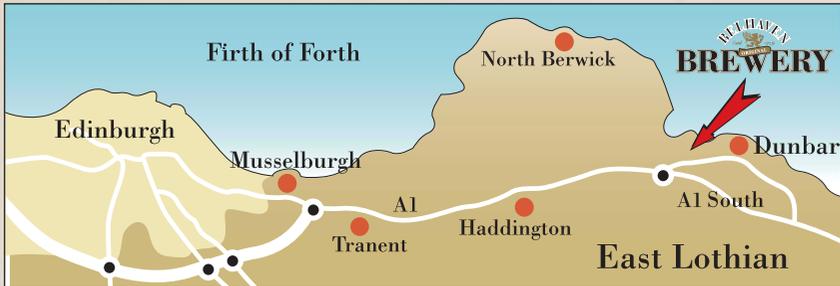


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## HOW TO GET TO BELHAVEN

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The Belhaven Brewery is signposted at the old village of Belhaven near the Mason's Arms public house. Dunbar is located only 30 minutes East of Edinburgh, just off the main A1 trunk Road from the South.

You can also travel by train from Edinburgh in only 25 minutes.

Tours of the brewery can be arranged but please telephone in advance of your visit.

**THE BELHAVEN BREWERY CO LIMITED**  
**DUNBAR EAST LOTHIAN EH42 1PE**  
**TEL: 01368 869200 FAX: 01368 865640**  
**EMAIL: [info@belhaven.co.uk](mailto:info@belhaven.co.uk)**  
**WEB: [www.belhaven.co.uk](http://www.belhaven.co.uk)**



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# WELCOME TO BELHAVEN

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Scotland's Oldest Independent Brewery

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**“BELHAVEN BEER IS THE  
BURGUNDY OF SCOTLAND  
...BAVARIA CANNOT  
PRODUCE THE LIKE”**

so said the Emperor of Austria

**“I STOPPED AT DUNBAR  
WHERE I TASTED  
THE BEST SMALL BEER  
I EVER HAD”**

so wrote James Boswell the famous diarist  
who wrote ‘the life of Dr Samuel Johnson’

**“BELHAVEN 80/- A BEER  
THAT IS RICH AND  
POWERFUL WITH A TASTE  
THAT WAS DISTINCTIVE  
AND MEMORABLE”**

So commented Tony Blair,  
Independent on Sunday 1993



## THE BELHAVEN STORY

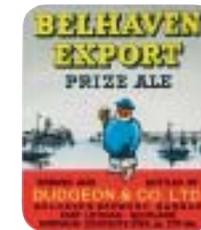
Belhaven lays claim to being the oldest independent brewery in Scotland and one of the oldest in Britain. Its history as a commercial brewery is well documented back to the year 1719, although it is probable that a brewery has existed on the site pre 16<sup>th</sup> century, as the wells and some of the cellar vaults in the brewery are known to date from around the time of the Reformation.

From the 12<sup>th</sup> century onwards, there was a great deal of monastic activity in the Dunbar area and Benedictine monks were granted land by the Earl of Dunbar both in the town and at a nearby harbour of Belle – later known as Belhaven (Fr. beautiful harbour). The monks who were noted brewers of ale worked the land and became well established and as a result, the area on which the present Belhaven Brewery now stands, became known as The Monks Croft.

There is little doubt that the monks took advantage of the excellent water available from

the wells and the proximity of fine quality local barley to brew good ale.

By the early 18<sup>th</sup> century, the site had come into the ownership of John Johnstone and this event is commemorated by the date 1719 carved on an old lintel on the cellar wall. It is generally accepted that under his ownership the brewery was established as “public”, brewing for commercial sale.



In 1814, a fire badly damaged the brewery (also noted on the lintel) and the opportunity was taken to rebuild it, including the surrounding older buildings. At the same time, a substantial new dwelling house was constructed adjacent to the brewery known initially as Belhaven Park, although soon to be known as Monkscroft House. The Johnstone dynasty ended in 1815 and was succeeded by Ellis Dudgeon who had wisely married into the Johnstone family. Thereafter, the brewery traded under the name of Dudgeon & Co, a name it was to retain for more than a century and a half.



# HISTORY OF BELHAVEN



Ellis Dudgeon, proprietor from 1811 and 1876

Ellis Dudgeon died in 1876 and was succeeded in turn by his son-in-law Alexander Hunter, a maltster from nearby Musselburgh. Some idea of the size of the brewery at that time can be gleaned from the surviving brewery books (now deposited with the Scottish Brewing Archives) and these show a variety of ales encompassing the traditional method of categorising beer in Scotland at that time – the “shilling” terminology. Dudgeons range stretched from light table/harvest beers 27/-, 36/- to stronger export ales such as 54/-, 80/- and six/seven guinea ale. The shilling system was purely an invoice price and although useful to denote ascending strengths of beers, this was not always the case, because of the different cask sizes.

The coming of the railway to Dunbar in 1846 greatly facilitated the dispatch of beer to inland destinations, but conversely exposed the country breweries such as Belhaven to competition from their larger counterparts. It is likely that as a result of this, Dudgeon started to concentrate on the malting side of their business although beer (on a smaller scale) was still brewed during this period.

In 1887, a further fire allowed extensive reconstruction in both the maltings and brewery

and again this is noted on the lintel.

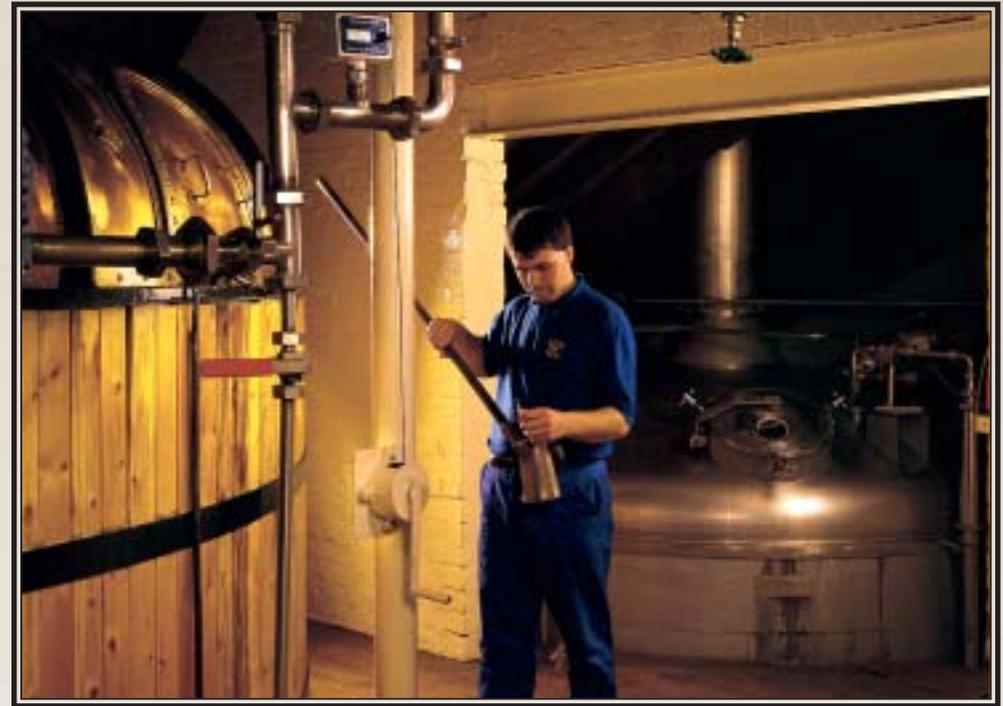
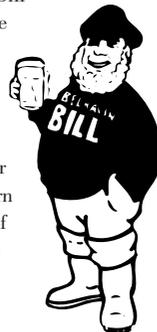
By the early 20<sup>th</sup> century, most of the smaller Scottish breweries had succumbed to the competition and were either closed or amalgamated into their urban counterparts. However, Dudgeon continued malting and brewing throughout both world wars – the military being a notable customer for Belhaven Beers. After the second world war, Ellis Hunter’s son, Alexander (Sandy) Dudgeon Hunter joined the firm and spearheaded the successful development of award winning ales culminating in winning the Brewers Challenge Cup in 1952 for Export Ale.



## BELHAVEN BILL

The early 1950’s saw the first appearance of the now famous ‘Belhaven Bill’ trade-mark, which was devised by Sandy Hunter in conjunction with his friend Bill Woolward. This depicted a large heavy fisherman wearing sea-boots, with Dunbar Harbour in the background.

Far from being modelled as has been claimed, on a particular personage, it was an idea born out of the cross-fertilisation of ‘Saxa-Sam’ (of Saxa Salt fame) and Father William (of William Younger’s beer).





Four horizontal lines for an address.

Mash tun and copper in the brewhouse.  
Belhaven Brewery, Scotland



Four horizontal lines for an address.

Brewery Garden.  
Belhaven Brewery, Scotland

Construction development in the early 90's



# HISTORY OF BELHAVEN

By the early 1970's, the malting side of Dudgeon and Co. Ltd was feeling the strain of competition from the modern automated plants and one option was to expand the brewing side of the business and close the floor maltings.

However, this was beyond the financial resource of the Hunter family and it was agreed to sell the business. Thus, in 1972, c. 250 years of family owned business came to a conclusion, however this was not the end, just the start of a new beginning. Over the next 20 years, Belhaven experienced a significant growth period during which a huge amount of brewing investment took place.

A Management Buy Out in December 1993, led by Stuart Ross, allowed the new management team to further develop the business.



In July 1996, the Company carried out a successful flotation on the London Stock Exchange and has recently changed its name to the Belhaven Group Plc to reflect the growing retail sales and pub acquisitions programme.

Since the flotation significant investment has taken place in process, packaging and the marketing of Belhaven brands.

# RECENT HISTORY

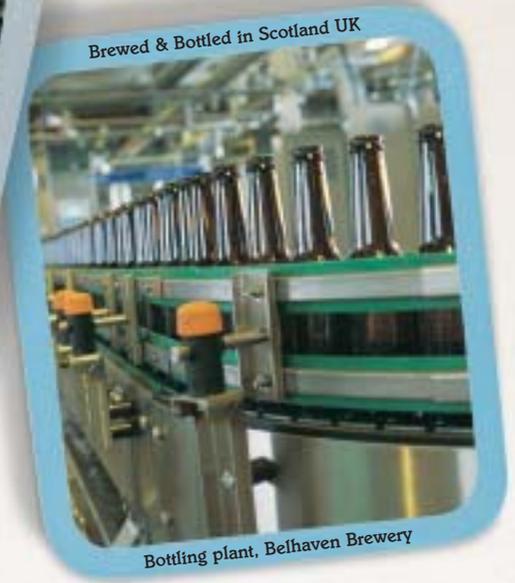
Over the last decade, there has been a drive towards continuous improvement in three main aspects of the brewery operations, namely - quality, reduction in energy costs and plant modernisation. With the growth of Belhaven Best, there was a requirement to ensure continuity of quality as well as increasing capacity. This was carried out by the introduction of new quality targets and tightening of allowed tolerances in every part of the process from malt intake to final package. Coupled with operator training and emphasis on laboratory checks, the management team could ensure that the requirements of the customer range can be met.

The fermentation tank farm that had been installed in the late eighties was augmented in 1995 with new dual purpose fermentation and conditioning tanks to raise the capacity from 64,000 Brls to 100,000 Brls/annum (a barrel is equivalent to 36 gallons or 288 pints). With state of the art malt handling equipment, upgraded wort production facilities, modern filtration systems and an automatic 4 lane kegging plant, the brewery is now well placed to brew and package all our beers within specification as well as franchise brewing for other Companies.

We also have over the last 12 years made substantial savings in energy costs with several initiatives. This includes the installation of a Combined Heat and Power Plant that generates 75% of our electricity, the installation of Reverse Osmosis equipment that allows us to use the original bore hole wells situated on site for brewing water (liquor) and a series of smaller initiatives e.g. low energy lamps, improved insulation, variable speed drives on motors that all help in the overall reduction of our energy costs.

In 2002, a capital spend of £1.5million allowed the installation of new bottling equipment to include a modern sixty head rinser/filler in association with new packaging equipment that provides maximum flexibility for various pack configurations and styles.

All these developments (and more) can be seen during the Brewery Tour which is an excellent example of the marriage of tradition with new technology and allows the visitor to experience a sense of history as well as an understanding of how fine beers are brewed and packaged.



INVESTOR IN PEOPLE

# THE BEST SUCCESS STORY

The most spectacular success story for the brewery has been Belhaven Best, launched into the Scottish market in 1991. A beautifully balanced smooth and creamy honey coloured beer; Best is dispensed using a mixture of nitrogen and carbon dioxide.

This nitro keg technology introduced in 1991, was a first for ales within the beer industry.

Belhaven Best had pioneered a new concept in beer drinking in Scotland, and the UK and its achievement was recognised in 1994 when Belhaven was awarded the Overall Scottish Marketing Award for an outstanding performance in a very competitive industry. Belhaven was also awarded The Scottish Marketing Millennium Award for its ongoing strategy for Best.

Since 1994 Belhaven has not rested on its laurels, it has been in the vanguard of beer product and beer packaging initiatives within the Scottish industry.

Not content with Best, Belhaven introduced Best Extra Cold in 1998. All the taste and flavour of Best but with the temperature dropped by a few

degrees to produce the ultimate in refreshing draught beer. Extra Cold was the UK's first extra cold beer brand and offered the consumer a more contemporary twist on the already popular brand.

You'll find Best and Extra Cold in pubs throughout Scotland.

Best is also exported abroad along with many other beers from the Belhaven portfolio; it is currently exported to countries such as U.S.A, Australia, Japan and throughout Europe.

How to get you hands on a pint of Best:

## SCOTLAND

Available in pubs, supermarkets and off licenses throughout Scotland.

## U.K

Please visit the online shopping facility on the Belhaven website. We are able to deliver beer to most of mainland U.K  
[www.belhaven.co.uk](http://www.belhaven.co.uk)

## OVERSEAS

Visit the overseas section of the Belhaven website for a list of our distributors abroad  
[www.belhaven.co.uk](http://www.belhaven.co.uk)



# BELHAVEN BEST THE CREAM OF SCOTTISH BEER

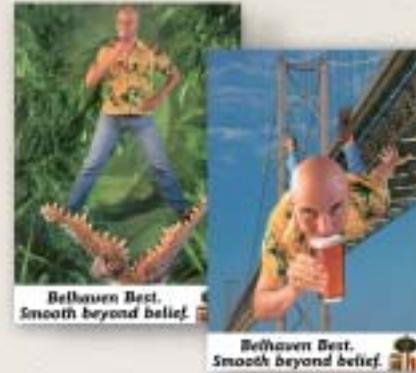
Belhaven dray



Belhaven branded taxi



Campaign: Smooth beyond belief, 1994-1997



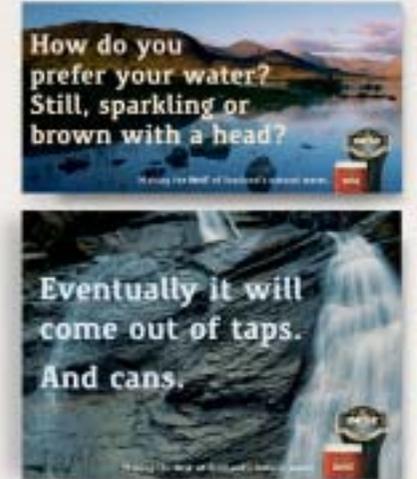
Campaign: No Contest, 1998-1999



Campaign: The Best is yet to come, 2001-2002



Campaign: Making the best of..., 2003



## OTHER BELHAVEN BREWS

### CLASSIC CHOICE

**ABV range from 4.6% to 5.2%**

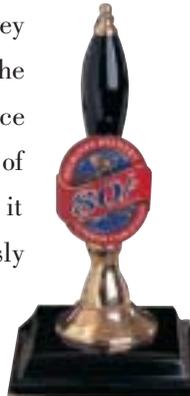
At Belhaven we just love beer. Truly adore it. So as a homage to the world's finest beer styles we've specially created the Belhaven classic choice range. Sample Belhaven's unique take on a rich medley of beer types - including Wheat, Bock, Spiced, Pilsener and Porter. We've also created a delicious Belgian style Fruit Beer with a Scottish berry-fruit twist. Proof we never forget our roots. Or our fruits.



### BELHAVEN 80/-(SHILLING)

**ABV 3.9%**

From an era when beer strengths were measured in money (a shilling being 5 pence in British money). Belhaven 80/- is the classic, hand pulled, cask conditioned Scottish Ale. Once described by the Austrian Emperor as 'the burgundy of Scotland'. He said 'famed as Bavaria is for it's strong beer, it cannot produce the like.' Today's experts have variously described Belhaven 80/- as 'malty & nutty' or even 'gooseberry pie & cream'. However people with great taste in beer usually like to let their taste-buds do the talking.



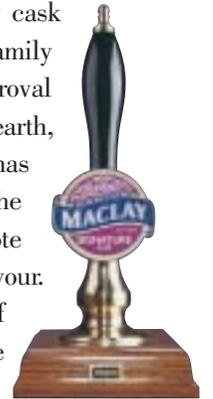
## OTHER BELHAVEN BREWS

### MACLAY SIGNATURE CASK ALE

**ABV 3.8%**

*'A welcome return to the cask ale from the heart of Scotland'*

For centuries the Maclay name was synonymous with quality cask conditioned ales from one of Scotland's oldest and finest family brewers. Now the Maclay name is back, stamping its seal of approval on this Signature cask. The same Maclay values of down to earth, honest Scottish beer can be found in this new real ale which has been brewed by Belhaven Brewery. Maclay Signature is the evolution of the hallmark Maclay beer. A pronounced malty note greets the tongue followed by a delicious digestive biscuit flavour. The originality of this beer is defined by the late addition of Styrian Goldings hops to each cask giving this brew a unique character. Some may say the Maclay Signature.



### ST. ANDREWS ALE

**ABV 4.6%**

*'Homage to the home of golf from the home of good beer.'*

While the burghermasters of one East Coast Scottish town were busying themselves with 'mashie niblicks', the brewmasters of Dunbar were more interested in mash tuns. Today this centuries-old fascination for fine beer has given us St. Andrews Ale. It's that rare modern phenomenon: beer that tastes like beer. 4.6% ABV, with a smooth, full bodied, malty flavour and fruity palate, a glass of St. Andrews Ale is the perfect mellow way to wind down.



# FROM WATER INTO BEER

## FRESH PURE SCOTTISH WATER

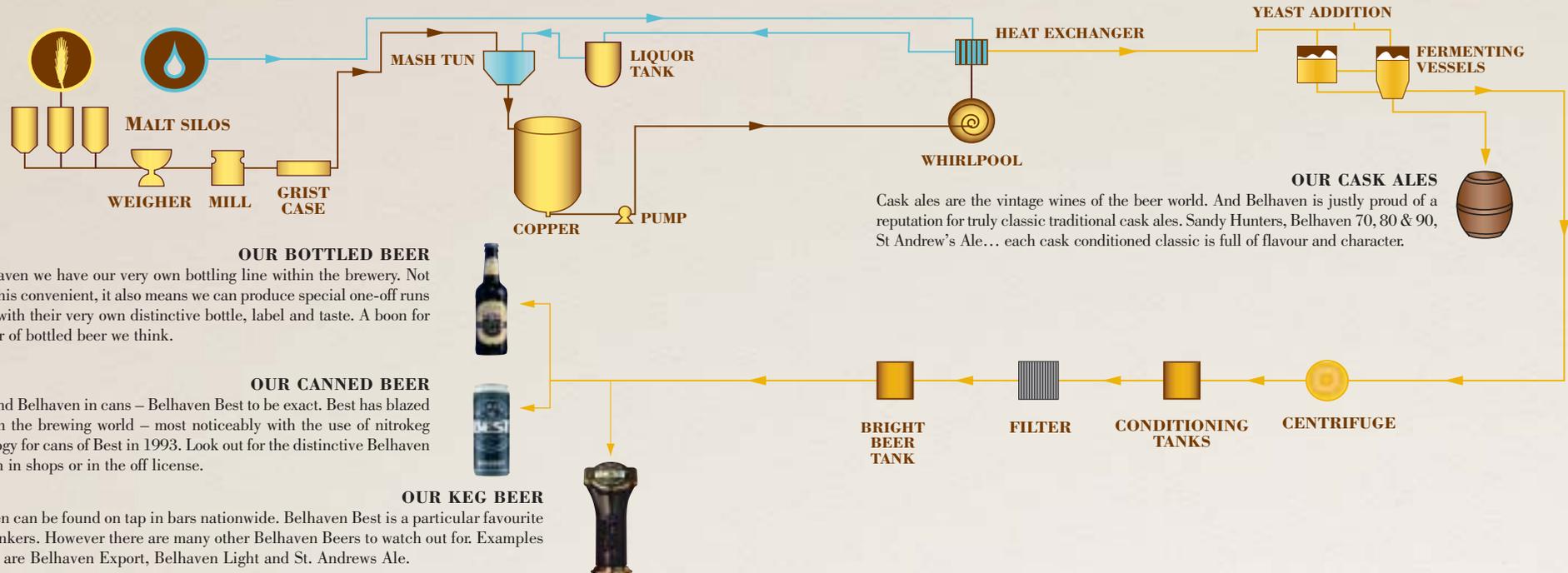
It is said that Scotland, in its lochs and reservoirs, possesses one of the world's largest supplies of fresh water. Amazing though that may be for a small country, there's a good reason for it. The Scottish rain. Like mercy in Shakespeare, the quality of our rain is not strained – it droppeth from the heavens for most of the year it seems.

## MALT & MALTINGS

The lushness of the land also makes Scottish cereal crops among the finest in the world. Belhaven uses locally grown barley, which is carefully malted using traditional methods. (The grain is allowed to sprout by spreading it out on the malting floor and turning it to ensure even germination).

## MILLING & MASHING

The malted barley is crushed to a fine consistency in the mill and then mixed with hot water in the Mash Tun. The mash stands for one hour to allow the naturally occurring malt enzymes to break down the sugars. The mash bed is then sparged with hot water that filters down through the mash bed allowing rapid extraction of the rich solubles.



## PACKAGING

The bright beer is then pasteurised, before packaging. Perfect packaging completes the beer making process. Belhaven's extensive packaging facilities allow us to create contemporary new beers in conjunction with the old favourites and popular classics – ready for you to enjoy.

## CONDITIONING

Beer in kegs, bottles or cans is conditioned to prolong its shelf life and develop flavour. The beer is stored cold in special maturation vessels prior to filtration into bright beer tanks.

## FERMENTATION

Healthy yeast is added to the cooled Wort, and over the next week or so, the yeast works to turn the sugars into alcohol. At the end of the fermentation process, the beer is chilled, stopping the fermentation but not killing the yeast. For traditional Real Ales, the beer is transferred to casks where a secondary fermentation takes place.

## WORT BOILING, SUGAR, HOPS & CLARIFICATION

The resultant liquid, which is known as the Wort, provides ideal nutrition for yeast growth. As the Wort is heated, sugar and hops are added – boiling sterilises the liquid and draws out the flavour and aroma of hops. The hopped Wort is then clarified in a whirlpool – which separates out the spent hops and other unwanted proteins.