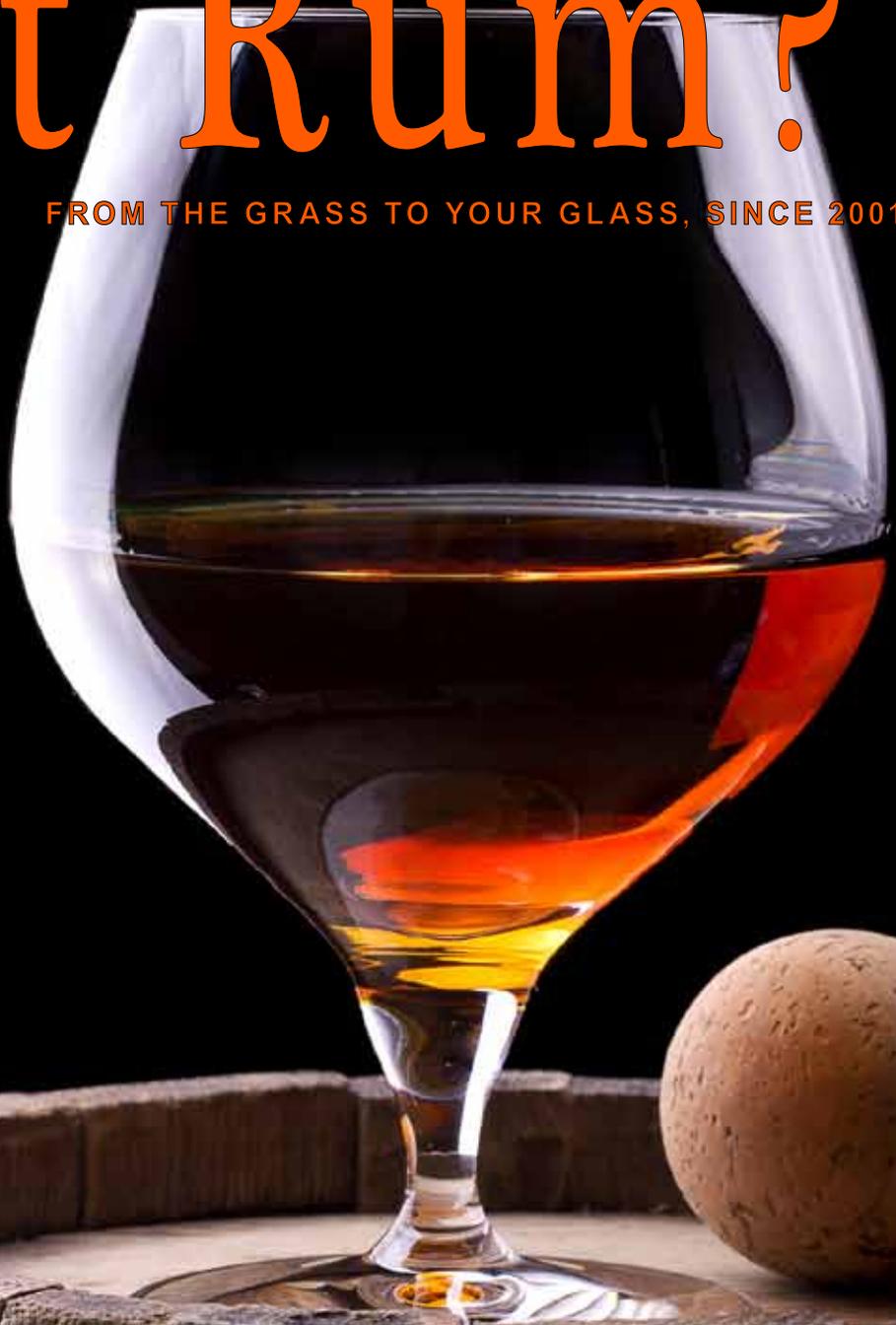


Got Rum?®

JUNE 2018

FROM THE GRASS TO YOUR GLASS, SINCE 2001!



**COOKING WITH RUM - ANGEL'S SHARE - CIGAR & RUM -
MUSE OF MIXOLOGY - RUM HISTORIAN -
RUM IN THE NEWS - EXCLUSIVE INTERVIEW -
FATHER'S DAY SPECIAL - RUM UNIVERSITY**



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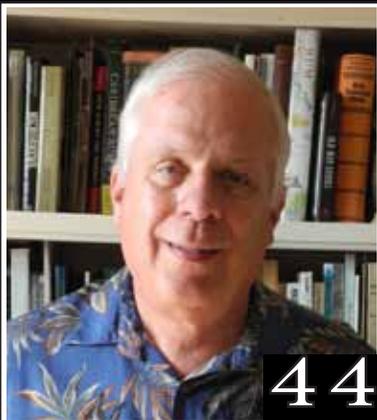
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FRONT COVER: Rum Atop Barrel

INSIDE SPREAD: Isolated Rum Storm

FROM THE EDITOR

The Power of Smell

When we detect a smell, consciously or not, the olfactory receptors in the upper part of our nose send electrical signals to our brain, along the olfactory nerve. The signal is received by the olfactory bulb, which then re-transmits it to other areas closely connected to it, which are collectively known as the *Limbic System*. Unlike our other physical senses, our sense of smell is the only one with a direct connection into the Limbic System, which is responsible for processing –among other things- emotions and memory. For this reason, scientists consider that of all our senses, the olfactory one is the most significant trigger of memory.

Think about how the smell of a certain spice or condiment can transport your mind to your mother's or grandmother's kitchen, or how the smell of a certain perfume or cologne can bring memories of a departed loved one. This power is not lost on marketers, who have learned to manipulate the scents in hotels, cars and shopping centers, with scientific studies demonstrating how people are more likely to spend time and money in stores with certain aromas than in equivalent un-scented establishments.

But can this apply to rum? Well, yes, it can! It is said that one of the advantages of well-rectified, charcoal-filtered neutral rum, is that it mixes very well in cocktails, regardless of what the mixers are. These insipid products do not have any congeners that can interfere with other flavors, so of course they are great for mixology. But being devoid of aroma-emanating congeners also puts them at a disadvantage, since there are countless consumers who've enjoyed freshly-squeezed sugarcane juice and who'd love to find hints of that goodness in their rum. The same applies to lightly caramelized cane syrup, *panela*, *jaggery*, *piloncillo* and other forms of brown sugar: they are the key to numerous childhood memories for countless people around



the world, and the leading rum brands are missing out on the opportunity to showcase those innate recollection triggers in their products!

Good bartenders will still be able to create excellent cocktails using higher-congener white rums; they will actually enjoy the challenge and will be happier to serve the drink, knowing they are working with innate and intrinsic aromas that can be traced all the way back to the sugarcane.

Cheers,

Luis Ayala, *Editor and Publisher*

LinkedIn <http://www.linkedin.com/in/rumconsultant>

Do you want to learn more about rum but don't want to wait until the next issue of "Got Rum?"? Then join the "Rum Lovers Unite!" group on LinkedIn for updates, previews, Q&A and exclusive material.

THE ANGEL'S SHARE

by Paul Senft



My name is Paul Senft - Rum Reviewer, Tasting host, Judge and Writer. My exploration of Rums began by learning to craft Tiki cocktails for friends. I quickly learned that not all rums are created equally and that the uniqueness of the spirit can be as varied as the locales they are from. This inspired me to travel with my wife around the Caribbean, Central America, and United States visiting distilleries and learning about how each one creates their rums. I have also had the pleasure of learning from bartenders, brand ambassadors, and other enthusiasts from around the world; each one providing their own unique point of view, adding another chapter to the modern story of rum.

The desire to share this information led me to create www.RumJourney.com where I share my experiences and reviews in the hopes that I would inspire others in their own explorations. It is my wish in the pages of "Got Rum?" to be your host and provide you with my impressions of rums available in the world market. Hopefully my tasting notes will inspire you to try the rums and make your own opinions. The world is full of good rums and the journey is always best experienced with others. Cheers!

Clairin Casimir Rum

2018 has been an eventful year for the U.S. rum market with the entrance of several new products releasing every month. One new product line that arrived during the first quarter of the year was the Clairin line of rums. Each expression in this line is from either a blend of rums from different distilleries or a single rum. In this case Clairin Casimir is a rum that is double distilled using a copper pot still by Faubert Casimir in the village of Baraderes Haiti and blended to 48.3% abv.

Appearance

The rum is crystal clear in the bottle and glass. Swirling the liquid creates a razor thin ring, that slowly thickens before reluctantly releasing a few thick tear drop legs that crawl down the glass. The ring and legs evaporate within in a minute, leaving behind large pebbles around the glass.

Nose

The aroma of the rum provides a boldly pleasant lemongrass note, with hints of ginger and herbaceous vanilla. Then I let the glass sit for a few minutes before revisiting it. The bold aroma were still present, but now a whole new array of note had joined them. Roasted nuts formed the baseline with black tea, fresh cut cucumber and melon rounded out by the slightest hint of salt and other minerals.

Palate

After the experience with the aroma I was completely unprepared for the experience of the first sip. The rum shyly delivers a lovely herbaceous kiss of sugarcane, immediately followed by a punch of fresh mint and salty olives. In quick succession I detected lemongrass, cinnamon, fresh fennel, and a touch of moldering earth and ethanol to round out the experience.

Review

Clairin Casimir is one of three Haitian rums released together in the U.S. market and I sampled them all for the first time at a trade event as a guest of La Maison and Velier at the beginning of the year along with rums in the Caroni line. This did in no way bias me one way or the other toward the rums, but did raise my understanding of how they are produced and the families in Haiti that help create them. The other two in the Clairin line; Vaval and Sajous will be reviewed other months. Since that presentation I have enjoyed Clairin Casimir rum neat, in a Ti punch, Daiquiri, Planters Punch, and its array of flavors shined in each experience. For those who are curious the Daiquiri and Ti Punch while they are made of the same ingredients, I found the Ti Punch was more citrus forward and played well with the herbaceous notes, in the rum, while the sweetness in the Daiquiri pulled the mint and mineral notes in the flavor profile. Reasonably priced at the time of this review, the three Clairin expressions are accessible in New York and a few online outlets. I am happy to add the Clairin line along with Rhum Babancourt to my collection of Haitian rums.



www.lamaisonandvelier.com

THE ANGEL'S SHARE

by Paul Senft

Foursquare Exceptional Cask Premise

In the past few years it has been interesting to witness the rise of Foursquare rums in the Global Rum market. When my wife and I began visiting rum distilleries, Foursquare rum distillery on Barbados was one of the first ones I visited in the Caribbean. Back then the distillery was known for making Old Brigand, the Doorly's, an Tommy Bahamas line. Since that time Tommy Bahamas rums have been replaced by Real McCoy, Doorly's rum line has seen serious growth, and Master Distiller Richard Seale has launched the Foursquare Exceptional Cask Series.

Premise is the eighth expression in his Exceptional Cask series. The rum is created from distilled molasses using a pot still and a traditional twin column still. The rums in this blend are a combination of rums aged for ten years in used bourbon casks and rums double matured for ten years in both bourbon and ex-sherry casks. The rum was blended and bottled to 46% ABV in January of 2018.

Appearance

The rum holds a solid golden amber in the bottle and glass. Swirling the liquid creates a medium band that quickly expands, beads, and then thickens before releasing thick slow moving legs.

Nose

Nosing the rum I discovered vanilla, charred oak tannins (roasted walnuts and tobacco leaf), with brown sugar, green apples, dried fruits (raisins and mango),

baking spices, and with a subtle banana note rounding it out.

Palate

The first sip of the rum the oak notes carve a foundation with the char, roasted walnuts, and tobacco leaf from the aroma along with a dark cacao, these notes are flattened slightly by baking spices and carbon notes. Subsequent notes bring forward the sweeter fruit notes in the flavor profile green apple, banana, red grapes, with a touch of ginger and allspice punctuating the medium finish.

Review

When I saw the name "Premise" I was curious to see what would this new rum would reveal and how it would compare to other rums in the series. Overall, I was pleased with the expression as it had an interesting complexity like other rums in the Exceptional Cask series but its own clear identity. The sherry and bourbon notes are blended and balanced nicely, and the way they were counterbalanced by the spice and carbon notes was surprising. I will be interested seeing what bartender create with this product as the flavor profile would do well in a range of classic and new cocktails. As a sipper it is enjoyable, but not my favorite of the series, so will set this one aside to share with friends. At the time this product was released the U.S. market also received the 2005 vintage and Dominus products. If all goes well and I am able to track them down, I will review both of them in the upcoming months.



@foursquare.rumdistillery

Would you like to see your rum reviewed here?

We don't charge fees to review rums, you don't even have to advertise, so what are you waiting for???

For more information, please send an email to: margaret@gotrum.com

COOKING WITH RUM

by Chef Susan Whitley



Hello, my name is Susan Whitley, I am passionate about great foods and beverages. I love finding recipes that incorporate my favorite ingredients and sharing the results with my friends and family.

Through this monthly column I will do my best to inspire you to incorporate the ***spirit of the tropics*** into your everyday cooking.

Sue@gotrum.com

Father's Day is just around the corner. Show him your appreciation for everything he has done for you by satisfying his appetite. Here is a main course with side dish that is sure to please your Dad and make him feel extra special. Just remember, after this amazing meal, Dad may just need to kick back and enjoy a siesta. Bon Appetit Dads!!!

Baked Rummy Pork Chops and Apples

Ingredients:

- 6 Pork Chops, 1 ½ in. thick
- Flour
- 1 Tbsp. Worcestershire Sauce
- 3 Red Apples, cored and cut in wedges
- Salt, Pepper and Paprika to taste
- 2 Tbsp. Crisco, can substitute with Olive Oil
- 2 Tbsp. Heavy Cream

"Goodness comes out of people who bask in the sun, as it does out of a sweet apple roasted before the fire."

— Charles Dudley Warner

1 tsp. Kitchen Bouquet
Sugar
Cinnamon
½ C. Water
½ C. Dark or Spiced Rum

Directions:

Season chops with salt, pepper and paprika then dip in flour. Fry in Crisco until golden-brown and set aside in a baking dish. Add 2 tablespoons of flour to grease in skillet and let brown. Add heavy cream, Worcestershire sauce, Kitchen Bouquet, water and rum, stir until smooth and pour over pork chops. Put approximately half an apple on top of each chop and sprinkle with sugar and cinnamon. Bake for 45 minutes to one hour at 350°F. For added rum flavor, pour half a cup of your favorite rum into the bottom of the baking dish. Baste often. If gravy is not thick enough, thicken with a paste made of one tablespoon of flour, 1 tablespoon of water and one of rum for every cup of gravy. Serves 6.



Rummy Mashed Potatoes

Ingredients:

4 Lrg. Russet Potatoes, chopped
(leave skin for fuller flavor)
1 Stick of Butter
Salt and Pepper to taste
½ C. Rum-soaked White Raisins
(use dark rum)
1 C. Finely Chopped White Onion

Directions:

The night before, soak raisins in a cup filled with rum.

Begin boiling water in a large pot. While you are waiting for the water to boil, in a skillet melt half a stick of butter then add the cup of finely chopped onions. Cook onions until slightly brown, caramelized. Add the chopped up potatoes in the boiling water and cook until potatoes are completely soft. Drain water and mash the potatoes. Add half a stick of butter and allow butter to melt completely, continue mashing. Add caramelized onions and salt and pepper to taste. Once mixed well, add the rum soaked raisins and blend. Serves 4-6. This is a great side dish for the Baked Rummy Pork Chops and Apples.



⊖ *Acidum mineralis*
⊕ *Acidum Vitrioli*
⊕ *c. concentratum, d. dilutum*
⊕ *Acidum Nitri, Ⓞ a n. phlogisticatum*
∇ *Aqua fortis*
⊕ *Acidum Salis Ⓞ a s. dephlogisticatum*
∇ *Aqua Regis*
⊕ *Acidum fluoris mineralis*
⊕ *Acidum Arsenici*
⊕ *v. Acidum Vegetabile*
⊕ *Acidum tartari*
⊕ *Acidum Sacchari*
⊕ *Acetum*
⊕ *a. Acidum animale*
⊕ *Acidum urinae; phosphori*
⊕ *Acidum formicarum*
⊕ *Acidum aereum; atmosphaericum*
⊕ *Sal alcalinus*
⊕ *p. Sal alc. purus (Causticus)*
⊕ *v. Alkali fixum vegetabile*
⊕ *m. Alkali fixum minerale*
⊕ *Alkali volatile*
∇ *Terra*
∇ *Lapis*
∴ *Arena*
∇ *Calx, p. pura (ustulata)*
∇ *Calx vitriolata (Selenites, gipsum)*
∇ *Terra ponderosa*
∇ *Magnesia*

making your own
**Pear and
Thyme Rum
Liqueur**

Ingredients

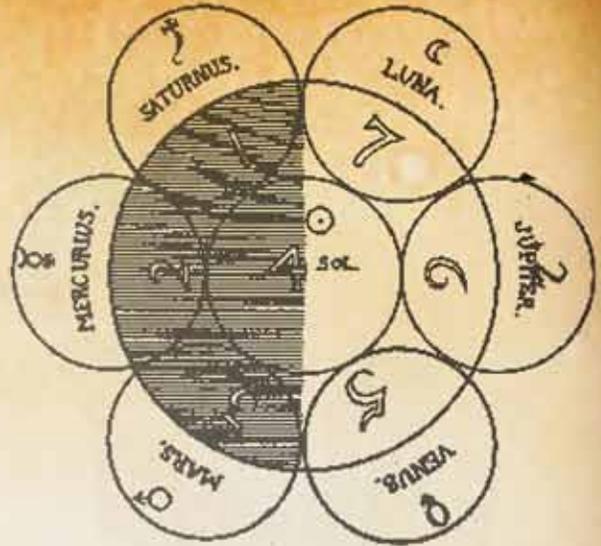
- ½ lb. Ripe Pears
- 2 Apples – Peels Only
- 1 Tbsp Chopped Lemon Thyme
- 1 C. Evaporated Cane Juice
- 1½ C. High Congener (Heavy) Rum

Directions

Cut up the pears (with their peels) and put them in a large jar with the remaining ingredients. Add the rum and make sure that it covers everything.

Allow the mixture to soak for 2 weeks in a cool, dark area. Shake often to keep everything mixed. Strain when complete and re-bottle.

Allow this to mellow for 2-4 weeks before enjoying

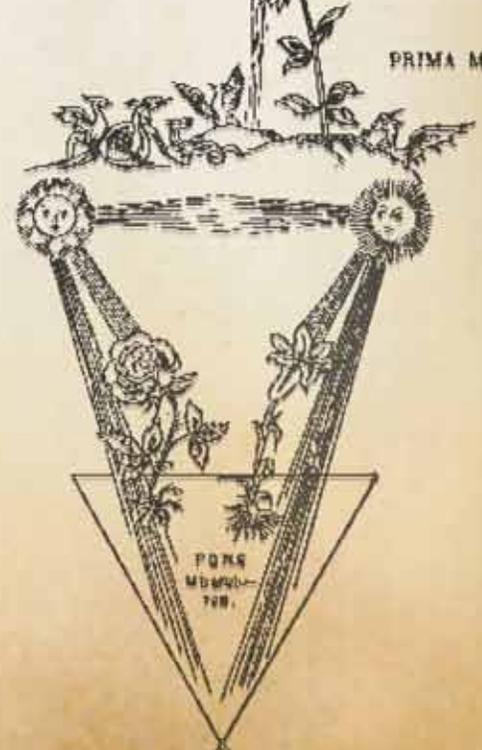


Did you know that...

- Thyme is the leaf of a low-growing shrub in the mint family called *Thymus vulgaris*. Its tiny grayish-green leaves rarely are greater than one-fourth inch long. For use as a condiment, thyme leaves are dried then chopped, or ground. Thyme is grown in southern Europe, including France, Spain, and Portugal. It is also indigenous to the Mediterranean.
- Thyme is often included in seasoning blends for poultry and stuffing and also commonly used in fish sauces, chowders, and soups. It goes well with lamb and veal as well as in eggs, custards, and croquettes. Thyme often is paired with tomatoes. Thyme has a subtle, dry aroma and a slightly minty flavor.
- Ancient Greeks considered Thyme a symbol of courage and sacrifice. Tradition tells that Thyme was in the straw bed of the Virgin Mary and the Christ child. In the Middle Ages, ladies would embroider a sprig of Thyme into scarves they gave to their errant knights. At various periods in history, Thyme has been used to treat melancholy, reproductive system ailments, and to improve digestion. In the 18th century, it was recommended as a cure for a hangover.



PRIMA MATERIA



Source: www.topfoodfacts.com



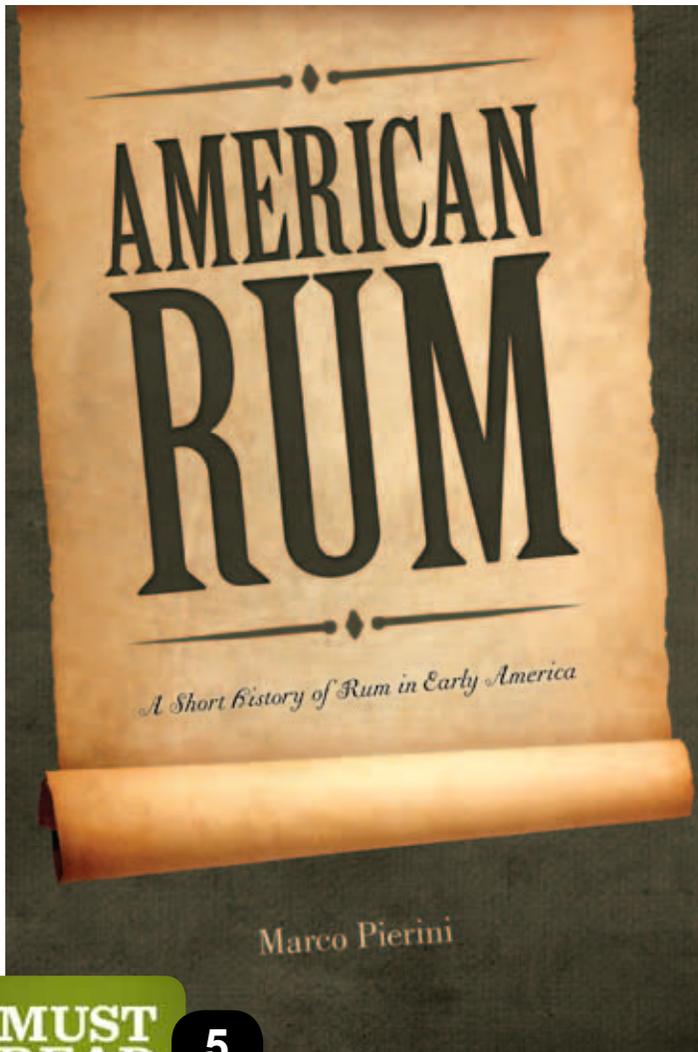
RUM
DAD'S
RESERVE

A gift wrapped in brown paper with a blue ribbon and a white tag that says "Happy Father's Day!". The gift is set against a blue background.

**Happy
Father's Day!**

Gift Ideas For Father's Day





Gift Ideas For Rum-Loving Fathers:

1. www.amazon.com/Col-Conk-Bay-Aftershave-Cologne/dp/B001B8E6OQ
2. www.amazon.com/ARTISAN-HAMMERED-Moscow-Copper-Straws/dp/B076JCBF1S
3. www.amazon.com/Whiskey-Barrel-Coffee-Ground-Sampler/dp/B079Y6S291
4. www.amazon.com/Bourbon-Barrel-Liquor-Decanter-Dispenser/dp/B0002P5MUC
5. www.amazon.com/American-Rum-Short-History-America/dp/1546408304
6. www.amazon.com/Ready-Use-Slush-Mix-Assorted/dp/B01HC42C5M



Homemade Lavander, Sandalwood & Bay Rum Shaving Cream

For this Lavander, Sandalwood and Bay Rum shaving cream, you'll need the following ingredients:

- 1 Tbsp Avocado Oil
- 1 C. Coconut Oil
- 10 drops of Sandalwood Essential Oil
- 15 drops of Lavender Essential Oil
- 20 drops of Bay Rum Essential Oil
- 3 Tbsp Castile Soap
- 1 tsp Vitamin E Oil

Directions:

Combine all the ingredients in a cold bowl using a mixer for 4 minutes. The mixture should be light and fluffy.

Transfer your shaving cream to a container.

Depending on the temperature of your bathroom, the cream could melt or harden. This is normal. You can re-whip the mixture if you like the fluffy texture.

<https://www.bulkapothecary.com>

THE MUSE OF MIXOLOGY

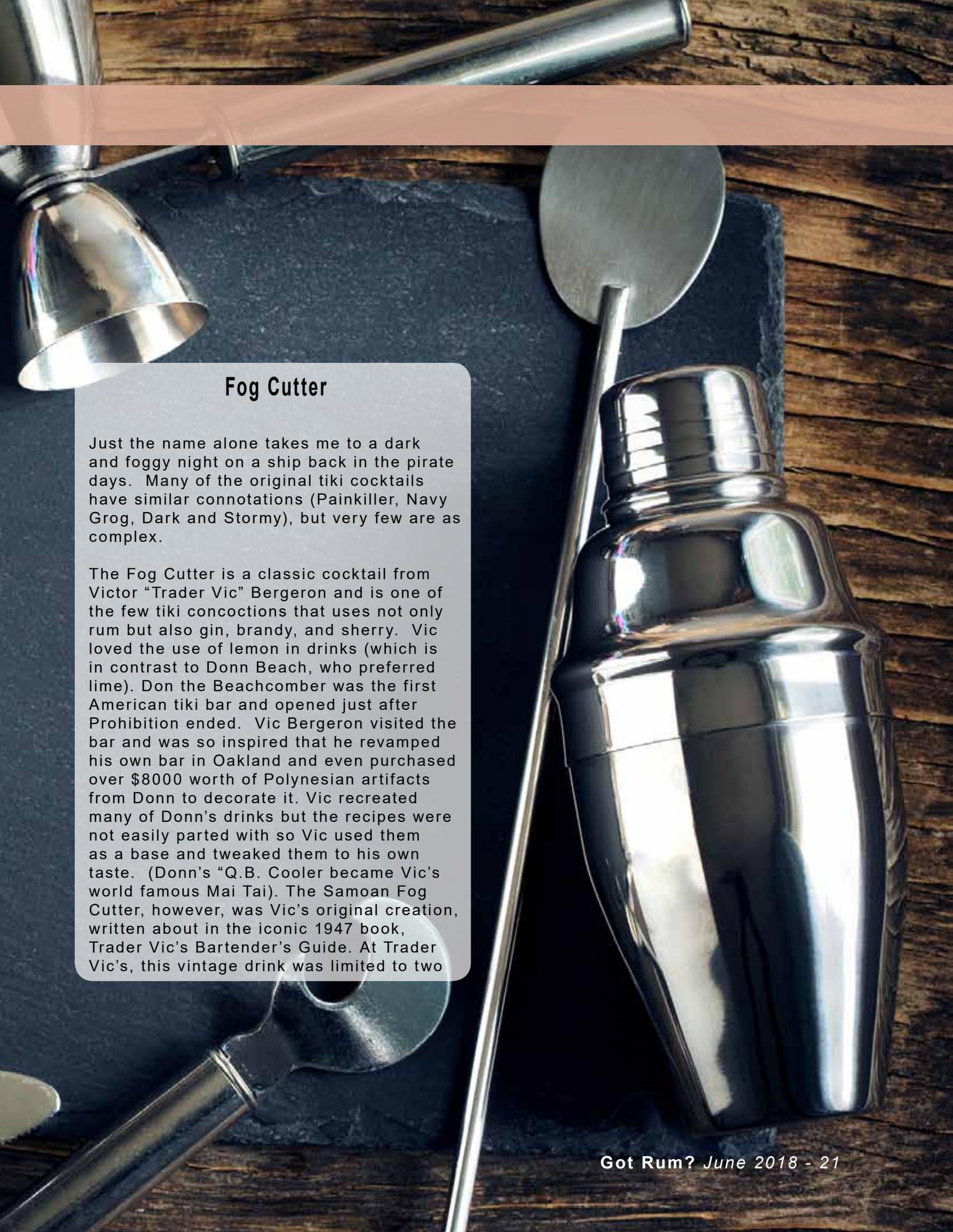
by Cris Dehlavi



My name is Cris Dehlavi and I am a native of Arizona, but have lived in Columbus, Ohio for the past 13 years with my daughter, Desi. I have been running the bar program at "M", of the Cameron Mitchell Restaurant group since 2005. I am currently the President of Columbus USBG as well as a consultant for bars and restaurants nationally.

In 2013, I attended the rigorous B.A.R. 5 Day Spirits Certification and have been recognized as one of the top mixologists in the U.S.A. I am one of the senior managers of the prestigious apprentice program at Tales of the Cocktail and work as a mentor to many bartenders around Ohio.

My contribution to Got Rum ? magazine will include everything from reviews of national cocktail events, articles on mixology, garnish trends, recipes and techniques, to interviews with some of the leading bartenders in the industry.



Fog Cutter

Just the name alone takes me to a dark and foggy night on a ship back in the pirate days. Many of the original tiki cocktails have similar connotations (Painkiller, Navy Grog, Dark and Stormy), but very few are as complex.

The Fog Cutter is a classic cocktail from Victor "Trader Vic" Bergeron and is one of the few tiki concoctions that uses not only rum but also gin, brandy, and sherry. Vic loved the use of lemon in drinks (which is in contrast to Donn Beach, who preferred lime). Donn the Beachcomber was the first American tiki bar and opened just after Prohibition ended. Vic Bergeron visited the bar and was so inspired that he revamped his own bar in Oakland and even purchased over \$8000 worth of Polynesian artifacts from Donn to decorate it. Vic recreated many of Donn's drinks but the recipes were not easily parted with so Vic used them as a base and tweaked them to his own taste. (Donn's "Q.B. Cooler became Vic's world famous Mai Tai). The Samoan Fog Cutter, however, was Vic's original creation, written about in the iconic 1947 book, *Trader Vic's Bartender's Guide*. At Trader Vic's, this vintage drink was limited to two



per person..... In fact in his Bartender's Guide he was quoted as saying "Fog cutter, hell. After two of these you won't even see the stuff." Martin Cate, owner of Forbidden Island in Alameda, California has his own version and has even registered the name on his car license plate, FGCUTTR. This cocktail is a perfect example of balance--- the use of rum, gin, brandy AND sherry are tricky if not measured properly. When made correctly all 4 spirits should be present, and the citrus combined with the orgeat adds the classic tropical flavors you expect in a tiki drink. There are many variations of this classic, because of course all of us in the mixing business tend to take an original recipe and change a few ingredients to make it our own. I personally prefer the Trader Vic version, but have included a couple of others that are also delicious.)

Samoa Fog Cutter from Trader Vic's Bartender's Guide

- ½ oz orgeat syrup
- 2 oz lemon juice
- 1 oz orange juice
- ½ oz dry gin
- ½ oz brandy
- 1 ½ oz light Puerto Rican rum
- ¼ oz sherry
- Mint for garnish

Blend all ingredients except sherry in blender with one scoop of shave ice. Pour into mug. Add ice cubes and float sherry. Decorate with mint and swizzle.

Lost Lake Chicago's Fog Cutter Recipe

- 1 oz. gin
- 1 oz. aged rum (Lost Lake uses El Dorado 3 Year)
- 1 oz. Cognac
- 2 oz. fresh lime juice
- 1 oz. orgeat
- ½ oz. sherry (Lost Lake uses Lustau East India)
- ½ oz. curaçao (Lost Lake uses Pierre Ferrand Dry)
- ½ oz. simple syrup
- 1 dash Angostura bitters

Combine all ingredients in a shaker tin with crushed ice and shake hard. Strain into tiki mug with more crushed ice, garnish with all things tiki-- flowers, mint and umbrellas.

Difford's Guide Fog Cutter Recipe

- 1.5 oz Bacardi Carta Blanca Superior White Rum
- .75 oz Cognac
- .5 oz Rutte Dry Gin
- 1.5 oz Fresh orange juice
- .5 oz Fresh lemon juice
- .5 oz Giffard orgeat syrup
- .5 oz Amontillado Sherry

Shake first 6 ingredients with ice, pour into tiki mug or glass, fill with fresh ice and float sherry on top.

THE RUM UNIVERSITY LIBRARY

www.RumUniversity.com



THE Rum[®] UNIVERSITY

Welcome to The Rum University Library. In addition to the material found on our official website, we also periodically publish on "Got Rum?" reviews of books on topics including fermentation, distillation, aging, mixology and many more. You can also find additional valuable material at

www.RumBook.com

Michael Owens and the glass industry

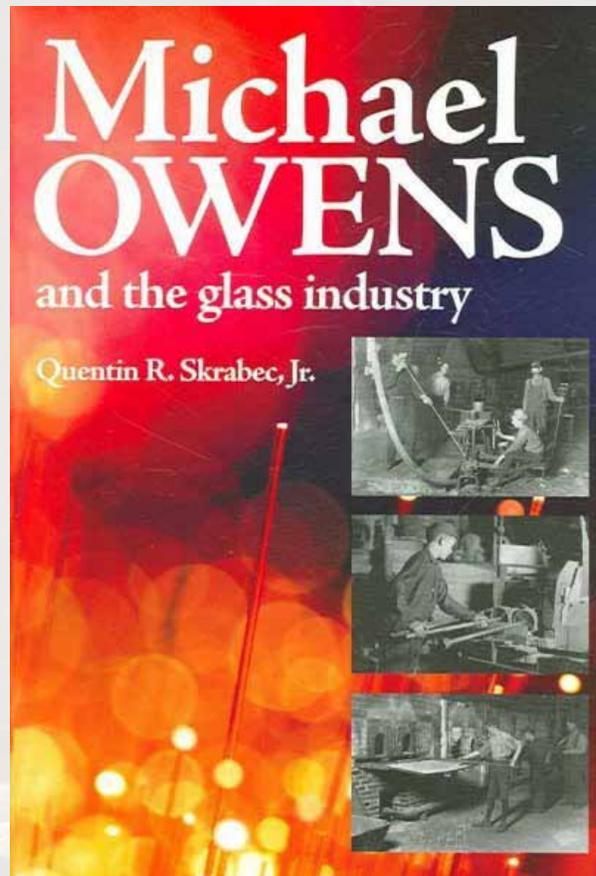
(From the Publisher) Michael J. Owens' innovations in mass-produced glass paved the way for modern conveniences in use today. His invention, the Owens Bottle Machine, transformed the American diet by standardizing and sanitizing food and beverage containers. His automated inventions were vital to electric lighting, advanced optics, and automotive safety, as well as the reduction of child labor.

In this first biography of the unassuming visionary, artist, and craftsman, a historical account of glass making sets the stage for Owens, born in 1859 to an Irish West Virginian mining family. With nine companies and forty-nine patents bearing his name, Michael Owens ultimately became known as the father of project management. This is an engaging account of this unpretentious, resourceful, and dynamic industrialist and inventor, who began as a glass blower.

Quentin R. Skrabec's long list of academic degrees includes a Ph.D. in manufacturing management from the University of Toledo, an M.S. in metallurgical and industrial engineering from Ohio State University, an M.S./B.S. in management, operations, systems, and organizational leadership as well as an M.B.A. in business administration, organizational leadership, and behavior from Robert Morris University, and a B.S. in materials engineering from the University of Michigan. He has written over fifty articles and five books on history, industrial history, and business. Dr. Skrabec is a professor at the University of Findlay and is a sought-after speaker for management conferences, having appeared at over thirty national gatherings.

He stands next to Thomas Edison in the pantheon of inventors. Commercial products stamped with his name are ubiquitous in modern life. His inventions are directly responsible for safety glass in car windshields and consistently proportioned medicine jars. His designs have changed the way we illuminate a dark room and buy pasteurized milk. Michael J. Owens has left an indelible mark in human history, yet his name often has been overlooked publicly, until now. Michael Owens was a driven but unassuming man who shunned the spotlight, wanting only to create. In this first biography of a visionary, artist, and craftsman, Quentin R. Skrabec's research has uncovered a resourceful, colorful, and dynamic industrialist and inventor. This insightful account sets the stage for Owens by going back to the beginning--the history of glass as an art form.

ISBN-13: 978-1589803855



Rum and Glassware

Part III

by Luis Ayala

In the previous two issues we started exploring the history of glassware in an attempt to -in the last installment of this series- answer the question of “Which rum glass is better for me to enjoy drinking my favorite rum?”. So far we’ve discussed a brief history of glass manufacturing and we’ve also explored our innate attraction towards shiny objects and our need to visually inspect what we are about to ingest.

In this month’s chapter, we can begin to explore the intricacies of volatile aromas and their relationship with the tasting/nosing experience.

The alcohol present in all fermented beverages is the result of sugars that were transformed by yeast and, in some cases, bacteria. The majority of this alcohol is present in the form of Ethanol, but ethanol is not the only alcohol that can be present. Different distillates are characterized by the presence or absence of other forms of alcohols, collectively known as “congeners.” Vodka, for example, is almost exclusively ethanol, while Whisky and Tequila also have traces of Methanol and higher alcohols such as Butanol, Propanol, Pentanol and others, plus the aldehydes, acids and esters associated with those alcohols. Rum can be like Vodka, very neutral and devoid of congeners, or it can be like Whisky or Tequila, with a very similar range of flavors and aromas. Furthermore, Rum can be aged in a variety of casks and blended with a number of ingredients, all of which also impart different aromatic and taste characteristics, but more on this later on.

The role alcohols play in the delivery of fragrances is not trivial: perfumers have known for many centuries that flower and fruit oils are not very volatile, but when combined with alcohol, the alcohol-oil solution evaporates more easily, leading to a better dispersion of the aromatic compounds (meaning it is easier to detect and appreciate them by smell, especially from a distance).

But what do perfumery and essential oils from fruits and flowers have to do with Rum? Do rums have oils? If we take a look back at the alcohols formed during fermentation, and we list the potential types that can be formed, ordered by their number of carbon atoms, our list would start like this one:

- Methanol (1 carbon)
- Ethanol (2 carbons)



- Propanol (3 carbons)
- Butanol (4 carbons)
- Pentanol or Amyl alcohol (5 carbons)
- And so on

The interesting thing to know here, is that all alcohols with more carbon atoms than ethanol are considered to be “Higher Alcohols” or “Fussel Oils”. They are called “Higher Alcohols” because they require a higher temperature than the “Lower Alcohols” in order to become volatile. In other words, they are less volatile than the alcohols with fewer carbon atoms. Higher Alcohols in large concentrations are not soluble in 100% water, but they are soluble in water + alcohol mixtures. The higher the concentration of these higher alcohols, the more alcohol and less water is needed in order for them to remain soluble.

Methanol and Ethanol are both considered to be odorless and tasteless, although they do have a characteristic “alcoholic” smell, but as we move into alcohols with higher number of carbon atoms, as well as the aldehydes, acids and esters they produce, the aromas become more diverse and intense.

Aging of the rum also determines how many wood-extractive components will be present. The type of wood used (American, French or other oaks), its size (volume to surface ratio), the heat treatment of the internal surface (natural, toasted or charred) are all crucial to our understanding of what is -or should be- in an aged rum. Some of the wood-extractives include: HMF, 5MF, Furfural, Vanillin, Syringaldehyde, Coniferaldehyde, Guaiacol, 4-methyl guaiacol, Trans lactone and Cis lactone.

As if the above flavors were not enough, many rums are also blended with sugar and caramel, and many others are aged or finished in wine barrels, even in fortified ones, such as those used for Sherry or Port. These finishing barrels can and do impart additional flavors and aromas found in the wines they once held. In some places, the “blending wines” are added directly to rum, bypassing the finishing barrels.

By now you are aware of the fact that “rum” does not simply mean one type of alcohol, but rather a wide range of alcohols, congeners and additives, all of which have different aromatic and taste components. Stay tuned as we explore this topic in greater depth next month.

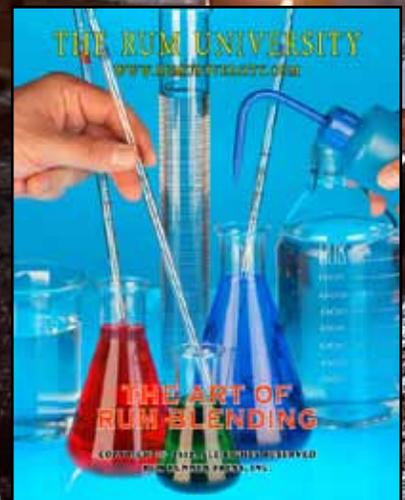
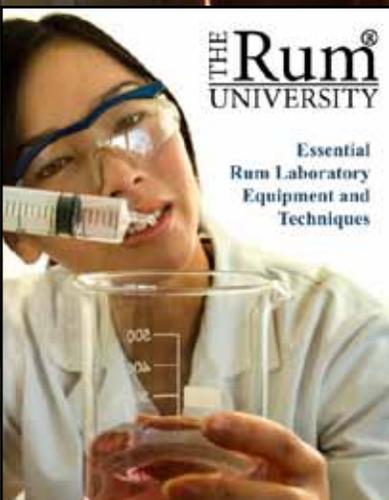
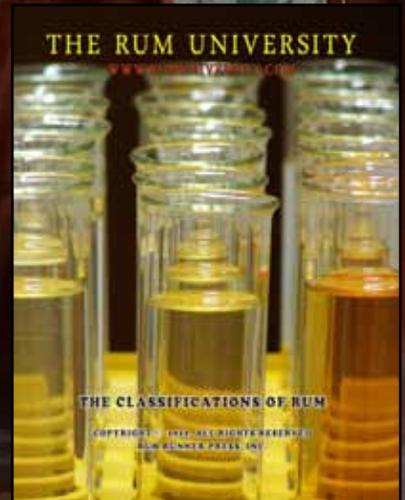
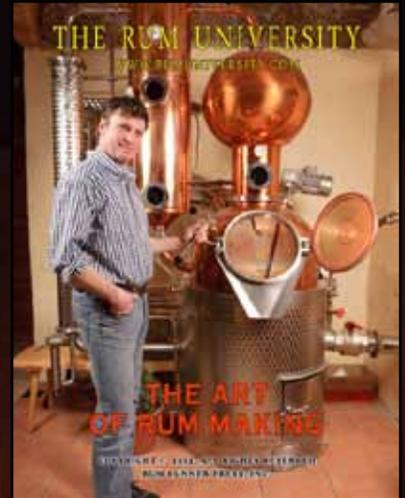
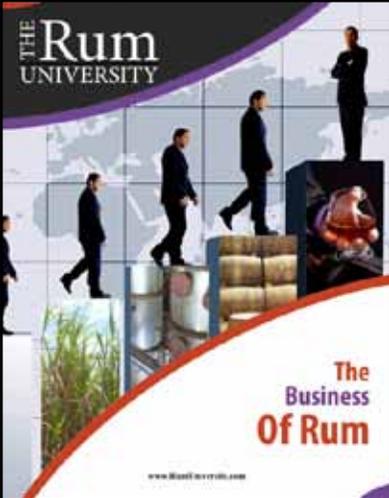
Cheers!

Luis Ayala

Source: www.historyofglass.com



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The rum industry owes its present success to many people who, through their vision, wisdom, ingenuity and/or dedication were able to innovate or improve existing processes. In this new series we will explore these individuals, to honor their memories and to –hopefully- inspire a new generation of game-changers.

Featured Biography: Michael J. Owens

Michael Joseph Owens was born in Mason County, West Virginia in 1859. At the age of 9 he joined his father at a coal mine, but an injury to his eye resulted in his mother removing him and sending him to Wheeling to become an apprentice at a glassware maker, where youngsters comprised about a quarter of the workforce. Michael worked there, earning 30 cents a day while putting in two five-hour shifts, six days a week, in an environment where temperatures regularly exceeded 100 degrees F. in the summer.

Early Career

While at the glass factory, Michael Owens worked in every position available, gaining hands-on knowledge that would later help him manage plants while also improving existing processes. By the time he turned 15, he was a journeyman glassblower, but he also faced trouble breaking through the proverbial “glass ceiling” into management because of discrimination against Irish Catholics common at that time. Michael’s big break came in 1888, when Mr. Edward Libbey moved the Libbey Glass Company from Boston to Toledo, Ohio, to save on fuel and transportation costs and to avoid union strikes, which had depleted his resources. Owens responded to an ad recruiting skilled workers.



At first, the new plant struggled to take off, and -according to Owens observations- many workers were lazy or had negative attitudes. He stuffed the suggestion box with so many ideas that Libbey appointed him superintendent. The first thing Owens did was fire all 500 employees and shut down the operation. He then hired back only those who worked hard and recruited other old colleagues. He led by doing, arriving before sunrise and leaving 12 hours later. Productivity and product quality soared, with improved delivery times and fewer costly remakes.

When Owens started managing at the end of 1890, the firm had racked up a loss for the year of \$3,000 dollars (\$76,500 in today’s money). By the end of 1891, the operation had completely turned around and the company had earned \$75,000 (about \$1.9 million in today’s dollars).

Also in 1891, Libbey opened an additional plant in Findlay, Ohio, where it could be

powered by natural gas. Owens was put in charge of this factory to make bulbs for Edison General Electric, whose normal supplier was crippled by a strike.

Owens had pondered ways to simplify the process in a way that would eliminate much of the work by the boys who handled the molds for each product. Now came motivation to act: a strike threat. The Findlay mold boys, seeing they were in short supply, threatened to walk out, even though they were paid double the national average. While the boys stayed on the job, Owens worked with the plant blacksmith to produce a mold-opening device that could be operated by a glassblower by foot, eliminating the need for some of the boys. It was the first major change in glassmaking in 2,000 years. Owens kept tinkering — and kept the glass piece from sticking to the mold by coating the mold with a paste. He landed patents for the mold opener and paste in 1894 and made them for sale to other firms. These two improvements increased productivity tremendously. He eventually lowered the cost of bulbs by 90%, making them affordable for everyone. General Electric was so delighted, it made Libbey Glass a regular supplier and in 1918 bought the rights to the bulb-making process.

Libbey and Owens built a factory for the public to visit at the Columbian Exposition in Chicago. This first fully electrified World's Fair would draw 7 million people and launch new products like soda, hamburgers and postcards, while making international brand names of companies such as Wrigley, Pabst and Aunt Jemima.

Returning to the Toledo factory, Owens built a machine to make small drinking glasses called tumblers and the tops for kerosene lamps called chimneys. Meanwhile, the board of Libbey Glass saw Owens' experiments as risky, so he and Libbey bolted and created Toledo Glass Co. in 1895.

Entrepreneurship and Innovation

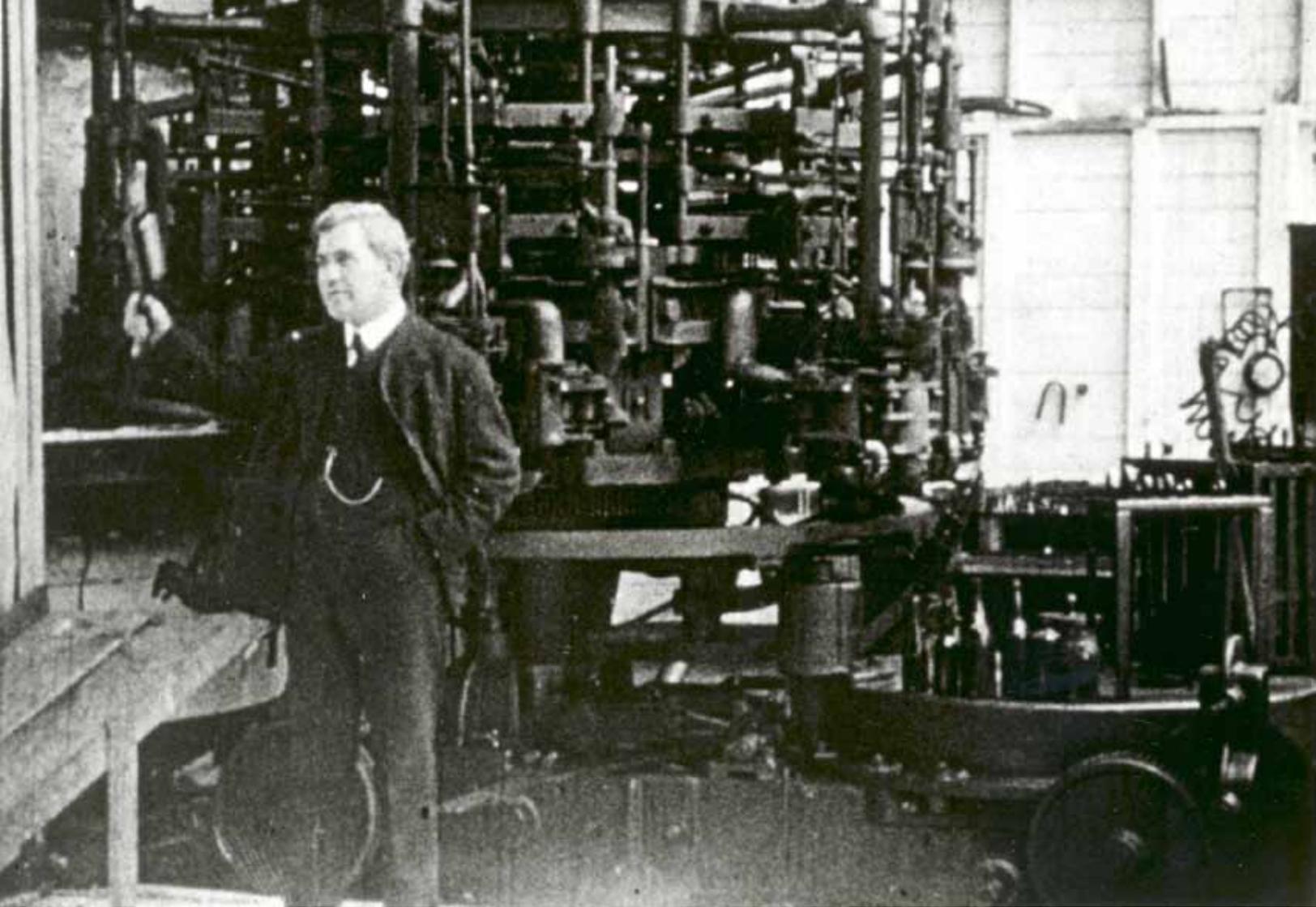
According to author Quentin Skrabec (see Rum Library, page 21), "The Libbey-Owens team would be one of the most unique and successful industrial partnerships ever" and "Libbey was a natural entrepreneur with strengths in marketing and finance, while Owens was the ideal intrapreneur or master inventor within the company. Together, they pioneered the whole concept of corporate research and development."

Over the next five years, backed by engineers and mechanics, Owens launched a revolution in making glass containers. "Owens was the antithesis of a modern director of research, who makes slow, steady progress," said Skrabec. "He is best compared to Steve Jobs of Apple (AAPL). Both were un-credentialed and had tempers and rough personalities. Conceptualization was their specialty, and they would draw rough ideas for others to develop. They were perfectionists with big ideas who could advance technology in quantum leaps, uninhibited by previous technical paradigms or functional departments."

The technical challenge was to find a way to have a machine create the neck of a bottle. Owens pulled it off in 1899 with the first version of an automatic bottling machine. By the time he completed the fifth version of his machine -which had 10,000 parts- it was able to produce five times more bottles per hour, compared with the handblown method, and it was ready to go into commercial production.

Owens Bottle Machine Co. rose in 1903 to make the equipment and sell licensing. It took a royalty of half the estimated labor cost reductions and charged high fees or took company stock for exclusive rights for one industry. Its shares rocketed 2,300% by 1916.

With the domestic market for bottles doubling from the turn of the century to 1907, Owens Bottle Machine took control of most the industry in America and Europe, making it the



Michael J. Owens posing in front of one of his bottling machines.

first U.S. company to be truly multinational, according to Skrabec.

“Owens’ impact was profound and is still felt in our company today,” said Al Stroucken, CEO of Owens-Illinois. “Our employees feel tremendous pride in being glassmakers and in the legacy of innovation he left behind. We carry that tradition and commitment to forward thinking with us every day.”

Did you know that...

- Glass never decomposes, making it the worst candidate for landfill entombment! Experts suggest that it would take 1 million years for a simple glass bottle to completely break down under normal landfill conditions.
- Glass is one of the most sustainable consumer materials — considered to be a truly “cradle-to-cradle” packaging material since it never loses its integrity during the recycling process and is infinitely recyclable — and yet U.S. citizens dispose of “enough glass every two weeks to fill a skyscraper comparable in size to the 1,350-foot towers of the World Trade Center.”

Sources:

Michael Owens and the Glass Industry, by Quentin R. Skrabec and www.investors.com

THE RUM HISTORIAN

by Marco Pierini



My name is Marco Pierini, I was born in 1954 in a little town in Tuscany (Italy) where I still live. I got a degree in Philosophy in Florence and I studied Political Science in Madrid, but my real passion has always been History. Through History I have always tried to know the world. Life brought me to work in tourism, event organization and vocational training. Then I discovered rum. With Francesco Rufini, I founded La Casa del Rum (The House of Rum), that runs a beach bar and selects Premium Rums in Italy, www.lacasadelrum.it

And finally I have returned back to my initial passion: History, but now it is the History of Rum. Because Rum is not only a great distillate, it's a world. Produced in scores of countries, by thousands of companies, with an extraordinary variety of aromas and flavors; it has a terrible and fascinating history, made of slaves and pirates, imperial fleets and revolutions.

All this I try to cover in this column, in my FB Profile: www.facebook.com/marco.pierini.3 and in my new Blog: www.therumhistorian.com

I have published a book on Amazon: *"AMERICAN RUM - A Short History of Rum in Early America"*.

THE ORIGINS OF ALCOHOLIC DISTILLATION IN THE WEST

5. THE WATER OF LIFE AND THE FRANCISCAN FRIARS

In the 1200s a new concrete and experimental culture was developing throughout Latin Europe, focusing on practical things and centering around human beings and their needs. Central and northern Italy was one of the centers of this culture, which embraced alchemy.

The word alchemy is looked down on today, associated with odd and unreliable occult practices, but in those days it was viewed very differently. Alchemy was a serious matter in the 1200s; a practical branch of knowledge that was actively pursued, very different from the abstract, theoretical discussions of many European scholars of the day. Before it was classified among the 'occult sciences', alchemy was openly and amply debated by philosophers and theologians. Interest in the subject should not be identified as a propensity for irrational, secret, morally questionable practices, but as an expression of intellectual openness to a form of knowledge of nature that was



Cimabue -Italia - Assisi Basilica di San Francesco.

not purely theoretical, but took into account human action in the world and aimed to perfect it.

The alchemists transformed the substances they worked with into something new and different, something that did not exist in nature. New substances, the fruit of the actions of the human mind and hands on the material world. This innovative character struck the first western readers and translators of alchemic texts: here was a field of knowledge that went beyond the information obtainable from sensory perception, allowing human beings to intervene actively in the hidden processes of the material world, understand the invisible dynamics that regulate creation and thus interact with them.

This attitude was maintained until the early 1300s, when philosophical-theological judgement and social condemnation became harsher, leading to condemnation of alchemists, but only to the extent that they were counterfeiters. It was not until later that alchemy was condemned as an occult science, at the end of the century, in a treatise entitled *Contra alchimistas* by one Nicola Eymerich, Inquisitor of the Crown of Aragon.

But let us return to the 1200s, when the subject of alchemy was addressed by many of the greatest minds of the day, including a number of Franciscan friars. Inspired by charity toward the suffering of humanity, they wanted to discover medicines to treat the illnesses that afflict the human race. And one of the most interesting substances produced by the alchemists was the so-called *aqua* (water), that is, alcohol.

Simplifying things a little, the alchemists subjected various substances of plant or animal origin to the action of fire within a closed apparatus to separate the volatile and solid parts. The solid material settled at the bottom, while the vapors separated from them rose up and were conveyed through a pipe, in contact with which they condensed, finally taking the form of a liquid offering the essential properties of the initial substance in a 'subtle' and 'spiritual' form, far removed from the heaviness of the matter. This procedure evolved rapidly, culminating in the distillation of wine with the production of alcohol. With great effort and expense, they finally managed to obtain small quantities of a strange, colorless liquid that burned like fire. The name initially given, in Latin, to the

substance thus produced was aqua (water), because it was colorless as water. The Franciscan alchemists were fascinated by the new product, believing it to be a powerful medicine that could treat and prevent numerous illnesses and preserve health and youth: practically a panacea. In the Middle Ages, Latin was the common language of the cultivated people, and the new, wonderful medication was soon referred to as *aqua vitae* (water of life) or even *aqua ardens* (burning water).

There was a great proliferation of authors and works discussing the distillation of wine and the production of aqua vitae for medicinal purposes, to treat illnesses of all kinds and improve human life. The Franciscan friar Bonaventura Da Iseo, who died in 1280, stands out among these with his "*Liber Compostille*". A great friend of Albertus Magnus, close to Roger Bacon and in contact with the young Thomas Aquinas, and therefore in touch with the greatest minds of the time, the friar describes the numerous medicinal waters that were by that time commonly used in medicine, including the production of alcohol, with distillation of both essences for making rosewater and wine for the production of *aqua vitae*. He believed that this knowledge should be put at the disposal of all men:

"Of these waters I shall speak, of the many truths I have learned about them over time, learning, experimenting and preparing numerous medicines... Human nature requires physical waters as well as medicinal waters; and so we, to whom God has granted the privilege of knowing many secrets... have decided to offer in this book an exemplary treatise on medicinal waters, for the use of the good and written with great care and sense, so that he who composes it and works on the basis of it will be considered a good physician: and not only a good physician, but an experimenter capable of producing miraculous medicines and effects and a good prophet."

Aqua Vitae is the Latin name by which it was known, resulting in the Italian *acquavite*, the French *eau-de-vie*, the German *aquavit*, the Scandinavian *akvavit* and more, including the Gaelic *uisgebeatha*, which then became whisky.

There were two basic types, right from the start: *aqua vitae simplex*, made of distilled wine alone, practically nearly pure alcohol; and *aqua vitae composita*, in which plants, roots and medicinal herbs of all kinds were added to the distillate. *Aquavite simplex* is the ancestor of today's distillates: grappa, brandy, whisky, etc., while *acquavite composita* is the ancestor of our liqueurs, bitters, aperitifs, etc. There were numerous recipes for *acquavite composita*, because the medieval pharmacopeia was largely based on plants, herbs and roots from the natural world, but it was made in three basic ways. In one of these, the herbs and so on were added to the wine and then the mixture was distilled. In another, the wine was first distilled alone and then infused with the herbs; in the third method, *aquavite simplex* was combined with herbs in the alembic and distilled again.

At this time, and in these places, the serpentine column began to be used to collect the vapors, an innovation with a decisive effect on the quantity and quality of the distillate.

According to Forbes, "The change in *cooling methods* during the Middle Ages was most important and it must have been the prime factor in the preparation of low boiling compounds like alcohol. It is true that it is conceivable to distill alcohol in the ancient cucurbits and alembic without cooling the delivery tube and even when cooling the head, but only if the temperature could be regulated carefully. But usually the too fierce heating and the long digestion period before distillation drove off the low boiling fractions. As we have mentioned this digestion period was considered most important by the alchemist, because in this period the alcohol or similar compound was considered to be formed by the heat applied to the content of the cucurbit."

Moreover, "The word alembic changed its meaning during the Middle Ages, it gradually came to denote not only the still-head but the combination of head and cucurbit. The latter meaning won on the long run, perhaps aided by the fact that the technical evolution of the still led in this direction. Though the Arabic chemists preferably used glass apparatus the alchemists often combined earthen ware cucurbits with strongly luted glass alembics.



Roger Bacon, byname Doctor Mirabilis (Latin: "Wonderful Teacher"), English Franciscan philosopher and educational reformer who was a major medieval proponent of experimental science.

As the glass industry evolved, it became more and more common to use both glass cucurbits and alembics and gradually they were blown or cast in one piece. The glass industry, an important factor in this art, received great impetus from the growing general use of glass for windows and chemical vessels. At the same time the existence of a flourishing industry at Venice and Murano must have influenced chemistry too." (Forbes)

Doctors, and particularly surgeons, did not hesitate to appropriate this new pharmacological device, and had noted the antiseptic properties of alcohol: "It is highly effective on wounds, if washed with it." In the mid-thirteenth century the production and consumption of *aqua vitae* that is, alcohol and other medicinal waters, like rosewater, was an established practice in northern and central Italy, though still in

a medical context alone, and practiced by many as an act of charity.

Not without raising some problems. Let us read what Salimbene of Parma writes in his Cronica about a noblewoman named Mabilia who lived in Ferrara, in northern Italy, around the year 1250: "She was a beautiful, wise, clement woman... not miserly with her property, she gave generously to the poor. In her palace she had an oven in a secret chamber – I have seen it with my own eyes – in which she herself prepared rosewater for the sick. For this reason the physicians, booksellers and pharmacists who sold medicinal herbs did not look upon her favorably. But she did not mind, concerned solely about helping the sick and doing the right thing in the eyes of God."

Marco Pierini

A close-up photograph of a person's hand holding a small, realistic globe of the Earth. The hand is positioned on the right side of the frame, with the thumb and index finger supporting the globe. The globe shows the Americas and surrounding oceans. The background is a soft-focus, vibrant green forest or garden scene. The overall mood is one of environmental care and responsibility.

RUM

and
the

Environment



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- Avoiding the use of plastic straws
- Planting trees, etc.

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RUM IN THE NEWS

by Mike KUNETKA



NEWS

FELIX JUAN SERRALLES NEVARES

Felix Juan Serrallés Nevares, chairman of Destilería Serrallés, producer of Don Q Rum, has passed away at the age of 83. The Serrallés family first produced and sold rum in Puerto Rico in 1865 and in 1934 they created their now iconic Don Q brand whose name pays homage to fictional character Don Quixote. On Monday, May 7, 2018, Destilería Serrallés released this statement: "It is with deep regret that Destilería Serrallés and its Board of Directors confirms the passing of our Chairman, Felix Juan Serrallés Nevares. "Don Fao", as he was known to close relatives, company employees and friends, was the company's President and CEO from 1981 until 2017 and a member of the family's 5th generation. Under his vision and tenure, Destilería Serrallés experienced unparalleled business growth and innovation, solidifying a leadership position for Don Q Rum in Puerto Rico and driving an aggressive expansion into the USA and other international markets. He will be remembered by all at Serrallés, and those who knew him for his noble spirit, his passion for the company and his brilliant intellect. His values and legacy will continue to lead the way for generations to come."

WEST INDIES RUM AND SPIRITS PRODUCERS ASSOCIATION

Regional rum producers, members of the West Indies Rum and Spirits Producers Association (WIRSPA), met last month to discuss a range of issues which impact the ability of the sector to achieve international competitiveness.

Speaking at a tasting of Authentic Caribbean Rums in Trinidad, WIRSPA chairman and head of the Guyana conglomerate Demerara Distillers (DDL), Komal Samaroo, noted that

although the sector's brands were positioned as high-quality products in the premium and super-premium segments of the market, many competing brands received incentives and subsidies which resulted in a highly unequal playing field. And he said a key thrust for the sector is an international drive to protect authentic origin. "Our brands are anchored in the unique history and heritage of our countries," Samaroo pointed out, noting that "many so-called premium products are assembled from various origins, without any authenticity or true origin, and flouting rum rules." Referencing the decreasing availability of regional molasses, he added that producers were challenged with raw materials constraints on one end and facing subsidized products in the market at the other. Referring to DDL efforts to support the local sugar industry in Guyana as a means of securing molasses supplies, he noted that several other producers were moving in the same direction. Those moves, he said, "can only redound to the benefit of our countries by maintaining employment in agriculture and increasing local value added".

His sentiments were echoed by Chairman of Angostura, Dr. Rolph Balgobin, who noted that his board had also tasked the management of Angostura to "provide an analysis of whether we should get into sugarcane production for the purpose of producing molasses." Trinidad's Minister of Trade and Industry Paula Gopee-Scoon, in her remarks, congratulated the sector on its achievement of world-class quality and drive for international competitiveness.

Noting that Caribbean Community (CARICOM) trade ministers had recently formed a special working group to examine factors impacting the competitiveness of the sector, she committed to working with colleague ministers and industry representatives to ensure that the industry receives the support it needs as

These are the most recent and noteworthy headlines in the rum industry. If you want us to share your news with our readers, please send an email to Mike@gotrum.com. Mike Kunetka is a land-locked rum enthusiast, he is based in Colorado, USA.

the flagship export sector of the region.

HABITATION VELLIER AUSTRALIA AND EAST COAST LIQUOR

East Coast Liquor has gained the exclusive distribution rights for Velier rums in Australia and is joined by Tatu Kaarlas of Refined Vices to promote and distribute the brands nationally. East Coast Liquor offers an exclusive range of products from La Maison & Velier, which will initially be available through East Coast Liquor wholesale and Liquor MOJO™ online retail for pre-order as of May, and select venues starting from June. From the Velier collection East Coast Liquor will launch the Habitation Velier range, featuring rums from Worthy Park and Hampden in Jamaica, and Foursquare and Mount Gay in Barbados. A project created by Velier's owner, Luca Gargano, Habitation Velier is the world's only range of Pure Single Rums acting as a reference point to the type of rum produced by each distillery's unique pot still.

The vintage Pure Single Rums are entirely aged in the tropics, ensuring a natural, accelerated aging compared to European ageing, at the expense of higher angels share. A unique range of products from Haiti will also be available in four different expressions. Clairin is an artisanal sugarcane spirit, or rhum agricole, made from sugar cane juice with the exception of Clairin Le Rocher, which is made from syrup. Similar to Mezcal, the process of making it is entirely organic and pesticide free, hand cut, native grown sugarcane, spontaneous fermentation with no added yeasts, distilled in fire or steam heated pot stills, or in a pot with a small column, to bottling proof. Clairin is raw, flavorful, and as an all-natural spirit it is different from batch to batch, and is truly handmade the way it has been for the last 200 years. In addition to Clairin and Habitation Velier, East Coast Liquor will offer a number of highly anticipated bottlings from Velier, including Foursquare Principia and Destino, and a very special bottling of Royal Navy Rum, the

oldest blend of British Caribbean rums of the 21st Century. From the La Maison du Whisky collection, the Transcontinental Rum Line Panama, Guadeloupe and Barbados rums will be available in limited quantities.

HAVANA CLUB

Pernod Ricard-owned Havana Club has redesigned the label for its Añejo Especial expression to reflect the brand's Cuban roots and "authentic" production process. Havana Club Añejo Especial is a blend of young and old Cuban rum bases, which have been aged again in white oak barrels. The new look is presented on premium crafted paper and is inspired by Cuban street culture, featuring blue and red edges. The design also features tree rings, two oak barrels and a sand timer to communicate the brand's double-aged maturation method. The new label is available in several markets, including the UK, France, Germany, Switzerland and Belgium. In addition, an Especial Cuba Libre serve is being promoted in UK bars and supermarkets and will also be supported across Europe through festival activations, such as the Especial Sessions at Tomorrowland in Belgium and Musik I lejet in Denmark. Nick Blacknell, marketing director at Havana Club International, said: "At Havana Club, we are proud of our Cuban culture, authentic rum production methods and revolutionary spirit – all of which are now reflected in the new Havana Club Especial label. The classic Cuba Libre serve will inspire a whole new generation with the refreshing taste of rum and cola. "We have seen what has happened in the gin category over the past five years and we expect the rum category to experience the same resurgence."

MYER'S RUM

Both Fortune and Bloomberg have reported that Diageo is looking to sell off part of its portfolio, including Myer's Rum, Seagram's VO, Popov Vodka and Goldschlager. Diageo is reportedly trying to sell the brands as part

RUM IN THE NEWS (continued)

by Mike Kunetka



The image shows a stack of newspapers on the left, slightly out of focus. In the foreground, four white dice are arranged in a row, spelling out the word 'NEWS' in large, bold, black letters. The dice are resting on a surface that appears to be a newspaper page.

of a single transaction, which means they will likely go to a private equity firm. It has hired Centerview Partners to sell the brands and expects the sale to net proceeds of up to \$1 billion. The sale might also include additional brands. Reportedly, the move is to allow the liquor maker to focus its attention on its pricier brands that are seeing a higher amount of growth.

MONTANYA RUM

Montanya Distillers, a craft rum distillery located in the Colorado Rocky Mountains, takes another step to integrate sustainability into every aspect of its business. The distillery has partnered with terrapass® to offset its carbon emissions from distilling, business travel, outgoing freight, and inbound shipping. Through the partnership, Montanya is offsetting about 52 metric tons of carbon dioxide equivalent (MtCO₂e) this year. The offset will help fund a Forest Management Project, which absorbs and stores about 2,500 more metrics tons of CO₂ each year than neighboring forests. This project is equivalent to taking about 550 cars off the road each year. The sale of carbon offsets is a critical way the forest is funded since it doesn't rely on taxpayer money. "I am really excited about this new relationship because it has helped us to more quantitatively measure every single input and output in our company," noted Karen Hoskin, co-founder and CEO of Montanya Distillers. "From Amazon shipping to freight of rum, to shipping of our bottling supplies, to Sysco restaurant supplies, to natural gas under our stills, we're now measuring every aspect of our carbon output. Then once we calculate, we're able to offset our emissions directly. The previous company we used didn't put us through these vigorous calculations and didn't connect us directly

to their outcomes, which made it harder to assess our success."

Carbon offsets help make up for the carbon footprint left behind. Although carbon offsets can be confusing, it's quite simple in application. Projects are designated to reduce carbon dioxide emissions (in Montanya's case a community forest) and then companies and individuals fund these projects directly. One carbon offset equals one ton of reduced emissions.

To celebrate their tenth anniversary, Montanya recently released Montanya Aniversaria. This limited release (only 325 bottles) is available in Colorado at their Tasting Room in Crested Butte, Colorado. It is barrel aged for three and a half years in an American White Oak barrel that previously aged Laws Colorado Bourbon. The rum is then transferred for an additional four months to a French Oak barrel that previously aged Sutcliffe Vineyards Cabernet Sauvignon and Port. The final finishing barrel for the last several months comes from Peach Street Distillers Bourbon in American White Oak. Laws, Sutcliffe Vineyards and Peach Street Distillers are all local, Colorado companies.

Also new from Montanya is a line of Cocktail Bitters. These are handcrafted using traditional methods and infused in high proof Montanya Rum. The company makes six different flavors: Cucumber Jalapeño, Pineapple Habanero, Citrus, Grapefruit, Cherry Black Pepper, and Thai Chili as well as seasonal varietals like Fig and Cinnamon. The bittering elements include gentian, cinnamon, cassia, and citrus peels. The flavor profiles are built by infusing fresh fruits, dried fruits, seeds, nuts, chili peppers, and vegetables. The infusions take about a month and the bitters are bottled by hand at the distillery.

They are best used to add a pop of flavor and balance to cocktails without adding all the sugary or watery elements of simple syrups and mixers.

L&L RUMSHOP – BOTTLE YOUR OWN RUM

The Caribbean Journal calls it the Most Creative Rum shop in the Caribbean. The L&L Rumshop on the island of Nevis, which is also home to the Nevis-made Clifton Estate Rum, is now giving guests the opportunity to bottle their own personalized editions of the rum. Guests can wait their turn to bottle their own rum and then get their name and the date engraved on the bottle. Guests fill their bottle, they cork it and then they seal it with wax. If Theron, the owner of Clifton Estate, is in the shop, he'll sign the bottle as well. (Clifton Estate, a spiced rum from Nevis, took home the Double Gold in the Spiced Rum category this year's Caribbean Rum Awards in Saint Lucia. It's just a little something to create a special experience for anyone coming to the shop," L&L proprietor and regional rum expert Mark Theron told Rum Journal. "A trip to L&L Rumshop should always be a fun and memorable experience." The new experience has already proven to be a big hit in Nevis, both for locals, travelers and cruise passengers a like. It's not hard to see why.

KOLOA RUM

Since the mid-April flooding, employees of Koloa Rum Co. have contributed and collected monetary, clothing, food and water donations to help those in need. "We are grateful to not have sustained any damage," said Bob Gunter, President and CEO of Koloa Rum Co. "Unfortunately, communities on the North and South shores were not so lucky. Many families and businesses have suffered great losses." Koloa Rum Co. matched employee gifts by three, and contributed the money to Malama Kauai. "The value of their donations totaled \$2,377," Gunter said. "Our staff members and their families have been so generous, and I'm proud to work alongside each and every one of them." In addition, Koloa Rum Company Store in Kilohana hosted a "Rum for Relief" day on April 21, in which 100 percent of rum sales was donated to Malama Kauai, for food relief. "Kauai is a strong community, filled with aloha, and we have banded together

to rise from this disaster. We will keep you updated as the rebuilding process advances," Gunter said.

JAN STEPHENSON FLAVORED RUMS

Award winning Dented Brick Distillery has been awarded a contract to produce and distribute Jan Stephenson's Tropical Fruit Flavored Rums. The distillery produces Passion Fruit, Pineapple, and Mango flavored rums for Jan. The rums were released at the 75th Wine and Spirits Wholesalers Association Annual Convention in Las Vegas in May. All three rums won medals, with Mango and Pineapple winning Silver Medals in their premiere spirits competition, and Mango winning 2nd place in the cocktail competition. The collaboration is relying on Dented Brick's expertise as an award winning Rum distillery, having won the prestigious Rum XP Gold in Miami in 2017, and with Jan's experience and expertise gained running Jan Stephenson Wines. Jan's hometown in Australia is called the Central Coast, and also home to the top food and wine region, the Hunter Valley. The Paso Robles region of California has the same topography and so many similarities Jan's home country, that she instantly had a connection. She now has over 500 acres of fully sustainable vineyards, first planted in 1973, and have flourished in the rich soil of the gentle rolling hills of Paso Robles. Jan Stephenson inspired a generation of female golfers by helping bring the game into the mainstream in the 1970's. After 3 major championship wins and 16 LPGA Tour events, Jan is sharing her secret recipe for winding down and enjoying the beautiful sunsets of her Australian home - a taste of the Outback.

ANGOSTURA

The House of Angostura® has taken home four medals at the prestigious and highly competitive Spirits Business – Rum and Cachaça Masters 2018 competition. Both Angostura 1919® and Angostura® 7 Year Old rum won gold medals in the competition, with the judges singling out Angostura 7 Year Old's "good integration of wood". Meanwhile, Angostura® Reserva and Angostura® 1787 copped silver. The Spirits Business –Rum & Cachaça Masters competition aims to find and reward the finest rum and cachaça brands on the world stage.

EXCLUSIVE INTERVIEW

by Margaret Ayala



Mr. Andy Keller, Head Distiller & Production Manager, Blackwater Distilling.

Distilling “craft” rum is relatively easy, but distilling it consistently well in a competitive environment requires discipline, dedication and well-tuned skills. For these reasons I am thrilled to share this interview with all our readers, so they can learn more about Andy Keller, whose passion and skills are highly recognized and rewarded in the craft industry. Cheers!

Margaret Ayala, Publisher



Q: What is your full name, title, company name and company location?

Andy Keller, Head Distiller & Production Manager, Blackwater Distilling, Stevensville, MD.

Q: Can you tell us a little bit about Blackwater Distilling and what inspired you to start your own distillery?

Blackwater Distilling was founded by Chris and Jon Cook, and we put out our first product, Sloop Betty Vodka in 2011.

We were Maryland’s first fully licensed distillery in four decades, and we wanted to bring distilling back to a state that had before and directly after Prohibition been one of the largest distilling states in the nation. I personally got into distilling out



of a love for the product, and a need to make something tangible. After college I had worked briefly at a winery in Napa Valley before joining a big PR firm where I worked for a couple years. It was a great experience, but at the end of the day I hadn't made anything. I couldn't hand out press releases at Christmas like my dad hands out pieces of handmade miniature furniture. I got into home brewing, which I did religiously for about six years before I started seriously considering starting a brewery. But looking at the market, there were thousands of breweries and I didn't think I really had anything unique to add to that space. At one point I read an article about craft distilling, and I was hooked. I started collecting as many articles and books as I could and teaching myself about distilling.

Q: What have been some of the biggest challenges you have faced, on your journey to opening up the distillery?

Being the first distillery in the state in forty years, we faced challenges at every step. Many jurisdictions thought of distilleries as smoke-belching factories, and it took a while to find a locality that would work with us on zoning. Several government offices had only one person who had ever inspected a distillery before, so there was a learning curve both on our end as well as for the state and the local government.

Q: Do you have any advice for someone who is considering opening up their own distillery?

A lot of "product" people like me hope to start breweries or wineries or distilleries.



S401

S402

S301
PICAROON
MARYLAND RUM
BLACKWATER
DSP-MD-15000

S302
PICAROON
MARYLAND RUM
BLACKWATER
DSP-MD-15000

S201
PICAROON
MARYLAND RUM
BLACKWATER
DSP-MD-15000

S202
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S101
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S102
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DSP-MD-15000

S03

PICAROON
MARYLAND RUM
BLACKWATER
DSP-MD-15000

S04

PICAROON
MARYLAND RUM
BLACKWATER
DSP-MD-15000



Having a great product is crucial, but it's not enough for success.

If your first love is making the product, don't forget that the product is only one part of the business. It takes money to let people know you exist, and it takes money to get your product on liquor store shelves and back bars, so make sure you're setting your fundraising sights high enough to cover all the needs of the business and not just the plant and equipment.

And if your first love is running a business and you just want that business to be a distillery, make sure you've got someone who can make a top-notch product. With more distilleries opening up every day, it's going to take a great product to stay competitive.

Q: What rums do you currently have in your portfolio?

We've got a rapidly expanding portfolio of rums. For all our rums right now, we start

with a golden cane syrup. It gives us a lighter but more well-rounded and complex flavor than molasses.

Our first releases in 2015 were un-aged, our Picaroon White and Picaroon Gold Rums. For both, our goal is to be more flavorful than the big-brand white and gold rums but to be just as approachable. Many of the big-brand white rums are essentially sugar cane-based vodkas, distilled to near neutral and relentlessly carbon filtered. You'll be able to taste our white rum in a mojito or daiquiri, and in a way that adds to the drink.

Our gold rum is our white rum with a touch of caramel that we make from scratch in the distillery from evaporated cane juice.

Rounding out our un-aged rums is our 120 proof Picaroon Overproof White Rum. While our 80 proof white rum gets a light carbon filtration, the overproof stays unfiltered in order to retain the full flavor of the raw rum.



BLACKWATER

BLACKWATER DISTILLING
PICAROON
COLD BREW RUM LIQUEUR
COFFEE
BLACKWATER 30%

In late 2016 we emptied our first rum barrels to create our Picaroon Dark Rum. Picaroon Dark is a blend of our rum aged for between 18 and 24 months in new, charred American oak, our un-aged rum, our house-made caramel, and a small amount of an intensely aromatic blend of rums from the French West Indies. We've been fortunate to win "Best of Category" with the dark rum at the American Distilling Institute competition in both 2017 and 2018.

Recently we released our first 100% aged rums. We age almost exclusively in 53-gallon barrels (with the exception of some larger barrels and a handful of 25-gallon barrels), so we've had to exercise some patience. In February we released the first batch of our flagship product, Picaroon Solera Aged Rum. We have a true solera consisting of five levels of five barrels each. We'll be bottling only twice a year, and each bottling will yield only a few hundred bottles, so it's an extremely limited product. We use two different yeast strains for the solera aged rum, and a variety of barrels, including new American oak, used bourbon and rye barrels, and used port and red wine barrels. I love the product already, but as we get into subsequent bottlings, we're going to have an even more rich and complex solera aged rum.

Recently, we also released our first "single barrel" rum. I use the quotation marks because the rum has been through two barrels (a year and a half in used bourbon and another year in second-use port), but the bottling is from a single barrel. And finally, we have our Picaroon Cold Brew Coffee Rum Liqueur, which is our white rum infused with vanilla beans and allspice berries, blended with a cold brew coffee that we make with locally roasted beans, and sweetened with a house-made caramel syrup.

Q: Congratulations are in order for you, as you recently won "Best of Category" with your Picaroon Dark Rum at the 2018 American Distilling Institute Craft Rum Awards. Now that you have this award, what is next? What other milestone would you like to reach?



Thanks! I've been tweaking our fermentations and have been really happy with the results. I'm excited to see how the next batches of our un-aged rums fare in competition. I'd certainly like to see more "Best of Category" awards! Behind the scenes, I've been working on introducing bacteria to our fermentations to create some of the heavier flavors found in some of my favorite Caribbean rums.

Q: Do you have signature cocktails? If yes, which one is the most popular?

We aren't able to serve cocktails at the distillery yet, although we will be expanding and opening a tavern in the next few months. At home I love to make a Rum Boulevardier (2 parts rum, 1 part Campari, 1 part sweet vermouth) or a Rum Old Fashioned (rum, sugar, Angostura bitters, orange peel) with either our dark rum or solera aged rum. And our solera aged rum in particular is wonderful neat or on the rocks.

Q: Are you currently setting barrels aside for a much older rum bottling in the future?

Setting aside barrels for long aging is a tough thing to do at this point. I do hope that we can be releasing at least four-year-old rums before too long.

Q: Where are your rums currently available for purchase?

We're distributed throughout Maryland and Washington, DC, and we hope to be in Delaware this year.

Q: Do you also distill or plan to distill other spirits in addition to rum?

Right now, rum is the vast majority of what we distill in-house, although we have a number of blended vodkas and whiskies and distill a bit of malt whiskey on site. I'm working on gin right now, as well as more rum liqueurs.

Q: Do you offer tours of your distillery?

We're open 12-5 seven days a week and we do a tour/tasting on each hour, no reservations require. If you've got a group of more than 15 people we always appreciate a heads up. We're working on moving/expanding into a new location soon, where we'll be opening a full tavern in addition to moving much of the production there. We've made a lot of progress with the local legal environment over the past seven years, and we're excited to take advantage of one of the most significant changes and be able to serve our spirits in a way that is much more familiar to the vast majority of people: in cocktails.

Q: I understand you offer a "VIP Bottle Club". Can you tell us more about this club?

The VIP Bottle Club is a quarterly subscription to our spirits and mixers from other local producers. Each quarter, we select two or three of our spirits and potentially one of the locally made mixers that we carry and put them together with some suggested recipes. It's a fun way to explore our portfolio at a good discount off of retail, and we try to include limited and hard-to-find spirits. Our last set, for example, included our

long-sold-out "Geist," which was a whiskey we distilled from bock, doppelbock, and Oktoberfest beers from one of the major Munich breweries and aged in new oak for 13 months. You can find all the info at <http://www.blackwaterdistilling.com/vipbottleclub>. Unfortunately with shipping of spirits permitted in so few states, it's pick-up only right now.

Q: If people want to contact you, how may they reach you?

I can be reached at akeller@blackwaterdistilling.com and you can follow me on Instagram at [@distillerpants](https://www.instagram.com/distillerpants). You can follow Blackwater Distilling on Instagram at [@blackwaterspirits](https://www.instagram.com/blackwaterspirits), on Facebook at [/BlackwaterDistilling](https://www.facebook.com/BlackwaterDistilling), and on Twitter [@BlackwaterTM](https://twitter.com/BlackwaterTM).

Q: Is there anything else you'd like to share with our readers?

Drink more rum—and seek out the good stuff! Rum in my opinion is the most diverse and interesting category of spirits. There are so many rabbit holes you can go down as a drinker and as a producer. Americans in particular think of rum in terms of the two or three main brands they can find on the shelves of most liquor stores, and that's an extremely poor representation of what the category has to offer. I'm sure your readers are well aware, but one thing that's surprising to so many people who walk through our door is that a good aged rum is just as sippable neat or on the rocks as a good aged bourbon or scotch whiskey. So, thanks to you for spreading the gospel of rum, and thanks to your readers for be willing to explore the fun things we craft producers are doing with the category!

Again Andy, thank you so much for the opportunity to interview you. I wish you and your team much success and look forward to seeing what else you have in stock for us.

Cheers!
Margaret E. Ayala



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CIGAR & RUM PAIRING

by Philip Ili Barake



My name is Philip Ili Barake, Sommelier by trade. As a result of working with selected restaurants and wine producers in Chile, I started developing a passion for distilled spirits and cigars. As part of my most recent job, I had the opportunity to visit many Central American countries, as well as, rum distilleries and tobacco growers.

But my passion for spirits and cigars did not end there; in 2010 I had the honor of representing Chile at the International Cigar Sommelier Competition, where I won first place, becoming the first South American to ever achieve that feat.

Now I face the challenge of impressing the readers of "Got Rum?" with what is perhaps the toughest task for a Sommelier: discussing pairings while being well aware that there are as many individual preferences as there are rums and cigars in the world.

I believe a pairing is an experience that should not be limited to only two products; it is something that can be incorporated into our lives. I hope to help our readers discover and appreciate the pleasure of trying new things (or experiencing known things in new ways).



The Brown Manhattan

I know very well that most of my readers are enjoying a climate that is opposite of the one here in the southern hemisphere, but I wanted a warming cocktail to deal with the cool temperatures we are having, something along the lines of a Digestif, one that would set the stage for a free afternoon, something I don't really have but wish I did.

Creating the cocktail was very easy, by design, so that it can be recreated at home by most readers, without requiring a lot of ingredients. I created it in the same manner you prepare a Manhattan: refreshing the ingredients and the glass, this way the drink is not served with ice (which would continue diluting it) and is warmed slightly as we smoke the cigar.

The ingredients are:

- 3 oz. Santa Teresa Gran Reserva 1796 Rum
- 2 oz. Vermouth Rosso (here I used my custom blend, which I keep permanently refilling with wine and liquor, Solera-style)
- 1 oz. Coffee Liqueur

The preparation is simple:

Pour all three ingredients into a tumbler (or a plain, large glass), add ice cubes and stir with a bar spoon until the liquid is cool. Strain into a chilled serving glass (I keep mine in the freezer) that will allow for

Got Rum?





Photo credit: @Cigarill





Photo credit: @CigarIli

the cocktail to remain cool and warm up slowly over time.

The cigar I selected was a Churchill (7 x 56) from Carlos Toraño's "The Brick" line. I was saving this cigar for a different occasion (considering its smoking time) but after mixing the cocktail I thought it would go very well with it. I like the origins of the tobaccos, especially Honduras and Nicaragua, in a box-pressed format that makes it well-deserving of the moniker. My cigar had a very even-colored wrapper, so let's see how the pairing unfolds!

The cocktail was everything I expected it would be: it was smooth, complex and the rum notes had the right intensity for the pairing to work, making sure that the rum was front and center. Moving on to the cigar: for me, the first third is always too weak, I know that everyone has their preferences, but with this size cigar makes the first third seem even weaker, compared to what will follow. Honduras' tobacco also reminds me of a couple of other brands, especially in the initial puffs.

By the time I reached the second third, the cigar was becoming stronger and the cocktail was getting slightly warmer, which was a perfect match. For me the pairing worked much better at this point than during the early stage; I think those who appreciate dark tobacco and coffee would agree with me.

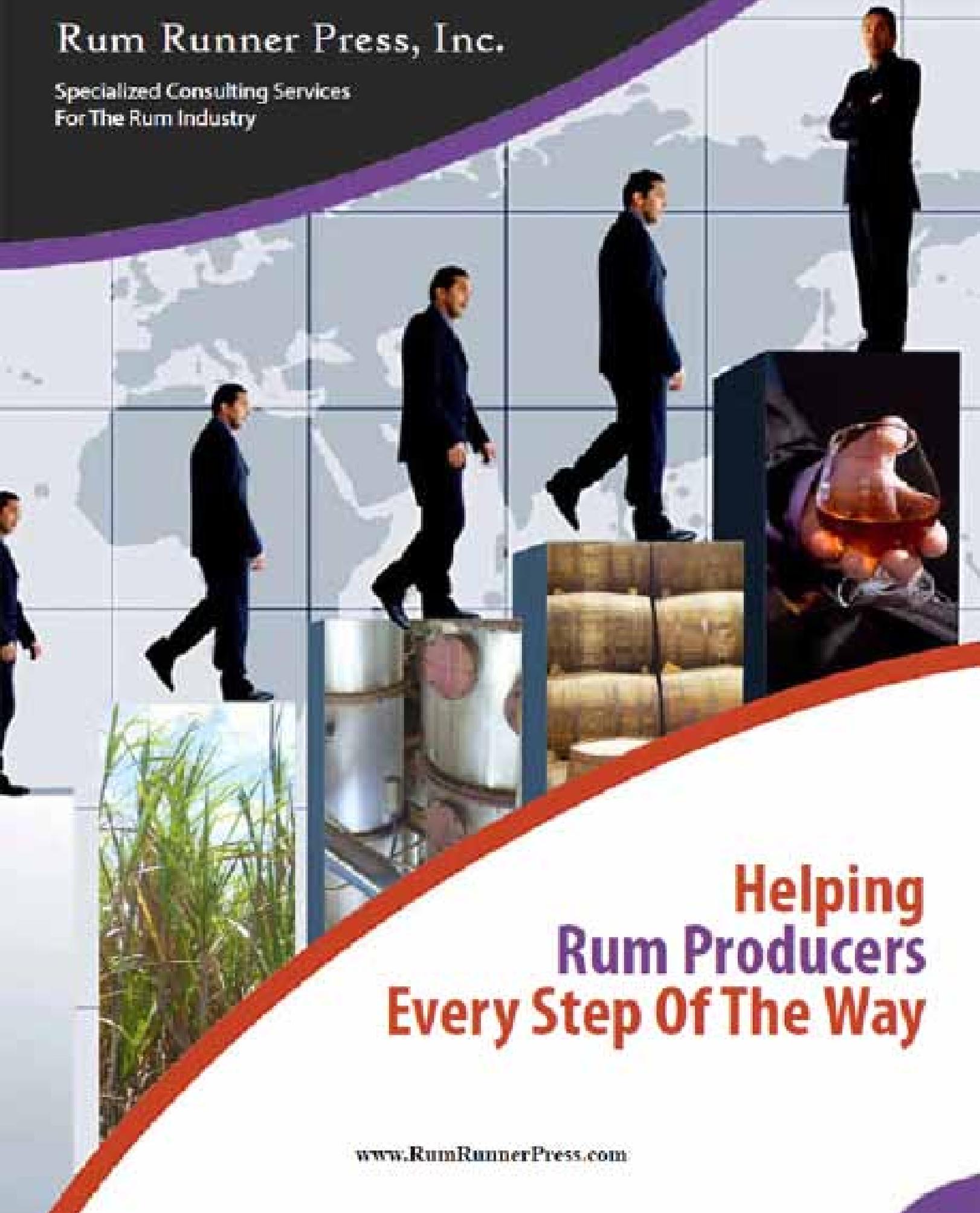
I highly recommend the pairing, especially during an afternoon that is more on the cool side than on the hot one. I hope it is easy enough that many readers will attempt it. Hopefully all those who try it will agree that it is a pairing that only gets better and better!

Philip Ili Barake
#GR CigarPairing



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