



Celebrate Scotland's whisky producing heritage in this guide to all of the distilleries operating across the country.

Discover the history of these sites across the Campbeltown, Highland, Islay, Lowland and Speyside regions, and the whiskies they produce.

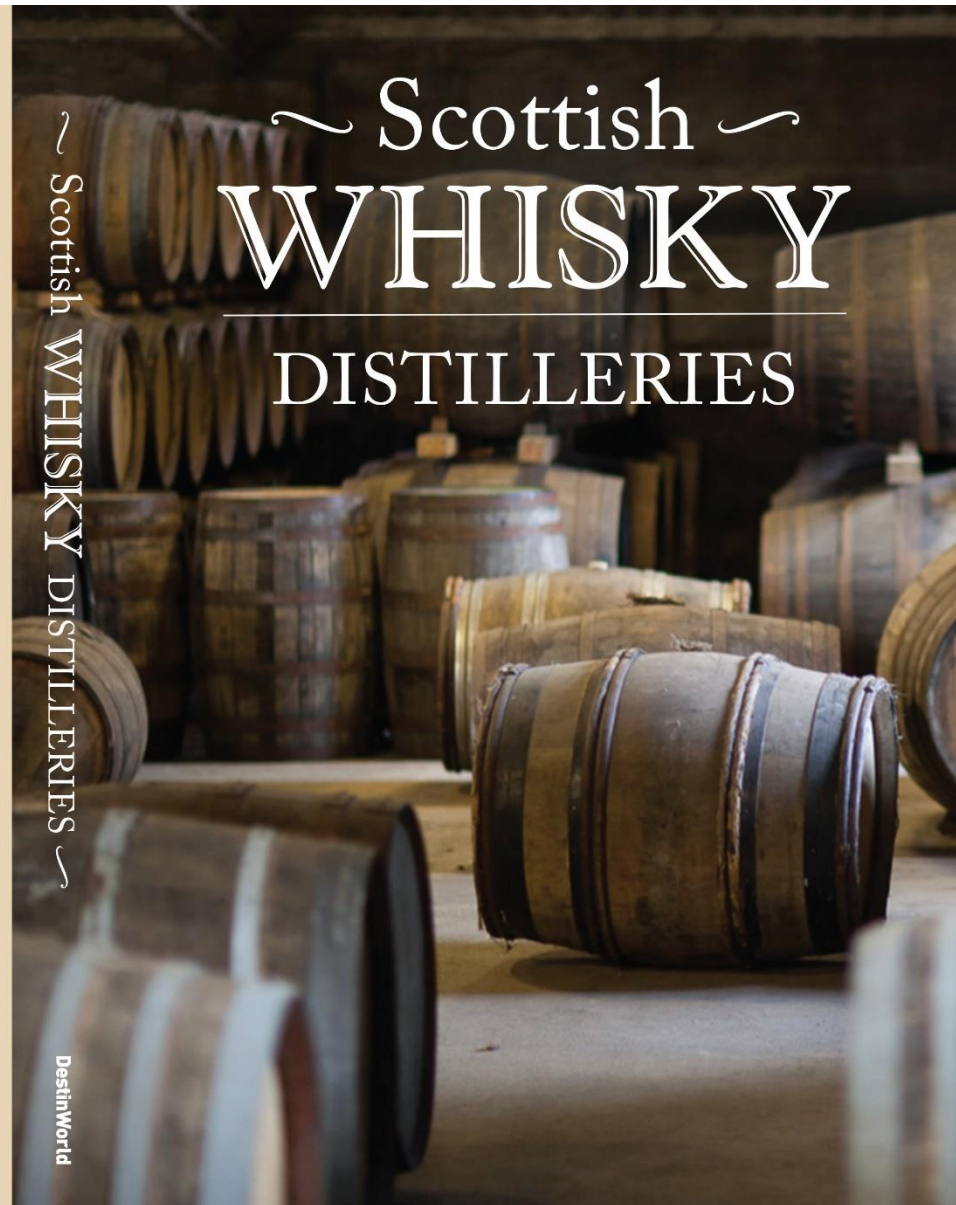
See what makes each distillery special, from its location to the unique ingredients which give its whiskies their individual taste, and of course the passionate people behind each one.

With maps and visitor information, plan your Scottish distillery tour today.



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 publishing



Scottish WHISKY DISTILLERIES

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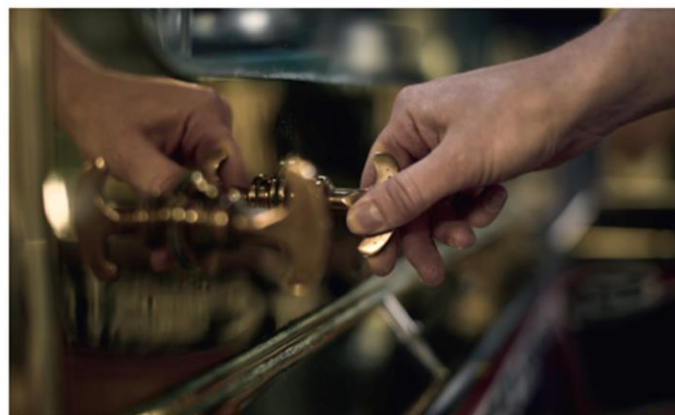
## The Process

**BEGINNING WITH THE** barley as a basic ingredient, it is first of all malted. This involves moistening the barley with water so that germination begins and an enzyme is given out which converts its starches into sugar. It is then left to dry on large floors, which halts the germination process. Some distilleries malt their own barley, often burning peat during the drying process to add a smoky flavour. Others import barley that has already been imported.

The next stage sees the malted barley added to a large mash tun and mixed with hot water. This serves the purpose of extracting the sugars, and creates a porridge-like substance known as wort or mash. The sugary water mixture by product is then extracted from the grist and added to a washback where yeast is mixed in and heated up.

This process, known as fermentation, can take at least two days, if not three or four, depending on the distillery's process and ingredients. The result is a mildly alcoholic liquid known as wash, which is then distilled.

Distillation is completed in large conical vats known as stills, and these vary from one distillery to the next in terms of size and shape. You will often see the stills on a tour of a distillery. First, the wash is boiled, leaving the alcohol to vaporize off first and flow into the shell-and-tube condenser, where it is cooled and condensed back into a liquid known as spirit. Sometimes distilleries use a worm tub instead of the condenser, which creates a heavier spirit. Before the next stage, in Scotch whisky production the spirit is usually distilled a second time in a spirit still.

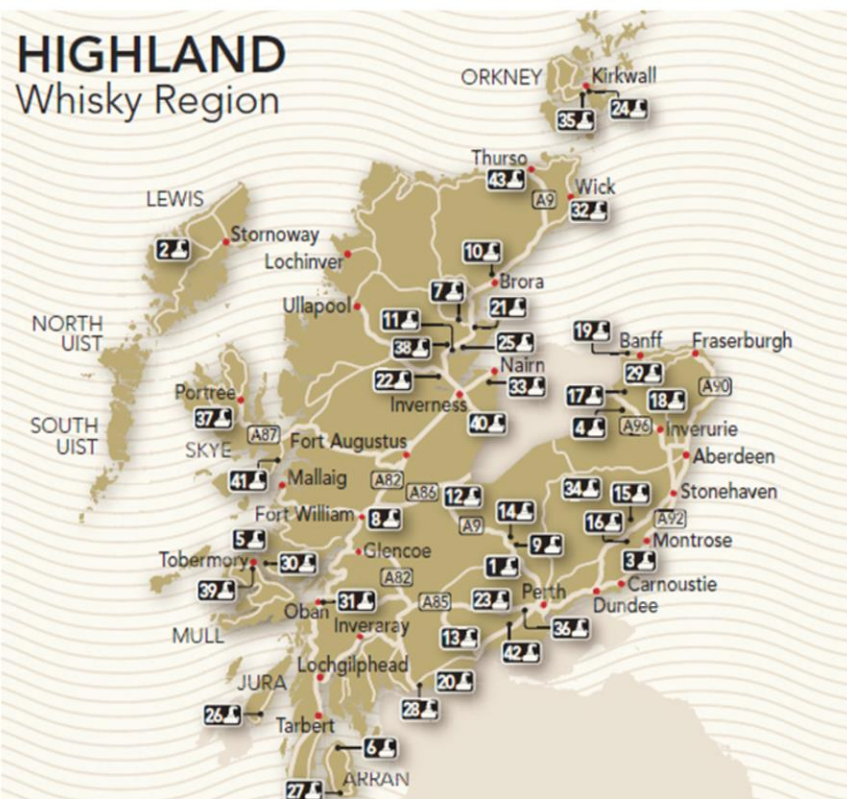


The usable part of the spirit from the second distillation is sent to the spirit safe, where distillers can sample it to get a flavour of how the batch (or indeed a brand new whisky) might ultimately taste.

The rest is sent to fill barrels, where the maturation process takes place. Distilleries place a lot of importance on the barrels they use. These are usually American oak barrels, which have been used in bourbon production, or sherry casks used in the production of Spanish sherry. Scotch whisky is always filled into these used casks as the flavours are important to the final taste of the product.



# HIGHLAND Whisky Region



- |                  |                     |                     |
|------------------|---------------------|---------------------|
| 1. ABERFELDY     | 16. GLENCADAM       | 31. OBAN            |
| 2. ABHAINN DEARG | 17. GLENDONACH, THE | 32. PULTENEY        |
| 3. ARBIKIE       | 18. GLEN GARIOCH    | 33. ROYAL BRACKLA   |
| 4. ARDMORE       | 19. GLENGASSAUGH    | 34. ROYAL LOCHNAGAR |
| 5. ARDNAMURCHAN  | 20. GLENGOYNE       | 35. SCAPA           |
| 6. ISLE OF ARRAN | 21. GLENMORANGIE    | 36. STRATHEARN      |
| 7. BALBLAIR      | 22. GLEN ORD        | 37. TALISKER        |
| 8. BEN NEVIS     | 23. GLENTURRET      | 38. TEANINICH       |
| 9. BLAIR ATHOL   | 24. HIGHLAND PARK   | 39. TOBERMORY       |
| 10. CLYNELISH    | 25. INVERGORDON     | 40. TOMATIN         |
| 11. DALMORE      | 26. ISLE OF JURA    | 41. TORABHAIG       |
| 12. DALWHINNIE   | 27. LAGG            | 42. TULLIBARDINE    |
| 13. DEANSTON     | 28. LOCH LOMOND     | 43. WOLFBURN        |
| 14. EDRADOUR     | 29. MACDUFF         |                     |
| 15. FETTERCAIRN  | 30. NCN'EAN         |                     |

## Aberfeldy



Lovers of whisky may usually turn their noses up at blends, preferring the quality and flavours of a well-crafted single malt. Yet as you read through this book you will no doubt notice just how many distilleries today make a living off providing malt for blends, and have always done so. In fact, blends are often the most commercial types of whisky, selling more bottles than any other, and are the entry point for new whisky fans the world over. True whisky connoisseurs will, therefore, appreciate the value of blends and the important part they play in Scottish whisky production. And so we arrive at Aberfeldy. A Highland distillery in Perthshire, it is home to one of the biggest

**Address:** Aberfeldy, Perthshire PH15 2EB  
**Phone:** +44 1887 822010  
**Web:** [www.dewarsaberfeldydistillery.com](http://www.dewarsaberfeldydistillery.com)

### Visitor Centre

Voted one of Scotland's best visitor attractions, Dewar's Aberfeldy Whisky Distillery has a large visitor centre which displays the history of whisky production (with an emphasis on blending). It also has a café, restaurant, bar and shop. A range of guided tours of the distillery are available, with tastings. Booking is advised.



Isle of Arran

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## Isle of Arran



One of the most incredible locations of all Scottish distilleries, Isle of Arran at Lochranza is also one of the more recent. It was established in 1993 on a location across the water from Robert Burns' birthplace

**Address:** Lochranza Distillery, Lochranza, Isle of Arran KA27 8JU  
**Phone:** +44 1770 830264  
**Web:** [www.arranwhisky.com](http://www.arranwhisky.com)



### Visitor Centre

Visitors are able to book in advance for tours to learn more about the distillery. Isle of Arran also has a cafe known as CASKS which sells refreshments and local produce, as well as the whiskies produced here.

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town with a growing tourist trade, and this should serve the distillery well as it grows and (literally) matures.

To date it is producing gins, vodkas, and blended whisky, with single malts on the horizon. It has installed four stills for the latter, with aged American and sherry oak barrels sourced for ageing.

#### Visitor Centre

Visitors can come and explore the highly-rated visitor centre and learn how The Borders Distillery is producing whisky (and other drinks), take a tour and buy something in the gift shop. Tours must be booked in advance.

**Address:** Commercial Rd, Hawick TD9 7AQ  
**Phone:** +44 1450 374330  
**Web:** [www.thebordersdistillery.com](http://www.thebordersdistillery.com)

## Cameronbridge

Cameronbridge was the first distillery to produce grain whisky using Robert Stein's Column method. It opened in 1824. Today it is owned by Diageo and is an important constituent for its blends. It has been much upgraded and expanded, and even produces Gordon's gin and Smirnoff vodka at the site. It's most

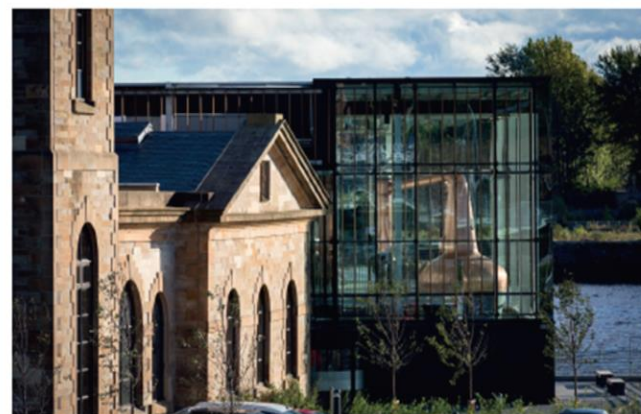
notable contribution is to David Beckham's Haig Club whisky.

#### Visitor Centre

No

**Address:** Windygates, Leven, Fife KY8 5RL  
**Phone:** +44 1333 354061

## The Clydeside Distillery



Following The Glasgow Distillery, The Clydeside Distillery opened in 2017 and is also bringing whisky production back to the heart of Glasgow after decades of absence. It is located in the old Pumphouse at the entrance to Queen's Dock and it is producing a new Clydeside Single Malt whisky, distilling by hand in this historic setting. It has 2 stills at present and sources water from Loch Katrine.

#### Visitor Centre

The Clydeside includes a café, shop and you can book onto a range of tours to discover the distillery and its working areas, as well as enjoying a tasting session.

**Address:** 100 Stobcross Road, Glasgow G3 8QQ  
**Phone:** +44 141 212 1401  
**Web:** [www.theclydeside.com](http://www.theclydeside.com)



twice-distilling, and the use of sherry casks from Spain, rather than the more usual bourbon barrels. There are six stills (though not all are in constant use), and the distillery has a capacity of 3.5 million litres of spirit per year. Almost 70,000 casks are to be found maturing in the many warehouses on site. A visitor centre was opened in 1973, long before whisky tourism became big business. Tours offer visitors an insight into this family-run business and the whiskies it produces, from the standard range, to the famous Glenfarclas 105 Cask Strength, and the Family Casks range.



## Glenfiddich



The best known of all the whisky brands and distillers in Scotland, Glenfiddich is a tale of determination and self reliance which has resulted in it becoming one of the world's largest producers.

Glenfiddich was the best-selling single malt whisky for over 40 years until recently overtaken by The Glenlivet. Yet with such large numbers of sales still today, second place is nothing to be sniffed at. This distillery, in the Speyside whisky hotbed that is Dufftown, was also the first to open a visitor attraction in 1969 – something that wouldn't be possible without a wide following for its products.

Started in 1886 by William Grant, a former soldier and employee at Mortlach Distillery, Glenfiddich began life with old stills and buildings put up by hand. But it worked, by producing spirit that was sold to blenders and a developing a determination to make his business successful.

Glenfiddich began producing its single malts in the 1960s, which was a smart move as it began the public's love affair with the drink and helped it become the best-selling bottle. It was so popular that the distillery was expanded in 1974 to 31 stills. Today it has 32, and produces up to 14 million litres per annum.

**Address:** Dufftown, Keith  
AB55 4DH  
**Phone:** +44 1340 820373  
**Web:**  
[www.glenfiddich.com](http://www.glenfiddich.com)

### Visitor Centre

Visitors to the distillery's revamped £2 million visitor centre will learn of its history, production methods, and products. Enjoy tutored tasting sessions, meals, afternoon teas, gifts and of course guided tours. It makes a great day out.



## The Macallan



The Macallan is one of the great names in Scottish single malt whisky distilling. Founded in 1824 on Easter Elchies Farm, it had a fairly quiet start and plodded along until being sold in 1892 to Roderick Kemp. His family and descendants continued running the distillery until expansion and modernisation in the 1960s and a greater focus on single malts over blends began to shape the output. The Macallan's famous 10-year-old (one of the best-selling single malts) was released in 1978. The distillery was sold to Highland Distillers in 1996, and it is here that The Macallan story really began to take off.

While its choice of finishing in sherry casks was considered unusual and part of the popular flavour of The Macallan, it began using bourbon casks in the early 2000s which resulted in a change in the flavour and range on offer.

The Macallan is now a large producer, with 12 wash and 24 spirit stills, 21 washbacks, and a

**Address:** Easter Elchies, Aberlour AB38 9RX  
**Phone:** +44 1340 318000  
**Web:** [www.themacallan.com](http://www.themacallan.com)

### Visitor Centre

A visitor centre was opened in 2001, and in 2014 this was superseded by the present facility which is one of the best among Scotland's whisky distilleries. With stunning architecture and interiors, guests are taken on an immersive experience through the proud heritage of The Macallan. Various tours are on offer of different lengths and prices, and should be booked in advance. The Elchies Brasserie offers a gastronomic experience paired with The Macallan Distil Your World London Single Cask. You can also relax in The Macallan Bar. The Distillery Boutique sells produce, limited edition bottles and other gift items.

## Scottish Whisky Distilleries



capacity for 15 million litres per annum. Water is sourced from boreholes on the estate.

Today's new distillery and visitor centre buildings are designed to produce electricity through a new biomass generator, which also feeds local houses. The wonderful location of the distillery in the Elchies Forest, with its wonderful views, is well worth discovering.



