

A Special Journey to
Tone Numata
Breweries and Winery

利根沼田酒窖巡訪之旅

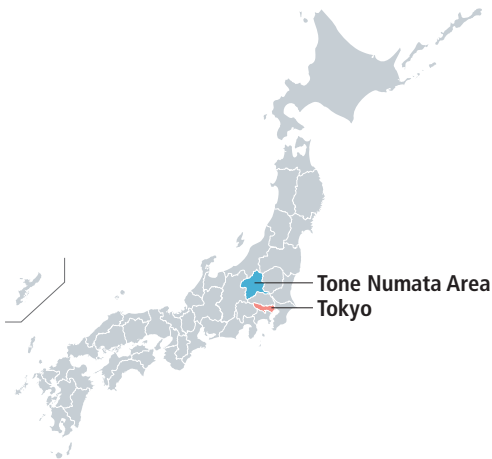


Pilgrimage to mountain villages blessed
with delicious water

巡遊里山，走訪出好水的聖地

Visit the Tone Numata Breweries and Winery

利根沼田的酒窖巡訪之旅



The Tone Numata area around the headwaters of the Tone River in northern Gunma Prefecture, Japan, is located about an hour from Tokyo. It is dotted with breweries that use its fresh water blessed with rich natural elements.

Take a luxury tour through six of its highly distinctive sake and beer breweries and one winery to meet the brewers, taste the delicious products, and stroll through the land where they are created.

Embark on a special journey where you can experience this area's unique food culture and history like you have never seen before.

利根沼田地區位於群馬縣北部，利根川的源流域，距東京約60分鐘車程，星點散佈著使用受大自然恩惠的天然水釀酒的酒窖。

在7個富有個性的日本酒、啤酒、葡萄酒的酒窖展開巡訪之旅，邂逅釀酒師，品飲美酒，漫步於釀酒之地，踏上奢華的酒窖之旅吧。

近距離接觸該區域獨有的飲食文化和歷史，這應該會是迄今為止從未體驗過的特別旅行。



Richly unique breweries and winery of the Tone Numata area

利根沼田地區富有個性的酒窖

Six breweries and one winery dotted around Minakami, Kawaba, Numata, and Showa (Tone District) located in the north of Gunma. Experience the appeal of each brewery and the winery offering a unique taste of the area.

位於群馬縣北部的水上町、川場村、沼田市、利根郡昭和村散佈著7個富有個性的酒窖。

請體驗只有在這一區域才能感受到的各種風格的酒窖的魅力。



永井酒造 Nagai Shuzo

Mt. Hotaka sits in Kawaba, Gunma. This sake brewery uses the clear meltwater to craft beautiful sake embodying the stunning natural environment of Kawaba.

武尊山佇立於群馬縣川場村。使用雪融化的清水釀酒，以展現川場村自然美的精美釀酒為目標的酒窖。

Main brand: Mizubasho Pure



<https://bit.ly/39qbAZZ>



土田酒造 Tsuchida Shuzo

Sake brewery that combines traditional methods from the Edo era (1603-1867) with the latest technologies. Teaching future generations the diverse possibilities of Japanese sake.

挑戰將江戶時代(1603-1867)的傳統技法與最新技術相融合的釀酒方式的酒窖。向下一代傳達日本酒的多樣性。

Main brand: Shin Tsuchida



<https://bit.ly/3o780eQ>



大利根酒造 Otone Shuzo

Sake brewery at the foot of Oze surrounded by the Oku-tone mountains that strives to create sake the owner / chief brewer himself wants to drink.

坐落於奧利根群山環繞的尾瀨山腳下的酒窖。藏元杜氏以釀造出自己想喝的美酒為目標。

Main brand: Sadajin Junmai-shu



<https://bit.ly/37ju2r9>



永井本家 Nagai Honke

Sake brewery that emphasizes the rice, natural elements like water and air, and a winter handcrafted process.

精選「米」、水、空氣等「自然環境」，採用「手工製作」的冬釀法的酒窖。

Main brand: Tonenishiki Junmai-shu



<https://bit.ly/2VhUhm>



奧利根ワイナリー Okutone Winery

Modeled after Napa Valley, California! Boutique winery in Oku-tone, Gunma.

以美國加利福尼亞州的納帕谷為範本！群馬縣奧利根的精品葡萄酒廠。

Main brand: I'm Chardonnay



<https://bit.ly/33sPb0r>



月夜野クラフトビール Tsukiyono Craft Beer

Produced in the town of Minakami, Gunma! Craft beer recognized by famous international review panels.

發祥於群馬縣水上町！在世界著名的審查會上獲得認可的精釀啤酒。

Main brand: Yuhi no Tsukiyono Pilsner



<https://bit.ly/3qafDps>



Kawaba Beer (道の駅 川場田圃プラザ) Kawaba Beer

Brewed with crystal clear water from the iconic Mt. Hotaka! Craft beer from Kawaba, Gunma.

使用從地標武尊山流出的清水作為釀酒之水！群馬縣川場村的精釀啤酒。

Main brand: Yukihotaka Pilsner



<https://bit.ly/33nF96>

Model Course

2 Days & 1 Night

Close to Tokyo! Tour of Breweries in Tone Numata

東京近郊好去處！在利根沼田展開酒窖巡訪之旅



Day 1

1. Kawaba Den-en Plaza Roadside Sta. is a treasure trove of leisure activities that receives 2 million visitors a year. 2-3. The farmer's market in the plaza is full of local beer and vegetables that are perfect souvenirs. 4. Craft Beer Restaurant Hotaka has its own on-site brewery. 5. Try draft beers like Weizen, Amber Ale, and Yukihotaka Pilsner as well as IPA bottled beer. 6. See the old days of rural life in the Nango no Magariya residence of a long-established family. 7. Try deep-rooted local customs like soba (buckwheat) noodle making (reservation required).

Scan the QR !

Kawaba Den-en Plaza
Roadside Sta.



<https://bit.ly/2Jcu8Jk>

Kawaba Beer
Kawaba Den-en Plaza Roadside Sta.



<https://bit.ly/33nTF96>

Nango no Magariya



<https://bit.ly/33pzp6U>

Kinshu Sanso



<https://bit.ly/39pJ94V>

A 2-day, 1-night model course around the breweries in the Tone Numata area, located about one hour from Tokyo.

利根沼田地區距東京約60分鐘的車程，巡訪散佈在這裡的酒窖，展開2天1夜的經典路線。

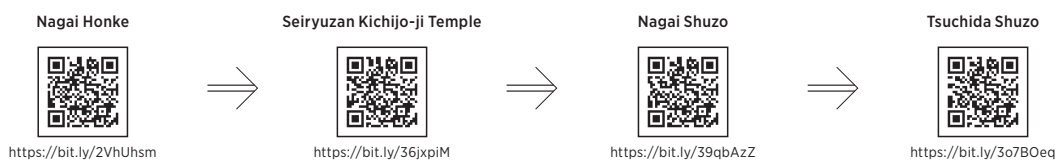
Go to Kawaba Den-en Plaza Roadside Sta. about a half hour drive from Jomo-kogen Sta. Shop at the farmer's market in the plaza and try different local brews at Craft Beer Restaurant Hotaka (1, 2, 3, 4, 5). From there, drive about 20 min. to Nango no Magariya to experience traditional Japanese culture (6, 7). Spend the night at Kinshu Sanso, about a half-hour drive away. The next morning, tour the Nagai Honke sake brewery (8, 9). Afterwards, visit Seiryuzan Kichijo-ji Temple (10, 11). Finish with a tour of Kawaba's two largest breweries, Nagai Shuzo (12, 13) and Tsuchida Shuzo (14, 15).

從「上毛高原站」乘車約30分鐘到達「道之站 川場田園廣場」。在設施內的「農家市場」購物，在「當地啤酒餐廳武尊」品飲當地啤酒(1·2·3·4·5)。然後乘車約20分鐘到「南鄉的曲屋」，體驗日本的傳統文化。(6·7)。乘車約30分鐘，在錦繡山莊住宿。第二天早上，在「永井本家」參觀酒窖(8·9)。然後前往「青龍山 吉祥寺」(10·11)。最後在川場二大酒造「永井酒藏」(12·13)和「土田酒造」(14·15)參觀酒窖。



Day 2

8. Nagai Honke sake is specially handcrafted with a focus on water, air, and air temperature. 9. Tonenishiki is the top brand from Nagai Honke. Honjozo-shu on the left, and junmai ginjo-shu on the right. 10-11. Enjoy seasonal flowers at Seiryuzan Kichijo-ji Temple, called the 'flower temple.' The colored leaves in fall are a sight to see. 12-13. Sake brands brewed at Nagai Shuzo. From the left, Mizubasho Pure, Mizubasho series (year-round sake, vintage, dessert sake), and Mizubasho Artist series. 14. Tsuchida Koji Ninety-nine, an unprecedented innovative sake made with the maximum ratio of malted rice, 99%. 15. Explaining the special brewing style with the *kimoto* method that uses fungi and food rice with a low polishing ratio.





Sake / 大利根酒造
Otone Shuzo

Each lecture by the owner / chief brewer sheds light on the secret world of sake brewing, its methods, and history, drawing many visitors again and again. Reservation by phone or email is required.

藏元杜氏釀造日本酒的神祕世界，以及與釀酒和歷史相關的講解，每次造訪都會有新的發現，回流客很多。請務必用電話或郵件事前預約。



<https://bit.ly/37ju2r9>

1. Sign for Tone Numata brewery and winery tourism posted in front of seven locations in the Tone Numata area. 2. The building was perfected for sake brewing by blocking out UV rays and using skylights for temperature control. 3. The tour finishes with sake tasting while learning the features of each one.

Sake / 永井本家
Nagai Honke

See the brewing process by the owner / chief brewer and taste pure sake and junmai-shu from the prestigious elegant Tonenishiki brand. You can only savor the taste of fresh brews here at the brewery.

可以參觀藏元杜氏精心的釀造過程，品飲高規格的名酒「利根錦」的生酒、純米酒等。造訪酒窖才能夠享受到品飲剛釀好的美酒之樂。



<https://bit.ly/2VhUshm>



1. Owner / chief brewer Nagai speaks about the key points in front of huge vats of steamed rice. 2. Freshly extracted sake is pasteurized (filtered and heat-sterilized) before storage. 3. Also try the fruit wine made with fruit from Kawaba area orchards.

“Glass Blowing” experience to try before tasting Tsukiyono Craft Beer!

在品飲月夜野精釀啤酒之前體驗「吹製玻璃」!

Brewery Tours

You can actually tour the sake and beer breweries and the winery sprinkled throughout the Tone Numata area (reservation required).

Meeting the chief and other brewers will be an experience to remember.

在利根沼田地區散佈的日本酒、葡萄酒、啤酒的釀造所，可以參觀釀酒現場（需預約）。與杜氏和釀酒師的邂逅，會成為特別的體驗吧。



1. Grape picking starts in early October with Chardonnay grapes. 2. Winery tour at the vineyard that looks stunning against the blue sky. 3. Tasting. You can buy the ones you like right there.

Wine / 奧利根ワイナリー Okutone Winery

In the Winemaker Tour led by a vintner, see the vineyard and winery and partake in a tasting of the different types of wine like Cabernet Sauvignon and Pinot Noir.

由釀酒師親自帶領的酒廠之旅，可以參觀葡萄田和釀酒廠，品飲卡本內蘇維濃、黑皮諾等不同品種的葡萄酒。



<https://bit.ly/33sPbOr>

Beer / 月夜野クラフトビール Tsukiyono Craft Beer

At Restaurant Dobry Den on the Tsukiyono Craft Beer (brewery) premises, enjoy fresh brew with dishes containing local ingredients. (Reservation not required)

在月夜野精釀啤酒（釀造所）中併設的「餐廳 DOBRY'DEN」，可以品嚐到使用當地食材製作的料理和剛釀好的啤酒。（無需預約）



<https://bit.ly/3qafDpS>



1. Dark beer that won bronze at the AIBA2019. 2. You can also have small glasses of each of the 5 types to taste and compare. 3. Some glasses were designed to match the beer concept.



Glass-making factory / 月夜野びーどろパーク Tsukiyono Vidro Park

Blown glass workshop at the on-site Glassworks Factory! Make your own tumbler!

在附設的玻璃工坊體驗吹製玻璃！製作原創玻璃杯吧！



<https://bit.ly/3612ld0>

1. Shape the melted glass as you like. 2. In about 20 minutes, your tumbler is ready!

Sightseeing

Tone Numata offers both magnificent nature, from Mt. Tanigawa and Suwa Gorge to the Fukiware Falls, as well as countless activities to enjoy in the rich outdoors. You can also enjoy activities like trekking and hiking.

除了能欣賞到谷川岳、諏訪峽、吹割瀑布等雄偉的自然景觀外，置身於四季色彩斑斕的美麗大自然中盡情享樂其中，也是利根沼田地區的魅力。還能享受健行和爬山等活動的樂趣。



谷川岳 / Mt. Tanigawa

One of Japan's top 100 mountains where you can experience magnificent nature. From the terminal aerial tramway station, Tenjintoge, walk another 2.5 hours to the summit. It is best to come equipped for mountain climbing.

能感受到雄偉自然風光的日本百名山之一。從纜車終點站天神峠步行約2個半小時，即可到達山頂。推薦穿著登山裝備。



<https://bit.ly/3mp1P8l>

1. Enjoy the starry sky during the Tenku Night Cruising event from early summer to fall.
2. The Ichinokura-sawa Rock Cliff Trekking Course in lush early summer is excellent.



諏訪峽 / Suwa Gorge

This gorge was formed by the clear Tone River water. It is a famous outdoor leisure spot with many activities.

利根川清冽的流水形成的溪谷。這裡也是著名的戶外休閒場所，可以盡情享受豐富多彩活動的樂趣。



<https://bit.ly/3ijOXzo>



吹割の滝 / Fukiware Fall

Waterfall that is also called the "Niagara of the East." One of Japan's top scenic spots offering a view of the huge 30-meter-wide falls and stunning gorge.

有「東洋的小尼加拉瀑布」之稱的瀑布。可以一次飽覽寬30m的雄偉瀑布和美麗的溪谷，是日本首屈一指的觀光勝地。



<https://bit.ly/3fPfc50>



迦葉山 弥勒寺 / Kasyuzan Miroku-ji, temple

A historic temple partway up sacred Mt. Kasho. Also known for housing Japan's largest mask of a tengu (red-nosed goblin), a real sight to see!

鎮座於靈峰迦葉山的半山腰的寺院，歷史悠久。因擁有「日本最大的天狗面具」而廣為人知，氣魄驚人！



<https://bit.ly/2KUdkax>

Accommodation

Hot spring lodge where you can delight your senses with local ingredients, local sake and a view overlooking gorgeous mountain scenery and the river terrace formed by movement in the Earth's crust 10,000 years ago and the gorgeous mountain scenery. The lavish space will melt away your travel fatigue.

溫泉旅館坐落於1萬年前因地殼變動而產生的河階地形和群山環繞之地，可欣賞壯麗的風景，享用使用當地食材製作的美食和當地酒。在極盡奢華的空間療癒旅行的疲勞吧。



1. Part of the appeal is the lineup of sake designed to pair well with your meal. 2. The lavish space that embodies a Japanese resort vibe offers ultimate relaxation. 3. Every room has its own open-air bath to enjoy the Tanigawa hot springs.

別邸 仙寿庵 / Bettei Senjuan

This well-known resort is enclosed in the serenity of the gorge set against the famous Mt. Tanigawa. Traditional Japanese design and modern construction are combined to create a unique and soothing luxurious space.

借景名峰・谷川岳，佇立於靜寂溪谷之中的著名旅館。享受日本的傳統設計與現代建築相結合的獨一無二的奢華空間。



<https://bit.ly/36hJSTL>



錦綉山莊 / Kinshu Sanso

Free-flowing hot spring resort where you can view the woven tapestry of a beautiful garden and the magnificent Mt. Hotaka. It has only 10 guest rooms. This secluded retreat for adults lets you enjoy total privacy and quiet tranquility.

可眺望到美麗的庭園和壯麗的武尊山相映之景的源泉溫泉旅館。只有10間客房。這是一處能盡情享受滿滿私人感、安靜時光流逝的浪漫隱秘之家。



<https://bit.ly/39pJ94V>



悠湯里庵 / Yutorian

Hot spring resort that sits in a rural landscape spread over the southern foot of Mt. Hotaka, counted as one of Japan's top 100 mountains. One highlight is the beautiful straw-thatched roof houses that were carefully moved and reconstructed over many years.

佇立於日本百名山之一武尊山麓田園風景之中的溫泉旅館。將擁有悠久歷史的茅屋精心改建而成的旅館建築也非常值得一看。



<https://bit.ly/37glf8d>

Premium Brewery Tour



1. The stunning view from Miroku-ji Temple partway up Mt. Kasho. 2. Miroku-ji Temple also houses Japan's largest *tengu* mask that is 6.5 m high with a 2.8 m long nose. 3. Tsunenori Abe, owner and chief brewer of Otone Shuzo, speaks deftly from his wealth of knowledge about sake. 4. Tasting time with the popular Sadaijin Junmai-shu as well as daiginjo-shu and pure sake. 5. Traditional Numata craft using mulberries and a pottery wheel. 6-7. Sake cups that offer the unique warm appeal of wood.

Day Trip — 01

Experience Japanese culture through sake breweries and sake cups

Guided tour by chartered car

透過參觀酒窖和酒器來體驗日本文化的旅行 包車附嚮導

Visit Otone Shuzo, one of the Tone Numata breweries, for a tour and a tasting. Also visit an ancient temple known for its *tengu* guardian spirit and stunning scenery and a workshop where wooden sake cups are crafted, for a day of learning about sake and experiencing Japanese culture, crafts, and history. Full-day accompaniment by a guide to ensure you have a phenomenal experience.

造訪利根沼田的酒窖之一的「大利根酒造」，享受參觀酒窖和試飲的樂趣。還可以參觀以天狗守護神和絕景而聞名的古刹、製作木造酒器的工坊，在1天內瞭解日本酒，接觸日本的歷史、文化、傳統工藝的旅行。一整天都有嚮導陪同，為您提供精彩的旅行體驗。

Book here!



<https://bit.ly/36ifsjP>

- Tour company: Sake Tours (saketours.com)
- Price: 37,500 yen/person (Includes a chartered car from Jomo-kogen, brewery experiences, a guide, and lunch. Does not include travel costs to Jomo-kogen or the Minakami Onsen Village or costs for souvenirs.)
- Number of people: At least 4
- Inquiries and reservations: info@saketours.com (reservations at least 7 days in advance)

Tour Schedule

11:20 AM	Arrive at Joetsu Shinkansen Jomo-kogen Sta.
12:10 AM - 1:10 PM	Kashozan Miroku-ji Temple
1:30 PM - 2:15 PM	Lunch (soba noodles)
2:30 PM - 4:00 PM	Otone Shuzo brewery tour and tasting
4:30 PM - 5:00 PM	Numata Kokeshi Craft
5:20 PM	Finish at Joetsu Shinkansen Jomo-kogen Sta.



1. Underground water from Mt. Hotaka, one of Japan's top 100 mountains, that is used to create Tsuchida Shuzo sake. 2. Crafted with Edo era methods that use zero additives to draw out umami from the rice. 3. Tsuchida Shuzo sake brands feature a variety of aromas and sweetness levels even using the same kimoto method. 4. Shop on the Tsuchida Shuzo premises that sells sake as well as fermented foods and other products. 5. Headwater tour where you can try the water that is used in fermentation at Nagai Shuzo. 6. Taste Nagai Shuzo's Mizubasho Artist Series Floral Sparkling.

Day Trip — 02

Go by chartered car! Tour of the two largest sake breweries in the Tone River headwater area

包車前往！利根川源流域的兩大酒窖之旅

The Tone River is the largest that runs through the Kanto region. The headwaters are in an area that is famous for its beautiful environment and clear water. Let a chartered car take you to two sake breweries that have been brewing in this home of water and greenery for over 100 years. Learn the history and culture of the cellar and how to make sake and enjoy sake tasting. This brewery tour offers a special experience and lets you delve deep into the world of sake.

流經關東的最大河流——利根川。其源流是以美麗的自然和乾淨的水源而聞名的地區。在這片「綠水青山之鄉」，包車巡訪採用傳承百年的釀酒技藝的2個酒窖。瞭解酒窖的歷史和文化，參觀釀酒技藝，品飲多種美酒。這是在寶貴的體驗中感受日本酒的精彩世界的酒窖之旅。

Book here!



<https://bit.ly/33soF7Z>

- Tour company: Japan Wonder Travel (<https://japanwondertravel.com/>)
- Price: 22,000 yen/person (Includes a chartered van from Takasaki Sta., brewery experiences, and a guide. Does not include lunch, travel costs to Takasaki Sta., or costs for souvenirs.)
- Number of people: 4-9
- Inquiries and reservations: staff@japanwondertravel.com (reservations at least 3 days in advance)

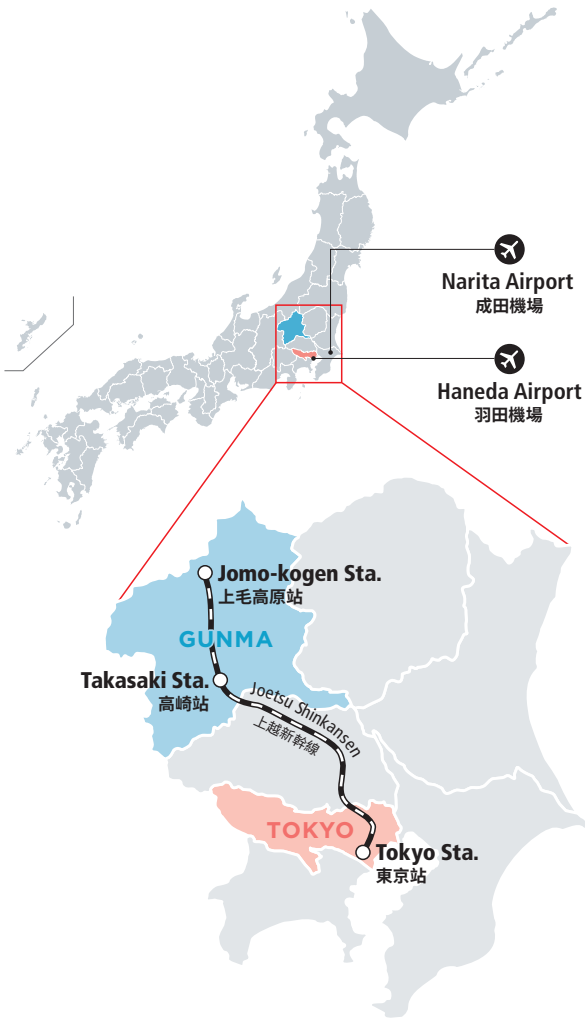
Tour Schedule

9:00 AM	Meet up at Joetsu/Hokuriku Shinkansen Takasaki Sta.
10:00 AM - 11:30 AM	Brewery tour and tasting at Tsuchida Shuzo
Noon - 1:30 PM	Lunch (Tsuchida Shuzo or Kawaba Den-en Plaza Roadside Sta.)
2:00 PM - 3:30 PM	Headwater tour and tasting at Nagai Shuzo
4:30 PM	Finish at Joetsu/Hokuriku Shinkansen Takasaki Sta.

*Schedule is subject to change in the event of rain

Getting there from Tokyo

從東京前往的交通方式



By Train | 搭乘電車

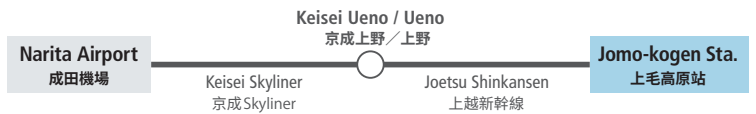
About 1 hour from Tokyo Sta. | 從東京站出發約60分鐘



About 90 min. from Haneda Airport | 從羽田機場出發約1小時30分鐘



About 1 hour 40 min. from Narita Airport | 從成田機場出發約1小時40分鐘



Brewery touring is a breeze in a taxi from Jomo-kogen Sta.!
從上毛高原站搭乘計程車巡訪酒窖非常便利！



Kan-etsu Transportation | 關越交通

