

Water, rice and yeast are indispensable for sake brewing. In Kanagawa Prefecture, you can visit sake breweries that take pride in their use of these ingredients to produce exclusive sakes.

## ■ Izumibashi Sake Brewery (Rice)

Izumibashi is one of the few breweries in Japan that makes sake entirely from rice they cultivate themselves—a rare, fully integrated approach—and is known for its exceptional quality both in Japan and abroad, including earning a Gold Medal at the International Wine Challenge (IWC). By growing its own sake rice and brewing in-house, Izumibashi can safeguard quality at the source, prioritize safety, and maintain full traceability throughout the entire process. It is also one of the closest sake breweries to central Tokyo, located about 40 minutes from Shinjuku by express train.

### Exclusive Program

You will gain general knowledge about sake as well as the brewery's philosophy and dedication to rice cultivation. You will follow the grain's journey end to end—from the actual rice paddies to rice polishing and brewing—seeing each step that turns rice into sake. A guided tasting led by the kurabito, brewery worker, then highlights how different rice varieties and polishing ratios affect flavor, and pairs sake with small bites so you can experience food matching in practice.

As an option, a special English-language tour is available, led by an internationally certified sake sommelier with hands-on brewery experience, offering clear guidance from brewing fundamentals to tasting techniques.



## ■ Nakazawa Sake Brewery (Yeast)

With nearly 200 years of history, this brewery uses natural yeast discovered in the locally grown Kawazu cherry blossoms, as well as yeast found 100 years ago. Nakazawa can be reached in about 10 minutes from Odawara Station, making it an ideal stop on the way to or from sightseeing in Hakone.

### Exclusive Program

With a private guided tour led by the brewery owner, you'll learn about the sake-making process and the special yeasts developed by the brewery before touring the production facilities and finishing with a tasting that lets you experience the distinct characteristics of each yeast.

