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Writing for the Journal of the Scottish Brewing Archive Association

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SBAA Journal - Volume 15

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Editorial

Allan P. McLean reflects on the brewing heritage of Scotland

Here's a sobering thought. Of the 200 commercial breweries in Scotland in 1900, only three survive as breweries continuing on their original sites. Two of them are in premises clearly recognisable as historic – Belhaven at Dunbar and the Caledonian Brewery at Slateford Road in Edinburgh – while the third, Tennent's Wellpark Brewery in Glasgow, is of heritage interest but is a modern plant on an historic site.

As a refreshing thought it is interesting that there are around 100 other breweries in Scotland, many quite recent additions to the industry that we chronicle and celebrate.

These facts indicate that Scottish brewing has a present and future as well as a past. So our interest is wider than the already wide past. It is good to enjoy the present and prepare for the future. But keeping memories of the past alive is important to help foster an understanding of the background from which the current scene grew and the future will develop.

Much of the past is documented in the Scottish Brewing Archive cared for by the University of Glasgow Archive Services. There are also other records elsewhere, including national and local records that those studying local history will want to examine as part of their studies.

In addition it is good to capture the living memories of those who worked and work in the industry. The Journal has carried the writings of brewers and others who worked in the industry recalling aspects of their working lives for the record, to inform and entertain. This edition continues that joyous trend, with a fascinating insight into marketing by David McGowan and another instalment by Bill Brown on the breweries of Craigmillar,

accompanied by memories from other people, and a second phase of reminiscences by Richard Rees about his time with Scottish & Newcastle.

On this occasion, Richard follows his previous commentary on brewing at Holyrood by telling of work at the New Fountain Brewery which was created when S&N expanded across the road at Fountainbridge from the original William McEwan site. He brings to life the way that brewing thrived along the thoroughfare of Fountainbridge on the West side of Edinburgh. To look now at its open spaces and construction work, it can be difficult to envisage just how important the area was in the story of Scottish brewing. Richard's article is a timely reminder.

Brewing has ceased at Holyrood, Fountainbridge and Craigmillar but there are still traces of the past to be found at these locations – and there are still the memories of those who worked there, as well as the paper archives. It is part of the joy of fostering interest in the Scottish Brewing Archive, that we are protecting those memories as well as an understanding of what the paperwork meant.

The breweries of Craigmillar. Part two

Bill Brown *continues his history of the seven breweries of Craigmillar*

Introduction

At the beginning of the 20th century, Craigmillar and Duddingston Ales developed an enviable reputation and were exported worldwide, the very phrase 'brewed in Craigmillar' being synonymous with quality. Each of the seven breweries had its own name but with the incorporation of the title 'Craigmillar', identification often became confusing {see Fig. 1]. Eventually this problem was overcome when, through common usage, each of these Edinburgh breweries became known by its company name, e.g. Drybrough's Brewery, as opposed to Craigmillar Brewery.

Figure 1. Beer labels

Deuchar's Duddingston Brewery

Robert Deuchar started brewing in Newcastle and by 1897 the business was registered under the name of Robert Deuchar Ltd. Two years later, in

1899, his business acquired a brewery at Duddingston, Edinburgh. The Duddingston Brewery had only been built in 1895 and was available for purchase due to the bankruptcy of its previous owners, Pattisons Ltd. Robert Deuchar extended his business further in 1900 by acquiring the Edinburgh brewer Simson & McPherson Ltd.

Deuchar's brewery at Craigmillar not only survived the two World Wars as a business, but also continued to prosper. Following the death of Robert Deuchar he was succeeded by his son, Farquhar, who became the major shareholder, and when he died in 1950 his shares were passed, in the short term, to Trustees. The business survived a number of takeover bids, but in 1953 Newcastle Breweries Ltd. (NBL) was successful. However in 1960, when Scottish Brewers Ltd. merged with NBL, the future of the Duddingston Brewery was put in doubt. Brewing stopped in 1961 and, although the maltings continued to operate until 1971, the brewery was demolished shortly afterwards.

Although the Deuchar's brand continues today, it has no links with the original brewing business, and is instead a successful beer brewed at the Caledonian Brewery in the west of Edinburgh.

Drybrough's Craigmillar Brewery

Drybrough originally brewed at Tolbooth Wynd and in 1874 extended into Craigend Brewery in the North Back of the Canongate. In the early 1890s, when the Waverley railway station was being expanded, Drybrough and the North British Railway Company did a deal, as outlined in a previous *Journal*. [1] In 1892 a decision was made to move to a green-field site next to the circle line of the Edinburgh Suburban and South Side Junction Railway

[1] McLean, A. The wheels on the train go round and round … *The Journal of the Scottish Brewing Archive Association*, 2014, 14, pp.30-36.

at Craigmillar. This proved to be an excellent move and soon afterwards Drybrough became registered as a Limited Company.

Drybrough's beers were very popular, not only locally, but also in the South and West of Scotland and North East of Scotland. They also supplied beer to the Alnwick Brewery in Northumberland and Ballingall & Son Ltd. in Dundee. In 1965 Drybrough & Co. Ltd. was taken over by Watney Mann Ltd. In spite of a massive advertising campaign the famous 'Red Barrel' ale never took hold in Scotland. In 1987 the brewery was sold for £40.5m to the Allied Lyons Group, along with 187 licensed houses. However, shortly afterwards Drybrough's brewery was closed, a devastating blow to the community. For a time a microbrewery operated on the site, which is now an architectural salvage yard. Imposing blocks of modern flats, overlooking the playing field, now occupy the main area of the former brewery.

Maclachlans' Castle Brewery

In 1889 George and John Maclachlan opened their first Castle Brewery at Maryhill in Glasgow, and in 1901 opened the Craigmillar Castle Brewery. They also built up a chain of pubs called the 'Castle' licensed houses. The 'Castle' motto was ***Fortis et Fidus*** meaning ***Strong and Trustworthy.*** In 1907 the Maryhill Brewery was closed with all brewing transferred to Craigmillar. Castle Ales were especially popular in the West of Scotland and a sizable export trade to South Africa and India was established. With the increasing popularity of bottled beers, especially after the Second World War, Maclachlans extended their range of bottled products to include Brown Ale, Castle Ale, Export Ale and Stout. In 1957 Castle Ale became available in cans. Draft beer was delivered by rail tankers for bottling and canning at the former Gordon & Blair brewery at Parkhead in Glasgow.

In 1961 Maclachlans Ltd. was taken over by J. & R. Tennent Ltd. and for a few years Castle canned ale was the only product to survive. In 1966 following the upgrading of the Tennent's Wellpark Brewery in Glasgow, and the merger with United Caledonian Breweries (UCB) the Castle Brewery became surplus to requirements and was closed. This was yet another nail in the coffin for Craigmillar as a major centre of brewing, but like it or not, the direction in which all of this was heading was inevitable.

Murray's Craigmillar Brewery (later re-named Murray's No 1 Brewery)

In 1886 William Murray & Co. built the first of the seven breweries on a site known as 'Cairntows land' situated half a mile south of Duddingston Kirk and next to the Duddingston and Craigmillar railway station. (Cairntows Farmhouse steading is situated at the crossroads of Peffermill Road and Duddingston Road West. The Davidson family occupied this farmhouse in 1817). In 1922 Wm. Murray & Co. Ltd. purchased the North British Brewery (see below), with brewing continuing until 1930 at No 1 Brewery, after which it was used for storage until it was sold in 1953. The building was converted into a distribution, storage depot and box-making unit, and subsequently incorporated within the 'Castlebrae Business Centre', at which time Peffer Place was extended to meet Harewood Road.

Murray's No 2 Brewery: the North British Brewery

In 1897 the partnership of Blyth & Cameron commenced brewing at their 'new' North British Brewery and in the same year merged with John Somerville & Co.; the new company was registered as John Somerville & Co Ltd. In 1922 the brewery was taken over by William Murray & Co. Ltd. Now owning two breweries, to avoid confusion the breweries were re-named as Murray's No 1 Brewery and Murray's No 2. This purchase was necessitated because the output from No 1 Brewery was totally inadequate to meet demand.

No 2 Brewery was a modern and much larger brewery, with its own bottling hall, and fitted the bill for the expanding trade. It was a move that was to provide an excellent investment for shareholders. Right up to 1950 various upgrades were made to the No 2 Brewery that not only made it much more efficient but also made it attractive for any future merger. As a direct consequence in 1950 the firms of William Murray & Co. Ltd. and Aitchison Jeffrey Ltd. were merged to become United Caledonian Breweries (UCB). In 1960 UCB was taken over by Northern Breweries of Britain Ltd., later known as United Breweries Ltd., and in 1962 was transferred to a Charrington Group holding company. Brewing and bottling continued until 1964 when the brewery was closed for good.

(All of this gives a flavour of the effects of "Merger Mania". However it must be noted that this was not confined just to the brewing industry. From 1955 this was a national phenomenon for many years.)

Paterson's Pentland Brewery

The Pentland Brewery, the smallest of the seven breweries, was situated adjacent to the north side of Deuchar's and unlike the other six had a separate rail connection (laid in 1900) from Cairntows direct to the St Leonard's branch-line (part of the Edinburgh & Dalkeith Railway that became part of the North British Railway in early Victorian times). In 1936 T. Y Paterson & Co. Ltd. was taken over by James Aitken & Co. (Falkirk) Ltd., one of whose trademarks was a tiger in a cage with the caption 'Strength Behind Bars'. Brewing continued until the late 1930s when the brewery was requisitioned in aid of the war effort. Prior to its demolition in the late 1950s, the building was used for general storage purposes. The site is now part of the Peffermill Industrial Estate.

Raeburn's New Craigmillar Brewery

W. & J. Raeburn brewed at their Merchant Street Brewery in Edinburgh from 1863 until 1897 when the site was bought over by the Trustees of Heriot College to extend the College. In 1901 the Raeburns purchased a green-field site at Craigmillar, and commenced production in 1902. In 1913 the brewery was taken over by Robert Younger Ltd., who was based at St Ann's Brewery at Abbeyhill in Edinburgh, close to the Steel Coulson brewery at Croft-an-righ. During the 1930s recession, and as an inter-war economy measure, brewing ceased at the New Craigmillar Brewery. After the war, apart from the maltings, the brewery buildings were sold to The Brewers Food Supply Co. Ltd. who later moved to Mitchell Street/Peffer Place. William McEwan & Co. Ltd. took out a lease on the maltings and continued to use this facility right up to the early 1960s. In the early 1970s 'Dodge City', a DIY superstore and one of the first of its kind in Scotland, was built on the site. A large crowd came to witness the opening of the store by Peter Gilmore, the actor who played the part of Captain Onedin in that very popular long running (91 episodes) BBC TV saga 'The Onedin Line'.

Some memories from people who worked in Craigmillar breweries

The gaffer of the shop (cooperage) was an excellent cooper and one of his passions was feeding the birds. Each day at 12 noon on the dot, he would walk into the yard, arms outstretched and palms laden with broken up rolls. The birds perched on his head and shoulders waiting in turn to be fed. He became known as the Bird Man of Deuchar's.

And here are some comments from some former brewery workers:

"Coopering is not a trade; it is a craft – the ancient craft of coopering."

"At Robert Deuchar's, apprentice coopers attended day release school and evening classes, and were told by the Managing Director that he expected

apprentices to win prizes at the Day School. He then went on to say that not winning prizes was bad for the image of the Brewery!"

"There was a sad occasion when a wagon full of empty barrels was being unloaded at the rail siding, and when the wagon door was opened, a barrel tumbled out and killed the operative outright. The wagon had not been properly loaded."

"All the breweries had their own rail sidings, which greatly facilitated the delivery of raw materials and the dispatch of their finished products to market."

"At their peak, at the turn of the century, the Craigmillar and Duddingston breweries, along with their associated maltings, cooperages and ancillary activities, employed upwards of two thousand people."

Figure 2. Part of the former DRYBROUGH signage

The end of an era

Drybrough's was the last of the seven Craigmillar breweries to be closed. Its closure signalled the end of an era. Today, however, there are still some tell-tale signs of breweries that once dominated the skyline in Craigmillar (see Fig. 2 above).

It would be good if this included a brewery!

Figure 3. The author, Bill Brown, at a recent display on the Craigmillar breweries

Brewers in Tranent

Jim Lawrie *describes the results of his research into the brewing history of the ancient town of Tranent*

Introduction

Tranent is one of the most ancient towns in East Lothian and lies ten miles east of Edinburgh and seven miles from Haddington. Its name is derived from its natural situation: 'Trev-er-nent' which means 'the village on the ravine'. It was once an important mining town with coal being mined as early as the 12th century. East Lothian was long known as Haddingtonshire.

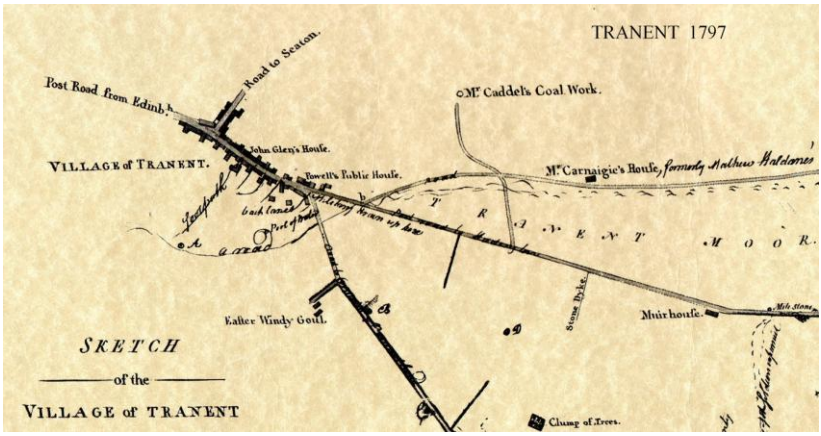

Figure 1. Map of Tranent

In 1745 Tranent was on higher ground than the nearby battlefield of Prestonpans where Bonnie Prince Charlie's Jacobite army routed the Hanoverians led by Sir John Cope. Then, 52 years later, Tranent was also the site of what historians later dubbed 'Scotland's Forgotten Massacre', where 12 unarmed people were killed by a cavalry unit following the

Tranent Militia Riot, when the local population disagreed with the enforced recruitment of Scots into the military.

Although other parts of East Lothian tend to be associated with brewing heritage, it is interesting to note that brewing also features in Tranent's history. Several breweries existed over the years before and after the Battle of Prestonpans. Jim Lawrie, an SBAA member who has researched brewing in East Lothian, acquired fresh information on these brewers, much of which is based on research in the National Archives of Scotland in Edinburgh (references to relevant documents are provided in the text). What follows is an opportunity to find out some of that history. A visit to Tranent can also help identify locations mentioned. There is a pleasant walk along part of the route of the former Tranent and Cockenzie Tramway, a coal-carrying horse-powered 18th century railway that leads to and beyond the site of the Battle of Prestonpans.

Tranent brewers and brewhouses

'Spence's Land', now the area of Tranent Tower and the houses between there on Church Street and Sandersons Wynd were described as having a brew-house in a record dated 1661/62, along with a malt kiln, malt barn, well and steepstone. [sasines RS27/3 page 99, National Archives]. Earlier records do not appear to mention the brew-house, although they are sometimes not clear and also at times written in Latin. [sasines RS25/13 p.66, RS25/22 p. 278, RS25/26 p.164]. Even later records omit reference to the brewhouse although they mention the malt kiln, malt barn, and steepstone. [SC40/7/27 p. 34 dated 1718, RS27/16 pp150, 152 (dated 1664, 1667, RS27/19 p. 180 – dated 1671].

John Anderson

John Anderson, brewer in Tranent, pursued a debt owing to him at Haddington Sheriff Court on the 8th October, 1719 [SC40/7 p.157]; his location is not known.

Cairns Crook

Cairns Crook, was a brewer in Tranent whose wife Mary Scott was heir to her aunt, Mary Scott, meal-maker in Tranent [SC40/57/20 p.47, dated March 1876].

Matthew Haldane

Matthew Haldane, in his will of September 1785, includes assets described as "dwelling house and yard with brewhouse, dovecot, and other offices hereto belonging on the west side of the town of Tranent as previously possessed by the said Matthew Haldane" [Testament registered at Edinburgh 26th June 1817, CC8/8/143].

Matthew Haldane's Brewery was located at the west end of Tranent when it was just a village that was part of Haddingtonshire. The property was situated at the junction of Church Street and Bridge Street and previously belonged to George Buchan Hepburn of Smeaton, owner of many of the estates within the town. This is almost certainly the site now occupied by the Keepers Arms public house (see Fig. 2) and the attached building, which jointly have a yard and parking area behind.

Matthew Haldane's private dwelling house was at the north side of Tranent Moor close to the back road to Wester Adniston, as shown on a sketch map of the village dated 1797.

Matthew Haldane purchased the property in July 1780 [SC40/57/20, part 2, pp.225, 230]. A dwelling house and dovecot were already established there as well as a brewhouse. This was likely to have been the former

brewhouse and barns tenanted by the Tranent brewer, David Nicholson (see below), who died on the 27th December, 1719. Nicholson had flourished as a brewer in that part of the Church Street area in the early 1700s, and the inventory after his death included substantial brewing equipment. Sometime after the purchase Matthew Haldane had other offices built on the brewery site.

Figure 2. Keepers Arms

Haldane died around 1789 and the Trustees of his estate sold the brewery and other individual buildings to William Murray in May 1789 for the sum of £205 [SC40/57/20, part 2, p.236; sasines 1781 -1821, No. 399; RS27/334 p.263]. Murray (see below) at that time was described as a "coal grieve in Tranent" who was married to Marion Rennie.

Robert Johnson

Patrick Cleghorn, a servant of Robert Johnson, brewer in Tranent, was a witness at Haddington Sheriff Court in 1737 [SC40/51/1].

Robert Laing

Robert Laing was described as a brewer at Myles Farm on the outskirts of Tranent. His son William Laing died September 1774 [Tranent parish mortality Bill CH2/357/2, including the Register of Testaments for Robert Laing]

William Murray

William Murray purchased the brewery and other buildings from the estate of Matthew Haldane (see above) in May 1789 for the sum of £205 [SC40/57/20, part 2, p.236; sasines 1781 -1821, No. 399; RS27/334 p.263]. Murray at that time was described as a "coal grieve in Tranent" who was married to Marion Rennie. William Murray's brewhouse premises took in the junction of today's Church Street and Bridge Street, and was the former site of the 17th century 'Master of the Household's House'.

William Murray's brewery flourished and in September 1809 he purchased a neighbouring property from a John Cadell of Cockenzie. After William Murray's death on 9th June 1818 all of the properties passed into the hands of his son James Murray, a local brewer and baker. By July 1824 the commercial property included a bake-house as well as a brewhouse. James Murray also owned land in Edinburgh's Canongate.

A lease dated the 23rd November 1793, was granted in Tranent by Katherine Finlayson, widow of deceased Alexander Finlayson, and daughter of the deceased John Wilson, which was described as: "That under flat of the tenement of houses, with the room commonly called the back room, up stair in the second flat", though no location is given. This

lease was to Thomas Ewart, day labourer, Tranent at £5 10/- sterling, yearly for seven years after Whit Sunday 1794. Thomas Ewart was obliged not to sell any drink "either, porter, strong ale or beer except for William Murray (see above), brewer at Tranent" [SC40/57/21, bundle 1795/96 f.141]. Katherine Finlayson, with her sister Margaret Wilson, owned the property later known as the Crown Hotel on Tranent's High Street, that was formerly owned by their uncle George Kirkwood, merchant in Tranent [Sasines 1781-1820, No. 657, RS27/383 p.213]. The Wilsons held property at what is now 'The Orchard' in Church Street, though it is not certain if this John Wilson is of the same family.

John Duncan, wholesale ale and porter dealer and bottler, Church Street, Tranent, was declared a bankrupt in December, 1876, and discharged in October 1877 [SC40/7/37, p. 752 & 771]. The Valuation Rolls of 1876-77 record that Peter Scott, carter, Tranent, was the proprietor of premises in Church Street being a house and stable belonging to the proprietor and bottling premises' occupied by John Duncan, bottler. This would be at the rear of today's Fa'side House on Church Street, opposite the Town Hall. The piece of ground on which this was apparently situated belonged to Hislop & Company, distillers, Prestonpans, and Robert Hislop, the individual and only partner of that firm, in July 1840, before being sold to the Scott family [Sasines 1846-1850 Nos. 304 & 305]. Previously it had been a part of a larger area which was owned by William Murray. This part was sold in October 1804 to John Davidson, a collier in Tranent, which made mention of "reserving to said William Murray full use and enjoyment of a water run" which passes through these grounds, leading from a steepstone in a brewery occupied by him, William Murray [Sasines 1821-1830, No. 187, RS27/965, p. 10].

Tranent Gas works was later in this area and in 1885 there were numerous complaints of the broken state of the water channel there, mostly due to

traffic at the Gas Works; a crossing was to be put in place [Tranent Burgh Records, Police Commissioners, minutes of meetings 377/2/3, dated 1st July 1885]. This was not Murray's Brewery but, as noted above, further up Church Street, at the back of Fa'side House, the Gas Works is shown on the ordnance survey map of the 1890s, which shows the general area. What was the original "tenement of land" was broken up. There is reference to a malt barn and kiln as well which may have become the site of the Gas Works [SC40/58/7, pp.285, 289; SC40/58/8 p.3].

David Nicholson

After the forfeiture of the Seton Estate there were surveys of rentals in Tranent and other places, which included (dated November 1716) Mr David Nicholson, who possessed a house, brewery and barns at 200 merks rental yearly, with an obligation of keeping such in good repair; no location was given [Forfeited Estates papers, Linton Estate, E661/2 f.3]. It is suggested that this brewery was on the site of what was later Murray's Brewery, taking into consideration the status of Nicholson here. David Nicholson died on the 27th December 1719, and his testament gives an inventory, which includes brewing equipment [Registers, Edinburgh, 3rd March 1721, CC8/8/88].

Isobel Seton

Isobel Seton, widow of John Smith, saltgrieve in Cockenzie, became a brewer in Tranent and pursued debts owing to her at Haddington Sheriff Court in June 1742 [SC40/7/29, p.571; also 1733, 1734 and 1743, SC40/7/29 p.604, SC40/7/30 p.175, SC40/60/9 of 1734 bundle f.38].

Robert Watt

Robert Watt, brewer in Tranent, had an action against him at Haddington Sheriff Court in March 1738. He was the son of William Watt, a feuar in Giffordhall [SC40/60/16].

William Whitecross

William Whitecross, brewer in Tranent, was a witness to a contract in Tranent on the 18th August 1801 [Sasines 1781–1820, No. 1086, RS27/476, p.92].

What's in a name?

***John Reade** charts the development of brewing and beer styles*

Introduction

It can be something of a challenge choosing for the first time a new untried beer that you know you will like. Whether you prefer to buy your beer from the cask in your local, or as a bottled beer from the supermarket or off licence, both the numerous taps along the bar counter and vast array of bottled beers on the shelf can be quite misleading.

Arguably, things were so much simpler in 1650. Firstly, ales and beers were only really available from the cask either to drink-in or take home (in a jug). There was only a very limited choice of beer styles anyway. Basically, there were only four styles: *light nut-brown* and *dark brown,* available either as ale (un-hopped and flavoured with herbs or other plants) or as hopped beer. You would also then have the choice for each of them either as *strong* or *small* ales/beers or as a mix, commonly called *two penny*. Move forward 350-plus years and you are now faced today with at least more than 20 different beer types, many with names and descriptions greatly different from their initial origin.

Beer types

The question most often asked by visitors to the Brew House is about the name and its relevance to the type of beer. I will attempt to explain the differences and provide a general glossary of beer types. The first thing to remember is that the basic ingredients of beer have generally remained unchanged for centuries and still consist of only four main elements: malted grain, hops, water and yeast (although some speciality beers may have other flavourings, such as fruit and herbs, added).

Another major difference to note is how the beer is stored, packaged and served both at the brewery and at the point of sale. Refrigeration and other technological advances have enabled keg and bottled beers to be filtered so that in effect the live beer is killed off at the brewery. Euphemistically, the brewers term these types of beers as 'brewery conditioned'. The beer is then artificially carbonated so that it will have a much longer shelf life, it can be served at lower temperatures, and there is little or no reliance on skilled bar staff to ensure consistency. By way of contrast, cask-conditioned and bottle-conditioned beers contain live yeast and continue to mature before serving. They do, however, have a much shorter shelf life, and a much greater reliance is placed on both the brewer and pub landlord to keep and serve them correctly. These types of beer are today commonly referred to as real ales. Historically, ale was not hopped, unlike all real ales today.

The first major difference in beer types today is that between what we commonly call lager and other types of beer. The word *lager* derives from the German word for storeroom. Before refrigeration these types of beer were stored in deep caves and cellars in order to allow them to mature fully. Refrigeration has since enabled this type of beer to be brewed globally. However, the basic difference between lager and British styles of beer starts much earlier during the brewing process. The biggest difference is that lager is fermented using a different type of yeast (known as a bottom-fermenting yeast) that works at a lower temperature (between 8 to 12 C) than British top-fermented beers (between 15 and 21 C). The hops used in lager brewing generally have lower bittering qualities and this, combined with longer storage at lower temperatures, gives the satisfying, refreshing crispness of the drink, especially in hot weather.

Although there are a great number of different brands of lager on sale generally, variations in taste are more due to differences in the maturation

process and the amount and quality of grain or the hops used rather than any intrinsic difference of beer type. At the quality end of the market are lagers such as the pilsners from the Czech Republic that use traditional Bohemian malt and Saaz hops and are still matured in large vats in the cellars of Pilzen. At the other end of the scale you may experience those beers that, whilst purporting to be lagers or even pilsners, bear little or no evidence of any maturation period or the use of quality ingredients.

Real ales

Although total UK consumption of beer has been declining over the last decade, sales of real ale have continued to rise year on year. Whereas the early 20th century saw the closure of all of Fife's breweries, now there are five, two of which have become established in Dunfermline recently: Abbot Brew House (see Fig, 1) and De Brus Brewery. Whilst lager sales continue to fall and lose market share, both sales of cider and real ale have continued to rise.

Surprisingly, most real ales are based upon re-working of the various beer styles developed in the 18th and 19th centuries. Although they often adopt the original names, in many instances they are not being true to their roots. The only new beer type to be introduced to the real ale market over the last 20 years is that labelled as *golden* or *summer* ale, or as *blonde* beer, in effect the product of the real ale brewers' successful response to counter the rising threat from lager. Typical Scottish examples of this range of beers include the highly popular Jarl from Fyne Ales, St Andrews Blonde from Eden Brewery and Adventuress from Dunfermline's Abbot Brew House. These types of beers are brewed using light malts, often with some lager malt, and bittered with light citrusy hops from Australia, New Zealand and the USA.

Figure 1. Abbot Brew House

Pale ales

Beware though, as a number of this new wave of beers are incorrectly marketed as being *IPA*s but although similar in their use of top-fermenting ale yeasts, their lower alcohol by volume (ABV, measured as a percentage) and lack of more highly kilned malts, indicate that calling them an *IPA* (India Pale Ale) would be regarded as a misnomer in original terms. Historically *IPA* was the beer name given by the Burton-upon-Trent brewers in the 1820s. The beers originally had to withstand a long sea journey around the Cape of Good Hope to India, crossing the Equator twice on route. The beer was heavily over-hopped and usually had an ABV of more than 6% (see Fig. 2). The high hop rate of the original style would make the beer undrinkable within the normal maturation periods that apply these days to beer brewed in Britain for consumption in their country of origin, and historical strengths intended for a hot climate would

be less quaffable in a cold one. Historically, the beer was matured in casks prior to shipping and this and the resultant long journey allowed the hops to mellow, resulting in luscious fully-matured ale. Many beers now described as *IPA* would be regarded as a pale shadow of a true *IPA* that was originally designed for transport to India.

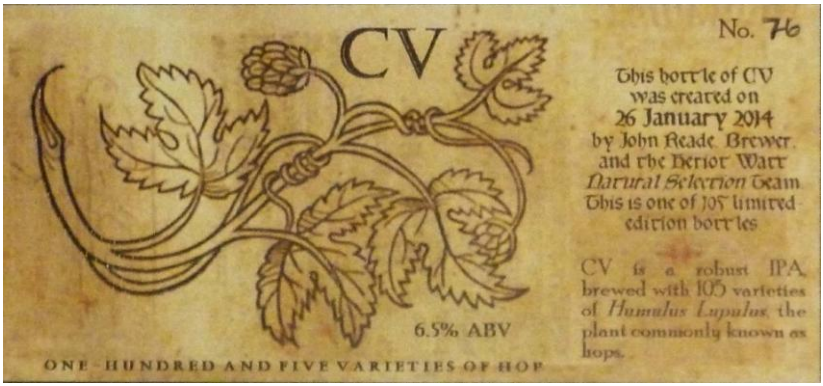

Figure 2. Beer label for Abbot House CV

During the 1700s Dunfermline was famous for its nut brown beers, probably because this was the only type of beer available in the town at that time. But outwith Dunfermline things were about to change. The invention of coke provided a smoke-free fuel for the curing of malt, thus enabling greater control of the kiln and the production of lighter malts – thus *pale ales* were born. However, the problem the Dunfermline brewers faced was that good pale ale required hard water, whereas Dunfermline's water supply was suited more to traditional nut brown and other dark beers.

Porter

The 18th century also saw the introduction of another major type of beer – *porter*. Today there is much confusion between what constitutes a *stout* and

a *porter*. Frankly, if you see a beer advertised as a stout or a porter, there is unlikely to be any great difference; they are both essentially a dark beer with moderate to strong hoppiness. It is only when other things are added to alter the taste that differences become marked, such as in Oatmeal Stout, Sweet Stout and Plum Porter, all recent variations of the basic beer type. To Georgian brewers the term *stout* simply meant a strong or robust beer and was applied to all beer types whether they were light or dark. Pale stout, brown stout and stout porters, were all types of beer from that period. It was only with the emergence of the Guinness brand that stout became recognised as the dark beer it is today.

Porter initially originated from London and, arguably, was created to combat the influx into London of provincial pale ales, because London water made good dark beer but indifferent pale ales. Originally porter was made entirely with brown malt. It was a stronger more heavily hopped version of the sweet brown beers of that time. It was very popular and over time changed from a dark brown colour to a black beer as the amount of brown malt was reduced and replaced by black malts and roasted barley. There was a whole range of porter related beers. Common porter, best porter, export porter, Scotch porter, stout, double stout, triple stout, oatmeal stout and Russian stout were all variations on the porter and stout theme of beers available in Scotland.

In 1861 one of the four breweries operating in Dunfermline at that time was located on Knabbie Street (today's Carnegie Drive, the brewery being sited at the current Bruce Street junction, a site chosen in modern times for a Tesco store). The brewery owner, James Hamilton, went into sequestration and the papers lodged list the types of beers he brewed, namely: held porter, scotch porter, (common) porter, pale ale, sweet ale, table beer and small ale. Only the terms porter and pale ale are recognisable beers today.

Scottish versus English beers

Even though you may still encounter the occasional traditionally named Scottish beer when you next go to the pub or off licence, more likely than not only the brewery name will indicate to you where the beer has been brewed. Developments in brewing science, technology and marketing have ensured that former differences between Scottish and English beers are much harder to find and now almost all types of beer can in reality be brewed just about anywhere. Nowadays you are just as likely to encounter a traditionally English light hoppy bitter that was brewed north of Inverness as south of the border. However, this was not always so.

Traditionally, there were marked differences in Scottish and English beer: in character, taste and name. Scottish beers were generally darker, more malty and less hoppy brews than their English counterparts. They were generally sweeter, being a product of beers fermented in a cooler climate and reflecting the lack of an indigenous hop industry. Indeed, many Fife breweries still produced beers they termed *sweet ales* right up to the end of the 19th century, with there being no comparable English equivalent.

The 19th century saw the introduction of many new beer types leading to the use of a variety of different names. In England a beer that was lightly hopped and ready for drinking young became referred to as a *mild.* It could be either light or dark in colour as the name referred to the amount of hops used. The equivalent beer in Scotland was, and still often is, referred to as a *light* or *60/-*.

Around 1880 there were changes to how duty was charged on beer and this led to the widespread adoption of the 'shillings' terminology that was peculiar to Scotland. In effect this was initially the price of beer charged by the brewer for a cask, reflecting the amount of malt used and hence the strength of the finished beer. *Light* or *mild* beers would often be referred to

as *42/-* or *48/-*, *pale ales* as *54/-*, *heavy* as *70/- export* as *80/-* and *strong ales* as *90/-* up to *15 guineas (315/-).* The range of shilling beer names you will encounter in the pub today is now restricted to 60, 70, 80 and 90 shillings.

In England the public started to refer to the pale ales that were sold in cask as *bitter* with stronger pale ales being termed *best bitters*. In Scotland the equivalent of bitter would be *heavy* (reflecting the higher hop rate in comparison to *light*) or *special* (a term that came in with the 20th century introduction of keg beers) or *70/-*. The equivalent of *best bitter* would now be *export or 80/-*. The English called the stronger, long matured beers a range of names such as *stock ales, old ale, stingo* and, the name still commonly used today, *barley wine.* Historically, the Scottish equivalent was a range of beers given a high shillings rating or numbers but today these stronger beers are either referred to as a *90/-* or a "*wee heavy*". A once famous dark beer name was *No 3 Scotch Ale*.

Another modern development has seen successful global marketing making the brand name synonymous with the beer type - the best example being *Guinness*. Likewise, I doubt if anyone now asks for a lager anymore but orders using the brand name – *Tennent's lager*, *Stella Artois, Budweiser, Peroni,* etc. In fact, for many years *lager* was known in Britain as '*lager beer*' to differentiate it from *ale*.

Conversely, most real ales, whilst they still generally stick to using traditional descriptions, tend also to adopt a wide variety of names reflecting their origins. For example at Abbot Brew House all our beers are associated with Dunfermline and its heritage roots. Others adopt more hidden meanings. Some of my favourites include Inveralmond brewery's *Thrappledouser* (named after the old Scots word *thrapple* for throat) and *Lia Fail* (Gaelic name for the Stone of Destiny) and Wells & Youngs honey beer, *Waggle Dance* (the waggle dance being the name given to the movement a bee performs to alert the hive to a source of nectar). So next

time you are in the pub and see an unusual name on the pump clip why not try and find out what it means – maybe it will add to the drinking experience?

The SBAA visited the Abbot Brew House in Dunfermline last year, where John Reade the brewer made us very welcome. During John's talk of welcome it became obvious that his knowledge of brewing history in Scotland and Dunfermline in particular was up there with the best. A few months later Harvey Milne made John Martin aware of several beer articles that appeared in the Dunfermline local paper written by John Reade, who later gave permission to include some of his words in this year's Journal. This may give readers the idea to try something different when next in a pub – and to discover the origins of the beer and its name.

How it all began for two fine beers

David McGowan *sheds light on the origins of two memorable beers: Gillespie's Malt Stout and McEwan's Champion Ale*

Gillespie's Malt Stout

In the late 80s, early 90s, a new name appeared on the beer scene in Edinburgh. Gillespie's Malt Stout literally popped up overnight across many of Edinburgh's famous hostelries, and in the late 90s the brand disappeared almost as quickly as it arrived. So, where did it come from, and why did it disappear?

In the late 1980s, I had just moved back to Edinburgh, and I was working in a hybrid sales and marketing role with Scottish & Newcastle (S&N), and was fortunate to work with Gillespie's for more than 10 years. Note the way, I refer to Gillespie's as if it were a real person; all brands have a personality ... at least to marketers they do! There are various explanations as to why S&N decided to enter the stout market and why they chose the name Gillespie's. So, first things first: why enter the stout market?

Historically, S&N had numerous stout-type beers in their portfolio, many appearing under the McEwan's and Younger's umbrellas, but due to various government restrictions on raw materials during the early 1900s, most stout production had stopped, except, of course in Ireland. In the late 1980s there was a resurgence in the stout market, nearly all of which was driven by Guinness, and which was linked to the commercialisation of St Patrick's Day and technical innovations such as draught-in-a-can technology.

Like many of the major brewers, S&N supplied free trade and tied retail outlets with a comprehensive portfolio of drinks – a one-stop shop – which included brands they owned outright, brands they had UK distribution rights for (e.g. Beck's), wines from Waverley, and of course a whole range

of soft drinks and other beers which were part of their wholesale range. Within this portfolio, Guinness was their lead stout.

With the Harp Brewery Joint Venture in Edinburgh now closed, S&N bought Guinness at wholesale prices, and then sold the beer to their customers. Despite the strong negotiating hand of S&N as the leading free trade brewer, the price they bought Guinness for was always going to be higher than the price of an in-house brand. And therein lay the commercial dilemma. The stout market was growing, and consumers were switching from more profitable in-house brands, brewed by S&N, to Guinness, and this 'cannibalisation' resulted in lost profitability.

The obvious solution was for the S&N procurement team to push for a better price on Guinness, but this Gaelic 'brick wall meets a hard place' negotiation was proving to be fruitless, and so S&N decided to launch their own stout. Several names were considered, including a brand using the McEwan's and Younger's umbrellas. Having chosen not to use their two core brand families, a search was launched for a suitable name.

The name Gillespie's was linked to an historic brewery business associated with Glasgow and Dumbarton[2]. The organisation developed a good reputation for its stouts and porters, hence as S&N searched for a name for their re-entry into the stout market, Gillespie's had a lot of strong credentials. The brand was initially launched in draught, in Scotland and Central TV regions and in 1992 a draught-in-a-can version, featuring the tapstream system, was introduced.

My own involvement at this stage was to help launch the packaged version. At the time, I was an Account Manager working on the Tesco

[2] A short history of Gillespie and Sons Co. Ltd. by T. Daniel Kane and Charles McMaster is available for reference in the Scottish Brewing Archive at the University of Glasgow Archive Services.

account, and the decision to launch a packaged version was partially inspired by the Tesco buyer, who was from the Midlands, having tried the beer in his local, asking if we had plans for a packaged version. Hence, the initial launch of the packaged version in Scotland. To stimulate trial in the off-trade, the product was often jointly promoted with McEwan's Export, which was the number one beer in the off-trade.

Figure 1. Gillespie's font and glass

Over the next four or five years, Gillespie's (see Fig. 1) continued to flourish across the UK, and sales continued to grow. The reason the product grew was simple. It was good. It had the full body of Guinness, but was slightly sweeter making it more accessible for IPA drinkers, and even premium lager drinkers like myself. However, the acquisition of Courage in 1995 created a strategic challenge for Gillespie's, as the acquisition also included the Beamish Brewery in Cork. With no real choice but to back Beamish, a decision was made around 1997, to effectively cut

support for Gillespie's and promote Beamish Red and Beamish Black instead – neither of which was a lasting success.

Gillespie's continued as an off-trade product until approximately 2001, when in the light of minimal support and declining sales, the brand was withdrawn. However, this wasn't quite the end of the story. At various points between, I was involved in running a specialist business unit within S&N, which produced own-label beers, exclusive brand marques and nurtured some of the specialty beers which required more focus and attention.

With no significant off-trade presence in the stout market between 2001 and 2004, limited batches were produced as an 'exclusive' for firstly Asda, and then for the emerging discounter chain Aldi. Indeed, for approximately 18 months, Gillespie's was effectively an own-label stout for Aldi, until they began selling O'Connell St, which was produced by S&N at their plant in Cork. Sadly, in 2004, the final batches of Gillespie's disappeared from the supermarket shelves. However, it is interesting to note the number of folks who still have fond memories.

McEwan's Champion Ale

In 1997/8, in a move designed to set them apart from their competitors and to increase sales of premium beers, Tesco, working in conjunction with Richard Morrice of the Morrice Partnership, introduced their first Tesco Beer Challenge. The entry rules were quite simple. It had to be a new brew, and the prize for the winner was distribution for the winning beer in Tesco's stores, offset by offering Tesco exclusivity for six months.

The competition immediately captured the imagination of myself and colleagues at the recently formed Scottish Courage Exclusive Brands (part of Scottish & Newcastle plc). Here was an opportunity for us to work with our colleagues in Brewing & Operations, to show the world what we could

deliver. (At this point, I have to be honest and say that much as though I relished the competition, my cynical hat said, "We are too big to win this, the winner will be a small brewer").

Our Operations Director was equally enthused by the competition, and came up with the brilliant idea of replicating the challenge internally across all the UK breweries owned by S&N. And so, the gauntlet was thrown down, with some excellent beers coming forward from Fountainbridge, Tyne, Tadcaster, Royal and Berkshire breweries. An internal judging panel selected the winner, a 7.3% Scottish Ale developed by the brewing team in Edinburgh.

The next stage was to put the liquid forward in an unbranded format for the judging day in London, where a team of judges including a famous beer-writer, the late Michael Jackson, the Buying Team at Tesco, and journalist James Brown, chose the winner. To say we were delighted by our success is an understatement, but this is where the real work began. We had approximately ten weeks to get the product on the shelves - liquid produced, bottles sourced, bar codes at the ready, but the most important decision was a name.

The name McEwan's No1 Champion Ale was based around the winning liquid being brewed from a McEwan's yeast strain, whilst No1 and Champion were a reflection of our winning status. From this, the brand designs were created, which featured the Tesco Challenge winner's logo, and a back-label message was developed telling the story of the brew and was attributed to the Production Director at Fountainbridge Brewery. Incidentally, the sentiment of the back-label message today doesn't vary significantly from the original. One interesting twist in the whole competition; it is a rare occasion when a leading supermarket tells you they will distribute your brand in 300-plus stores, and then asks how much it costs!

The product went into outlets in late summer, and Tesco/The Morrice Partnership did an excellent job of promoting both the competition and the beer in outlet, with Champion Ale (see Fig. 2) rapidly establishing itself as one of their top five bottled ales. In early 1999, the beer received another boost after *Telegraph* beer writer Robert Joseph described Champion Ale as "quite simply one of the best beers I have ever tasted". Never ones to miss a trick, after an interesting negotiation with the *Telegraph*, we put this quote onto point-of-sale and a collar-label on the bottle.

Figure 2. Champion Ale beer label

By now, the brand had established itself as a "top 3 bottled ale" within Tesco, but our period of exclusivity with Tesco was nearing completion. The decision to extend the exclusivity for another six months was a quick and simple one. A year after the beer was launched, we started to sell it to a wider audience and, with only one exception, other off-trade customers were interested in stocking it in their stores.

Again, we used the Robert Joseph quote to promote the beer, although understandably rival supermarkets wanted us to remove the Tesco Beer Challenge Winner's Logo. And so, in late 1999 the start of the Champion Ale journey continued and to this day, the brand continues to be one of the UK's most popular bottled ales, now part of the Charles Wells Group.

John Martin recalls that this article came about by chance after he met David McGowan when they attended a talk by Allan McLean. "I had not met David before and at the time we swapped our contact details. It was a few weeks later that David and I met up to further discuss some of the points that had been raised during Allan's talk, namely the origin of Gillespie's Malt Stout and McEwan's Champion Ale," John said. "Following our discussions, David not only agreed to write this article on the two beers, but also joined the SBAA. I am a great believer that one thing can lead to another and so it proved in this instance," he added.

Crossing brewtown from Holyrood to New Fountain

Richard Rees *returns to a theme that enthralled readers of the 2014 Journal*

"Richard, we would like you to go to New Fountain to fill one of two new Senior Brewer positions. They have a few problems there and you know about computers. Lew Grant will look after the brewhouse and fermentation. We need you to manage maturation and filtration and also the production planning."

Now I had been to Fountain before when I first joined Scottish and Newcastle as a graduate trainee in 1972. It was their first graduate intake – just 4 people, plus 2 specialists, one of whom I later married….

My first office had been in the personnel department within Gilmore Park. In its prime, it had been the Boardroom offices of the North British Rubber plant which had been built between the Union Canal to the south, and Fountainbridge to the north.

The North British Rubber Company, an American concern founded to use Charles Goodyear's patent for vulcanising rubber, had acquired the site, formerly Castle Silk Mills, in 1856 (coincidentally the year when William McEwan established the original Fountain Brewery nearby). The North British Rubber Company started production making tyres, conveyors, combs, golf balls, hot water bottles, rubber flooring and, above all, (or should it be below all) rubber boots. At the start of World War I, the War Office had commissioned the company to construct a sturdy boot suitable for the flooded trenches. During the war 1,185,036 pairs of trench boots were made, with mills running 24 hours a day to keep up with the Army's demand.

North British Rubber was bought by Uniroyal Limited in 1966, and sold on a number of times subsequently before a management buy-out in 2004 established an independent company, Hunter Boot Limited, of green welly fame. Physically, the plant had expanded across Gilmore Park to the east and across Viewforth to the west. The business (now Uniroyal) moved out to Newbridge in the 1960s. Most of the buildings had been demolished by 1971, to be replaced by the New Fountain Brewery, which started operation in 1973 (see Fig 1.).

Figure 1. New Fountain Brewery

It was this brand-new computerised brewery, designed as a series of process blocks, that I looked out on as I started my career in the brewing industry in 1972, little knowing that I would be helping to manage the plant only a few years later. In those days, lunch (and breakfast) at Fountain was taken in the Old Fountain canteen. The canteen was located on the roof of the Old Fountain Brewhouse. For me, this meant crossing Dundee Street, dodging the No 4 and 34 buses I used to get to my flat in

Jeffrey Street, and entering Old Fountain through the original main gate, resplendent with the McEwan's clock cantilevered out above Fountainbridge.

The setts of the courtyard within concealed the original brewery well, sited on a geological fault that ran under the site towards the Castle. This water source, together with the transport links provided by the Union Canal to the south and the Caledonian Railway to the North, provided the reason for the location (and name) of Fountain Brewery. In the corner of the courtyard lay a vast goods lift, and it was by this means that you ascended to the delights of the canteen. A Fountain employee, always immaculate in blue bib and braces overalls, and a light coloured check sports jacket, breast pocket full of pens arrayed as if they were medals, operated the lift.

The old canteen was indeed full of all sorts of delights. The most obvious was the magnificent view: north across the Firth of Forth to Fife, east to the Castle. Then there was the menu, subtly different from what I had been used to in Northumberland. At breakfast, floury baps not rolls, filled with Ayrshire roll bacon or slicing sausage (not links, and beef not pork), black pudding and fried egg. And the lunchtime charms of beef olives, haddock rather than cod on Fridays, stovies and, of course, haggis (but not that often). But the most important part was the service by waitresses. No self-service cafeteria then: table service was provided by Minnie and Ina. "What'll it be today, my son?" "Two bacon, one egg, hen." Bless them both, the real people.

5pm meant an exodus from the office to Betty Blyth's bar, The Fountain, where we did our best to consume quarter gills of Mackinlay's along with halves of oxidised beer. The impact of the Excise regime, and the need to use every drop of duty-paid beer had a terrible impact on quality, especially when pasteurised beers came along. A "shushing" meant that somebody was going to sing…. Ah those were the days.

New Fountain was very modern for the time but with a strong admixture of operating practice of Holyrood Brewery: a gas-fired boiler house – later equipped for oil-burning with bunded tanks[3] and a 60-metre high multi-flued stack in order to get better prices for the gas as we could switch to oil at peak times; and a Balfour of Leven brewhouse – cereal cooker, mash mixer, lauter tun, stainless steel coppers with external calandria, whirlpools, 30 tonnes grist.

The FV (fermentation vessel) block beside the canal on the west side of Gilmore Park contained the wort paraflows, yeast-handling, cylindro-conical fermenters (installed in two phases with 1,000 barrels and 1,200 barrels of working capacity), and two Alfa-Laval centrifuges to pump fermented beer to the maturation (MV) block. The MV (maturation vessel) block contained 40 huge vertical, dish-bottomed MVs without upstands. Two (later three) Stella Meta candle filters were there to process beer for kegging and bottling on the Old Fountain site, and for canning at the new High Speed Can Lines on the west side of Viewforth. Beer for so-called Bright Beer and cask was pumped to tanks in Old Fountain on the other side of Fountainbridge.

Like all such plants, it was constantly being modified. A block of 2,500 hectolitre Unitanks (DPVs) arrived. High-gravity brewing (@1055 collection gravity) came along too. Much of this was in response to the construction of the High Speed Can Lines (HSCL), as the small-pack demand from the supermarkets grew rapidly. Much of the philosophy behind New Fountain was a blend of the new, and of the past experiences gained from Holyrood of lauter tuns and conical FVs. A strength, undoubtedly, but it also brought weaknesses too, weaknesses which appeared elsewhere in many of the new mega-breweries built at the time.

[3] The bund lining system is a fast setting coating protection for tanks

When Lew Grant and I were parachuted in, we found the brewery had got itself in a mess they could not deal with however hard they tried. Superficially the issue was that the brewery was "only" producing 40,000 barrels per week, when it should have been producing 50,000. Indeed it was hardly producing more than the Holyrood brewery. And we were heading into what became the very hot summer of 1976 when the UK beer market was close to its peak. It had become "One man's fantasy, everybody else's nightmare".

I had started university in 1969, and been told immediately to forget everything I had been taught at school, as we would be leading the charge to move from qualitative analysis to quantitative systems modelling. And we were given access to the most powerful computer in the UK to do this, which was as they would say now, pretty cool. I rapidly discovered that if I worked night shift, I could get more bandwidth, and would finish at dawn, thence to the river for many miles of rowing on the water, and finally on to supervisions, where I would promptly fall asleep. Sad but true, I had found computer simulation addictive.

But I gained the experience and the analytic tools which were rapidly to show where the causes of the problems at New Fountain lay and how they could be solved. The immediate problem was getting bright beer supply moving out to packaging. That was what paid the bills, and if we didn't clear the MVs then we could not clear the FVs and we could not brew. So of course everybody blamed the MV block, and that meant it was the MV Block Manager's fault. Me.

A charming and deeply Christian gentleman, Cedric Tadman, Taddy to all who knew him, did the production planning. In retirement, dear Taddy was to suffer a shocking and untimely demise when he fell through an open hatch into the cellar of a shop he was visiting. Taddy kept things going whilst I analysed why the MVs were struggling. The clue was the

problem of steadily increasing tank bottoms stocks, which reduced output, and reduced our capacity to produce beer. This had been seen as failure by the MV department rather a symptom of a much wider malaise.

Taddy was able to provide me with the MV records and we quickly produced graphs showing the spread of dwell times in the MVs. The target maturation time (for ales) was 72 hours, with a limit of 60 hours when authorised by the lab manager on a case-by-case basis. The graphs showed that the average dwell time was 58 hours and there was significant leptokurtosis[4]. Not some awful mediaeval disease, but rather that the minimum dwell was not much less than 58, I think it was about 56, but the maximum was about 96 hours. It was realised that in these long-stay tanks was beer that should have been filtered before the weekend, but was not ready then and had to wait until after the lengthy CIP process was completed.

Remember the MVs were vertical and dish-bottomed with no upstand. Not exactly helpful when settling time is cut short, and huge amounts of tank bottoms had to be drawn off before a bright(ish) flow could be presented to the filters. Needles to say, the analysis showed that filter runs were also found to be very short, despite the best efforts of the crew to avoid putting this frankly cruddy beer on fresh filters. Candle filters take an age to drop and flush, and woe betide anybody who tried to rush the coating of the candles.

Unlike the rest of the brewery, the MV crew worked three shifts Monday to Friday. They also had a pretty steady and expensive weekend of overtime

[4] For a definition of clustering of points along an X-axis, look up "leptokurtic" on Google.

to try to have BBTs filled with filtered beer ready to be pumped into the packaging areas ahead of the start of kegging, canning and bottling on Monday at 6 am. But the crew valued their Saturdays and Sundays and were not happy at having to work weekends when their filters could be on recycle during the week, waiting for rough matured beer to become available. Negotiations started to put the MV crew on seven-day continental: push-back to start with, but then the union convener pointed out that, in reality, we could split the crew between the existing three shifts and the continental system. Rapid agreement all round. The un-gumming process had started.

Working back up the process, there were two rough beer mains from the FV block to the MV block. Two Alfa centrifuges drove the beer at 250 barrels per hour, but did not adequately clarify the beer, especially when the FV dwell time was shorter than desirable and the beer needed to be sent to MV as quickly as possible. So that explained the source of the contents of the MV tank bottoms.

Onward to the brewhouse, where the records showed that the brewhouse was often at a standstill, with coppers, lauter tun and mash mixer all full, waiting for FVs of the correct size to become available. The brewhouse produced brew lengths of 1,000 and 1,200 barrels (a barrel being 36 gallons) depending on the grist: the FVs were also 1,000 barrels (Phase 1) and 1,200 barrels (Phase 2).

Statistical analysis suggested that if three FVs were empty, there was a 95% chance that a FV of the correct size would be available. The penny dropped that if the FV-MV transfer programme started about three hours before the brewing programme commenced then those FVs would be available.

In parallel with this analysis, a computer simulation model of the brewery was built to test the proposals. The model was written in FORTRAN, and a

bank of computers in Philadelphia was hired to do the number-crunching. No Internet then, of course. A POTS (plain old telephone system) line to Carlisle, thence by so-called high-speed line to the Transatlantic Satellite Dish at Goonhilly Down in Cornwall, linked my teleprinter to the GEISCO computing facility in the USA.

Now this was a very slow process. One day my boss brought the Production Director, Michael Van Gruisen, to see what I was doing. MHVG was a man of the old school, ever charming, of military bearing. Allegedly he had mashed in at Tyne Brewery in his mess kit, spurs and all. I will never forget his opening small-talk gambit when we first met: "Do you beagle, Rees?" "Well not in public, sir," was my inadequate reply.

The teleprinter had a heartbeat message to show it was connected: "Please wait. Please wait. Please wait." MHVG: "Not quite sure what you are doing, Rees, but you have a very polite computer. Jolly good. Keep me informed."

To my delight, and not a little astonishment, the model confirmed that by simply delaying the start time of the brewing programme, the current hiccups in the process would disappear and output would rise. As importantly, the spread of dwell times in MV would reduce sharply and the average time would rise significantly, producing brighter beer and enabling longer and more reliable filter runs.

And so it proved. Production did indeed rise, to a peak of 55,000 barrels in a week and 300,000 barrels over six weeks. Consistent availability of beer allowed production plants to sort their underlying technical problems: more reliable packaging allowed better performance in the MVs and a virtuous cycle was created. The HSCLs went on to become the fastest lines in the world, producing 100,000 cases of 44cl cans in a day.

Of course not everything went well. At the start of each day I would visit the MV block sample room to sign off the filtered beers in BBT awaiting packaging. Now I was blessed with the presence on my team of not only the senior shop steward (Dougie) but also the union convener (Alec). Contrasting characters, Dougie could have "Fred McKite moments"[5]. The normally smiling Alec was not known as "Bouncy Begg" for nothing.

The beers were presented in glass sleevers for me to check for nose, flavour and appearance. The shift team did CO2, colour, pH and clarity for me. Normally my task was a routine and pleasant one. One evening, the usual procedure commenced. The first sample was quite normal. The next looked and nosed normally but when tasted revealed a strange, almost earthy, taste: three in 1 oil came to mind. I had been working with an engineer on some kit that afternoon and assumed I must have carried some lubricant on my fingers or mouth without realising it. Much washing of hands was undertaken. Back to the sleevers, and one after another gave the same result on my palate. Now somewhat worried, I went into the neighbouring filter room and found "Bouncy" on duty.

"Alec, can you taste some beers for me?" "Aw boss, you're setting me up, aren't you." But secretly flattered, he went through to the sample room where we found the shift controller, David, looking at the history of the beers with a puzzled expression. All three palates agreed: oil. Bouncy dashed through to the filter room to tell the operators to put all the filters on recycle. David stopped all beer movements to the packaging areas with a request to resample all tanks. An operator, Jimmy Glass, was despatched to the DPV (dual purpose vessels) block to sample the rough beer tanks. These proved free of any taint. The Bright Beer Tanks (BBTs) were sampled

[5] Fred Kite was the bolshie shop steward played by Peter Sellers in the film "I'm all right Jack!"

again as were the filters. There was an oil flavour, but no impact on head, nor even a surface sheen.

A visit to the very warm and dry filter powder store room showed the painful truth: many of the bags were oil stained. A call to the supplier's rep, the much missed Alastair Lawson, "Alastair, I think we have a problem."

The post-mortem the following morning showed that the filter powder had been delivered on a vile rain-swept day, so dark that it was like night in the early afternoon. The bags became wet and of course the paper they were made of darkened. Nobody noticed anything wrong as the pallets were sent up to the store on the goods lift. However, this lift, despite being in a new building, and despite the knowledge that the greater part of the filter powder was imported, had been sized to just accept the small traditional UK pallet, not the standard European ones. As a result the powder was being delivered from France to a store in Livingston and then re-palletised onto the smaller pallet. Unfortunately, the pallets used this time had previously carried drums of tractor lubricant and the powder bags on the base layer had sucked the oil out.

My only consolation was that my team knew exactly what to do to recover the situation and got on with that, whilst the usual emergency management meetings were undertaken. We lost very little production time, but quite a lot of beer of course. Another Edinburgh brewery found the problem in package, but fortunately before despatch. But another had sent their beer out to trade….

On another occasion, a supplier's tanker used for wort syrup and clearly marked "for food products only" had been used to move a batch of phenol, and the wort syrup was contaminated with a phenol crystal about the size of a fingernail. This was not detected until after the brews receiving the

syrup had been collected. Result: about 6,000 hectolitres of beer for destruction, quite a challenge to negotiate with both the Customs and the City Council Drainage folk.

And the sadness one snowy morning of the inimitable Jimmy McKay, Tanker Bay foreman, when he learned that one of his drivers had been killed at Co'path when the tanker skidded.

On reflection, I realise that New Fountain, despite its modernity in automation and lack of hands-on contact with the product, was much like Holyrood, characterised by its people rather than its technology.

Figure 2. Scotch Ale beer label

I am writing this during a visit to Belgium to see what is happening in their breweries. A lot of technology, with no expense spared, and yet each plant having a quite different feel. The crucifix above the desk of the engineer in a monastery brewery, a neighbourhood brewery whose operation reflected the engineering background of the Production Director, and the family brewery. Technology yes, but it was not dominating the people using it. A

particular joy has been watching and listening to the younger brewers (and brewsters) and their enthusiasm for brewing at a human scale.

I used to brew Scotch Ale for Belgium (see Fig.2): I have just seen a bottle in the bar. Thanks for reading this.

Richard Rees offers this postscript to his fascinating personal account of his times at S&N's Edinburgh breweries "Dear Reader, I was delighted by the response to my article in last year's Journal on Holyrood Brewery. I became aware afterwards that I did not mention my white-coat and brown-coat brewing colleagues. So, to Jim, Ian, the illustrious Giles, Bob, George, Arthur, Jimmy, Tom, Alan and many others, not to mention the engineers, instrument mechanics, sparks and plumbers, and the shift teams who made it all possible, simply, Thank you."

Collection of beer related poems

John Martin *waxes lyrical on the subject of beer*

Introduction

Over the last few years I have come across a few beer-related poems either at the Scottish Brewing Archive or via a variety of other sources. In fact our very own Harvey Milne recited a verse from the Alloa Ales poem at our last Christmas social at the Sheep Heid. This was a follow-up to a film that Harvey made available to view at last year's AGM in Falkirk. The film gave us a guided tour of Alloa Brewery where Harvey used to work. All this gave me the idea of bringing together a selection of beer-related poems.

Auld Lang Syne (2nd verse)

An' surely ye'll be your pint-stoup,
  An' surely I'll be mine;
An' we'll tak a cup o' kindness yet,
  For auld lang syne.

Robert Burns

Heather Ale: A Galloway Legend

From the bonny bells of heather
  They brewed a drink lang-syne,
Was sweeter far then honey,
  Was stronger far than wine.
They brewed it and they drank it,
  And lay in a blessed swound
For days and days together
  In their dwellings underground.

There rose a king in Scotland,
A fell man to his foes,
He smote the Picts in battle,
He hunted them like roes.
Over miles of the red mountain
He hunted as they fled,
And strewed the dwarfish bodies
Of the dying and the dead.

Summer came in the country,
Red was the heather bell;
But the manner of the brewing
Was none alive to tell.
In graves that were like children's
On many a mountain head,
The Brewsters of the Heather
Lay numbered with the dead.

The king in the red moorland
Rode on a summer's day;
And the bees hummed, and the curlews
Cried beside the way.
The king rode, and was angry,
Black was his brow and pale,
To rule in a land of heather
And lack the Heather Ale.

It fortuned that his vassals,
Riding free on the heath,
Came on a stone that was fallen
And vermin hid beneath.
Rudely plucked from their hiding,

Never a word they spoke;
A son and his aged father --
Last of the dwarfish folk.

The king sat high on his charger,
He looked on the little men;
And the dwarfish and swarthy couple
Looked at the king again.
Down by the shore he had them;
And there on the giddy brink --
"I will give you life, ye vermin,
For the secret of the drink."

There stood the son and father,
And they looked high and low;
The heather was red around them,
The sea rumbled below.
And up and spoke the father,
Shrill was his voice to hear:
"I have a word in private,
A word for the royal ear.

"Life is dear to the aged,
And honour a little thing;
I would gladly sell the secret,"
Quoth the Pict to the king.
His voice was small as a sparrow's,
And shrill and wonderful clear:
"I would gladly sell my secret,
Only my son I fear.

"For life is a little matter,
And death is nought to the young;
And I dare not sell my honour
Under the eye of my son.
Take *him*, O king, and bind him,
And cast him far in the deep;
And it's I will tell the secret
That I have sworn to keep."

They took the son and bound him,
Neck and heels in a thong,
And a lad took him and swung him,
And flung him far and strong,
And the sea swallowed his body,
Like that of a child of ten; --
And there on the cliff stood the father,
Last of the dwarfish men.

"True was the word I told you:
Only my son I feared;
For I doubt the sapling courage
That goes without the beard.
But now in vain is the torture,
Fire shall never avail:
Here dies in my bosom
The secret of Heather Ale."

Robert Louis Stevenson

Where have all the breweries gone?

When CAMRA cried with hint of scorn
"Where have all the breweries gone?"

I thought I'd take a backward look
At an old-established brewery book

It was by chance quite heaven sent
To find out where these breweries went
So I made myself a lengthy list
And please excuse the ones I've missed

Where have all the breweries gone?
No Knox of Cambus, no Cameron
Never again will we praises sing
For good old Campbell Hope & King

Where is the pint that's too good to hurry
Brewed at Craigmillar by William Murray
And McLennan & Urquhart of Dalkeith
Their blessed memory we will keep

And tell me friend, just where the hell
Have John Youngs gone from Ladywell
And Duddingston looks quite neglected
Now Drybroughs and MacLachlans have defected

And others from us have been taken
Like Aitchison, Jeffreys, Mackay and Aitken
And other names we'll never see
Are Wrights, and Ballingalls of Dundee

George Youngers are no longer there
As neither are Gordon & Blair
Robert Youngers have left St. Anns
As Fowlers have at Prestonpans

Oh how I wonder where they are
Deuchar's and Morison's (with one 'R')
There's Ushers and Bernard T &J
They've also just slipped away

Calders sadly have gone down
And Blairs of Alloa in that town
But Maclay & Co still survive
To keep the tradition yet alive

And nobody yet has quite replaced
Steel Coulson, tho' they were Glasgow-based
But Hail Caledonia for Lorimer & Clark
For they are now back on the park

Now at the present we've arrived
To view the lads who have survived
To Tennents of Glasgow and Alloa too
And S & N we owe our due

And out of town, not very far
We have Belhaven in Dunbar
And beer is brewed down at Traquair
That's guaranteed to turn your hair

Anon (per Ridland Tait)[6]

[From *Barnard's Noted Breweries of Great Britain and Ireland*]

O, Dowie's ale! Thou art the thing.
That gars us crack, that gars us sing.

[6] Dating from a time in the late 20th century before even more brewers left the scene

High fill your tankards, fill apace,
We'll drink away to fame;
Younger's pale Ale shall be our chase,
Friendships and joy our game.

A draught of stout is good, no doubt,
And so's a glass of wine;
And "Mountain Dew" is sometimes, too,
A favourite of mine;

But good as all of those potions are,
As daylight it is clear,
Naught can surpass a foaming glass,
Of sparkling bitter beer.

Anon

Oh, Gude Ale Comes

Oh gude ale comes and gude ale goes,
Gude ale gars me sell my hose,
Sell my hose, and pawn my shoon,
Gude ale keeps my heart aboon.

I had sax owsen in a pleugh,
They drew a weel enough;
I sell'd them a' just ane by ane,
Gude ale keeps my heart aboon.

Gude ale hauds me bare and busy,
Gars me moop wi' the servant hizzie
Stand i' the stool when I hae done,
Gude ale keeps my heart aboon.

Oh, gude ale comes and gude ale goes,
Gude ale gars me sell my hose,
Sell my hose, and pawn my shoon,
Gude ale keeps my heart aboon.

Robert Burns

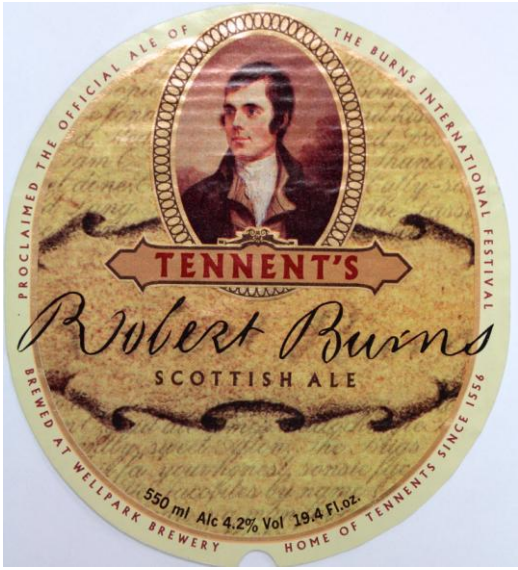

Figure 1. Robert Burns beer label

Alloa Ales

Awa' wi black brandy, red rum and blue whiskey
An' bring me the liquor brown as nut;
O! Alloa Ale ye can make a chiel frisky,
Brisk, faewming a' fresh frae the bottle or butt.
An awa wi' your wines – they are dull as moss water,
Wi' blude colour'd blushes, or purple, or pale;

Guid folks gif ye wish to get fairer and fatter,
They aye weet your seasans wi' Alloa Ale!

Gif ye wish healthie habits an' wad be lang livers,
Then spirituous drinks ye s'ould never fash wi';
But Alloa Ale ye may drink it in rivers,
An' the deeper ye drink, aye the better ye'll be,
Sae potent as physic its virtues are valued,
They daily wha drink look hearty an' hale;
O ye a' hae heard tell o' a Balm hot in Gilead,
Tak my word for't t'was neathing but Alloa Ale!

Then countrymen croud roun' the bizzing ale bicker,
An waur no on whisky your siller an' sense;
Nae gate ye'll fa' we' the like o' this liquor,
That thro' body and saul can sic vigour dispense.
Let nae Brandy-bibber scare you wi his scoffin,
At prudence in drink – till he tire lat him rail;
Ilk a dram that he drinks is a nail in his coffin,
But you'll lenthen your life-lease wi' Alloa Ale.

John Fowler's Ale

Though grey are my locks, and wrinkled my brow,
Though my strength and my eyesight both fail,
I'm as blithe as the lark and cheerful e'en now,
O'er a bottle of John Fowler's Ale.

I covet not riches to render me blest,
And honours I count no avail;
Of all my enjoyments, the one I like best,
Is a bottle of John Fowler's Ale.

To those who despise the comforts I find,
And liquors of all kinds assail,
I would venture to say they would alter their mind,
If they tasted but John Fowler's Ale.

Such blessings as these we should never despise,
But make it a rule without fail,
Not to drink to excess but be merry and wise,
O'er a bottle of John Fowler's Ale.

Henry Grover, 1839

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