

山ほどの、うまい酒を。

山地が84%を占める山国、長野。

山岳地形ならではの冷涼な気候

山肌を流れる清らかな雪解け水

山裾では良質な酒米が育まれ

山も眠る厳しい冬に、酒は仕込まれます。

山並みに隔てられた広い県域には、多様な風土と独自の文化が育まれ

山とある苦楽も越えて、今も80の酒蔵が切磋琢磨しています。

山から生まれた豊かな自然と

山あいで育まれた多様な風土と独自の文化

山と人が織りなすこの環境が高品質で個性豊かな酒を醸します。

山ほどの、うまい酒を。

## Mountains of Taste. Nagano Sake.

Mountains cover 84% of Nagano Prefecture.

Mountain highlands create a uniquely cool climate and

Mountain slopes deliver pristine snow-melt water down to

Mountain valleys that nurture high-quality sake rice which, even as

Mountains sleep in deepest winter, brewers make into sake.

Mountain ranges separate the prefecture into diverse environments with unique cultures.

Mountain hardships are overcome by its 80 sake breweries working in friendly competition.

Mountain-born rich environments.

Mountain-bred unique places and cultures.

Mountains and people woven together brew sake of high quality and distinct character.

Mountains of Taste. Nagano Sake.



Photo by Jun Yamagishi

## GI NAGANO

生産基準を満たした長野県産酒だけがその産地名を独占的に名乗ることが出来る制度です。産地の名称が厳格に保護されることで、国内におけるブランド価値の向上やさらなる輸出の拡大の実現を目指しています。



Nagano Prefecture established the GI Nagano geographical indication standards to protect and to promote the region and the sake produced within it. These standards aim to raise brand value within Japan, and to expand exports around the world.



南北212km、東西120kmに及ぶ県域。酒蔵の標高も300mから900mとさまざま。山並みに隔てられた盆地ごとに、取り巻く気象も、水質も、暮らす人々の気質や言葉も、食文化も一様ではありません。この多様性こそが長野SAKEの個性です。全国2位の酒蔵数を誇る長野80蔵。酒蔵の数だけ存在する蔵元の想いと、それを表現した酒の個性を、これからも大切にしていきます。

山あいに息づく  
山ほどの多様性

## Mountains of Difference Nurtured in the Valleys

Nagano runs 120km east to west and 212km north to south, with sake breweries situated from 300m to nearly 1000m in elevation. Each mountain valley harbors its own unique climate, water quality, local customs, dialect, and food culture. This diversity is what defines the character of Nagano sake. The prefecture boasts 80 sake breweries—the second-highest number in Japan—and each brewery aims for its own special style and taste.



3000m級の山々を覆う豪雪は長い年月をかけて森の地下を伏流。多様な個性をまとって地上に現れ、夏には田を潤して寒暖差の大きい気候と共に良質な酒米を育て、冬には仕込み水となって厳しい冷え込みと共に緻密な酒を生み出します。長野県には、ほかにもワイン、味噌、醤油、漬物、チーズなど、微生物の力を活かす造り手が多数。まさしく山の醗酵王国なのです。

山の恵みが育んだ  
醗酵王国

## Mountain Blessings Nurture The Fermentation Kingdom

Snowmelt from 3000-meter mountains absorbs the character of each mountain as it flows beneath the forest. In summer, it feeds the rice fields, and along with the highland warm days and cold nights, it cultivates superior sake rice. In winter, it provides the brewing water that combines with the deep cold to create finely crafted sake. Nagano's many artisans use the power of microbes to ferment not only sake but also wine, miso, soy sauce, pickles, cheese, and more. Truly a mountain-born Fermentation Kingdom.

## YOMOYAMA NAGANO

全国4都市で開催される長野県酒造組合最大のイベント。80の酒蔵数を誇る長野の蔵元が一同に終結し、自慢のラインアップをお披露目します。お目当ての銘柄を造り手のよもやま話と共に楽しみください。



Nagano Sake Brewery Association's biggest tasting event, staged in four cities across Japan. The event features an impressive lineup of sakes selected by each of Nagano's 80 breweries. The event is called "Yomoyama" because that expression means "telling various stories," and at these events you can enjoy tasting delicious sakes while hearing their stories straight from the brewers themselves.

## NAGANO SAKEカントリーツーリズム

蔵元を巡り多種多様な環境や文化、造り手の想いに触れていただく「長野SAKEカントリーツーリズム」。達成者には豪華プレゼントも！QRコードからスタンプシートをダウンロードしてご参加ください。



## NAGANO SAKE COUNTRY TOURISM Sake Brewery Stamp Rally

Join the rally and visit participating breweries to get a taste of their unique environments, cultures, and sakes in this Nagano Sake Country Tourism program. Use the QR code to download and print the stamp sheet before you start. Send in your completed stamp sheet to receive a special prize!



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山紫水明の大自然と共に醗酵王国長野を造り上げたのは、ものづくりに真正面から立ち向かう人々の存在です。耕作に適した土地が限られ、冬の厳しさは折り紙付き。こうした逆境と戦い続けたことで、いつしか人々の血にはものづくりスピリッツ(精神)が育まりました。肉眼では見えない微生物の力を活かすという高度な技が花開き、さらに、そこにとどまることなく技を磨き続けています。

## Mountain Toughness Instills The Spirit of Craftmanship

Along with the beautiful yet severe mountain environment, what makes Nagano Prefecture a fermentation kingdom are its hard-working crafts people. Struggling for generations with limited arable land and unforgiving winters has instilled the spirit of craftsmanship deeply into the blood of the people here. Not only have they learned to harness the power of organisms invisible to the naked eye, they always strive to sharpen their skills even more.

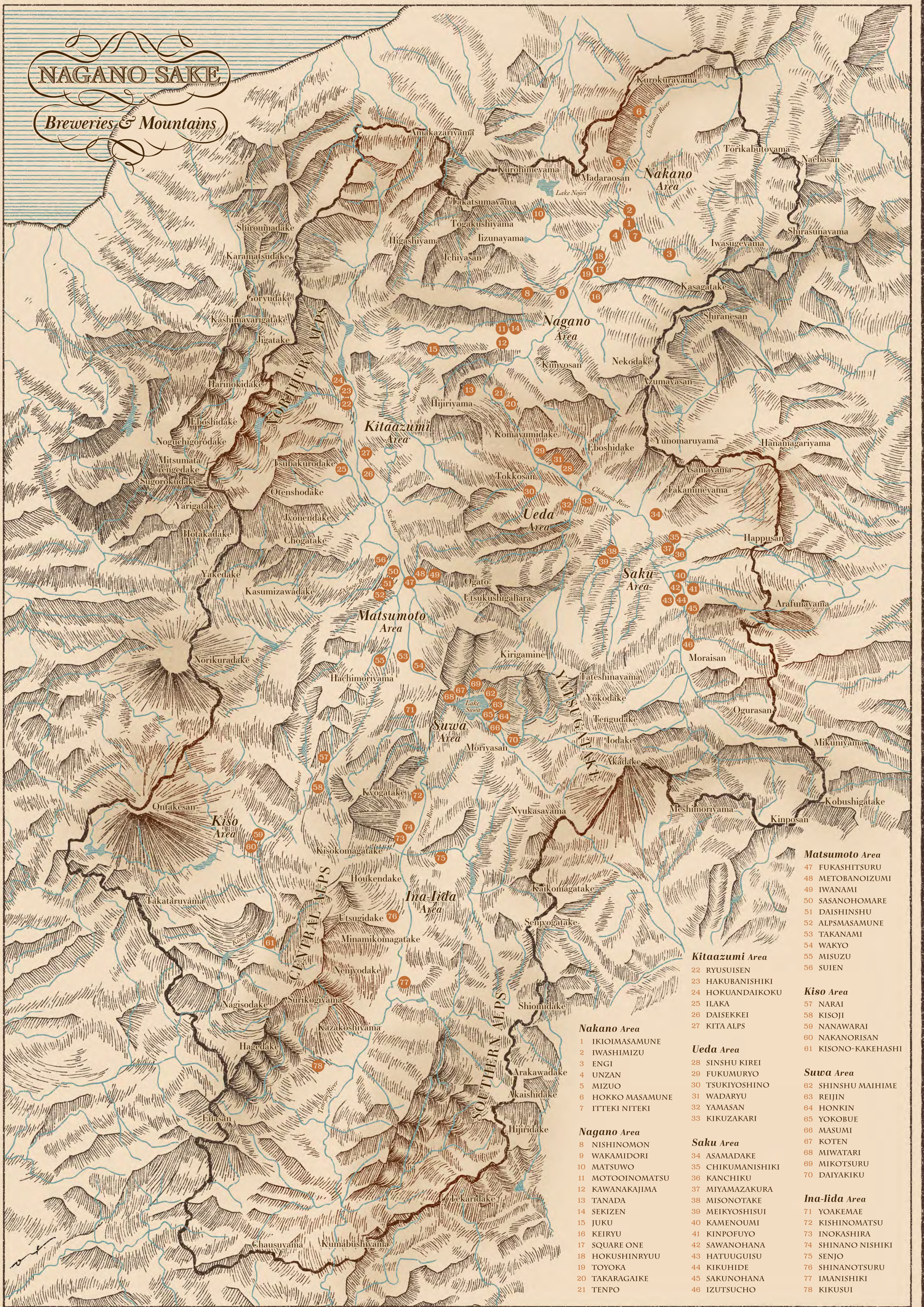
山の厳しさが培った  
ものづくりスピリッツ





# NAGANO SAKE

Breweries & Mountains



- Nakano Area**
- 1 IKIOIMASAMUNE
  - 2 IWASHIMIZU
  - 3 ENGI
  - 4 UNZAN
  - 5 MIZUO
  - 6 HOKKO MASAMUNE
  - 7 ITTEKI NITEKI

- Nagano Area**
- 8 NISHINOMON
  - 9 WAKAMIDORI
  - 10 MATSUO
  - 11 MOTOOINOMATSU
  - 12 KAWANAKAJIMA
  - 13 TANADA
  - 14 SEKIZEN
  - 15 JUKU
  - 16 KEIRYU
  - 17 SQUARE ONE
  - 18 HOKUSHINRYUU
  - 19 TOYOKA
  - 20 TAKARAGAIKE
  - 21 TENPO

- Kitaazumi Area**
- 22 RYUSUISEN
  - 23 HAKUBANISHIKI
  - 24 HOKUANDAOKO
  - 25 ILAKA
  - 26 DAISEKKEI
  - 27 KITA ALPS

- Ueda Area**
- 28 SINSHU KIREI
  - 29 FUKUMURYO
  - 30 TSUKIYOSHINO
  - 31 WADARYU
  - 32 YAMASAN
  - 33 KIKUZAKARI

- Saku Area**
- 34 ASAMADAKE
  - 35 CHIKUMANISHIKI
  - 36 KANCHIKU
  - 37 MIYAMAZAKURA
  - 38 MISONOTAKE
  - 39 MEIKYOSHISUI
  - 40 KAMENOUMI
  - 41 KINPOFUYO
  - 42 SAWANOHANA
  - 43 HATUUGUISU
  - 44 KIKUHIDE
  - 45 SAKUNOHANA
  - 46 IZUTSUCHO

- Matsumoto Area**
- 47 FUKASHITSURU
  - 48 METOBANOIZUMI
  - 49 IWANAMI
  - 50 SASANOHOMARE
  - 51 DAISHINSHU
  - 52 ALPSMASAMUNE
  - 53 TAKANAMI
  - 54 WAKYO
  - 55 MISUZU
  - 56 SUIEN

- Kiso Area**
- 57 NARAI
  - 58 KISOJI
  - 59 NANAWARAI
  - 60 NAKANORISAN
  - 61 KISONO-KAKEHASHI

- Suwa Area**
- 62 SHINSHU MAIHIME
  - 63 REIJIN
  - 64 HONKIN
  - 65 YOKOBUE
  - 66 MASUMI
  - 67 KOTEN
  - 68 MIWATARI
  - 69 MIKOTSURU
  - 70 DAIYAKIKU

- Ina-Iida Area**
- 71 YOAKEMAE
  - 72 KISHINOMATSU
  - 73 INOKASHIRA
  - 74 SHINANO NISHIKI
  - 75 SENJO
  - 76 SHINANOTSURU
  - 77 IMANISHIKI
  - 78 KIKUSUI