THE ART OF BLENDING AND COMPOUNDING LIQUORS.

INTRODUCTORY REMARKS.

It is a generally well understood fact that the thirsty individual who takes his glass of whiskey at any of even the first-class public bars, saloons or parlors, does not know what he drinks. The proprietor who purchases, and the bartender who dispenses, the liquors are probably also in the same blissful state of ignorance. Very few persons, outside of those engaged in the wholesale trade, understand what is meant by blending and compounding liquors.

The moment a barrel of liquor leaves the
bonded warehouse, the first thing thought of, and done, is to reduce its cost. The blender knows how to make the bonded liquor produce a profit of 25 to 50 per cent. on the amount he paid for it, and frequently a great deal more.

For the changes made by these cheapening processes neither the saloon-keeper nor his bartender is responsible; they can only offer for sale what they are able to purchase. The purchaser accepts the liquors he buys for what they are represented to be.

The profits derived from this system of blending and mixing must be very great, judging from the large commissions that a rectifier is able to allow his agents for the sale of his products, amounting, sometimes, to $20 and $30 per barrel, and even more.

The object of this work is to give the dispenser of liquors thorough and practical information, by which he will be enabled to
compound and blend liquors for his own purposes, and thus secure the additional profit, and at the same time produce as good an article as the market affords—if not better.

The methods and receipts contained in this work are all given by one who has been in that line of business for many years, and they are substantially those in general use at the present time. The cost value noted for each product is closely reckoned, and will only vary in a trifling degree as the market price of the ingredients employed may fluctuate from time to time; but, as the trade rates for the manufactured liquors generally follow those fluctuations, the margin of profit will remain about the same.

If, however, there should be no desire on the part of the purchaser to manufacture liquors for himself, still the information afforded here will enable him to judge of the actual value of the goods he buys.
WHISKEY IN BOND.

All whiskeys, as soon as they are distilled, are placed under the supervision of a Government Agent in a bonded warehouse, where they are permitted to remain stored for three years, if not sooner withdrawn.

Before a permit is granted for the withdrawal of whiskey from bond, a tax of 90 cents per gallon of proof spirits must be paid.

As the bonded warehouses are usually heated so as to keep a uniform temperature of about 90°F Fahrenheit all the year round, there is a natural shrinkage in the contents of every barrel.

This shrinkage or outage is mainly due to the absorption and evaporation of the water, and the consequence is an increase in the proof-strength of what remains in the barrel, so that at the end of three years, although the outage may be considerable, the actual
WHISKEY IN BOND.

loss of proof-liquor will not be much, if any, over four gallons.

The following table will show the probable outage of each barrel, with the increase of proof, and Government allowance at the expiration of each six months; it being understood that a barrel when placed in bond contains 45 gallons.

TABLE OF OUTAGE, GOVERNMENT ALLOWANCE, AND GAIN IN PROOF, EACH SIX MONTHS.

<table>
<thead>
<tr>
<th>Months</th>
<th>Government Allowance</th>
<th>Proof Gallons</th>
<th>Wine Gallons</th>
<th>Above Proof</th>
</tr>
</thead>
<tbody>
<tr>
<td>6</td>
<td>$1\frac{1}{2}$</td>
<td>43$\frac{1}{2}$</td>
<td>44</td>
<td>3 per ct.</td>
</tr>
<tr>
<td>12</td>
<td>3</td>
<td>42</td>
<td>43$\frac{1}{2}$</td>
<td>5 do.</td>
</tr>
<tr>
<td>18</td>
<td>4$\frac{1}{2}$</td>
<td>42</td>
<td>43</td>
<td>5 do.</td>
</tr>
<tr>
<td>24</td>
<td>5$\frac{1}{2}$</td>
<td>41</td>
<td>42$\frac{1}{2}$</td>
<td>7 do.</td>
</tr>
<tr>
<td>30</td>
<td>6$\frac{1}{2}$</td>
<td>39</td>
<td>42</td>
<td>9 do.</td>
</tr>
<tr>
<td>36</td>
<td>7$\frac{1}{2}$</td>
<td>38</td>
<td>41</td>
<td>12 do.</td>
</tr>
</tbody>
</table>

There will be usually during three years a shrinkage of 10 to 12 gallons in the contents of each barrel, and the increase in the
percentage of proof of the remaining contents will be from 16 to 18 per cent.

The tax for withdrawal at the end of three years is computed in the following manner:

When a barrel of whiskey is placed in bond it contains full 45 gallons usually rather over; it would probably, in three years, suffer a shrinkage of 12 gallons; at the same time the increase of proof of the remainder would be about 16 per cent.

Original bulk, say $45\frac{1}{2}$ gallons.

Shrinkage, 12 do.

\[
\begin{align*}
\text{Leaving, } & 33\frac{1}{2} \text{ Wine gallons.} \\
16\% \text{ of } & 33\frac{1}{2} = 5\frac{1}{3} \text{ Increase of proof.} \\
38\frac{5}{6} \text{ Gallons, proof.}
\end{align*}
\]

On which the tax of 90 cents per gallon has to be paid, amounting to $34.95. In some cases it may be that the shrinkage is greater than 12 gallons, but in that case the holder suffers, not the government.
In order to give a general idea of the value of the whiskeys produced by the leading distilleries, the following table is offered, showing the average market price per gallon when newly distilled and first placed in bond, and subject to a tax of 90 cents per gallon when withdrawn:

<table>
<thead>
<tr>
<th>Rye Whiskey</th>
<th>Price in Bond</th>
<th>Distillery</th>
<th>Office</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hainesville</td>
<td>.65</td>
<td>West Virginia</td>
<td>Philadelphia, Pa.</td>
</tr>
<tr>
<td>Gibson</td>
<td>.70</td>
<td>Philadelphia, do</td>
<td>do</td>
</tr>
<tr>
<td>Dougherty</td>
<td>.65</td>
<td>do</td>
<td>do</td>
</tr>
<tr>
<td>Guggenheimer</td>
<td>.70</td>
<td>Pittsburgh, do</td>
<td>Pittsburgh, Pa.</td>
</tr>
<tr>
<td>Monticello</td>
<td>.60</td>
<td>Baltimore, do</td>
<td>Baltimore, Md.</td>
</tr>
<tr>
<td>Mount Vernon</td>
<td>.65</td>
<td>West Virginia</td>
<td>Philadelphia, Pa.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Bourbon Whiskey</th>
<th>Price in Bond</th>
<th>Distillery</th>
<th>Office</th>
</tr>
</thead>
<tbody>
<tr>
<td>McBrayer</td>
<td>.65</td>
<td>Frankfort, Ky., do</td>
<td>Louisville, Ky.</td>
</tr>
<tr>
<td>Monarch</td>
<td>.60</td>
<td>Owensboro, Ky., do</td>
<td>Owensboro, Ky.</td>
</tr>
<tr>
<td>Atterton</td>
<td>.50</td>
<td>Cynthiana, Ky., do</td>
<td>Louisville, Ky.</td>
</tr>
<tr>
<td>Mallingly</td>
<td>.40</td>
<td>Louisville, Ky., do</td>
<td>do</td>
</tr>
<tr>
<td>Crow</td>
<td>.40</td>
<td>Lexington, Ky., do</td>
<td>do</td>
</tr>
</tbody>
</table>

It is only in the very highest grades of blended liquors that the products of the foregoing distilleries are used in any large proportion. The lower grades are made up more or less with spirits, which cost from $1.10 to $1.25 per gallon, tax paid, and this
is where the compounder's profit begins. It will be shown, further on, how these spirits may be employed to produce the different grades of liquors at the prices required.

FRUIT JUICES AND FLAVORINGS.

All newly-distilled liquors and spirits have a rough and pungent taste, which must be remedied before they can be used as beverages. This is done by fruit-juices or flavors, which are mainly alcoholic extracts of fruits or other substances, and are employed in certain proportions to counteract the raw taste of the new spirits.

These extracts may be prepared with very little difficulty, and generally better and cheaper than they can be purchased ready-made, for in these days, articles used only for the purposes of adulteration are them-
selves largely adulterated and, in the case of fruit-extracts especially, often factitious.

A very simple apparatus may be made, which will answer every purpose.

Procure a barrel of, say, 40 gallons capacity; about four inches from the bottom insert a tightly-fitting false bottom, pierced with a considerable number of holes about a quarter or a third of inch in diameter; fit a faucet in firmly, below the false bottom, and the macerating tub is ready for use.

The ingredients to be macerated should be well bruised, and placed in the barrel, and the fluid used poured on them and the whole allowed to macerate together for not less than three days, and as much longer as possible. If these general directions are properly carried out, the following extracts will be all that can be desired. Smaller quantities may be made by using smaller proportions of each ingredient.
FRUIT JUICES AND FLAVORINGS.

PRUNE JUICE.

Macerate, Prunes, 100 lbs.
Raisins, 25 "
with proof Spirits, 30 gals.
and Water, 7\(_{2}\) "

PEACH JUICE.

Macerate, Dried Peaches, 100 lbs.
Dried Apples, 25 "
with Proof Spirits, 40 gals.

ST. JOHN’S BREAD EXTRACT.

Macerate, St. John’s Bread, 100 lbs.
Dates, 25 "
with Proof Spirits, 40 gals.

RAISIN EXTRACT.

Macerate, Raisins, 200 lbs.
Liquorice Root, 4 "
with Spirits, 40 gals.
FRUIT JUICES AND FLAVORINGS.

17

TEA EXTRACT.

Macerate, Green Tea, 25 lbs.
Currants, 100 "
with Spirits, 40 gals.

The flavoring extracts just described are all used in every rectifying establishment, although the fact is surrounded with a great deal of secrecy on the part of the rectifiers. There is nothing injurious in any of these extracts, and this recommends their use above all others; they are harmless and efficient aids both to the liquors and to the pocket.

The same cannot be said of other compounds sometimes used for the same purpose in the very cheapest grades, and they should never be employed for two very efficient reasons:

First—They are poisonous in their character.
Second—Their effects on the liquor are not permanent.

Fusel Oil of Corn, compounded with Sulphuric Acid, Sulphate of Copper, Oxalic Acid, Chloroform, Acetate of Potash, Ammonia, &c., &c., cannot be considered either attractive or wholesome.

The rectifier, who conducts his business at all honestly, takes great pains to extract all the fusel oil from the liquors which pass through his hands, and it seems utterly incomprehensible why the same injurious substance should be afterwards introduced under, perhaps, a still worse form than before.

Nevertheless, they are frequently used, and the formulae for preparing these cheap flavors are given, leaving their use to the choice of those who will.