

Five Whiskeys from the Buffalo Trace Distillery

Buffalo Trace
Eagle Rare

Blanton's Special Reserve
Hancock's Reserve
Rock Hill Farms

A tasting done by Whisky Montreal on July 15, 2013

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Bourbon is American Whiskey. On May 4, 1964, the United States Congress recognized Bourbon Whiskey as a "distinctive product of the United States." The Federal Standards of Identity for Distilled Spirits (Code of Federal Regulations title 27, part 5, subpart C.) state that bourbon must meet these requirements:

- *Bourbon must be made of a grain mixture that is at least 51% corn.*
- *Bourbon must be distilled to no more than 160 proof (80% abv).*
- *Neither coloring nor flavoring may be added.*
- *Bourbon must be aged in new, charred oak barrels.*
- *Bourbon must be entered into the barrel at no more than 125 proof (62.5% abv).*
- *Bourbon, like other whiskeys, may be bottled at not less than 80 proof (40% abv).*
- *Bourbon that meets the above requirements and has been aged for a minimum of two years may (but is not required to) be called Straight Bourbon.*
- *Straight Bourbon aged for a period less than four years must be labeled with the duration of its aging.*
- *If an age is stated on the label, it must be the age of the youngest whiskey in the bottle.*
- *Only whiskey produced in the United States can be called bourbon.*

The rules apply to all products sold inside the United States, whether made in the US or imported. American whiskey can also be Rye, Corn Whiskey, Wheat Whiskey and others. Similar to European regulations, except Europe requires three years of aging and doesn't require new, charred oak barrels.

Traditionally Whisky in Scotland is made from a wort. Wort is made by cooking the grains and then removing the solids before fermentation. Bourbon is made from a mash. A mash is made by cooking the grains and leaving them in during fermentation. A sour mash is made by adding some of the liquid from a previous fermentation to the new mash. Ensures a consistency.

Initially rum and gin were produced in the United States. After independence there was a general westward expansion of the population. Transporting the ingredients to make rum and gin became increasingly more expensive. Making alcohol with local grains was much cheaper.

1791 the United States federal government instituted a tax on whiskey to pay off debts incurred from the war of independence. It was levied unequally and in 1794 there was the

whiskey rebellion in western Pennsylvania. It is commonly believed that because of the rebellion farmers moved west to Kentucky. Not quite the case. The people rebelling moved south to Louisiana and there had been lots of small scale distilling done in Kentucky for many years prior to the rebellion.

Bourbon as we know it was likely invented by the Louis and John Tarascon. Brothers from near the cognac region of France. Built a mill and a warehouse in Louisville, Kentucky and were in "the perfect position to purchase whiskey coming down the river, age it, ship the better tasting product to New Orleans and sell it." - [Mike Veach, Kentucky Bourbon Whiskey]

Throughout the 19th century various technological advances and improvements happened. Continuous still, rick system for aging, bottling, marketing and advertising, etc. Excise tax on alcohol initially paid when made, over time increased to after aging eight years in "bonded warehouses." Straight vs. Rectified whiskey

1861 The Civil War begins

1862 A whiskey tax is re-imposed at \$0.20 per gallon increases to \$2 per gallon by 1865

1865 The Gilded Age begins; the Civil War ends

1868 Federal tax is reduced to 50 cents a gallon

1879 Frederick Stitzel patents the rick system for storing barrels

1887 The "Whiskey Trust (K.D.&W. /&D. & C.F.)" monopoly is formed; O.F.C. and Carlisle are NOT part of the Trust

1897 bottled in bond act (4 years, 100 proof, one distiller, one distilling season, unadulterated)

1906 Pure Food and Drug Act prevented the "manufacture, sale or transportation of adulterated or misbranded or poisonous or deleterious foods, drugs, medicines and liquors."

1920 Prohibition to 1933. Although certain states enacted prohibition as early as 1907. Seen as an attack on German culture (lots of German immigrants at the time) but with WW 1 German's were bad guys. 6 companies Schenley (Buffalo Trace), what became National Distillers Product Co., Glenmore Distilleries, Brown-Forman, Frankfort Distilleries, Stitzel – Weller. One pint (473ml) of 100 proof spirits per patient every 10 days. Doctors & dentists 12 pints per year for office use. Bakers 12 pints of rum or brandy per year.

1930s consolidation and return to business

1934 60 distilleries are refurbished and ready to start up production again

1940s Boom, during WW 2 switched to industrial alcohol production

1950s Boom

1970s Bust

1984 Single Barrel invented, Japan enables bourbon industry to climb out of its hole, super aged becomes popular

1992 Small Batch invented

1999 Bourbon Trail

2000s Craft Distilleries

Taste Buffalo Trace & Eagle Rare

Mashbills, Yeast and Aging

Buffalo trace only uses 5 different mashbills,

The recipe is crucial, but what yeast strain are you using? Are you using one at all or just using a dry yeast, are you using a jug yeast, a family jug yeast? Then what proof you bring it off the still? What's the barrelling proof? Where you store it in the rack house and for how long? What's the bottling strength and do you cold chill filter it? All are good questions...So that's my argument. All bourbons fall in to 3 general bourbon recipes. A Traditional, a High Rye, and a Wheat.

Traditional Bourbon Recipe (my term, not industry's) – 70-80% corn –with the balance rye and some barley. Think of sweet and spicy, back of the tongue experience. Bourbon can be up to 100% corn, but corn becomes neutral during aging only keeping the sweetness, so a flavoring grain of rye is used, and of course the barley for converting those starches in to sugar, and that biscuity quality and hints of chocolate.

High Rye Bourbon Recipe – 18% + rye – dials back on the corn, keeping basically the same amount of barley as a Traditional Bourbon, but doubles up on the rye. Rye is a back of the tongue experience, and gives it that nice white pepper spice like a slice of rye bread. These bourbons will be less sweet and more spicy.

Wheat Bourbon Recipe – 70-80% corn – similar to Traditional, but replace the rye with wheat. Wheat allows the sweetness of the corn, and the sugars from the barrel to be more pronounced. Think "soft and sweet", with a front of the tongue experience.

<http://www.whiskeyprof.com/theres-only-3-general-bourbon-recipes-yall/>

Since a water molecule is very small, it is easier for it to escape through the barrel than the much larger alcohol molecule. Because the atmosphere at the top of a Rickhouse is very hot and dry, the water molecules escape much faster than the alcohol molecules thus driving the proof UP in those barrels also concentrating the flavors.

Barrels at the top of a Rickhouse age at an accelerated pace.

Conversely the atmosphere at the bottom of the Rickhouse is moist and cool. Since a water molecule is very small, water can penetrate the barrel from the surrounding moisture and that drives the proof DOWN in those barrels.

Barrels at the bottom of a Rickhouse age at a slower pace, and the flavors are not as pronounced. With 3 barrels on each floor, you can easily see by this diagram that bourbons age differently all through the house. So it really showcases how a Single Barrel Bourbon will taste a little different from barrel to barrel.

If you mingle several barrels together from different floors as in a Small Batch Bourbon, then that product will taste more consistent from bottle to bottle, and batch to batch.

Mainline bourbons like Evan Williams Black Label, and Jim Beam White Label are from a larger number of barrels collected from all areas of the Rickhouse.

Small Batch and Single Barrel Bourbons generally come from more specific areas of the Rickhouses, and in either one Single Barrel, or a dump of a lesser number of barrels for a Small Batch.

Different distilleries define Small Batch differently, so keep that in mind with # of barrels in a dump or areas of Rickhouses, or specific Rickhouses themselves as the Small Batch.

<http://www.whiskeyprof.com/whiskey-201/>

In talking with distillers, I've learned something that is very useful when looking at bourbon and other American whiskeys. The agreed on percentages of what makes up the final flavor of a whiskey is as follows:

- 10% yeast strain
- 15% distillation
- 25% small grains
- 50% maturation

Corn – is what gives Bourbon its signature sweetness, and is considered the “engine” that provides the highest yield of alcohol per bushel of all the grains. The flavor of corn is prevalent fresh off the still in the White Dog; but over years of aging, the corn becomes neutral, and lends mostly in the over all sweetness to the finished product. *Corn is not a small grain

Barley – is prized mainly for its enzymes for converting starches to sugar for the fermentation process so the yeast can feed on the sugars. Where corn is the “engine”, malted barley is considered the “horse power” that delivers these enzymes. Barley provides some flavor with the underlying malty and chocolate notes along with some dryness. Usually only around 5% – 14% of any grain bill, the use of barley is mainly for those enzymes, and gives it that slight biscuity texture. The alpha amylase are the power house that immediately break the starches down to sugars, and the beta amylase break them down further in to fermentable sugars for the yeast.

Rye or Wheat – contribute most significantly to the flavor of mature bourbon. They are referred to as the “flavoring grains”. Any grains can be used like oats, or even brown rice, but these two are primarily used, with Rye being the dominant flavoring grain with distillers by 90%.

Wheat – Wheat results in a sweeter tasting bourbon, but not because the grain is sweeter. Wheat is not as rich as rye so it allows more of the sweetness of the corn and vanilla to show through. The Three Recipe's or Mash Bill's in bourbon Traditional Bourbon Recipe (my term, not industry's) – 70-80% corn –with the balance rye and some barley. Think of sweet and spicy, back of the tongue experience.

MATURATION – 50 %

Barrels and Aging – Barrel Sizes – 53 gallon vs. 5 gallon

Maturation is 50% Of Final Flavor of Bourbon The Barrel and aging provide varying flavors depending on how long it is aged for, and what type of warehouse, and the location of those barrels inside a rack house. Barrel aging is responsible for 50% of the final flavor of a bourbon depending on where the barrel is stored and for how long. Smaller barrels (5 Gallon, etc) have advantage of getting a lot of color and flavor quickly. Disadvantage, oxygen never really gets in to the barrel to work with the spirit well, and shorter aging means not many confection notes like vanilla, caramel, toffee, etc.

There are at least six different types of vanillas you get from a barrel. And it takes a good six years to get those vanillas out of a barrel. Bourbons 6 years or more will have more pronounced vanillas, and other barrel notes like: maple, butterscotch, brown sugar, caramel, ginger, clove, toffee, cinnamon, nutmeg, orange, graham cracker, walnut, almond, butter, anise, bacon, and toasted nuts, and many, many more.

Buffalo Trace Distillery did some extensive experimentation with 5 to 15 gallon barrels and found that their Buffalo Trace bourbon did not mature well in them, and the smaller the barrel used (the 5 gallon barrel) the worse the bourbon tasted. Buffalo Trace has also tried experiments with different parts of the tree used for barrels with positive results, but that was in 53 gallon barrels.

"The oxygen uptake will be more too, for the same reason of larger surface area. The slow oxygenation in a regular size barrel will never happen in a small barrel even if the intensity of aromatics is diminished by a different char or toast, so a small barrel will never have the balance of oxidation products achieved in a spirit aged in regular sized barrels."

Then when you look at the type of rackhouse you have to age the bourbon. Is it a palletized warehouse (barrels on pallets, usually single story set up). Traditional rick system in a 5 to 9 story rackhouse. The lower floors are moist and cool and the proofs will lower from entry proof, and the higher floors are hot and dry with the proofs rising from entry proof. You can get different tasting products by putting them in different style houses, or in different places inside the rackhouse.

<http://www.whiskeyprof.com/whiskey-301/>

At Buffalo Trace, they have wood and tin rackhouses, brick, and concrete block rackhouses. Bourbon ages differently in each type of house, so they put certain bourbons in certain types of houses, and thats what makes up the differences in their small batch and single barrels.

<http://www.whiskeyprof.com/whiskey-401/>

Buffalo Trace, #4 char, Independent Stave

#1, higher corn BT White Dog, Benchmark, **Buffalo Trace**, Old Charter, **Eagle Rare**, Col. E.H. Taylor, Geo. T. Stagg

#2, lower corn- Ancient Age*, Elmer T. Lee*, **Hancock***, **Blanton's***, **Rock Hill Farms***, Virginia Gentleman/Bowman Bourbons?

Wheat bourbon: Everything Weller, Van Winkle Special Reserve "Lot B"*, Old Rip Van Winkle*, Pappy Van Winkle 15 y/o*

Rye: Sazerac, Bowman Rye, Van Winkle Family Reserve Rye* (?)

Mash Bill 1 - Eagle Rare, Buffalo Trace

Mash Bill 2 - Rock Hill Farms, Hancock Reserve, Blantons

Mashbill 1 is a low rye content recipe(somewhere in the neighborhood of 80% corn).

Mashbill 2 is a rye recipe that contains more rye(how much I don't know but will guess it's around a 60-70% corn recipe).

the designation of the whiskey occurs after the aging.

Some of the top contributing aroma compounds include: guaiacols (smoky), cresols (barn, medical), eugenols (clove), furanones (caramel), lactones (coconut, peach) and vanillin (vanilla).

It is true that Eagle Rare is the same recipe is Buffalo Trace, however the main difference is that Eagle Rare is aged for 2 years longer AND it's a single barrel bourbon vs. a small batch like Buffalo Trace.

Where a barrel is stored is extremely important. Ground floor over time it can loose proof. Something barreled at 125 proof can go down to 120 proof over a very long time. Upper floors it will gain proof. Something barreled at 125 proof can go up to 170 proof over a very long time. Water molecules will permeate the barrel. Bourbon stored in the upper levels will get darker over time. Planning releases about two years in advance. "The bourbon that is made the day after making rye is awesome." Heaven Hill used to make rye two days/year. Now they make it once/month

the sweet spot in aging is between 6 and 9 years. At 12 years, most bourbons begin to lose their fight with the barrel they are aged in and become over oaked.

<http://youtu.be/ppg-ls0pRjc>

Whiskey is primarily composed of water and ethanol; the congeners – a term for any compounds in whiskey which are not ethanol or water – make up far less than 1% of the volumetric basis of a whiskey. However, it has been long known that this small fraction is what gives whiskey its unique character. Thus, much of the history of whiskey science is devoted to analyzing this congener fraction, including: how variations in production protocols affect it, what chemical compounds comprise it, and which of these compounds are actually important to the flavor of the finished whiskey.

unlike Scotch, it is distilled first to a relatively high proof (around 60% alcohol v/v) in a column still and then re-distilled in a “doubler” or continuous pot still.

Because whiskey’s history is, in many ways, a defining attribute for consumers, whiskey production is based strongly in tradition and resistant to change. Modern processing technology, therefore, is applied to whiskey production mainly to optimize alcohol production, reduce waste, and otherwise optimize the cost/profit ratio. Nevertheless, whiskey, and particularly American whiskey, is an important product for several reasons. It is an immensely profitable section of an already profitable industry. In recent years, super-premium whiskeys (which retail at \$40 a bottle and up) have grown in popularity. With an increasingly sophisticated marketplace willing to pay top dollar for premium products, the value of tradition and quality to whiskey producers is only increasing.

First, the cereal grains are milled or cooked to make their constituent starches accessible. Through the use of native enzymes in barley, these starches are converted into maltose, which yeast are able to ferment into ethanol. Once this fermentation is complete, the resulting alcoholic solution (a beer of about 5-6% alcohol v/v) is distilled to a much higher proof (usually 65-70% v/v) and stored in new, charred, American oak barrels. The final product is then aged for several years, a processing step which, although human intervention is minimal, is fundamental

Malted grain, usually barley, is important to whiskey making because the malting process, which involves sprouting and then drying the grain, facilitates the production of starch-breakdown enzymes in the sprouted grains (5). Barley, in the form of malted barley or malt extract, is particularly important because it contains high proportions of active α - and β -amylase, enzymes which convert the stored starch in cereals into sugars that yeast is able to utilize for fermentation. In most American whiskey barley (which has less starch) is kept to the minimum necessary to achieve full starch conversion. Bourbon usually contains about 70% corn, with the rest of the cereal content being divided between malted barley and rye, Water, while nominally tasteless and odorless, can affect whiskey production due to pH level or dissolved minerals; for example, it is generally thought that the iron-free limestone in Tennessee and Kentucky is important for their dominance of the American whiskey market (6).

The major American whiskey producers appear committed to large batch cooking for whiskey, rather than continuous processing (6). Once a mash percentage is decided upon, the grain, excepting the malted barley, is loaded into batch pressure cookers with water and steam injected to raise the pressure to 200 kPa for two hours, after which it is cooled to 62.5 °C and the barley is added to achieve starch conversion (8). This slurry, consisting of fermentable sugars, cereal fibers, and water, is then cooled fully for yeast inoculation and fermentation.

Generally, fermentation of the wort into beer is by a single, cultured strain of yeast, in order to avoid off-flavors and to maximize conversion of available sugar to ethanol. Distilling yeast is a subspecies of *Saccharomyces cerevisiae*, the species of yeast which is responsible for the fermentation of beers and wines, and is notable for being partially amylolytic, i.e., it is capable of fermenting starch-derived di- and tri-saccharides (9). While it is possible to hybridize or genetically engineer a yeast that is fully amylolytic, thus eliminating the need to rely on barley or rye malt for amylase, the law in some cases and distillers’ adherence to tradition in all cases tends to prevent

this. A typical fermentation runs 40-48 hours; although some evidence shows that short fermentations negatively impact the final spirit quality, longer fermentations increase the chance of microbial contamination of the wort, leading to off-flavor or reduced alcohol yield (5).

The effects of aging and storage in barrels have been the subject of a great deal of research. Oak wood, which is the required wood for American whiskey aging, consists of approximately 45% cellulose, 15% hemicelluloses, 30% lignin, and 10% extractable volatiles, oils, sugars, and other organic substances (all % w/w) (5). Charring the inside of the barrels (figure 2.5) has a number of further effects: the creation of a layer of "activated" carbon capable of adsorbing "off-flavors" (14, 15), increased availability of oak extractives like "whiskey lactone", and the pyrolysis of cellulose, hemicelluloses, and lignin, which produces a number of phenolic and heterocyclic aroma compounds with distinct smoky, sweet, and vanilla-like aromas, many of which are thought to be characteristic of American whiskey (10- 12, 15) (figure 2.6). By law, American whiskey must be aged in new barrels, but a body of research shows that further re-use of barrels reduces both the activity of the activated carbon and the availability of the extractives, indicating that the new char is an important element of the production process (14).

level 1 char= 10-15 seconds on torch;
#2 level char: 15-25 seconds on torch;
#3= 25-35 seconds on torch and
#4= 35-45 seconds on torch.

Barrels of distillate are stored for differing lengths of time in warehouses. While most American whiskey is bottled between 2 and 10 years of age, whiskey has no theoretical upper limit on aging. The areas of the United States in which whiskey is primarily produced have climates that lead to a concentration of alcohol with aging (as water evaporates through the semipermeable barrels), in contrast to, for example, the Scottish climate, which generally leads to the evaporation of alcohol during aging (the so-called "angel's share") (5). Thus, with no loss of valuable ethanol, American whiskey can be aged for extremely long periods. It is generally thought, however, that excessive aging in wood can lead to a loss of spirit character and domination by wood-derived flavor notes. It is possible to bottle at "barrel-strength", which can be as high as 65-70% alcohol (v/v), but most American whiskey is sold diluted with pure water to 40-45% alcohol (v/v).

It is well-known that the barrel used for maturing whiskey contributes much of the whiskey's flavor (15) – most, in the case of American whiskeys (5). Many of the important odorant classes in whiskey, especially lactonic and phenolic compounds, are extracted from wood during the maturation of the whiskey (32). Charring the interior of the casks, as is stipulated in the production protocols for American whiskeys, has a profound effect on the aroma profile of whiskeys aged in those casks, increasing positive sensory characteristics associated with mature whiskeys, such as smooth, vanilla, and sweet, while decreasing characteristics associated with immaturity, such as pungent, sour, oily, and sulfury (14). These changes were evident as soon as 3 months after the distillate was introduced to charred barrels. It has also been shown that these wood extractives affect the partitioning of esters and the solute interactions of water and ethanol (33). Thus, it is obvious that the charring of barrels in the production of American whiskey has a profound effect on the ultimate flavor profile.

One of the most important odorants extracted from wood in aged distilled beverages is a branched γ -lactone which is often referred to as "oak lactone" or "whiskey lactone", and is more systematically called β -methyl- γ -octanolide.

Sensory analysis, of course, has been applied not only to whiskeys, but to nearly all classes of alcoholic distillates. Peña y Lillo et al (59) compared a trained sensory panel's ability to discriminate between samples of pisco (an un- or lightly-aged grape spirit produced in several South American countries, in this case Chile) using orthonasal (sniffing) or retronasal (tasting) methods. They found that the panelists discriminated the samples slightly better using

orthonasal methods, although there was a large degree of variation between panelists and between spirit samples. The variance between samples, and the non-linear behavior of the "oak" attribute may indicate that tasting may provide better discrimination in some cases, such as when a large portion of the aroma compounds in a sample are derived from aging in wood.

Highly alcoholic distillates like whiskey have the potential for being difficult to analyze by nose, even for experienced assayers. In a review and refinement of guidelines for sample handling in the Scotch whisky distilling industry, the author noted that samples should always be provided at 20% abv (%v/v), in order to avoid olfactory fatigue for the assessors (60). Not only can the high ethanol content of whiskey cause fatigue, but varying concentrations of ethanol can affect odor perception and release, both physicochemically and perceptually, through synergistic and antagonistic sensory interactions (61).

From Jacob Lahne's Thesis

Dilution of a whisky to 23% abv maximises volatile release from distillates, optimising sensory assessment.

Origins of Flavour in Whiskies and a Revised Flavour.pdf

Taste Blanton's, Eagle Rare & Hancock

Buffalo Trace Distillery

The distillery is in Frankfort, KY 1,450 km from Montreal

"The tour they give here is still the best of the large plants,"

Founded by Col. Albert Blanton,

Native tribes didn't live here, but many different ones sought the buffalo that did. And long before there was a Frankfort, or a Leestown, this particular area was part of a major path of migration for buffalo. It was here that their trail (or "trace") crossed a shallow part of the Kentucky River

Hancock McAfee and Willis Lee established in 1775.

Distilling here began as early as 1787, but became a commercial enterprise after Benjamin Blanton went off to seek his fortune in the great California Gold Rush of 1849. Unlike many other "Forty Niners", he was quite successful. In fact, he struck it rich, didn't gamble or lose it all in investments, and returned to his home in Kentucky a very wealthy man. He bought the old Rock Hill farm near Leestown and established a distillery here in 1865.

he sold it only four years later. The man he sold it to named it the Old Fire Copper Distilling Company and began producing bourbon. OFC remained a very famous brand of bourbon until it was sold to Schenley (who still produces whiskey under that brand, although it's Canadian whiskey now and the name has been changed to "Old Fine Canadian"). Only a couple of years later, Col. Edmund Taylor purchased the facility. Colonel Taylor owned several distilleries in the Frankfort-Glenn's Creek area and it was during this period that he revolutionized the bourbon industry by introducing scientific methods of ensuring consistency and high quality. Taylor also didn't own the plant long however, passing ownership on to George T. Stagg (who was principal owner of the E.H.Taylor, Jr. Co.) in 1886.

Stagg added his own brand and changed the name to the Old Stagg Distillery, but he kept the OFC brand as well. He also continued to produce Old Taylor whiskey here. Eleven years later, he hired a young man named Albert B. Blanton, who was the son of founder Benjamin, and he went on to become the master distiller from 1912 until he retired in 1952. The distillery did not operate during Prohibition, but was used for warehousing and bottling of medicinal whiskey. In 1929, the Schenley Corporation bought it, and they began producing bourbon here in 1933.

During World War II, another Schenley company moved in and set up a "distillery within a distillery". George Dickel's Cascade Hollow, which had been driven from Tennessee in 1910 when that state declared itself dry a full decade before the rest of the country set up operations at this site.. The Dickel operation had moved originally to Louisville, but came to the Stagg plant shortly after Schenley purchased it. Sometime much more recently, perhaps in the eighties, a group of Schenley executives formed their own company and bought the distillery to operate it on their own. That didn't work out well and they shortly sold it to Sazerac, a New Orleans-based beverage corporation. This was in partnership with a Japanese group headed by Yutaka Takano. The new company was called Age International. Takano's group held the majority of the ownership until recently, when Sazerac began buying up more and more until they now hold a majority. This was the point where it became Buffalo Trace.
<http://www.ellenjaye.com/buffalotrace.htm>

the company went from the Old Fashioned Copper (OFC) Distillery to E. H. Taylor & Company, to the George T. Stagg Distillery, to the Schenley Distillery, to Ancient Age Distilling Company, to Leestown Distilling Company, Inc., to it's current official name of Sazerac, Inc. to Buffalo Trace

<http://www.ellenjaye.com/ancientage.htm>

A settlement was founded at the crossing in 1775, when brothers Hancock and Willis Lee established their camp with a small company of men.

There has been a working distillery on the grounds since 1787.

The first modern distillery was built on this site in 1857 and was the first to incorporate the use of steam power—a major advance in producing high-quality bourbon.

Today the Buffalo Trace Distillery site encompasses 119 acres and 114 buildings.

1870 Edmund Haynes Taylor Jr. purchases the distillery and invests a "small fortune" in modernizing the distillery. Distillery is christened "O.F.C." - Old Fire Copper its first name

1881 Warehouse A and the Dickel Building are built; they are still standing today
Warehouse C is built and still stands today

1884 Warehouse B is built and still stands today

1886 Steam heating system for the warehouses is installed

1904 The distillery is re-christened the George T. Stagg Distillery

1907 Warehouse D is built and still stands today

1919 157 operating distilleries in the industry. Elmer T. Lee is born

1929 The distillery is purchased by Schenley Distillers Corporation

1933 Prohibition ends, only six companies remain

Four Distilleries owned by Schenley - Scenley, Stagg, Pepper, and Squibb.

Brands: Golden Wedding rye, James E Pepper, Old Stagg, Old Quaker, Ancient Age (made in Canada as American style)

Distillery's fermenting capacity is increased

Cream of Kentucky and Echo Springs brands are launched

1935 The distillery's only "metal clad" warehouse, Warehouse H, holding 15,000 barrels, is constructed. The massive Warehouse I, holding 51,000 barrels, is constructed.

1939 Employment at the distillery reaches 1,000 people

1952 Warehouse "V," the world's only "one barrel" warehouse, is built in celebration of the 2 millionth barrel. Albert B. Blanton retires

1969 Exports to Japan begin

1970 The bourbon industry collapse begins

1984 The distillery introduces the world's first single barrel bourbon: Blanton's

1991 Employment dwindles to 50 people; the distillery is in danger of closing

1992 The distillery is finally returned to a family-owned business, being purchased by the Goldring family

1999 Distillery renovations are completed and the distillery is re-christened as THE BUFFALO TRACE Distillery. The distillery's new flagship brand — BUFFALO TRACE — is launched. The W. L. Weller and Old Charter brands are acquired

2009 E.H. Taylor label and barrel inventory acquired from Jim Beam; Master Distiller Emeritus Elmer T. Lee turned 90 years old

Ancient Age
Benchmark

Blanton's
Buffalo Trace
Buffalo Trace Experimental Collection
Eagle Rare
Elmer T. Lee
George T. Stagg
Hancock's Reserve
Old Charter
Rock Hill Farms
Sazerac and Thomas H. Handy Rye
Van Winkle and Pappy Van Winkle Bourbon and Rye
W.L. Weller

Taste Blantons, Hancock's and Rockhill Farms