

Frankfort Ky

COMPLIMENTS OF
E. H. TAYLOR, JR. CO.
DISTILLERS

FRANKFORT KY.

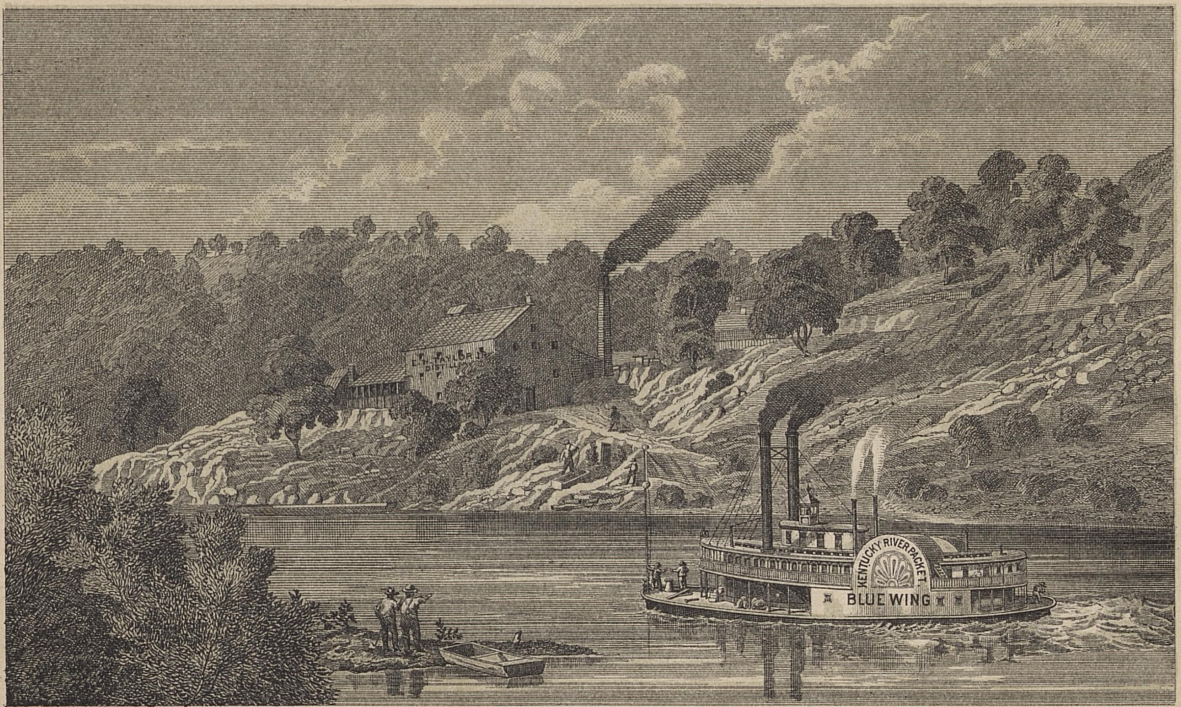
SHOBER & CARQUEVILLE LITH. CO. CHICAGO.



Fac-Simile of Cooperage and Trade Mark Brands.

9.23.63 lot purch. *(Spec Coll) Gooder Bargain Ctr

PLATE I.



ORIGINAL O.F.C. DISTILLERY IN 1869.

11

THE O. F. C. DISTILLERY.

THE commanding excellence of the celebrated O. F. C. Whiskey, and the leading features of its manufacture, have become household words in the American trade.

Established sixteen years ago, its reputation has grown with each successive season.

It is to familiarize the general public, and especially the whiskey trade, with the details of the manufacture of O. F. C. Whiskey, the locality of its production, and the processes that distinguish it from other less valuable goods, that this descriptive article is written.

The cut on the preceding page represents the original O. F. C. distillery, a stone and frame structure, established in 1869, on the spot where now stands the present handsome O. F. C. distillery. The former building was crude in appointments, unpretentious in appearance, and simply represented the then knowledge of the then modes of whiskey manufacture; but in the product was at once recognized the elements from which, with increased knowledge, continuous experiment, and applied skill has emerged the now famous O. F. C. Whiskey. The original building was torn down in 1873, to be replaced by the second O. F. C. distillery.

The second O. F. C. distillery is represented faithfully in the accompanying illustration. (Plate 2.) It was erected shortly after the destruction of the original structure, and aside from the lack of the more commodious and better adapted features of the present distillery, was, without doubt, the handsomest and best structure for the purposes to be then found anywhere in the country.

DESCRIPTION
OF
THE O. F. C., CARLISLE, AND J. S. TAYLOR
DISTILLERIES,

AND PROCESS OF WHISKEY MANUFACTURE APPLIED THEREIN.

THE MODEL DISTILLERY PLANT OF THE WORLD.

THE DETAIL OF WHISKEY PRODUCTION AT THE

O. F. C. DISTILLERY

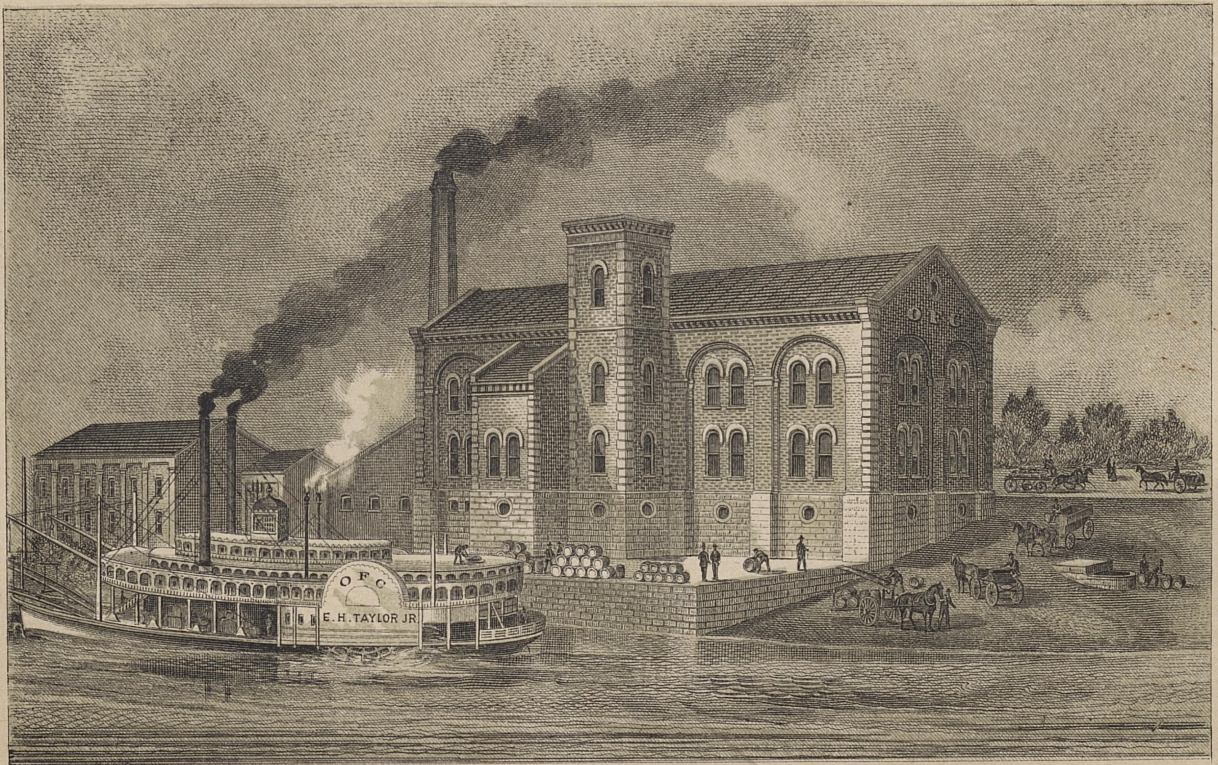
EXPLAINED FULLY AND ACCURATELY, AND HANDSOMELY ILLUSTRATED WITH ENGRAVINGS FROM DRAWINGS AND PHOTOGRAPHS TAKEN ON THE SPOT.

CAPITAL, \$500,000. SURPLUS, \$100,000.

E. H. TAYLOR, JR., CO., PROPRIETORS.

FRANKFORT, KY.

PLATE 2.



O.F.C. DISTILLERY DESTROYED BY FIRE IN
JUNE 1882.

The second O. F. C. distillery was destroyed by fire in the summer of 1882, and immediately the process of its restoration was begun, so that to-day it stands without a rival in the beauty of its design, the completeness of its appointments, and the adaptedness of every feature for the manufacture of a perfect whiskey.

Not a cent of expenditure has been withheld that could add a single detail necessary to the completeness of the product, whether relating to the distinguishing properties of the whiskey, or the subsequent storage for speedy maturity.

The experience of Mr. Taylor in the building of distilleries, and in the manufacture of fine whiskeys, has been especially availed of in replacing the old house with the present splendid distillery.

Whilst the process of manufacture, which has given so deserved a reputation to O. F. C. Whiskey, is continued, it is accompanied with many advantages, hereafter described, that have never heretofore been availed of, nor attempted. These will commend themselves to any ordinarily intelligent mind as an improvement (not an innovation) that is self-evident and greatly beneficial.

The O. F. C. distillery is situated in Franklin county, Kentucky, about one mile from Frankfort, the state capital—a region whose waters, climate, and special facilities have long since caused it to be known as the almost exclusive locality for the manufacture of pure, old-style, sour-mash whiskey. (See Plate 3—Distillery.)

The O. F. C. distillery is a handsome structure of brick, with stone basement, with apartments or sections specially allotted to the use of each branch of manufacture. Long experience aided in perfecting a building in which harmony in general product is aided by completeness in each detail. The edifice is 212 feet long by 85 feet wide, with two stories and tower over basement, and sectionized into fermenting room, mash room, meal and mill

PLATE 3.



O.F.C. DISTILLERY.

Shepley & Carquaine Litho. Chicago.

rooms, engine room, distilling room, and condensing room. Every feature (an unusual thing in distilleries) is included under one roof, from reception of grain and water to finished product. Permanence and solidity of construction will be noted throughout in the materials of stone, brick, iron, and copper that unite in the building.

THE SPRING.

The cut on the opposite page shows the reservoir spring, whose crystal waters issue in large volume from the solid limestone cliffs of the Kentucky River, and are immediately utilized in the manufacture of the O. F. C. Whiskey. It was the special properties favorable for producing a fine whiskey possessed by this spring that caused the selection of the locality as the site of the distillery. Distinguished chemists, including Dr. Peter, the former well known assayist of the Kentucky Geological Survey, have made analyses of its waters, and indorsed its fine properties in the particular named.

Prof. Barnum, chemist, of Louisville, Kentucky, whose analysis has been published, says :

“The water is of wonderful purity, and of peculiar adaptedness for the manufacture of whiskey.”

And again :

“Your water contains (what I never saw before) very appreciable quantities of phosphate of lime, which would have the same effect in promoting the growth of the yeast plant that a dressing of bone phosphate would on a wheat field. Of course, the more vigorous the growth, the better and more perfect the product.”

The temperature of this spring water is very uniform the entire year, never exceeding 60° Fahrenheit, and has properties closely identical with the celebrated Burton spring water of England.



SPRING SUPPLYING WATER TO O.F.C. DISTILLERY

THE MILL ROOM.

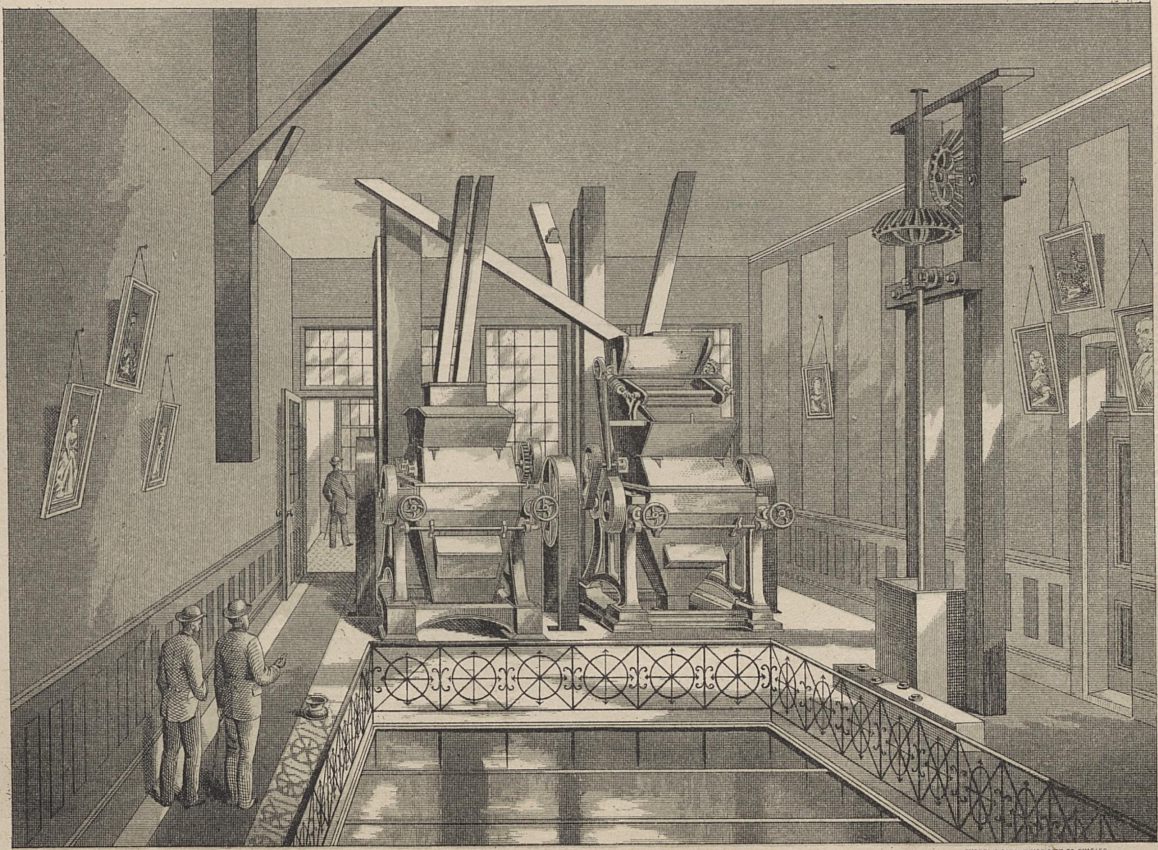
Besides using a richer and more expensive formula in the way of grain than do any other sour-mash distillers whatever, there is also used, instead of the stone mills employed by the latter, the *new corrugated* roll, which has, of late, made such vast improvement in the quality of flour. The principal objection to the old mills rested in the fact that the grain was *mashed* or pulverized, the grinding uneven, and the life of the product often destroyed by heating. The corrugated mill *breaks* the grain into a uniform granular mass, most suitable for the production of the starch properties and the action of the spirit-producing ferments. Two separate sets of rolls are used — a single-corrugated and a double-corrugated roll—the grain passing through both mills preparatory to the mash. (See Plate 5.)

The resulting meal of corn, and flour of rye and barley malt, is of a quality especially adapted to the mash, and superior far to that resulting from any other process.

The farmer does not expect a good yield from imperfect and rotten seed; nor the manufacturer a fine fabric from defective materials; nor the miller a wholesome flour from bad wheat — so, a fine whiskey, fine in body and flavor, cannot be evolved by any known process from either rotten, or sour, or unripe, or unclean grain.

Cleanliness, soundness, and maturity being made especial features in the selection of grain, the alcoholic product is found richer and riper in all desired qualities.

PLATE 5.



MILL ROOM AT O.F.C. DISTILLERY.

ENGRAVED BY CARQUEVILLE LITH. CO. CHICAGO.

THE O. F. C. MASH FLOOR.

The illustration (see Plate 6) shows the mash floor and employes engaged in the daily process of mashing. The floor is of two-inch oak, water-sealed, and covers a space of 10,000 square feet. Patent globe ventilators in the roof above afford easy escape for the steam vapors. Iron pipes and rubber hose convey hot and cold water, and copper pipes convey strained slop to such points of the room where needed. Meal is received direct from the hoppers in the room above, after being weighed in allotted proportions for each mash.

The mashing is conducted, as heretofore, by hand, in small tubs of a little more than one bushel capacity each, but the improved meal and flour gives to the mash an added excellence which the most superficial examination recognizes.

The strained sour spent beer used in mashing is obtained by a patented process, whereby the dead particles of meal are separated and cast off, and the rich, creamy liquid, full of yeasting power, is reserved for use. This liquid, or improved spent beer, is conveyed by copper pipe to the "heater" shown in the engraving, where it is heated to the temperature required for cooking the mash.

The mash completed, remains twenty-four hours on the mash floor in the small tubs before it is put to fermentation — the rye and barley malt being added at the juncture most suitable for developing the spirit properties.

The mash coolers, located between the mash floor and the fermenting room, contain numerous copper coils for conveyance of cold water, whereby the mash is cooled to a uniform temperature essential to perfect fermentation. This is accomplished under the ninety-six hour period, the process being spontaneous and self-continuous, under the accumulated aggregation of yeast spores, collected and contained in the strained spent beer used for mashing and for setting the vats.

PLATE E.



MASH FLOOR OF O.F.C. DISTILLERY

Wm. & J. G. & Co. Lith. Philad.

THE FERMENTING ROOM.

The fermenting room of the O. F. C. distillery is believed to be the handsomest and best in America.

In the construction of the fermenting room special attention was given to the attainment of cleanliness, light, and ventilation. In most distilleries, where the fermenters are not exposed on outside of buildings, the beer is fermented in wooden vessels, placed on wooden or dirt floors, and the walls of such vessels, as well as the floors, become saturated with acid from the daily washings. Bad smells predominate. Filth reigns beneath the working floor or platform.

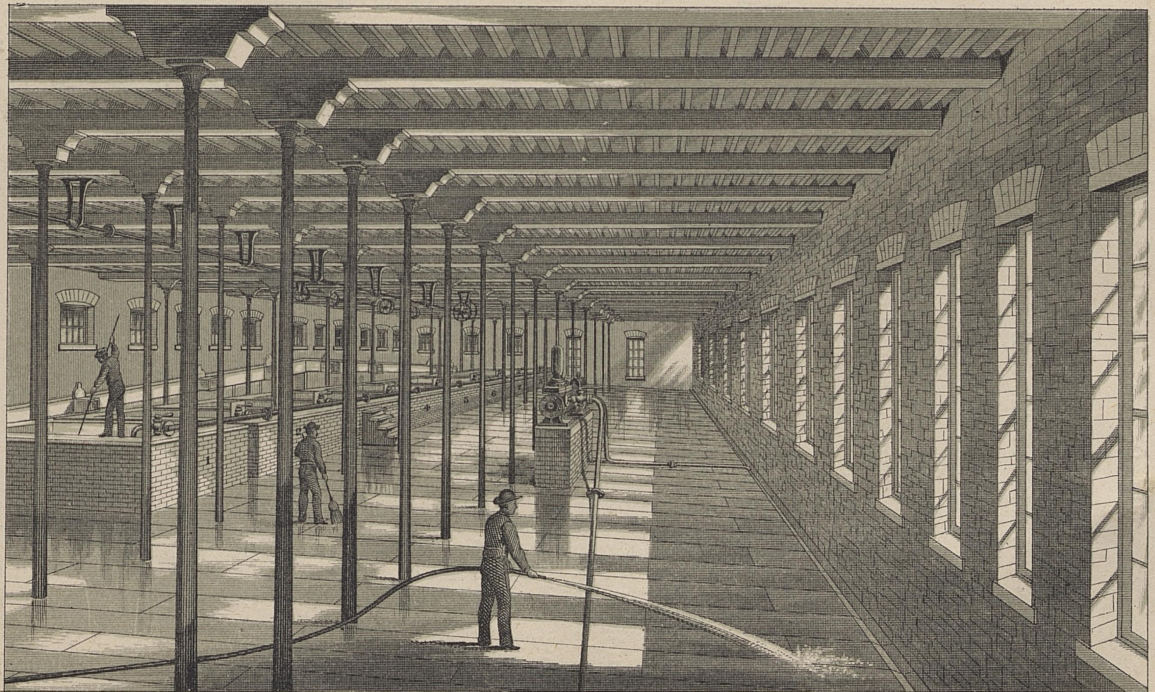
To remedy this objectionable condition the walls of the O. F. C. fermenting room are constructed of rough ashler from limestone quarries — the floor is grouted in best English cement, beveled to side troughing — and a fifteen-foot ceiling, supported by iron columns, with numerous windows, affords ample light and ventilation. The vats, eight in number, are constructed of brick, laid in English cement — the base six feet below the level of the floor, and the tops eleven feet below the ceiling. They are first lined with first quality of Portland cement, and this again lined with the *best sheet copper*, manufactured especially for the purpose.

There is no place for sourness, or decomposed acids, or disagreeable smells. Everything is sweet and clean. The vats, after use, are bright as a mirror in their polished surfaces.

After the beer has been permitted its proper stage of fermentation under the ninety-six-hour plan, it is drawn from the vats by a powerful pump, through copper suction pipes, and lifted directly into the beer stills without the intervention of the unclean beer receiver in use in nearly all distilleries.

There is no process of butter making in which greater care is exercised in every detail than in this O. F. C. process of fermentation.

PLATE 7.



FERMENTING ROOM AT O.F.C. DISTILLERY.

ROBERT A. CARROLL & CO. CHICAGO.

THE O. F. C. STILL ROOM.

The elimination of the alcohol from the fermented beer is accomplished by the process known as singling. (See Plate 9—page 21.)

The beer, under the methods of most distillers, is first heated in wooden tubs by vapor pipe from the stills. These tubs become sour and filthy, and even when proper attention is given, require frequent cleansing.

This firm has dispensed with these heating tubs, and uses a clean copper vessel of its own patent, air-tight, and of peculiar interior construction, exactly adapted to a uniform heating of the beer en route to the still. No sourness nor spoiled liquid can impregnate this vessel, and there is no loss of spirit vapors. The beer is pumped direct from the fermenting vats into the heater, whence it is conveyed to the *copper* stills (the great majority of distillers use ordinary *wooden* stills for boiling beer), and there boiled gently for the elimination of the better spirit, which is conveyed in shape of vapor to the improved condensers.

In architectural design, the still room is especially noteworthy. It is a spacious apartment, 43×38 feet, with ceiling 45 feet high, and, with condensing room attached, contains in complete and compact shape all the machinery essential to absolute distillation. This machinery itself, in solidity and durability of construction, in adaptation to ends to be attained, and in handsome finish, is unsurpassed.

The massive engine that furnishes the motive power for the complex, yet complete, system of this model distillery, is a fine specimen of mechanical skill and ingenuity.

DESCRIPTION OF PLATE 8.

The engraving on the next page gives a bird's-eye view of the O. F. C. and CARLISLE DISTILLERY premises and surroundings, looking southward.

On the right is the Kentucky River, with Lock No. 4, and the city of Frankfort in the distance, reposing in the valley of the Kentucky.

The distillery buildings proper lie parallel with the river ; the warehouses are opposite, with a broad avenue between. In construction and detached form they secure immunity from fire. The surface drainage is perfect.

The buildings and appurtenances occupy a plot of about twenty acres that is well set in grass, with macadamized roadways and dry sidewalks.

No view on paper will give any adequately correct idea of this splendid property and its picturesque and beautiful environments. In adaptation to uses, and in manufacturing capacity it is, of all distilleries, unquestionably the most costly in the world.



GENERAL VIEW OF O.F.C. & CARLISLE DISTILLERIES WAREHOUSES & GROUNDS.

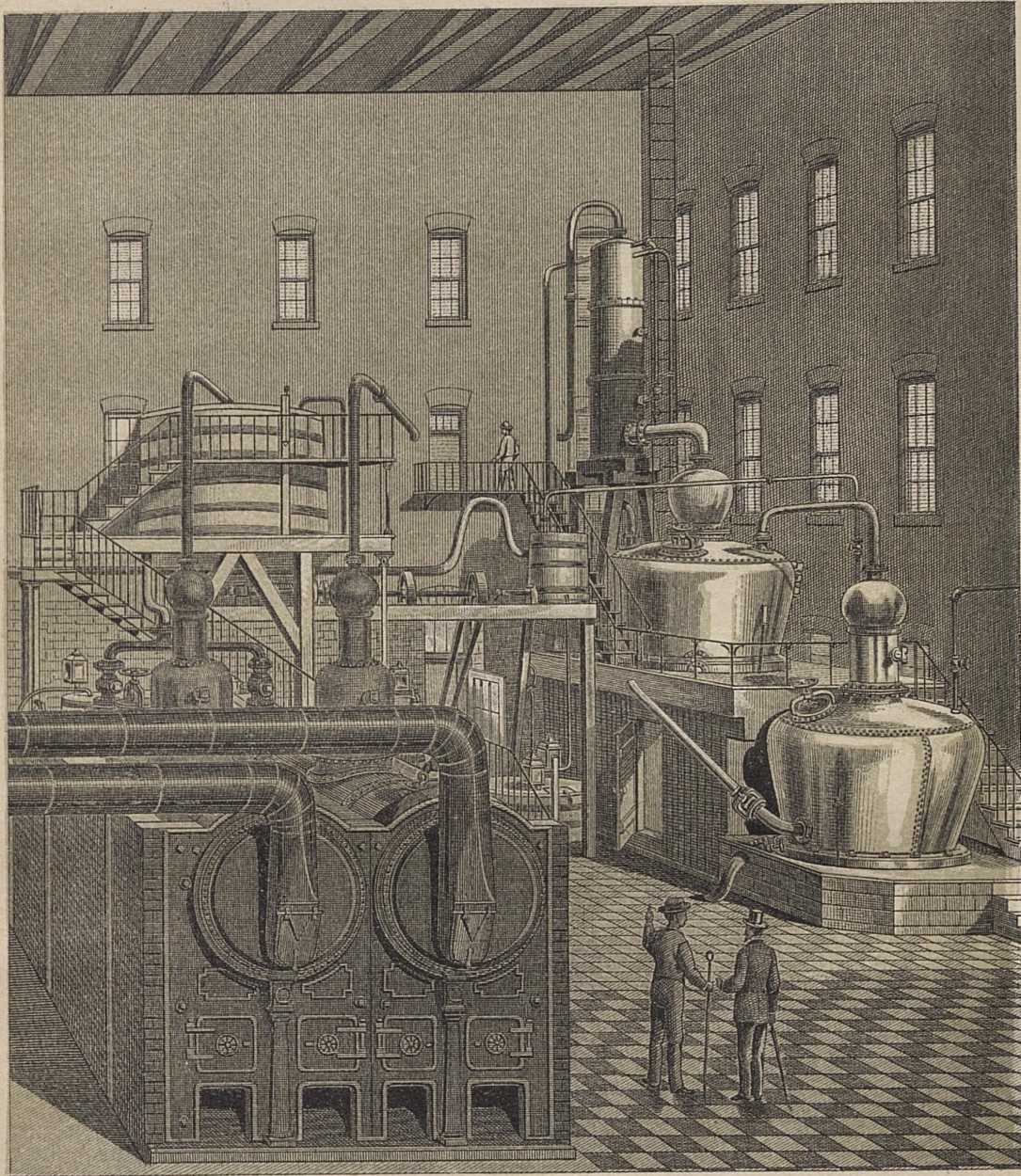
A GEOLOGICAL FACT.

The state of Kentucky has recently published an official Geological Map, authenticated by complete surveys, and showing the various strata that outcrop upon the surface and form the soil bed.

This map shows that in the small section of the state made world famous by its fine sour-mash whiskeys, the rare bird's-eye limestone of the lowest stratum of the Lower Silurian formation alone outcrops. This small section, with the exception of a small isolated strip in Powell's Valley in southwest Virginia and east Tennessee, is solitary in this one remarkable geological feature in the whole West.

The O. F. C. and other brands of the E. H. TAYLOR, JR., Co. are produced upon the depressed apex of this stratum, thus securing the best limestone drainage it can possibly afford. The result in fine whiskey is no doubt largely due to the water that, percolating through the limestone, becomes impregnated with its properties, and imparts them to the spirit during the process of manufacture.

Opinions and assertions are debatable—a geological fact, stereotyped in and reflected from the earth's crystallized strata, is as solid and immovable as the everlasting hills.



SINGLING AND DOUBLING ROOM OF
O.F.C. DISTILLERY.

THE CONDENSERS.

The vapor from the beer is converted by most distillers through a worm submerged in the water of a wooden tub. The O. F. C. method is to use cylindrical copper columns, containing an interior cylindrical vapor chamber, with close converging walls, on both sides of which cold water is constantly passing, the contact condensing the vapor, and precipitating a spirit shower that is gradually led by copper pipes to the receiving tub. (See Plate 10.)

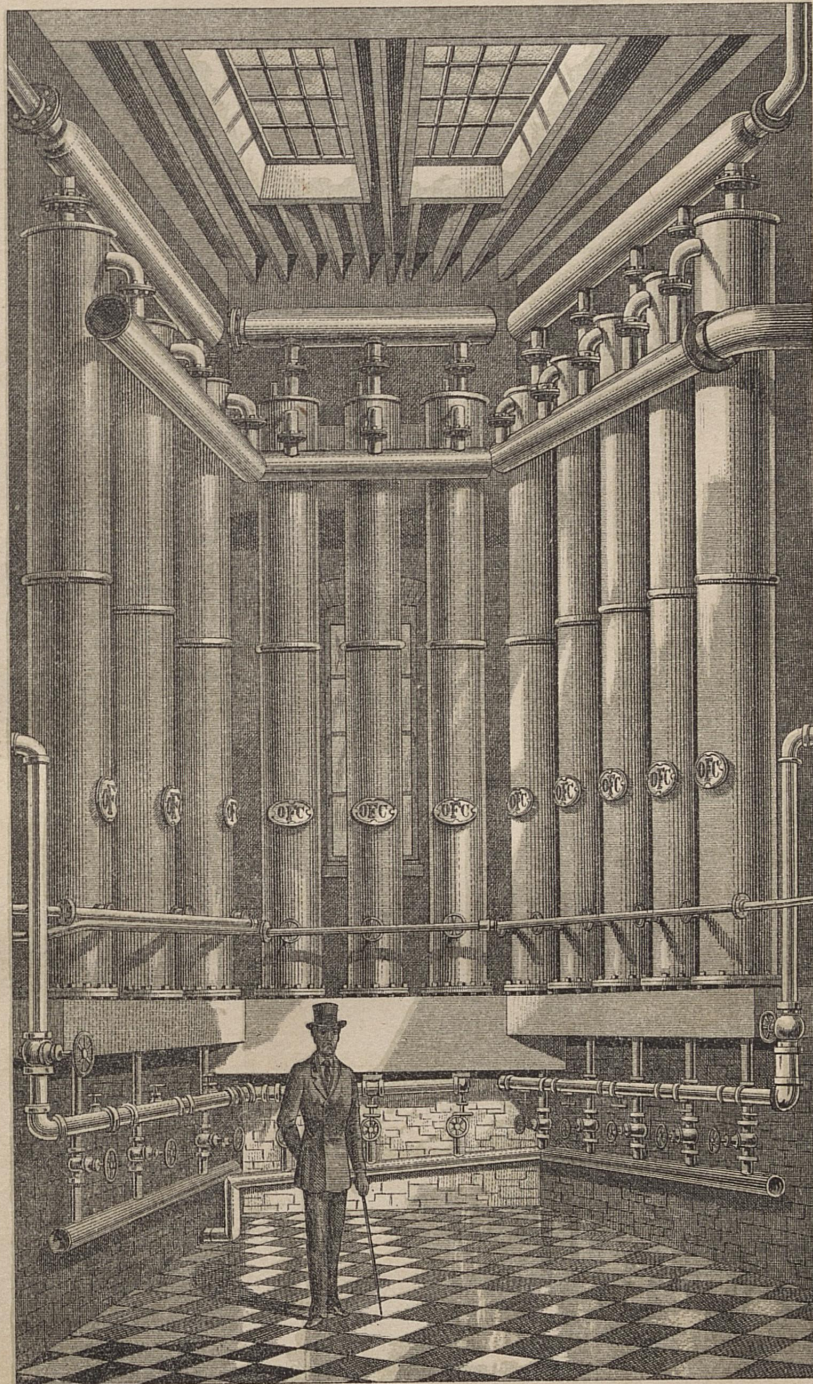
Besides many other advantages of this vastly improved process of condensation is the greatly lower temperatures at which reduction is completed, and the consequent lesser harshness of the product.

After condensation, the singlings are then transferred to other copper vessels known as "doublers," and again gently boiled over an open fire, the resultant vapors passing upward through columnar copper "caps," so arranged that the heavier essential oils, so deleterious to the product, may fall back into the still and pass off with the rejected refuse. The purer spirit vapor is condensed as in the singling process, and run to what is known as "proof whiskey."

Here all other distillers begin the barreling of the product as finished whiskey. The O. F. C. Whiskey, however, receives an additional finishing step that completes its character as a PERFECT whiskey, superior to all others.

The product is subjected, in air-tight vessels, to an atomizing process that is at the same time deterrent—each atom coming in contact with atmospheric oxygen, and causing an oxydation of the amylic alcohols (fusil oil) so injurious to other whiskeys.

This purely logical separation of the injurious salts of lead and copper (which other distillers never accomplish), and the oxyda-



CONDENSING ROOM AT O.F.C. DISTILLERY

tion of the fusil oils into odorous essences, gives us a whiskey, when first barreled, superior to any other product of the best distillation at two years of age.

Of this process and its results, Prof. Wayne, analytical chemist of Cincinnati, says :

“ I have examined the samples for impurities acquired in process of manufacture, such as the salts of lead and copper, and find none present.”

And again :

“ Your whiskey is remarkably free from fusil oil and other alcohols than the ethylic, to the presence of which (especially fusil oil — amylic alcohol) is largely due the intoxicating and stupefying effect of much of the whiskey sold at present.”

Not an atom of foreign substance is allowed to come in contact, by absorption, with the pure spirit in the oxygen process ; but freed of the injurious oils and salts common to all other whiskeys, it passes to the cisterns to be barreled in splendid packages — the pure oil of grain — the genuine O. F. C. Whiskey, without a rival throughout the world.

Col. A. M. Swope, long collector of the seventh revenue district of Kentucky, says of it :

“ In my judgment, there is not a better or purer article of whiskey made in the world.”

And it was this superior character of whiskey that, being exhaustively analyzed by him, obtained from Prof. R. Ogden Doremus, professor of chemistry and physics in the College of the City of New York, and of chemistry and toxicology in Bellevue Medical College, the following indorsement :

“ These facts (of analysis) commend it not only to the public who seek a superior whiskey, but also to the members of the medical profession in their practice.”

Prof. Barnum, analytical chemist, of Louisville, Ky., after mak-

THE O. F. C. WAREHOUSES.

The manufacture of a perfect whiskey is not so desirable a consummation if the subsequent storage does not preserve and improve its fine qualities. Hence the proprietors of the O. F. C. distillery have spared no pains or expense in providing substantial, dry, and commodious warehouses for such storage and constant supervision of the packages therein. These packages are manufactured at their own shops, of material selected in the mountain forests of Kentucky by their own agents, and are first-class in every particular.

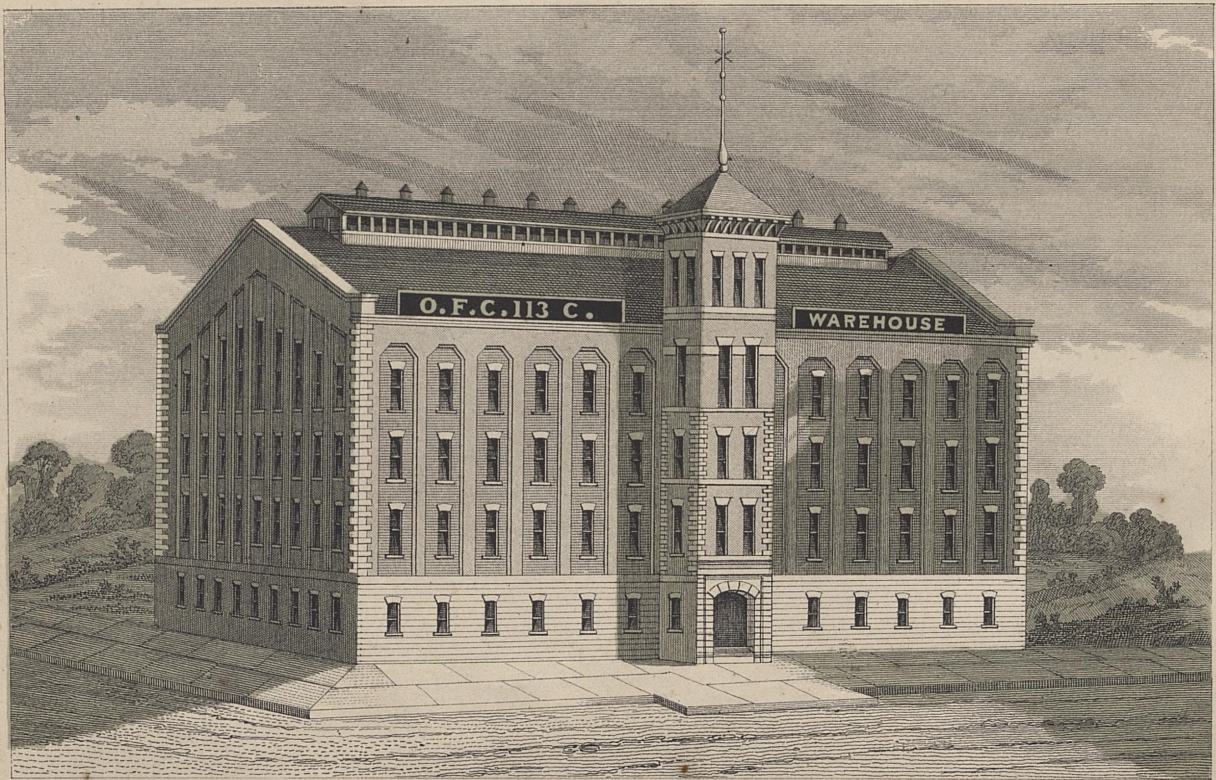
The illustration (see Plate 11), shows an exact view of the new O. F. C. warehouse, designed to reflect the best method of storage. Only the old-style three-tier storage is observed, whereby dryness, ventilation, and light — properties essential to ripen whiskey — are attained liberally. Every barrel of O. F. C. possesses the advantages stated. The dampness, darkness, and consequent low proof so often found in the dense aggregation of barrels in patent rick warehouses find no place upon the O. F. C. premises. A low rate of insurance is guaranteed by all insurance companies. Security is provided by competent watchmen and a watchman's clock.

CONCLUSION.

The foregoing facts illustrate the superiority of this unequalled whiskey, and the unquestioned responsibility of the manufacturers — E. H. Taylor, Jr., Co. — is pledged to the accuracy of the recital as embracing the exact methods, the identical processes, and the constituent elements employed in the production of each and every barrel of O. F. C. Whiskey.

The details observed in illustrating the methods of O. F. C. manufacture are, in general, substantially and practically descriptive of the processes used in the manufacture of the CARLISLE and J. S. TAYLOR whiskeys.

PLATE 11.



NEW O.F.C. WAREHOUSE.

ERBIL & CARQUEVILLE LITH. CO. CHICAGO. 27

CARLISLE DISTILLERY.

The Carlisle distillery, represented in the engraving, is located on the Kentucky River, just below and closely adjacent to the O. F. C. distillery. It is a large and handsome structure, 200 feet long by 45 feet wide, three stories, including the basement. The basement and boiler rooms are built of large blocks of Kentucky limestone, hammer-dressed, and the main edifice is of brick.

The fermenting room is 83 by 43 feet, with concrete floor, ample windows for light and ventilation, and 16-foot ceiling supported by strong columns. Eight large fermenting tubs contain the daily production of beer. The mashing is done by machinery, the grain scalded with strained spent beer, and a sufficient quantity of the spent beer to produce a perfect fermentation is mixed with the mash, in a cooled state, when placed in the fermenters. The fermentation is accomplished under the ninety-six-hour regulations.

The machinery throughout the Carlisle distillery is of the best quality, costly in construction, and well adapted to its uses. The stills are all of copper, four large boilers supply ample steam power, and iron tanks temporarily hold the fresh cold water drawn from springs in the vicinity. The water from these springs is first collected in a stone basin or reservoir, and then pumped to the distillery, some half mile distant, through underground iron pipes. These springs are identical in properties with that which supplies the O. F. C. distillery.

PLATE 12.



CARLISLE DISTILLERY.

SHIBRA & CARQUEVILLE, LITH. DE CHICAGO.

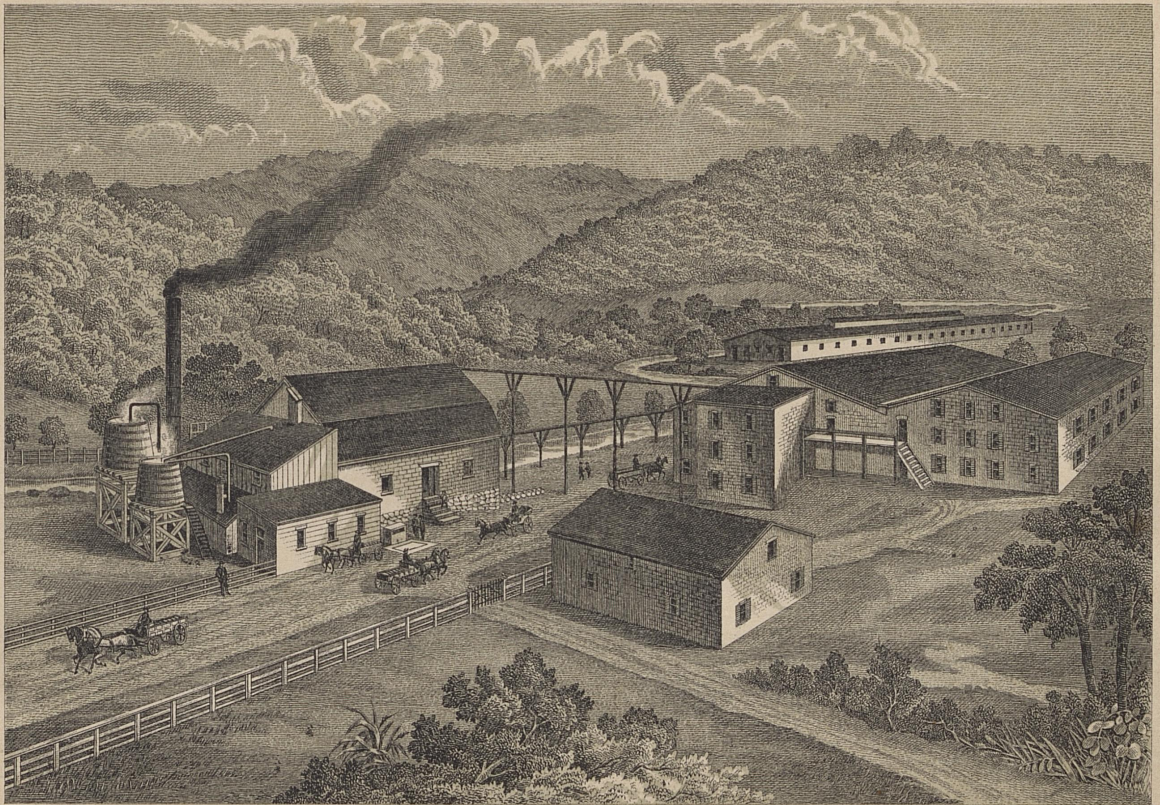
THE J. S. TAYLOR DISTILLERY.

The above distillery is located six miles from Frankfort, in the picturesque valley of Glen's Creek. The situation is so well adapted to the production of a fine whiskey that the site of the J. S. Taylor distillery has been used for distillery purposes at frequent intervals as far back as 1819. The building itself is an unpretentious structure of stone and frame—a genuine old-style sour-mash distillery. The mashing is done by hand in small tubs, and the mash, after proper mixture, is allowed to stand twenty-four hours before being placed in the fermenters. Strained spent beer is the fermenting agent used, and the ninety-six-hour plan observed in perfecting fermentation. The water used in mashing is obtained from a copious spring in the vicinity, issuing from the base of the lofty limestone hills. Copper vessels alone are used for cooking the beer, and separating and condensing the spirit vapor.

On the premises are three stone warehouses, having capacity for safe and well arranged storage of 8,000 barrels.

The product of the J. S. Taylor distillery has become so favorably known as a whiskey of fine flavor, purity, and general excellence that it is needless to elaborate the details of its manufacture. It is strictly copper-distilled, strictly hand-made, strictly sour-mash, strictly first-class.

PLATE 13.



J. SWIGERT TAYLOR DISTILLERY & WAREHOUSES
GLEN'S CREEK, WOODFORD COUNTY, KENTUCKY.

CASED GOODS.

Appreciating the fact that there was a large class of persons who, while desiring a pure article of whiskey, could not utilize it in the customary barreled shape, we have provided a complete establishment, directly under our supervision, for bottling our several brands of goods. The illustration on third page of cover faithfully represents our goods as they appear in genuine form of bottle and case.

The bottles are filled from the contents of old packages that have been thoroughly tested as to fineness and flavor. They are then packed for shipment in neat wooden cases of one dozen each, the latter being neatly branded and fastened securely with patent wire seal.

For family use, these goods are especially adapted, and the drug and retail trade will find them, in quality and attractiveness of shape, particularly suited to the popular demand.

CERTIFICATES OF REVENUE OFFICIALS.

(1)

O. F. C. DISTILLERY, FRANKFORT, KY., Feb. 6, 1886.

Having been assigned as U. S. Storekeeper at the O. F. C. distillery of E. H. Taylor, Jr., Co., and being requested by the proprietors to state the daily process of mashing observed at said distillery, it is as follows: The meal, after being crushed in the corrugated roller mills, is scalded in small tubs with hot, strained slop or spent beer from previous mash. It is then thoroughly stirred or mixed by hand, and allowed to stand on the floor in the small tubs till next day, when the rye and malt are added. The mass is then again well stirred by hand, and emptied into the fermenting tubs with an additional quantity of strained slop. After fermenting 72 hours, or until ripe, the beer is then distilled.

H. DUVALL, *U. S. Storekeeper.*

(2)

CARLISLE DISTILLERY, FRANKFORT, KY., Feb. 6, 1886.

I am the U. S. Storekeeper at present assigned to the Carlisle distillery of E. H. Taylor, Jr., Co. At the request of the proprietors I would state the process of mashing daily observed at said distillery as follows: The meal is first ground in roller mills, then scalded in tubs with hot, strained slop — the mash stirred by power. It is then allowed to stand one day, when the small grain — rye and malt — is added, and the mash broken up and put to fermentation in arge tubs with additional strained slop. The time of fermentation is 72 hours, after which the beer resulting is distilled.

H. FOUSHEE, *U. S. Storekeeper.*

(3)

J. S. TAYLOR DISTILLERY, Feb. 6, 1886.

At the request of the proprietors, I state that the process of mashing daily observed at the J. S. Taylor distillery, to which I am now assigned, is as follows: The meal is scalded in small tubs with hot, strained slop of the day's distillation. It is then thoroughly mixed by hand, after which it lays over one day. The rye and malt is then added, and after being well mixed by hand, the whole is then put in the fermenting tubs with a quantity of strained slop, and allowed to ferment 72 hours, when it is distilled as soon as ripe.

J. E. P. WOODSON, *U. S. Storekeeper.*

(4)

D. W. Voyles, Revenue Agent in the Internal Revenue Department, whose duty it is to inspect the condition of distilleries and bonded warehouses, on June 10 last reports thus officially. "As Revenue Agent under commission of the United States, I have to-day thoroughly inspected the distilleries and bonded and free warehouses, the property of E. H. Taylor, Jr., Co. I find them all in the most perfect and admirable condition. There is no respect in which it seems to me any betterment could be effected.

D. W. VOYLES, *Revenue Agent.*"

FRANKFORT, June 10, 1885.

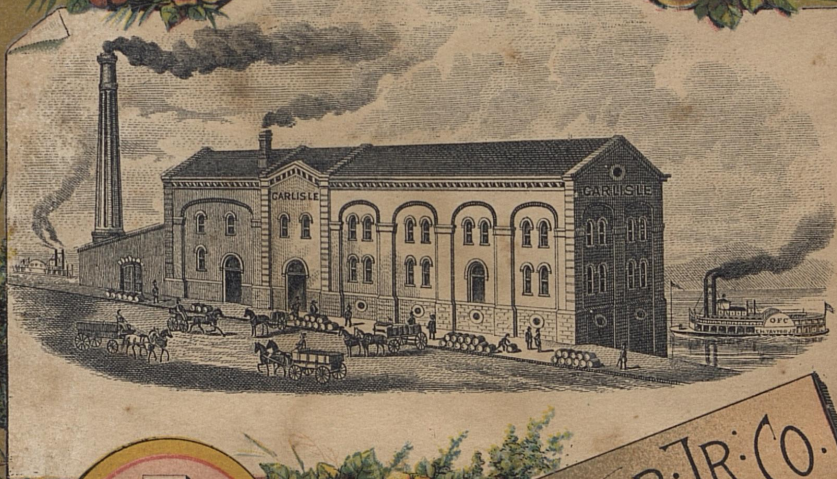


Fac-Simile of Cased Goods.

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IN EVERY APPLIANCE AND APPOINTMENT OUR
DISTILLERIES ARE THE COMPLETE AND
MOST PERFECT IN AMERICA



E. H. TAYLOR JR. CO.
DISTILLERS
OUR O.F.C. CARLISLE & J.S. TAYLOR
BRANDS ARE RESPECTIVELY THE HIGHEST
TYPES OF AMERICAN WHISKIES.