



ベロ立醸造

創業1889年 兵庫奥播州 木桶仕込み醤油



## History

Located at the foot of Mount Sengamine, where the famous spring water of the Matsui River flows, in the rural village of Taka, located in the Okubanshu region of Hyogo Prefecture, where, in 1889, Ichiju Adachi founded Adachi Shoten.

"I'm not good at creating things that are trendy, but I want to remain true to the origins and dedicate all my time and effort to create delicious soy sauce and miso."

This dedication to craftsmanship is the foundation of Adachi Jozo.

## Safe and reliable ingredients -

Farmers who grow grains are truly inspiring. The soybeans and wheat they produce may not always look perfect, but they have incredible hidden power.

At Adachi Jozo we mainly use organic soybeans and wheat.

But most important of all for us is to source our ingredients directly from farmers we know and trust. No matter how busy we are, we make sure to visit their fields and share thoughts and methods.

## Fermentation in Kioke (wooden barrels)

"Kioke are alive." This is something we always emphasize when talking about our wooden barrels. Kioke are considered best suited for fermenting shoyu (soy sauce), a traditional condiment passed down through generations since ancient times.

Yeast, lactic acid bacteria, and other microorganisms essential to shoyu production find a home on the wooden surfaces of the barrels. Over the decades, the environment created by these microorganisms becomes the source of Adachi Jozo's signature aroma.

## The beauty of a rural village, Taka -

Water from the Matsui Spring provides the essential natural environment for Adachi Jozo's shoyu and miso production. The brewery is surrounded by rice fields where Yamada Nishiki sake rice is grown, and if you travel a little further inland you can see terraced rice fields. Crystal-clear water and clean air are the best ingredients, and the distinct seasons, with hot summers and cold winters, make this the perfect environment for natural fermentation.

## World-renowned food safety -

Offering shoyu and miso that are not only tasty but also safe and reliable is our priority.

Adachi Jozo has achieved FSSC 22000 global food safety certification and we are committed to continuously improving the quality of our kioke-made organic shoyu, while striving to share it with the rest of the world.

## DO YOU KNOW (木桶) KIOKE ?

Today, kioke-brewed shoyu accounts for less than 1% of total soy sauce production. While brewing in plastic containers and stainless steel tanks has become the norm, wooden barrels bring character and romance to the brewing process.



### Reflexions on kioke

The traditional Yoshino cedar kioke at Adachi Jozo have been in use for over 100 years. If a barrel is left empty for too long without brewing, the hoops that hold it together will loosen and come off, rendering it unusable. It is only because our predecessors and their predecessors before them brewed shoyu year after year without a break that these wooden barrels still exist today. Brewing continuously for over 100 years, especially in times when facilities were much more limited, is no small feat.

I am always grateful to my predecessors who passed on these barrels to me. Whenever I come into the moromi storehouse, the barrels speak to me: "Just as your predecessors did in the past, continue to use us for a long time, and make sure you pass us on to the next generation." Perhaps it is only by passing on these wooden barrels to the next generation that I can truly become a full-fledged brewer.

### Kioke and the artisans

We produce shoyu using traditional methods passed down through generations. The moromi must is aged in the kioke for over 18 months. Since the barrels are uncovered, we cannot control the temperature; we let nature take its course. The moromi remains in the barrels in the warehouse until it is time to be pressed. In summer, fermentation is very intense and if you listen carefully, you can hear the moromi bubbling. In winter, it waits quietly for the return of warm weather. The master fermenter decides when it is time to press the moromi to extract the shoyu. Just like humans, each barrel has its own characteristics, which determine different degrees of ripeness. In addition, the weather and rainfall of that particular year also influence the result. The signal to begin the pressing process is a task entrusted only to an experienced craftsman who has been making shoyu for years and understands the nuances of each barrel.

### Microorganisms in the warehouse

One difference between kioke and FRP or metal tanks is that kioke are porous and smooth enough to leave a mark if you scratch them with your fingernail. Under a microscope, the surface of the wood appears covered in tiny pores, very similar to skin. This is where beneficial microorganisms such as yeasts and lactic acid bacteria nest, which give the brewery its exquisite flavor. In FRP or metal tanks, yeasts and lactic acid bacteria are present while the moromi is inside, but once the tank is washed, they disappear almost instantly. In contrast, with kioke, even after washing, these microorganisms remain. It is they who give Adachi Jozo its distinctive flavor and pass it down from generation to generation.



# Premium Shoyu

## Yui 結

“Yui (結Yui)” is soy sauce produced in wooden barrels by two brothers from a soy sauce brewing family. Our brewery has 32 wooden barrels that have been used for soy sauce making for over 100 years. Our soy sauce is aged in these barrels for a period of 12-18 months.

Each wooden barrel has its own character—the flavor and taste of the soy sauce changes depending on the season, temperature, and climate. We invite you to enjoy Yui soy sauce's different tastes and aromas each season.



The soybeans and wheat used for Yui soy sauce are grown organically by farmers in Hokkaido. The clear riverbed water of the Sugihara River is used in the brewing process, and the salt is from the Seto Inland Sea.



Why did we choose Yui (結 Yui) as our brand name? “結 (Yui)” means connection and relationship, and this is what we strive for.

It is our hope:

- to continue to work with wooden barrel craftsmen to ensure that the wooden barrel trade and culture is preserved.
- to continue to foster the relationships with organic farmers to ensure the finest produce in the brewing of Yui soy sauce for your table.

Saltiness	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Sweetness	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Umami	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>



Ingredients:  
Organic soybeans,  
organic wheat,  
salt.

## Ramen Iida Shouten uses Yui 結

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Iida Shouten da Shouten won the highest award at the TRY Ramen Award ramen contest for two consecutive years in 2017 and 2018.

In January 2018, he appeared in JonetsuTairiku "A Passionate Challenger" and is a global leader in the ramen industry.

## Ramen Tomita uses Yui 結

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Chuka Soba Tomita (中華蕎麦とみ田) is considered by many to be the number 1 ramen restaurant in Japan. Tomita has won the first prize at TRY (Tokyo Ramen of the Year) for 4 consecutive years and many Ramen tournaments. The award-winning tsukemen is incredibly delicious and words cannot do it justice.

## Yakitori Kyoto Tachibana uses Yui 結

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Tomonori Sakata, chef of the famous **Yakitori Kyoto Tachibana 燒鳥 京都橘**, turned his attention from Japanese cuisine to yakitori when he fell in love with Kyotamba chicken. Drawing inspiration from Japanese cuisine, this restaurant has been featured in the Michelin Guide for many years.

Visit our brewery!

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Come visit **Adachi Jozo**, located in a small town in Hyogo prefecture, central Japan, surrounded by nature. We'll introduce you to our wooden barrels and the policies we adhere to. You will also have the chance to taste our traditional soy sauce and miso!



Adachi Jozo

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