤 Suiryu	1834 Oudaideshin, Uda	0745-83-0036
25 北村酒造株式会社 Kitamura Syuzo Co., Ltd.	朝今 Shojo	172-1 Kamiichi, Yoshino-cho, Yoshino-gun	0746-32-2020
26 株式会社北岡本店 Kitaoka Honten Sake Brewery Co., Ltd.	八咫鳥 Yatagarasu	61 Kamiichi, Yoshino-cho, Yoshino-gun	0746-32-2777
27 藤村酒造株式会社 Fujimura Shuzo Co., Ltd.	万代老松 Mandai Omatsu	154 Shimoichi, Shimoichi-cho, Yoshino-gun	0747-52-2538




Shojo is a sake honed by an ancient history, a rich history.

Major label/ 狸々・Shojo

Founded in 1788. Ascetics and woodsmen on Mt. Yoshino treasured this as the "spiritual sake of Yoshino." Sake-brewing that does not cater to the times.

北村酒造 株式会社 **Kitamura Syuzo Co., Ltd.**
 172-1 Kamiichi, Yoshino-cho, Yoshino-gun
 ☎ 0746-32-2020
 ☎ 0746-32-2570
<https://www.kitamura-syuzo.co.jp>



"Sake-brewing that is pure and correct" is the philosophy of brewers in Miwa, Nara, where the god of sake abides.

Major label/ みむろ杉・三諸杉・Mimurosugi 今西・Imanishi

Founded in 1660 at the foot of Omiya Shrine, home to the god of sake. Local sake from Miwa brewed using an underground stream from sacred Mt. Miwa.

今西酒造 株式会社 **Imanishi Shuzo Co., Ltd.**
 510 Miwa, Sakurai, 633-0001
 ☎ 0744-42-6022
 ☎ 0744-42-3612
<http://imanishishuzo.com>



Beautiful sake that is eternal, beyond time.

Major label/ 百楽門・Hyakurakumon

Drawn to Bizen Omachi rice, ideal for sake. Single-mindedly brewing sake from only the best rice to draw out its flavor.

巨城酒造 株式会社 **Katsuragi Brewery Co., Ltd.**
 347-2 Nagara, Gose, 639-2321
 ☎ 0745-66-1141
 ☎ 0745-66-1548
<http://www.hyakurakumon-sake.com>



A deep nostalgia for traditional "yamahai" brewing. A simple taste based on the ancient mizumoto method.

Major label/ 金鼓・Kinko



Over a hundred years have passed since our founding in the foothills of Mt. Nijo. We pursue brewing good-quality sake, richly individualistic, with an emphasis on the traditional "yamahai" brewing technique.

株式会社 大倉本家 **Ookurahonke Co., Ltd.**
 692 Kamada, Kashiba, 639-0227
 ☎ 0745-52-2018
 ☎ 0745-78-0019
<https://kinko-ookura.com>

The birthplace of Japanese sake


Nara sake has a long and deep connection to the history of sake in Japan, and has played a key role in its evolution.

これからの酒。

はじまりの酒。

The Start and the Future of Sake.



A sake brewed using traditional techniques passed down strongly through generations of brew-masters in Yoshino, the eternal town.

Major label/ 八咫鳥・Yatagarasu

A sake with a mild mouthfeel, brewed using traditional techniques with the emphasis on being made by hand.

株式会社 北岡本吉 **Kitaoka Honten Sake Brewery Co., Ltd.**
 61 Kamiichi, Yoshino-cho, Yoshino-gun, 639-3111
 ☎ 0746-32-2777
 ☎ 0746-32-8744
<https://www.kitaoka-honten.com>



Our motto is to create sake that our customers love and which brings them joy.

Major label/ 談山・Tanzan

We started brewing sake at the foot of Tanzan Shrine in the Meiji period. We have a wide range of varieties such as nigori-zake, made using the first rice harvest of Yamato (Nara).

西内酒造 **Nishiuchishuzo**
 3 Shimo, Sakurai, 633-0042
 ☎ 0744-42-2231
 ☎ 0744-45-1015
<https://nara-tanzan.com>



A mild sake brewed from the harmony between the people and the land of Kujira.

Major label/ 鯨羅・Kujira

Sake made from an underground stream from Mt. Katsuragi, bubbling up from our own well. An easy-drinking sake with a clear finish and clean aftertaste, with a clean, spreading acidity.

千代酒造 株式会社 **Chiyoshuzo Co., Ltd.**
 621 Kujira, Gose, 639-2312
 ☎ 0745-62-2301
 ☎ 0745-62-0127
<https://chiyoshuzo.co.jp>



Sake-brewing that speaks to the hearts of our drinkers.

Major label/ 梅乃宿・Umenoyado

Our sake is brewed using Yamada Nishiki rice and ultra-soft underground water from the Katsuragi Range, giving it a gentle, fine-grained taste.

梅乃宿酒造 株式会社 **Umenoyado Brewery Co., Ltd.**
 27-1 Teraguchi, Katsuragi, 639-2135
 ☎ 0745-69-2121
 ☎ 0745-69-2122
<https://www.umenoyado.com>




Beautiful sake from Kashihara, offering history and pleasure.

Major label/ 御代菊天・Miyokiku

Founded in 1718 in Kashihara, the wellspring of Yamato culture. With quality above all, we protect our founder's "sake-brewing with care" beliefs.

喜多酒造 株式会社 **Kitashuzo Co., Ltd.**
 8 Gobo-cho, Kashihara, 634-0062
 ☎ 0744-22-2419
 ☎ 0744-25-3588
<https://miyokiku.com>



Tenri, the spiritual homeland. An inheritance of delicious sake-brewing fostered through history.

Major label/ 黒松稲天・Kuromatsu Inaten

Valuing connections among people, we are particular about the local rice, water, and people we use, brewing sake that goes well with meals.

稲田酒造 合名会社 **Inada Sake Brewery Co.**
 379 Mishima-cho, Tenri, 632-0015
 ☎ 0743-62-0040
 ☎ 0743-63-5563
<http://www.inaten.com>



Exploring the now while cherishing tradition and handmade values.

Major label/ 蟠長・Kicho

For more than 400 years since our founding, our motto has been "Sake has Soul." Our mellow yet elegant taste is woven from Ikoma's famous water and sake rice.

上田酒造 株式会社 **Ueda Sake Brew Co., Ltd.**
 866-1 Ichibu-cho, Ikoma, 630-0222
 ☎ 0743-77-8122
 ☎ 0743-76-0701
<https://ueda-syuzou.com>



Spreading "umazake" to a dozen or more countries.

Major label/ 春鹿・Harushika

Established in 1884 in Nara, a town that retains a nostalgic atmosphere, close to World Heritage sites such as the Kofukuji and Gangoji temples.

株式会社 今西酒造 西内商店 **S. Imanishi Co., Ltd.**
 24-1 Fukuchiin-cho, Nara, 630-8381
 ☎ 0742-23-2255
 ☎ 0742-27-3585
<http://www.harushika.com/>



A straightforward sake brewery that does not go with the times.

Major label/ 万代老松・Mandai Oimatsu

With quality first as our motto, we draw out the taste of the rice to create a rich sake that goes refreshingly down your throat.

藤村酒造 株式会社 **Fujimura Shuzo Co., Ltd.**
 154 Shimoichi, Shimoichi-cho, Yoshino-gun
 ☎ 0747-52-2538
 ☎ 0747-52-8739
<http://yoshino-umazake.com/natu.htm>



Local Ouda sake from Kagirohi-no-Sato.

Major label/ 千代乃松・Chiyonomatsu

Castle town of the Oda clan. The nature with which the cold climate blessed Uda, in Yamato Province, and its water and good quality rice are used to brew this tasty sake.

芳村酒造 株式会社 **Yoshimura Shuzo Co., Ltd.**
 1797 Oudamanroku, Uda, 630-2163
 ☎ 0745-83-2231
 ☎ 0745-83-0840
<https://www.begin.or.jp/~inadoya/>



The certainty of something founded three centuries ago.

Major label/ 松の友・Matsunotomo

We are a sake brewery along the clear banks of the Yoshino River, a land well-suited to making sake, which is so dependent on rice and water. We also make persimmon wine from Fuyu persimmons.

株式会社 山本本家 **Yamamoto Honke Co., Ltd.**
 1-2-19 Gojo, Gojo, 637-0042
 ☎ 0747-22-1331
 ☎ 0747-22-3366
<https://matsunotomo.com>



"Shodo Mukyukyoku": The road to making good sake is one that never ends.

Major label/ 吉野杉の樽酒・Yoshinosugi-no-Tarusake

Yoshinosugi-no-Tarusake is Japan's first bottled barrel-brewed sake. We brew sake that offers joy, that moves you, maintain tradition while continuing new challenges.

長瀬酒造 株式会社 **Choryo Shuzo Co., Ltd.**
 4 Minami, Koryo-cho, Kitakatsuragi-gun, 635-0818
 ☎ 0745-56-2026
 ☎ 0745-56-3080
<https://www.choryo.jp>



Local sake with a taste that weaves history and tradition.

Major label/ 出世男・Shusse Otoko

The only active sake brewery in Imai-cho, where streetscapes from the Edo period still remain. Our famous Shusse Otoko label is seen as a true sake for bringing good fortune.

河合酒造 株式会社 **Kawai Sake Brewery Co., Ltd.**
 1-7-8 Imai-cho, Kashihara, 634-0812
 ☎ 0744-22-2154
 ☎ 0744-24-1061
<https://www.facebook.com/syusseotoko/>



This is a dry "tanrei" sake made from rice, water, tradition, technology, and the natural environment.

Major label/ 都姫・Miyakohime

For 12 generations over 350 years, we have maintained the traditions of the famous Nara sake brand where we were founded, in Ichinomoto Iwaya.

増田酒造 株式会社 **Masuda Sake Brewery Co., Ltd.**
 42 Iwaya-cho, Tenri, 632-0003
 ☎ 0743-65-0002
 ☎ 0743-65-3231
<http://masuda-shuzou.co.jp>



Founded more than 300 years ago. This offering interweaves nature and tradition.

Major label/ 菊司・Kikusukasa

Founded in 1705, we have been continuously producing sake in the post-station town of Oze on the Nara Kaido road just before the Kuragari Pass.

菊司酒造 株式会社 **Kikusukasa Sake Brewery Co., Ltd.**
 555 Oze-cho, Ikoma, 630-0223
 ☎ 0743-77-8005
 ☎ 0743-77-8420
<https://kikusukasa.pro>




Toast with Hoshuku, the sake for celebrations!

Major label/ 豊祝・Hoshuku

A "Special Designation Sake" with 80% of its output junmai or higher. We are proud of the emphasis on hand-crafted sakes that dates back to our founding.

奈良豊澤酒造 株式会社 **Naratoyosawa Shuzo Co., Ltd.**
 405 Imaichi-cho, Nara, 630-8444
 ☎ 0742-61-7636
 ☎ 0742-61-7658
<http://nara-toyosawa.jp>

Life, completely fermented.

Major label/ 睡龍・Suiryu

A kimoto junmai sake matured for 20 years that the brewers consider tasty. First try some.

株式会社 久保本家酒造 **Kubohonke Sake Brewery Limited**
 1834 Oudaideshin, Uda, 633-2162
 ☎ 0745-83-0036
 ☎ 0745-83-3353
<https://kubohonke.com>



Aiming for sake that will please as many people as possible.

Major label/ 五神・Goshin 賢名生・Anou

Founded in 1924. A mellow sake produced in small batches, it draws on the fine-grained hand-made craftsmanship of the traditional Tajima style.

五條酒造 株式会社 **Gojoshuzo Co., Ltd.**
 1-1-31 Imai, Gojo, 637-0004
 ☎ 0747-22-2079
 ☎ 0747-25-3646
<http://sake-goshin.com>



Creating future sake as yet unseen while pursuing the traditions of Nara sake.

Major label/ 風の森・Kaze no Mori

We search for diverse sakes using brewing techniques that can only be achieved in modern times yet that express to the full the uniqueness of Nara sake.

浦長酒造 株式会社 **Yucho Shuzo Co., Ltd.**
 1160 Gose, 639-2200
 ☎ 0745-62-2047
 ☎ 0745-62-3400
<http://www.yucho-sake.jp>



A sake brewery that produces happiness for people through sake, music, and health.

Major label/ 歡喜光・Kankiko

We started when a dyer opened a sake brewery in the Meiji period. Our sake is brewed based on the traditions of Nara sake and our philosophy of "tradition and progress."

澤田酒造 株式会社 **Sawada Syuzo Co., Ltd.**
 6-167 Goido, Kashiba, 639-0226
 ☎ 0745-78-1221
 ☎ 0745-76-0005
<https://www.kankiko.jp>



Nakatani's Sake Brewery & Bar, offering a sake making experience alongside a sake bar. 2-4 Yanagi, Yamato-Koriyama

Major label/ 大和郡山 中谷・Yamato Koriyama Nakatani (5 mins walk from Kintetsu Koriyama Station)
 Hours: 13:30-19:00
 Closed Mondays and Tuesdays (open if a public holiday)
 Phone: 0743-85-7281

中谷酒造 株式会社 **Nakatani Brewing Co., Ltd.**
 561 Baniyo, Yamato-Koriyama, 639-1117
 ☎ 0743-56-2296
 ☎ 0743-56-2464
<https://www.sake-asaka.co.jp>



Founded in 1727, we emphasize unwaveringly serious sake-brewing in the mountains of Ikoma.

Major label/ 山鶴・Yamatsuru

"Umazake" where the aesthetics of junmai resonate with all five senses.

株式会社 中本酒造店 **Nakamoto Sake Brewery Co., Ltd.**
 1067 Kami-machi, Ikoma, 630-0131
 ☎ 0743-78-0005
 ☎ 0743-79-0360
<https://yamaturu.com>



A famous label from Tsuge, the town of ice storehouses.

Major label/ 金鼓・Kingaku

A deep taste brewed using traditional methods in a blessed natural environment. Refined sake from an arcadia.

倉本酒造 株式会社 **Kuramoto Sake Brewery Co., Ltd.**
 2501 Tsugehayama-cho, Nara, 632-0231
 ☎ 0743-82-0008
 ☎ 0743-82-1748
<https://kuramoto-sake.com>