INDUSTRIES OF INDIA

WHISKY

Water, Fire, Oak

SOURCE COMPANION

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How to read this companion

Every superscript number in *Whisky - Water, Fire, Oak* refers to one entry below. Each entry names the publication, gives the exact URL, states what was actually read there (full page, article extract, abstract, report listing, or search extract), and lists the claims in the book it supports.

Two honesty rules apply throughout. Where a source was read through an abstract or search extract rather than the full text, the entry says so. Where a number is a forecast, an estimate, or an industry body's own figure, the book says so in its own text.

Wikipedia entries are used only as tertiary orientation for uncontroversial dates and etymologies, never as the sole support for a contested claim.

The sources

S1. *Scotsman, 'History and origins of Scotch whisky'.* The Scotsman
https://www.scotsman.com/lifestyle/food-and-drink/history-and-origins-scotch-whisky-4251284
Read: search extract. **Supports:** Etymology: whisky from 'uisge beatha', water of life, in Scots Gaelic.

S2. *Scotland's People, 'First reference to whisky, 1494'.* National Records of Scotland
https://www.scotlandspeople.gov.uk/image-library/7197
Read: page text. **Supports:** Earliest written record: Exchequer Rolls 1494; Friar John Cor of Lindores Abbey granted 8 bolls of malt to make aqua vitae (ref E38/306).

S3. *Wikipedia, 'Uisce beatha'.* tertiary reference
https://en.wikipedia.org/wiki/Uisce_beatha
Read: article extract. **Supports:** Old Irish uisce + bethu; early English spellings uskebeaghe (1581), usquebaugh (1610), usquebath (1621), usquebae (1715); contraction to 'whisky'.

S4. *Wikipedia, 'Irish whiskey'.* tertiary reference
https://en.wikipedia.org/wiki/Irish_whiskey
Read: article extract. **Supports:** 1405 Annals of Clonmacnoise: chieftain dies after 'a surfeit of aqua vitae' at Christmas; context for Ireland's later decline.

S5. *D. W. B. Smith on classical distillation.* DOI 10.1179/043087775798240847
https://doi.org/10.1179/043087775798240847
Read: abstract/extract. **Supports:** Aristotle evaporated seawater and condensed fresh water; classical roots of distillation.

S6. *RSC, 'Whisky's Historical Development'.* Royal Society of Chemistry monograph chapter
https://books.rsc.org/books/monograph/830/chapter/575447/Whisky-s-Historical-Development
Read: chapter listing/extract. **Supports:** Alchemy at the heart of distillation; spread of national spirits; distilling literature.

S7. *ScotchWhisky.com, 'Whisky's curious medicinal history'.* Whisky Magazine feature
https://scotchwhisky.com/magazine/features/26449/whisky-s-curious-medicinal-history/
Read: search extract. **Supports:** Distillation knowledge from Persian/Arabic scholars (Jabir ibn Hayyan, Rhazes); Latin translations spreading the art in 12th-13th c. Europe; medicinal aqua vitae.

S8. *Bushmills, 'Our history'.* Old Bushmills Distillery (official)
https://www.bushmills.eu/history/
Read: page text. **Supports:** 1608 licence to distil granted in the area; Bushmills' claim as world's oldest licensed whiskey distillery.

S9. *Oxford Companion to Spirits & Cocktails, aqua vitae entry.* spiritsanddistilling.com
https://www.spiritsanddistilling.com/dictionary/acref-9780199311132-e-1208
Read: entry extract. **Supports:** 1556 act 'to prevent the making of aqua vitae', 'nothing profitable to be daily drunken and used', made 'especially in the borders of the Irishry'.

S10. *Whisky Magazine, 'Mythbusters: Cradle of Scotch'.* whiskymag.com
https://www.whiskymag.com/articles/mythbusters-cradle-of-scotch/
Read: search extract. **Supports:** Ferintosh estate described 1690 as 'ancient brewery of aquavity'; Duncan Forbes bought barony 1625; still set up 1670s - antiquity as tax-privilege argument.

S11. *RSC, 'Whisky's Historical Development'.* Royal Society of Chemistry monograph chapter
https://books.rsc.org/books/monograph/830/chapter/575447/Whisky-s-Historical-Development
Read: chapter listing/extract. **Supports:** Background for the distillation principle and early apparatus described in Chapter 4.

S12. *Whisky.com, 'Alcohol and water'.* whisky.com knowledge base
https://www.whisky.com/alcohol-and-water.html
Read: search extract. **Supports:** Whisky is mainly water and ethanol; flavourings under 1%; ethanol C2H5OH basics.

S13. *Chest of Books, 'Azeotropic Mixtures'.* chestofbooks.com (scan of standard reference)
https://chestofbooks.com/food/beverages/Alcohol-Properties/Azeotropic-Mixtures.html
Read: page text. **Supports:** Ethanol-water azeotrope: constant-boiling mixture at 78.15 C, ~95.6% alcohol; distillation cannot pass it.

S14. *Liebminger et al., whisky production review.* PMC8911989 (peer-reviewed)
https://pmc.ncbi.nlm.nih.gov/articles/PMC8911989/
Read: search extract. **Supports:** Composition and process of whisky; supports the 'less than one percent flavour compounds' framing and process stages.

S15. *Liebminger et al., whisky production review.* PMC8911989 (peer-reviewed)
https://pmc.ncbi.nlm.nih.gov/articles/PMC8911989/
Read: search extract. **Supports:** Same review: distillation strengths - 65-70% ABV for Scotch/Japanese malt, up to ~95% for grain whisky.

S16. *Scotch Whisky Association, 'Protecting Scotch Whisky'.* scotch-whisky.org.uk
https://www.scotch-whisky.org.uk/industry-insights/protecting-scotch-whisky/
Read: page text. **Supports:** Legal definition: Scotland-only production; cereals/water/yeast only; 3 years in oak casks <=700L; min 40% abv; distilled below 94.8% abv; no flavouring/sweetening; five categories; GI protection.

S17. *Annandale Distillery, technical notes: copper.* annandaledistillery.com
https://www.annandaledistillery.com/technical-notes/copper/
Read: search extract. **Supports:** Copper chosen for malleability and heat conduction; its chemical role in spirit quality; still-shape effects.

S18. *Waterford Whisky, 'The influence of copper'.* waterfordwhisky.com
https://waterfordwhisky.com/element/the-influence-of-copper/
Read: search extract. **Supports:** Copper reacts with sulphur compounds forming salts left in pot ale; desirable compounds from fermentation; Waterford's single-farm barley programme.

S19. *SWA handbook, Ch. 3 (Edinburgh mirror).* dcs.ed.ac.uk mirror of SWA 'Questions and Answers'

https://www.dcs.ed.ac.uk/home/jhb/whisky/swa/chap3.html
Read: search extract. **Supports:** Malt whisky = pot still process; grain whisky = patent (Coffey) still; four main stages of pot-still production.

S20. *Undiscovered Scotland, 'The Spirit Safe'.* undiscoveredscotland.co.uk
https://www.undiscoveredscotland.co.uk/usfeatures/maltwhisky/spiritsafe.html
Read: search extract. **Supports:** Spirit safe lets distiller manage cuts without contact; origins in 1823 duty-law changes; excise lock.

S21. *Oxford Companion, 'Coffey still / Aeneas Coffey' entry.* spiritsanddistilling.com
https://www.spiritsanddistilling.com/dictionary/acref-9780199311132-e-1328
Read: entry extract. **Supports:** Cellier-Blumenthal 1808 first practical continuous still; Stein 1828 Kilbagie; Coffey's 1830 patent, first commercially viable for grain.

S22. *ScotchWhisky.com, 'Whisky heroes: Aeneas Coffey'.* Whisky Magazine
https://scotchwhisky.com/magazine/whisky-heroes/20740/aeneas-coffey/
Read: search extract. **Supports:** Coffey's excise career, retirement, 1830 patent; 'gamekeeper turned poacher'.

S23. *Whisky Auctioneer, 'The backstory of blending Scotch whisky'.* whiskyauctioneer.com
https://whiskyauctioneer.com/learn/whisky-news/features/backstory-blending-scotch-whisky
Read: search extract. **Supports:** Andrew Usher's early-1860s vatted blend; blends dominate Scotch sales; Walker/Ballantine's/Chivas context.

S24. *WhiskyInvestDirect, 'Available whiskies: Cameronbridge'.* whiskyinvestdirect.com
https://www.whiskyinvestdirect.com/about-whisky/available-whiskies
Read: search extract. **Supports:** Cameronbridge as a major grain (column-still) distillery; context for the 1908-09 'What is Whisky?' settlement.

S25. *Walker & Stewart et al., fermentation in whisky review.* Beverages 2(4):38 / MDPI
https://www.mdpi.com/2306-5710/2/4/38
Read: abstract/extract. **Supports:** S. cerevisiae ferments wort sugars;

products ethanol, CO2, glycerol plus esters, aldehydes, higher alcohols, organic acids, sulphury and phenolic compounds; washback practice.

S26. *Waymark et al., 'Whisk(e)y flavour' review.* Beverages 9(3):64 / MDPI
https://www.mdpi.com/2306-5710/9/3/64
Read: abstract/extract. **Supports:** Key congener groups in whiskey: alcohols, esters, aldehydes, acids, phenols, lactones, terpenes, tannins; formed across process stages.

S27. *Difford's Guide, single malt production: malting.* diffordsguide.com
https://www.diffordsguide.com/g/1168/single-malt-scotch-whisky-production/malting
Read: search extract. **Supports:** Malting: partial germination releases starch for conversion to fermentable sugars, then drying (kilning); enzyme action in mashing.

S28. *Scotch Whisky Association, 'Facts & Figures'.* scotch-whisky.org.uk
https://www.scotch-whisky.org.uk/industry-insights/facts-figures/
Read: page text. **Supports:** 43 bottles/sec to 160+ markets; 2025 exports GBP 5.36bn; 72% of Scottish food-and-drink exports; 22m casks maturing (~12bn bottles); 156 operating distilleries (Sept 2026); 2.7m distillery visits 2024; ~90% of barley sourced in Scotland.

S29. *Distiller, 'Phenol count'.* distiller.com
https://distiller.com/articles/phenol-count
Read: search extract. **Supports:** Peat levels measured in ppm phenols in malt; heavily peated ~40-50ppm; Ardbeg Supernova 100ppm; Octomore 131ppm; kilning with peat smoke.

S30. *Scotch Whisky Association, Net Zero report.* scotch-whisky.org.uk (PDF)
https://scotch-whisky.org.uk/media/1733/scotch-whisky-net-zero-report.pdf
Read: listing/abstract. **Supports:** Study identifying key energy technologies to cut whisky emissions; water and climate as strategic questions.

S31. *The Dram List, 'Maturation science'.* thedramlist.com.au
https://thedramlist.com.au/whisky/fundamentals/maturation-science/
Read: search extract. **Supports:** Maturation processes incl. extraction; trade rule-of-thumb that the cask supplies the majority of mature flavour.

S32. *Oak wood composition for barrels study.* PMC9866382 (peer-reviewed)
https://pmc.ncbi.nlm.nih.gov/articles/PMC9866382/
Read: search extract. **Supports:** Quercus oak: ~45% cellulose, 25% hemicellulose, 20% lignin; extractives giving aroma/taste in maturation.

S33. *'Oak and its influence on maturation'.* smwhisky.com.au (technical PDF)
http://www.smwhisky.com.au/wp-content/uploads/2016/10/oak-and-an-overview-of-its-influence-on-maturation.pdf
Read: extract. **Supports:** Oak lignin's guaiacyl and syringyl units; breakdown products in matured drinks (vanillin family, spice/smoke notes).

S34. *Cask-stave analysis (vanillin/syringaldehyde).* dcs.ed.ac.uk mirror of published study
https://www.dcs.ed.ac.uk/home/jhb/whisky/papers/caskanal.htm
Read: abstract. **Supports:** Free vanillin, syringaldehyde, vanillic/syringic acids in four cask types; lignin degradation state; milled wood lignin unaffected by repeated use.

S35. *LCGC, 'Advances in ageing chemistry of distilled spirits matured in oak barrels'.* chromatographyonline.com
https://www.chromatographyonline.com/view/advances-ageing-chemistry-distilled-spirits-matured-oak-barrels
Read: search extract. **Supports:** Charring vs toasting; heat degrades lignin/macromolecules into flavour compounds; char layer's filtering role; extraction over ageing.

S36. *J. Inst. Brewing study of cask staves.* DOI 10.1002/jsfa.2740620210
https://doi.org/10.1002/jsfa.2740620210
Read: abstract. **Supports:** Phenolic extractives (vanillic/syringic acids, aldehydes) measured across new charred bourbon, used bourbon, first-fill and exhausted Scotch casks - progressive stripping by fill.

S37. *The Glenlivet, 'What is the angels' share?'.* theglenlivet.com
https://www.theglenlivet.com/en/our-community/articles/angels-share-meaning/
Read: search extract. **Supports:** ~2% annual evaporation in Scotland; factors: age, cask size, storage, climate; evaporation's role in maturation and flavour.

S38. *Decanter, 'The rise of Indian single malts'.* decanter.com
https://www.decanter.com/spirits/whisky/the-rise-of-indian-single-malts-562109/
Read: search extract. **Supports:** Indian single malts' cask experimentation; maturation under northern Indian climate; hot-climate acceleration context.

S39. *SMWS Unfiltered, 'Cask maturation'.* smws.com
https://unfiltered.smws.com/uk/08-2024/cask-maturation.html
Read: search extract. **Supports:** Dunnage vs racked vs palletised warehousing; casks up to a dozen high on racks; forklift logistics; cost trade-offs.

S40. *Kentucky Bourbon, FAQ.* kybourbon.com
https://kybourbon.com/industry/faq/
Read: search extract. **Supports:** 1964 Congressional resolution: bourbon a distinct product of the USA; new charred oak container requirement; other ABC rules.

S41. *BevNET, 'Macallan deepens supply chain with cask-maker acquisition'.* bevnet.com (2023)
https://www.bevnet.com/spirits/2023/the-macallan-deepens-supply-chain-with-cask-maker-acquisition-and-u-s-partnership/
Read: search extract. **Supports:** Edrington acquired Jerez cooperage Vasyma and partnered with Ohio's Coopers Oak; 30+ years supplying Macallan; supply-chain securing of casks.

S42. *Diario de Sevilla, 'Sherry cask: negocio de 100 millones de euros'.* diariodesevilla.es
https://www.diariodesevilla.es/economia/sherry-cask-negocio-100-millones-euros_0_2002938267.html
Read: search extract. **Supports:** Jerez regulator's 2015 voluntary register of cask seasoning (envinado); sherry-cask trade as lifeline business for the sherry region.

S43. *Sherry Wines (Consejo Regulador), 'Sherry cask'.* sherry.wine
https://www.sherry.wine/sherry-cask
Read: search extract. **Supports:** Bota jerezana seasoned casks; thousands produced in Jerez yearly for whisky and spirits ageing.

S44. *VinePair, 'How Bourbon Producers Are Rallying to Preserve America's White Oak Industry'.* vinepair.com
https://vinepair.com/articles/bourbon-producers-oak-preservation/
Read: search extract. **Supports:** White-oak conservation programmes by bourbon producers; forest-management alignment of harvest and regeneration; fragmented stave/cooperage supply chain.

S45. *Toneleria Antonio Paez Lobato.* toneleriapaezlobato.es (official)
https://toneleriapaezlobato.es/en/inicio-english/
Read: search extract. **Supports:** Jerez cooperage founded 1946; exports 38,000+ oak barrels a year; 55+ coopers; 14,000 m3 oak air-drying inventory.

S46. *BevNET, 'How the bourbon industry is coping with a white-oak barrel shortage'.* bevnet.com (2023)
https://www.bevnet.com/spirits/2023/how-the-bourbon-industry-is-coping-with-a-white-oak-barrel-shortage/
Read: search extract. **Supports:** White oak (Quercus alba) shortage warnings; demand, labour, climate, pandemic renovation pressures on stave supply.

S47. *Whisky Magazine, 'The genuine article: The Glenlivet in its 200th year'.* whiskymag.com
https://www.whiskymag.com/articles/the-genuine-article-the-glenlivet-in-its-200th-year/
Read: search extract. **Supports:** 1823 Excise Act response to illicit distillation; up to 14,000 illicit stills in early 1820s; detection unlikely in remote Highlands.

S48. *Oxford Companion, 'Glenlivet' entry.* spiritsanddistilling.com
https://www.spiritsanddistilling.com/dictionary/acref-9780199311132-e-129
Read: entry extract. **Supports:** George Smith (1792-1871), tenant of Duke of Gordon; distilling illegally since at least 1815; first Speyside licence 1824; Duke promoted the 1823 Act.

S49. *Chivas Brothers archive, 'Our story'.*
history.chivasbrothersarchive.com
https://history.chivasbrothersarchive.com/story/our-story/
Read: search extract. **Supports:** 1853 Act permitting vatting under bond; Spirits Act 1860 allowing duty-free blending across distilleries; birth of modern blending.

S50. *Scotch Whisky Association, 'The story of Scotch'.* scotch-whisky.org.uk
https://www.scotch-whisky.org.uk/discover-scotch/story-of-scotch/
Read: search extract. **Supports:** 1880s phylloxera devastated French vineyards; Scotch replaced brandy as preferred spirit (Chapter 12 notes the historians' nuance).

S51. *ScotchWhisky.com, 'Whisky heroes: the Pattison brothers'.* Whisky Magazine
https://scotchwhisky.com/magazine/whisky-heroes/7852/the-pattison-brothers/
Read: search extract. **Supports:** Pattison family dairy wholesalers; Pattison, Elder & Co formed 1882; blending boom and marketing excess.

S52. *Wikipedia, 'Pattisons (whisky company)'.* tertiary reference
https://en.wikipedia.org/wiki/Pattisons_(whisky_company)
Read: article extract. **Supports:** Pattisons Ltd blender/bottler 1896-1901; bankruptcy 1901; role in late-Victorian boom and collapse.

S53. *VinePair, 'The whisky loch'.* vinepair.com
https://vinepair.com/articles/whisky-loch/
Read: search extract. **Supports:** 1980s overproduction and demand collapse; accumulation of maturing stock; closures; 'whisky loch'.

S54. *Whisky Magazine, 'Silence is golden'.* whiskymag.com
https://whiskymag.com/articles/silence-is-golden-the-fate-and-future-of-closed-scottish-distilleries/
Read: search extract. **Supports:** 1983 a disastrous year with many distilleries shuttered; closed names later esteemed; DCL-era consolidation context.

S55. *Scotch Whisky Association, 'Big Map of Scotch Whisky' (2024).* scotch-whisky.org.uk (PDF)
https://www.scotch-whisky.org.uk/media/2285/2024-big-map-of-scotch-whisky.pdf
Read: extract. **Supports:** Speyside has more distilleries than any other region; regional characters; five-region map basis.

S56. *The Whiskey Wash, 'Staying relevant in the fast-paced world of new whisky distilleries'.* thewhiskeywash.com
https://thewhiskeywash.com/whiskey-articles/staying-relevant-in-the-fast-paced-world-of-new-whisky-distilleries/

Read: search extract. **Supports:** 107 Scottish distilleries in 2013, 150 as of Oct 2024 (SWA); 43 new in ten years; oversupply caution; Campbeltown expansion plans.

S57. *Master of Malt, 'The story of the Irish whiskey renaissance'.* masterofmalt.com
https://www.masterofmalt.com/blog/post/the-story-of-the-irish-whiskey-renaissance/
Read: search extract. **Supports:** Mid-19th c. Ireland: 88 licensed distilleries; largest distilleries in Dublin; Irish outsold Scotch; champagne/cognac-tier reputation.

S58. *Irish Distillers, 'Our story'.* irishdistillers.ie (official)
https://www.irishdistillers.ie/our-story
Read: page text. **Supports:** 1966 merger of Power, Jameson and Cork Distilleries into Irish Distillers; 1970s New Midleton; 1984 Midleton Very Rare; 1988 Pernod Ricard acquisition; Jameson passing 10m cases; 2022 investment plans.

S59. *Irish Times, 'Has the heat gone out of Irish whiskey?'.* irishtimes.com (18 Sept 2025)
https://www.irishtimes.com/special-reports/2025/09/18/has-the-heat-gone-out-of-irish-whiskey/
Read: search extract. **Supports:** Fifteen years of Irish whiskey as export success story; 2010s distillery-opening wave (supports the revival-wave passages).

S60. *Irish Times, 'Has the heat gone out of Irish whiskey?'.* irishtimes.com (18 Sept 2025)
https://www.irishtimes.com/special-reports/2025/09/18/has-the-heat-gone-out-of-irish-whiskey/
Read: search extract. **Supports:** Same article: distillery openings riding heritage-spirits interest; book phrases distillery counts cautiously as 'dozens'.

S61. *Kentucky Bourbon, FAQ.* kybourbon.com
https://kybourbon.com/industry/faq/
Read: search extract. **Supports:** Bourbon legal basics incl. 1964 'distinctive product' resolution and new charred oak; used for the statutory recipe paragraph.

S62. *eCFR, 27 CFR 5.143 (whisky standards).* Electronic Code of Federal Regulations
https://www.ecfr.gov/current/title-27/chapter-I/subchapter-A/part-5/subpart-I/section-5.143
Read: page text. **Supports:** US 'whisky' definition: grain distillate under 95% abv, oak storage, bottled at not less than 40% abv.

S63. *Distiller, 'Lincoln County Process'.* distiller.com
https://distiller.com/articles/lincoln-county-process
Read: search extract. **Supports:** Lincoln County Process: filtering new make through sugar-maple charcoal before maturation; synonymous with Tennessee whiskey.

S64. *Jack Daniel's, 'Charcoal mellowing'.* jackdaniels.com (official)
https://www.jackdaniels.com/articles/charcoal-mellowing
Read: search extract. **Supports:** Every drop passes through ten feet of sugar maple charcoal before the barrel; Tennessee recognition of the step.

S65. *Library of Congress, distilled spirits industry guide.* guides.loc.gov
https://guides.loc.gov/alcoholic-beverage-industry/distilled-spirits
Read: search extract. **Supports:** Prohibition closed most business; some distillers produced 'medicinal' whiskey under Volstead Act Title II sections 6-7; many never reopened.

S66. *Kentucky Distillers' Association, 'The Bourbon State' (Dec 2024).* kybourbon.com
https://kybourbon.com/industry-news/the-bourbon-state-challenges-mount-amid-record-production-landmark-barrel-inventories/
Read: page text. **Supports:** Record 14.3m barrels aging (as of 1 Jan 2024); $9bn economic engine; 23,500+ jobs; 2m+ Bourbon Trail visits; EU 50% tariff threat; barrel tax up 450% since 2009 and 20-year phase-out.

S67. *Whisky Auctioneer, 'Japanese whisky 101'.* whiskyauctioneer.com
https://whiskyauctioneer.com/learn/whisky-news/features/japanese-whisky-101-guide
Read: search extract. **Supports:** Settsu Shuzo sent Taketsuru to Scotland; apprenticeships at Longmorn and Bo'ness; notebooks.

S68. *Japan National Tourism Organization, 'Japanese whisky' guide.* japan.travel (official)
https://japan.travel/en/guide/japanese-whisky/
Read: page text. **Supports:** Shinjiro Torii founded Yamazaki 1923 (first Japanese malt distillery); Taketsuru left Suntory 1934 to found Nikka; 2003 ISC trophy for Yamazaki 12 as first Japanese win; 2015 Jim Murray named Yamazaki Sherry Cask world's best.

S69. *Canadian Club, 'Our story'.* canadianclub.com (official)
https://www.canadianclub.com/our-story
Read: page text. **Supports:** Hiram Walker founded 1858 in Windsor, Ontario; Walkerville company town; Canadian Club brand history; Prohibition-era cross-border trade.

S70. *Economic Times, India-UK FTA whisky coverage.* economictimes.indiatimes.com
https://economictimes.indiatimes.com/news/economy/foreign-trade/india-uk-fta-whisky-sector/articleshow/122745019.cms
Read: search extract. **Supports:** India imported/consumed ~259m 9-litre cases of whisky in 2024 (CIABC); FTA duty trajectory 150% to 75% then 40% over ten years.

S71. *Hindu BusinessLine, 'Whisky, the Indian way'.* thehindubusinessline.com
https://www.thehindubusinessline.com/specials/india-file/whisky-the-indian-way/article67780307.ece
Read: search extract. **Supports:** India's whisky market ~252m cases in CY23 (IWSR); dominance of molasses-based IMFL; Amrut, Paul John, Rampur emergence.

S72. *Decanter, 'The rise of Indian single malts'.* decanter.com
https://www.decanter.com/spirits/whisky/the-rise-of-indian-single-malts-562109/
Read: search extract. **Supports:** Indian single malts' international recognition; climate-accelerated maturation (also entry 38).

S73. *News18, Indian single malt awards coverage.* news18.com
https://www.news18.com/news/lifestyle/indian-single-malts-awards-9284109.html
Read: search extract. **Supports:** Indian single malts winning international awards incl. Indri, Rampur; blind-tasting recognition.

S74. *World Whiskies Awards, Kavalan 2015.* worldwhiskiesawards.com
https://www.worldwhiskiesawards.com/winner/whisky/2015/taste/kavalan-solist-vinho-barrique-single-cask-strength/22019
Read: award listing. **Supports:** Kavalan Solist Vinho Barrique named World's Best Single Malt 2015; Taiwanese whisky milestone.

S75. *Diageo, Scotch factsheet FY24 (PDF).* diageo.com
https://www.diageo.com/PR1346/aws/media/8361/diageo-fy24-preliminary-results-scotch-factsheet.pdf
Read: factsheet PDF. **Supports:** Scotch = 24% of Diageo net sales FY24; Johnnie Walker ~1 in 3 Scotch bottles sold globally.

S76. *The Spirits Business, Diageo FY24 results.* thespiritsbusiness.com
https://www.thespiritsbusiness.com/2024/07/diageo-fy-2024-results/
Read: search extract. **Supports:** Diageo FY24: Scotch net sales -10%; Johnnie Walker -6%; premiumisation pause.

S77. *Scotch Whisky Association, '2024 export figures'.* scotch-whisky.org.uk
https://www.scotch-whisky.org.uk/media/2271/2024-export-figures
Read: page text. **Supports:** 2024 exports GBP 5.4bn value; 1.4bn bottles (44/sec); India top market by volume (192m bottles); US top by value (GBP 971m); ~70% of average UK bottle price is tax.

S78. *SWA, economic impact report 2024.* scotch-whisky.org.uk
https://www.scotch-whisky.org.uk/media/2384/swa-economic-impact-report-2024.pdf
Read: report extract. **Supports:** GBP 7.1bn GVA contribution (2022); 66,000 UK jobs supported (41,000 Scotland); GBP 3 in every GBP 100 of Scottish GVA.

S79. *BBC News, alcohol duty hike (Aug 2023).* bbc.co.uk
https://www.bbc.co.uk/news/uk-scotland-66384781
Read: news article. **Supports:** 10.1% UK spirits duty rise Aug 2023 - largest in 40 years; industry reaction.

S80. *GOV.UK, US-UK tariff deal.* gov.uk
https://www.gov.uk/government/news/uk-us-economic-prosperity-deal
Read: page text. **Supports:** UK-US economic deal context; tariff positions for Scotch in US market (zero-for-zero aspiration).

S81. *Forsyths, coppersmiths (official).* forsyths.com
https://forsyths.com/
Read: site text. **Supports:** Forsyths of Rothes: coppersmiths building pot stills and distillery equipment worldwide; family firm since 1890.

S82. *Scotch Whisky Regulations 2009, regulation 8.* legislation.gov.uk
https://www.legislation.gov.uk/uksi/2009/2890/regulation/8
Read: statutory text. **Supports:** Legal categories and protection: Scotch Whisky Regulations 2009 reg. 8 (compulsory sales descriptions/categories).

S83. *SWA, 'Protecting Scotch Whisky' (Legal Affairs).* scotch-whisky.org.uk
https://www.scotch-whisky.org.uk/industry-insights/protecting-scotch-whisky/
Read: page text. **Supports:** GI protection actions in courts worldwide; SWA legal affairs work against fakes (same page as entry 16).

S84. *SWA, sustainability: climate change.* scotch-whisky.org.uk
https://www.scotch-whisky.org.uk/sustainability/climate-change/
Read: page text. **Supports:** Industry sustainability strategy; emissions reduction pathway; packaging, water, peatland commitments.

S85. *University of Glasgow / SUERC, radiocarbon authentication.* gla.ac.uk
https://www.gla.ac.uk/news/headline_706515.html
Read: news release. **Supports:** SUERC radiocarbon dating exposes fake antique whisky: radiocarbon signature of post-1950 atmosphere in purported 19th-century bottles.

S86. *City of London Police, cask investment fraud warning (Nov 2023).* cityoflondon.police.uk
https://www.cityoflondon.police.uk/news/city-of-london/news/2023/november/whisky-cask-investment-fraud/
Read: press release. **Supports:** Warning on whisky cask investment fraud; boiler-room tactics; advice for investors.

S87. *City of London Police, Cask Whisky Ltd case (Jul 2024).* cityoflondon.police.uk
https://www.cityoflondon.police.uk/news/city-of-london/news/2024/july/cask-whisky-ltd/
Read: press release. **Supports:** Enforcement against fraudulent cask investment scheme; victims and recovery context.

S88. *Inside the Cask, record distillery visitor numbers.* insidethecask.com
https://insidethecask.com/2025/03/18/record-visitor-numbers-for-scotch-whisky-distilleries/
Read: search extract. **Supports:** 2.7m distillery visits in 2024 - record whisky tourism; spend per visitor rising.

S89. *SWA, net-zero 2040 strategy launch.* scotch-whisky.org.uk
https://www.scotch-whisky.org.uk/newsroom/scotch-whisky-industry-commits-to-reaching-net-zero/
Read: press release. **Supports:** Industry commitment to net zero in operations by 2040; revised strategy 2024.

S90. *SWA, Net Zero report PDF.* scotch-whisky.org.uk
https://scotch-whisky.org.uk/media/1733/scotch-whisky-net-zero-report.pdf
Read: report listing. **Supports:** Same report as entry 30: technology pathway study for decarbonising distillation.

S91. *Difford's Guide, overproof / navy strength.* diffordsguide.com
https://www.diffordsguide.com/g/1084/overproof-navy-strength-spirits
Read: search extract. **Supports:** 57% abv 'navy strength' / 100 proof history; gunpowder test story and its myth status.

S92. *Rum Wonk, gunpowder proof myth.* rumwonk.com
https://rumwonk.com/2017/12/the-gunpowder-proof-myth/
Read: article extract. **Supports:** Debunking/qualifying the gunpowder-and-proof legend; historical context of proof spirits.

S93. *Sotheby's, Macallan Adami 1926 sale.* sothebys.com
https://www.sothebys.com/en/buy/auction/2019/finest-and-rarest-wines-spirits/the-macallan-fine-rare-60-year-old-1926
Read: auction record. **Supports:** The Macallan Fine & Rare 60 Year Old 1926 sold GBP 1.5m (2019) - then-record for a bottle of whisky/spirit at auction.

S94. *Scotch Whisky Association, 'Scotch Whisky exports to United States down 15% since tariffs implemented' (2025 export figures, Feb 2026).* scotch-whisky.org.uk
https://scotch-whisky.org.uk/newsroom/2025-export-figures/
Read: page text (incl. March 2026 revision note following HMRC export release). **Supports:** 2025 exports GBP 5.3bn, down 1.8% in value on 2024;

1.34bn 70cl bottles, down 4.3%; 43 per second. US: GBP 933m in 2025 (-4% value, -9.2% volume full year); May-Dec 2025 volumes down 15% and value down 7% under the April 2025 10% tariff.

S95. *GOV.UK, 'Big win for Scotch whisky as US tariffs are lifted' (24 July 2026).* gov.uk (Scotland Office / DBT)
https://www.gov.uk/government/news/big-win-for-scotch-whisky-as-us-tariffs-are-lifted
Read: page text. **Supports:** Zero US tariffs on UK whisky from 24 July 2026 under the UK-US Economic Prosperity Deal, following the agreement reached during the King's April 2026 visit; US was ~20% of UK whisky exports by value in 2025.

S96. *Reuters, 'India slashes bourbon whisky tariffs amid intensifying Trump criticism' (14 Feb 2025).* reuters.com
https://www.reuters.com/business/retail-consumer/india-slashes-bourbon-whisky-tariffs-amid-intensifying-trump-criticism-2025-02-14/
Read: page text. **Supports:** India cut bourbon duty from 150% to 100% (50% basic + 50% additional levy) in a notification dated 13 Feb 2025; other liquor imports unchanged at 150%.

S97. *UK government export guidance, 'Tariffs and customs for imports from and exports to India'.* business.gov.uk
https://www.business.gov.uk/export-from-uk/markets/india/trade-agreement/tariffs-and-customs-for-imports-from-and-exports-to-india/
Read: page text. **Supports:** UK-India CETA entered into force 15 July 2026; Scotch whisky (HS 2208.30) tariff cut from 150% to 75% on entry into force, with staged reductions to 40% over ten years.

S98. *Moneycontrol, 'India-UK trade deal cut Scotch whisky tariffs to 75%: why are companies facing a 150% duty dispute?' (2026).*
moneycontrol.com
https://www.moneycontrol.com/news/business/india-uk-trade-deal-cut-scotch-whisky-tariffs-to-75-why-are-companies-facing-a-150-duty-dispute-14066347.html
Read: page text (Reuters explainer republished by Moneycontrol, 2 Nov 2026). **Supports:** First significant India-UK FTA dispute: Indian officials argue bulk Scotch (about 80% of Scotch shipments to India) does not qualify for the 75% rate, asserting a 150% classification for compound alcoholic

preparations; bottled Scotch receives the reduced duty; UK government says it is working with India to resolve it.

S99. *Alcademics, 'How Column Distillation Works: Bourbon Edition'.* Alcademics (Camper English)
https://alcademics.com/how-column-distillation-works-bourbon-edition/
Read: page text. **Supports:** Column stills can be built from stainless steel but the vapour must interact with copper at some point: the rectifying section carries copper bubble-cap plates or copper packing, while the beer-stripping section may be stainless.

The illustrations

All fourteen interior illustrations are original artworks created for this book. They are illustrations, not photographs: they depict no real person, place or brand, and no real site or object should be inferred from them. None is offered as documentary evidence; the evidential load of the book is carried entirely by the text and its sources.

w01-stillroom.png (Chapter 1)
An apothecary's still room: copper alembic over a fire, herbs and manuscripts.

w02-potstills.png (Chapter 5)
Copper swan-neck pot stills in a Scottish still house.

w03-warehouse.png (Chapter 11)
A dunnage warehouse: casks resting on wooden rails.

w04-glass.png (Prologue)
A glass of whisky with the raw materials of its making.

w05-malting.png (Chapter 9)
A traditional floor maltings, barley turned by shovel.

w06-peat.png (Chapter 10)
Cut peat drying on a moor.

w07-column.png (Chapter 7)
A column (continuous) still hall.

w08-spiritsafe.png (Chapter 6)
A brass spirit safe with sample boxes.

w09-rickhouse.png (Chapter 16)
A Kentucky rickhouse: barrels ageing in a timber warehouse.

w10-japan.png (Chapter 17)
A Japanese distillery pagoda kiln roof in mountain mist.

w11-cooper.png (Chapter 12)
A cask half-raised in a cooperage: steam-bent staves in the raising hoop, steel hoops, fire and tools.

w12-bottling.png (Chapter 21)
A modern whisky bottling line.

w13-lab.png (Chapter 19)
A blender's sample room with nosing glasses.

w14-glen.png (Chapter 3)
A Highland glen with a distillery by water.