

# Got Rum?®

SEPTEMBER 2025

FROM THE GRASS TO YOUR GLASS, SINCE 2001!



**COOKING WITH RUM · ANGEL'S SHARE**  
**CIGAR AND RUM PAIRING · THE RUM MIXOLOGIST**  
**RUM IN THE NEWS · THE RUM LABORATORY**  
**THE SWEET BUSINESS OF SUGAR · THE SUGAR MILL**



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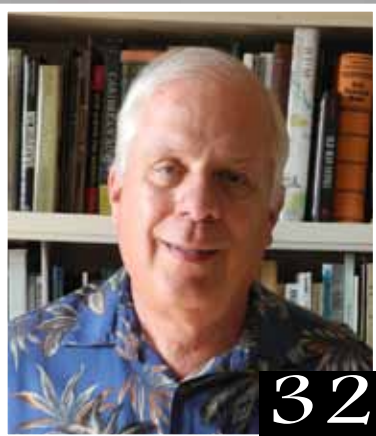




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# Got Rum?®

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**WWW.GOTRUM.COM**

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## FROM THE EDITOR

### *Filling In The Gaps . . . With Facts!*

Even though I've been offering rum consulting services for around three decades, I am still surprised during client engagements when I hear things such as:

- "We always adjust the pH of the fermentation, but we don't know why."
- "We always proof down our spirits by adding the water in stages, but we don't know if it really matters."
- "We never use PVC hoses to handle alcohol, but we don't know why."

Doing the right thing is important, but knowing WHY we're doing it is critical: it allows us to extrapolate or deduce additional things we should be doing to achieve the desired goals.

Sometimes we allow gaps to exist in our knowledge, either because we believe that gaining the additional knowledge is impossible or impractical.

Even the brightest minds are susceptible to this, so much so that there are names for this concept: "*The God of Gaps*" or "*The Alien of Gaps*" (the later for those who believe, for example, that the Egyptian pyramids were built by extraterrestrial beings, only because they can't accept or explain how humans could have done it).

Perhaps the best example of *The God of Gaps* is Sir Isaac Newton's assertion, in his famous *Philosophiæ Naturalis Principia Mathematica*, that a problem he could not explain scientifically was "fixed by God."

One of the best outcomes of science, over time, is that these "gaps" of knowledge are slowly replaced with facts. The growing accumulation of knowledge then leads to more questions (more gaps), and the cycle continues.



To be content with gaps as permanent fixtures in our knowledge base would be disastrous to our ability to improve ourselves, our societies and our industries/institutions.

So, next time you catch yourself saying something along the lines of "*I always do it this way, but I don't know why,*" challenge yourself to fill in that gap with facts. Chances are that those new facts will then shed light on additional areas of your life.

Cheers!

Luis Ayala, *Editor and Publisher*

**LinkedIn** <http://www.linkedin.com/in/rumconsultant>

Do you want to learn more about rum but don't want to wait until the next issue of "Got Rum?"? Then join the "Rum Lovers Unite!" group on LinkedIn for updates, previews, Q&A and exclusive material.

# THE ANGEL'S SHARE

by Paul Senft



My name is Paul Senft - Rum Reviewer, Tasting host, Judge and Writer. My exploration of Rums began by learning to craft Tiki cocktails for friends. I quickly learned that not all rums are created equally and that the uniqueness of the spirit can be as varied as the locales they are from. This inspired me to travel with my wife around the Caribbean, Central America, and United States visiting distilleries and learning about how each one creates their rums. I have also had the pleasure of learning from bartenders, brand ambassadors, and other enthusiasts from around the world; each one providing their own unique point of view, adding another chapter to the modern story of rum.

The desire to share this information led me to create **www.RumJourney.com** where I share my experiences and reviews in the hopes that I would inspire others in their own explorations. It is my wish in the pages of "Got Rum?" to be your host and provide you with my impressions of rums available in the world market. Hopefully my tasting notes will inspire you to try the rums and make your own opinions. The world is full of good rums and the journey is always best experienced with others.

Cheers!

## Flor De Caña Añejo Oro Reserve No 4

Flor de Caña rums are produced at Compañía Licorera de Nicaragua, which was founded in 1937 in Chichigalpa, Nicaragua. The molasses used to create their rum line is created from locally grown sugarcane. Using their proprietary yeast, they ferment the liquid for up to 48 to 72 hours in a continuous fermentation process before distilling the liquid in a five-column still. The rum is then aged in used bourbon barrels at their onsite aging facilities located on the estate property. They do not use any coloring or sweeteners to create their products. This product was blended to 40% ABV and bottled in an unspecified location.

A few things of note with all Flor de Caña products: the numbers on the label are not an age statement but are indicative of the maturity of the spirit in the bottle. They are a carbon-neutral distillery, and a good portion of it is powered by a furnace that burns waste from their sugar mill. In recent years they have also earned the Fair Trade certification, which notes that they adhere to strict environmental, safety, and social regulations for their employees.

### Appearance

The rum is bottled in a slender 750 ml bottle sealed with a metal screw cap that notes the company's 130th anniversary. The front label has a good deal of basic information, noting that it has no sugar, is gluten-free, and has no artificial ingredients, as well as their environmental efforts.



The liquid is a pale gold amber in the bottle and glass. Swirling the liquid creates a thick band that spins off fast-moving legs that leave a band of residue around the glass.

### **Aroma**

The aroma leads with caramel, a touch of dry fruit, herbaceous vanilla, and a hint of wood tannins.

### **Palate**

The rum leads with a strong rush of caramel and alcohol that conditions the mouth. The second sip delivers a mix of vanilla, dried apricot, toasted coconut, and black pepper. The pepper notes transition to a brief wood tannin “baking spice” dry finish.

### **Review**

When I began researching this rum, I learned that it is engineered to be used as an introduction to sipping rums but is used primarily as a cocktail ingredient. I can only see this rum being used in a sipping situation as a tool to compare the rum with other products created by the company. However, as a cocktail ingredient, this rum, along with the brand Extra Seco Blanco, sees a good deal of use in fruit juice-based cocktails, and I have seen it on quite a few menus while travelling in Central America. Overall, Flor de Caña Oro is a good, versatile rum for your home bar that is approachable for those new to rum.



www.flordecana.com

# THE ANGEL'S SHARE

by Paul Senft

## Koloa Single Barrel Kaua'i Reserve Single Batch Release

Over the years it has been interesting watching rums produced in the Hawai'i Islands establish their place in the rum industry. The Koloa Rum Company began producing rums from locally grown sugarcane. Within the past decade they began growing cane close to their Kaua'i distillery and using it to make their products. This single-batch product is their second release in the Kaua'i Reserve line. The first was a single barrel release, and this one refers to their production practice of producing rums in batches and then aging them in charred American white oak barrels. After aging the rum for a minimum of 5 years, they blend it to 46% ABV.

### Appearance

The short-necked 750 ml bottle has black and gold labels and a security wrap. The neck wrap secures a black plastic screw cap to the bottle. The labels provide some details about the rum and the company's practice of making their rum from pure cane sugar.

The rum holds a dark golden amber color in the bottle and glass. Swirling the liquid in the tasting glass generates a medium band and multiple waves of fast-moving legs. It takes several minutes for the band to evaporate, leaving a trace amount of residue around the glass.

### Nose

The aroma is a rush of honeyed sugarcane, toasted vanilla, citrus zest, and oak spices-ginger and allspice are dominant. The experience is punctuated by light grass and wood char notes.

### Palate

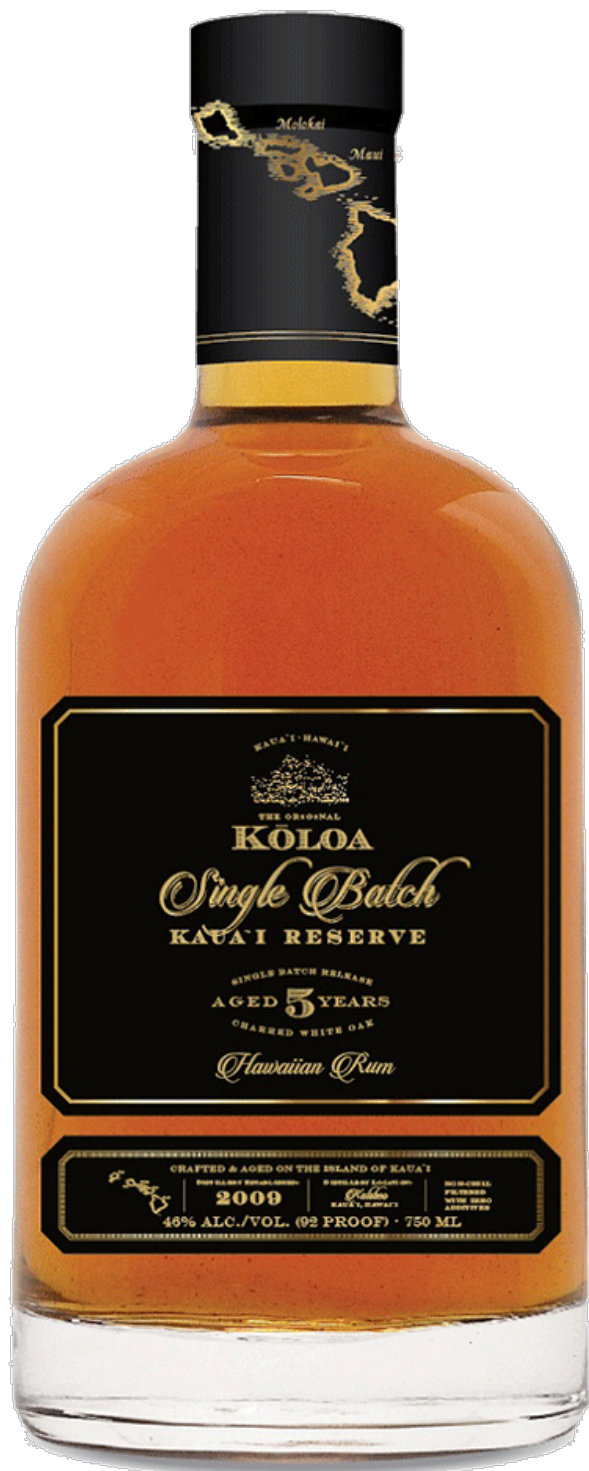
The first sip delivers a rush of smoky vanilla flavor as the proof of the rum scorches the palate. After the heat of the rum subsides, a strong black pepper note manifests and lingers. Additional sips reveal astringent oak tannins, orange zest, and caramel, with a strong pop of ginger midpalate. Charred oak notes and a hint of tobacco leaf, cardamom, and mango linger in a long, spicy, sweet finish.

### Review

In 2024, I reviewed their Kaua'i Reserve Single Cask product, and while the products are similar, there are noted differences. The flavor profile of this expression is more volatile and oak-forward. The spice and oak notes balance the sweetness of the vanilla, while smoke and char add nicely to the opening and create a dynamic finish for the rum.

At its core, this rum still feels immature to me and is very hot. It will be interesting to see how this brand evolves their reserve products, as more time in the barrel at their distillery's aging warehouse is only going to tame some of the immature wood notes and add more to the flavor profile. For now, I would recommend using this rum in Prohibition-era cocktails, as the proof and flavor profile need to be married with other ingredients to properly explore this expression.





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# COOKING WITH RUM

**Bringing the Spirit of the Cane  
Into the Heart of the Kitchen!**

by Chef Susan Whitley









## Chicken With Creamed Rum Sauce

### Ingredients:

- 1 lb. Boneless Skinless Chicken
- ¼ C. All Purpose Flour
- 1 Tbsp. Garlic Salt
- 2 Tbsp. Olive Oil
- 1 Tbsp. Garlic, chopped
- ½ C. White Onion, chopped
- 1 Tbsp. Dried Parsley
- 1 tsp. Red Pepper Flakes
- Sea Salt and Ground Black Pepper, to taste
- 1½ oz. Dark Rum
- ¼ C. Half-and-Half
- 1 tsp. Orange Extract

### Directions:

1. Cut chicken into bite sized pieces.
2. Mix garlic salt with flour and coat chicken pieces lightly, shake off extra flour from chicken if needed.
3. Set a wide pan on medium-high heat and add olive oil. Once the oil is hot add chicken pieces and fry until browned. Add the onions and garlic and cook until softened then add the remaining seasonings and deglaze pan with rum.
4. Stir in half-and-half and orange extract to make sauce. Once the sauce begins to boil, remove from heat and ready to serve. Goes great over rice or noodles. Enjoy!



Photo credit: [www.chefdehome.com](http://www.chefdehome.com)



## Rummy Apple Crisp

### Ingredients:

- 8 C. Sliced Apples, ½ inch slices (I recommend using a combination of Braeburn and Fuji apples)
- 1 tsp. Cinnamon Sugar
- 1 tsp. Lemon Zest
- 1 tsp. Vanilla Extract
- 2 oz. Dark Rum
- 1 oz. Orange Liqueur
- 2 Tbsp. Grandma's Original Molasses

### Ingredients For the Crumb Topping:

- 1 C. Granulated Sugar
- ½ C. Light Brown Sugar
- ½ C. All-Purpose Flour, sifted
- ½ tsp. Salt
- 6 Tbsp. Salted Butter, softened
- ¾ tsp. Ground Nutmeg
- ¾ C. Oatmeal
- 1 C. Walnuts, toasted and chopped
- Vanilla Ice Cream and Caramel Sauce, for topping



### Directions:

1. Preheat oven to 350°F degrees.
2. Arrange apple slices in a greased deep dish pie plate or large baking dish.
3. Sprinkle cinnamon sugar, lemon zest, vanilla extract, dark rum and orange liqueur on top of apples then drizzle molasses over apples.
4. In a separate bowl, mix both sugars, flour, salt, butter, and nutmeg with a pastry blender or in a food processor until crumbly; add the oatmeal and chopped walnuts and mix thoroughly. Spread mixture over top of apples.
5. Bake uncovered at 350°F degrees until apples are tender and top is lightly browned, approximately 1 hour.
6. Serve warm with vanilla ice cream and drizzle caramel sauce on top of the ice cream.

Photo credit: [www.katykeck.com](http://www.katykeck.com)

# THE RUM Mixologist

A space devoted to the exploration  
of classic and new rum cocktails

THE RUM<sup>®</sup>  
UNIVERSITY





## What Is Mixology?

Mixology is the study and skill of inventing, preparing and serving cocktails and other mixed drinks. Mixologists are experts in this field, but mixologists' knowledge goes beyond memorizing basic cocktail recipes: it includes historical information, basic chemistry behind flavor combinations and a capacity for combining common ingredients in new ways.

Join us, as we explore the essential collection of rum cocktail recipes that every mixologist needs to master.



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Photo Credit: Sense & Edibility



# THE RUM Mixologist

This Month's Cocktail:  
The Jungle Bird

## About The Jungle Bird

The jungle bird is a fun tropical rum cocktail that has a few interesting twists. It was created in the early '70s at the famed *Aviary Bar* inside Malaysia's *Kuala Lumpur Hilton*. If you're looking for a great-tasting rum cocktail that gives you the chance to play with a cool garnish, it's hard to beat this recipe!

## Jungle Bird

### Ingredients

- 1 1/2 ounces dark rum
- 3/4 ounce Campari
- 1 1/2 ounces pineapple juice
- 1/2 ounce freshly squeezed lime juice
- 1/2 ounce simple syrup
- Pineapple wedge and leaves, for garnish
- Maraschino cherry, for garnish

### Directions:

1. Gather the ingredients.
2. In a cocktail shaker, pour the rum, Campari, pineapple and lime juices, and simple syrup.
3. Shake vigorously.
4. Strain into an old-fashioned glass with a single large ice cube.
5. Garnish with a pineapple wedge adorned with a cherry and pineapple leaves to look like a jungle bird. Serve and enjoy.

A glass of amber-colored rum sits on a stack of old, open books. The background is a warm, golden-brown color, suggesting a library or a study. The glass is a simple, clear tumbler, and the rum inside is a rich, golden-brown color. The books are stacked on top of each other, with some pages visible. The overall mood is cozy and intellectual.

# THE Rum<sup>®</sup> UNIVERSITY LIBRARY

Reviews of books related to sugarcane, milling, fermentation, distillation, aging, blending and other topics related to the production or history of rum.

[www.RumUniversity.com](http://www.RumUniversity.com)



# Spirited: Cocktails from Around the World

## 610 Recipes, 6 Continents, 60 Countries, 500 Years

(Publisher's Review)

*"A lavish, gift-worthy stunner."* - The New York Times

*"This book might suffice as the only cocktail book a drinker needs."* - Epicurious

**A fully-illustrated, global celebration of classic and cutting-edge cocktails.**

This definitive cocktail recipe book for the home bartender includes 610 cocktail recipes from 6 continents and 60 countries, spanning 500 years. With most cocktails only including three or four ingredients, there is something for novice drink-makers and expert bartenders alike.

Drinks range from renowned iconic classics to lesser-known regional specialties to influential bespoke drinks — each reflecting the era, location, or bar that inspired it. In this book you will also learn how to set up your home bar, with advice on bar tools, glassware, syrups, garnishes, and more.

Spirited is organized by cocktail style, with notes on country or origin, era of invention, and infographic icons showcase ingredients and low alcohol-by-volume (ABV). Each recipe also includes a short text providing fascinating historical and cultural information about the drink. Essays are interspersed throughout, with topics ranging from the history of the cocktail, the culture surrounding aperitivo beverages, among others. A comprehensive index by spirit and ingredient is located at the end of the volume.

Chapters include: "Refreshing" beverages, followed by "Sours," "Spirit Forward" drinks, "Tiki and Tropical" combinations, "Coffee and Dessert" beverages, and concluding with delightful "Punches."

From the author that brought you the drink-maker travel guide *Where Bartenders Drink*. Celebrate at home with *Spirited*!

### About the Author

Adrienne Stillman is the co-founder, editor-in-chief, and event director of Dipsology,



a curated guide and community for cocktail enthusiasts. She also oversees strategy and marketing for wine, spirits, and hospitality clients, and is a certified sommelier. She is the author of *Where Bartenders Drink* (Phaidon). A native New Yorker, she lives in Napa Valley, California.

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A: Rum Central is located within the **Texas Triangle**, a region in Texas formed by the state's four main metropolitan areas. The **Texas Triangle** is one of eleven mega regions in the United States and is home to approximately 75% of the State's population. This area also benefits substantially from trade with Mexico, the United States' third largest trade partner.

A: Rum Central is 30 Miles from Austin, with convenient access to interstate highways, rail lines, airports and seaports (within 250 miles of 4 of the top 10 U.S. seaports), guaranteeing fast and efficient shipping of your dry and finished goods.

### **Q: Do you need more information?**

A: Contact us via our website below!

[www.RumCentral.com](http://www.RumCentral.com)

# 2025 Courses

Luis Ayala will be teaching the following at  
Moonshine University in Kentucky  
(<https://www.moonshineuniversity.com/>):

- Rum section of the 5-Day Distiller Course, July 28-August 1 2025
- Rum section of the 5-Day Distiller Course, October 20-24 2025

We will also be teaching the following  
courses at our campus in Texas:

## Q3 2025 Courses

- September 22 (Mon) - The Business of Rum
- September 23 (Tue) - The Classifications of Rum
- September 24 (Wed) - The History of Rum

**Sold Out**

## Q4 2025 Courses

- November 3 (Mon) - Introduction to Rum Blending
- November 4-5 (Tue-Wed) - Advanced Rum Blending



# 2026 Courses

Stay tuned for the **Moonshine University**  
and **The Rum University**  
2026 Course Schedule!

We also offer customized and private  
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# The Rum Laboratory

Presented by

THE **Rum**<sup>®</sup>  
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Join us as we explore the world of  
rum spices and flavors!  
In this series you will learn to flavor  
your own Rums and to create your  
own Liqueurs and Creams.





## The Rum University® Laboratory

Presents

making your own

# Cafe Noir (Coffee and Chicory)

### Ingredients

- 4 Tablespoons Drip-ground Coffee
- 2 Tablespoons Chicory (usually available at health food stores)
- 4 Cups Filtered Water
- 1/4 Teaspoon Salt (optional)
- Sugar to Taste (optional)
- Rum
- Scalded Milk (optional, for Café au Lait)

### Directions

Add ingredients (except for sugar and rum) to your coffee maker's basket and brew.

Serve with the sugar and rum on the side.

### Did you know that...

Though the root has been cultivated since ancient Egypt, chicory has been roasted, ground and mixed with coffee in France since the 19th century. (The term chicory is an anglicised French word, the original being chicoree.) The root traditionally was used on its own in tea or in medicinal remedies to treat jaundice, liver enlargement gout and rheumatism.



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Some manufacturers roasted chicory with two pounds of lard for every "hundredthweight," or cwt, of chicory "to give the chicory a better face." Parsnips were also added occasionally. Even burnt sugar was sold to coffee dealers and coffee-house keepers under the name of "black jack," according to an 1874 article published in the Chemical News and Journal of Industrial Science.

Chicory coffee was cheap and for this reason, it's been used in times of coffee shortage or economic crisis, like the Civil War and the Great Depression. It's also been used to stretch supplies in prisons. But if you ask a New Orleans native, it's all about the tradition.

Source: Smithsonian Institute







# RUM

## And The Environment

### ACTION ITEMS

September's Action Item Is . . .

#### **Eliminate single-use plastics**

The most environmentally friendly thing you can do with soft plastics (especially single-use plastics) is reduce your consumption of them. Simple changes like carrying a reusable water bottle or coffee cup can significantly cut down plastic waste. You could also opt for reusable shopping bags and choose products with minimal or no plastic packaging. In the mood for a party? Here are a few recommendations that avoid single-use plastics:

- Bubbles. Bubble blowing can be a wonderful interactive activity and it leaves no waste or litter that could harm the environment. There are plenty of non-toxic solutions you can buy (or even make at home), and kids never get sick of popping them!
- Kite flying. Flying kites is a fun way to get outdoors and connect with nature. The great thing about kites is that they are reusable. Kites are typically built from lightweight, sturdy materials and can provide endless hours of entertainment.
- Flowers. Flowers can add a touch of elegance to any event. They also create a fragrant, calming space for your guests. Using locally sourced and seasonal flowers can be an eco-friendly choice compared to other decor options.
- Paper decorations. With the same vibrant burst of color as balloons, paper decorations provide a reusable option that conveniently folds for storage, plus they can be recycled!

Whatever you do, don't forget about the post-celebration clean-up! This includes tidying up any confetti remnants, returning every party item back to their storage spots, and recycling whatever you can. As the old saying goes, leave nothing but footprints!



# RUM IN THE NEWS

by Mike Kunetka



## KO HANA DISTILLERS

On August 19th, a fire broke out near the fields of Kunia Camp on the island of Oahu, causing distress to residents and significant agricultural losses. Fortunately, the homes in Kunia Camp were spared, but the fire devastated the local agriculture. It took Robert Dawson, Co-Founder of Kō Hana Distillers, more than a decade to cultivate 15 acres of sugarcane in Kunia and in one day it was all gone. "We had 15 acres of 36 types of heirloom Hawaiian sugar cane growing here. We like to call it our 'museum collection.' These are canoe plants that were brought to Hawai'i 1,000 years ago. Before contact with the Western world, Hawaiians were growing these crops," said Dawson. Since 2009, we've been trying to cultivate and expand the production of these native canes and it just got wiped out, literally all 15 acres burned to the ground in this last fire. It's thousands of cases of rum that we will not be able to produce from this field," Dawson said. That sugar cane was harvested every year and used in the distillery's rum. Kyle Reutner, General Manager at Kō Hana, sent out an email stating: "We are incredibly grateful for all the support we've received over the past week.

These are the most recent and noteworthy headlines in the rum industry. If you want us to share your news with our readers, please send me an email to: [Mike@gotrum.com](mailto:Mike@gotrum.com).



Your thoughtful messages have provided us with comfort during this challenging time. As you may know, the fires in Kunia affected our estate fields adjacent to our distillery, as well as the plots of many neighboring agricultural partners. We would like to extend our deepest gratitude to the Honolulu Fire Department, the Navy Fire team, and all the dedicated individuals who worked tirelessly to ensure the safety of our community. A heartfelt mahalo to the HFD and Honolulu Police Department for their efforts in communicating effectively and apprehending the alleged arsonist. Looking ahead, we are committed to replanting our fields in Kunia and continuing our mission to grow high-quality Kō for people to enjoy around the world. While this fire has impacted some of our plans, we want to assure our bar and restaurant partners that there will be no delays in product availability. We are relying on our fields in Waialua and Haleiwa to maintain production continuity."

In December of 2022, I toured Kō Hana. I got to interview Robert Dawson and tour the distillery. Jennifer Sandage, Assistant Manager of the Tasting Room, gave me a tour of the cane fields and showed me the heirloom varieties of Kō. I was amazed at the variety of colors and sizes of the plants. (See the April, 2023 issue of Got Rum Magazine for my article.) It's hard to believe that all of those plants are gone. It will likely take over a year to regrow that area.

In other news, to help celebrate 25 years of Tiki Oasis, Kō Hana created a limited release of their Koho and Kokoleka rums, featuring custom artwork by renowned artist Mike Sourielle, Gecko, of Gecko's South Sea Arts, known for his master craftsmanship and authentic Polynesian art, Gecko's unique carvings and designs are the perfect complement to Kō Hana's exceptional spirits. This special release was timed for the anniversary of the world's largest Tiki festival. It included a limited number of bottles of their barrel-aged Koho (Kō Mahai'ula) rum and their rich, cacao-and-honey-infused Kokoleka rum. <https://www.kohanarum.com/>

### **FLOR de CAÑA**

Flor de Caña announced it has been named "Leading Ethical & Sustainable Spirits Producer" by the prestigious UK-based Global Brands Magazine. This international platform highlights and celebrates brands across industries that set new global standards in sustainability, innovation, and excellence, while driving a lasting and positive change in the world. Since 1890, Flor de Caña has embodied a vision of excellence rooted in deep respect for people and nature. From being the world's first spirit to be both Carbon Neutral and Fair Trade certified, to distilling with 100% renewable energy, planting one million

trees, and championing community development programs, the brand has consistently proven that sustainability and craftsmanship can go hand in hand. As the brand celebrates its 135th anniversary, this award stands as a powerful recognition of Flor de Caña's leadership in sustainable practices, not only within the spirits industry, but also in building a greener future for all. [www.flordecana.com](http://www.flordecana.com)

### **KULEANA RUM WORKS**

Kuleana Rum Works claimed top honors at two of the industry's most respected competitions: the 2025 American Distilling Institute International Spirits Competition and the 2025 Beverage Testing Institute World Spirits Championships. At the ADI competition, Huihui®, the company's signature blended white rum, was named "Best in Class", the top accolade that underscores the growing demand for transparently made, additive-free spirits. "Huihui was created to meet a growing demand in the spirits world, a clean, additive-free rum that speaks to both provenance and performance," said Steve Jefferson, Founder and CEO of Kuleana Rum Works. "With great flavor, no additives and our lowest price, Huihui® fills a crucial gap in the unaged rum category and is our top seller. So, this is especially exciting for the whole team." Simultaneously, Kuleana Rum Works won four Gold Medals at the BTI World Spirits Championships, one of the most rigorous blind-tasting competitions in the industry. Huihui® won a Gold Medal in the Blended White Rum category with 94 Points, Nanea® won a Gold in the Aged Rum Blend category with 93 Points, Hōkūlei® won a Gold in the Aged Rum Blend category with 94 Points and their Hawaiian Rum Agricole won a Gold in the Agricole category with 93 Points. "These awards reflect our obsession with purity, place, and process," added Jefferson. "Unlike most rums, we never add sugar, flavoring, or coloring. Our rums are just clean, expressive rum with exceptional flavor, the result of our care and craftsmanship. It's deeply rewarding to be recognized by the BTI." Kuleana Rum Works describes themselves as Farmers, Distillers and Blenders. As a Blender, they have access to rums from around the world. Occasionally, they find an old, dusty, forgotten barrel in a warehouse somewhere that contains amazing rum. It does not fit into their line of core products, but they can't pass it up. This is why they created their Special Release Program. The fifth release in this program, Dominican Republic 15, will be coming this month. The story of this fifth installment starts in February of 2009, as fresh cane juice is fermented and then distilled in a column still typical of the island's tradition. After aging in a once-used Bourbon barrel for 13 years, it was sent to the Netherlands, where it was poured into

a second barrel for two more years. When they first tried it in early 2025, they were stunned and knew they had to bring it home to Kohala to share. There are only 300 bottles available. <https://kuleanarum.com/>

### **MALIBU and DOLE**

Malibu has partnered with Dole to introduce Malibu & Dole Ready-to-Drink Cocktails, a new Ready-to-Drink coming early 2026. Inspired by the popular pairing of Malibu and Dole pineapple juice, which mixed together is one of the most popular ways people enjoy Malibu, this collaboration brings the summer mindset year-round in a convenient format. The new range captures the coconut essence of Malibu made with real rum, real pineapple juice from Dole, crisp sparkling water and other natural flavors. Each 12 oz. can contains just 130 calories [2] and is made with natural flavors, free from artificial sweeteners or colors. The line will include a variety 8-Pack, 12oz. cans with four mouth-watering flavors including Pineapple, Pineapple Mango, Pineapple Strawberry and Pineapple Dragon Fruit. Additionally, large format single cans (19.2 oz.) will be available in Pineapple and Pineapple Mango. "Malibu & Dole have had a long-standing relationship and have been enjoyed together by our consumers in bars and homes across the country for many years," said Natalie Accari, Division Vice President, GM, RTD & Convenience Pernod Ricard USA. "This innovation takes our consumers favorite serve and makes it even more accessible in a convenient format." "We are thrilled to embark on this new collaboration with Malibu," said Elisabeth Morris, Director, Brand and Licensing at Dole Food Company. "Both brands are leaders in their category and bringing them together in a highly desirable and convenient format will only enhance the consumer experience year-round." <https://www.malibudrinks.com/en-us/> <https://www.dole.com/>

### **EL DORADO**

Demerara Distillers Limited (DDL) has introduced the second release in its high ester blend series: Port Mourant (PM) / Diamond High Ester (DHE). This follows the successful launch of La Bonne Intention (LBI) / Diamond High Ester (DHE) expression back in 2024, which was widely praised by rum enthusiasts. This El Dorado High Ester Blend combines rum from the historic Port Mourant (PM) Double Wooden Pot Still with their exclusive Diamond High Ester (DHE) rum from the Double Retort Copper Pot Still. Both rums, PM and DHE, were distilled back in 2014 and aged in ex-bourbon casks before being blended together and bottled. Aged for 10 years and released at cask strength, this rum celebrates

the depth and diversity of Demerara rum making. The Port Mourant (PM) Double Wooden Pot Still was originally installed at the Port Mourant Estate, founded in 1732. The extra character and depth of the rum from this still made it a choice of the Royal Navy which had begun issuing an official daily ration of rum to its sailors. As Distilleries closed and consolidated this still was eventually moved to Uitvlugt and with the closure of Uitvlugt Estate in 1998, this still was moved to the Diamond Distillery in 1999 where today it remains. The Diamond High Ester (DHE) marque is produced by one small John Dore Double Retort Pot Still, that dates back to 1950 and is one of its kind at the Diamond Distillery. This high ester experiences a lengthy production process, with fermentation taking place over several months, and distillation at both a very slow rate and a very high reflux. <https://theeldoradorum.com/>

### **ANGOSTURA**

The Trinidad Guardian reported that weeks after he was chosen to be the Chairman of Angostura, former Sport Minister Gary Hunt has officially been elected to the board of directors of Angostura. Following a special meeting at the House of Angostura, the Radical Designs CEO and founder was confirmed in the role. The other nominees confirmed as directors on the company's board were Patricia Dindyal, Shival Maharaj, Roxane De Freitas, and Jennifer Frederick. Fraser Thornton who was also set to be elected to the board, withdrew without an official reason being provided at the meeting. In honor of their 200-year anniversary celebrated in 2024, Angostura has produced a Limited-Edition ultra-premium rum, CUSPARIA. An expression of heritage and innovation, CUSPARIA celebrates two centuries of rum-making excellence, while looking boldly at the future. Crafted in small batches, only 1,824 bottles were produced, CUSPARIA is a deliberate nod to Angostura's founding year, 1824. Each bottle is presented in a stunning, hand-cut crystal decanter with a matching stopper, elegantly encased in a bespoke gift box. This rare and luxurious blend of 21- to 24-year-old rums is matured further in a trio of exceptional casks: Madeira, Cognac, and Bourbon. The result is a spirit of remarkable depth and complexity that reflects two centuries of passion, precision, and Caribbean spirit. The name CUSPARIA was inspired by Galipea officinalis, a tree indigenous to Venezuela's mountainous regions from which the rare Cusparia bark is derived. This botanical connection speaks to the origins of Angostura's founder, Dr. Johann Siegert, who began perfecting his legendary aromatic bitters in Ciudad Bolívar, formerly known as Angostura, on the banks of the Orinoco River. <https://angostura.com/>



## DUPPY SHARE

The Spirit Business reported that Caribbean brand Duppy Share has set a Guinness World Record for the largest Rum Punch. The punch consisted of 332 bottles of Duppy White Rum, 750 liters Tropical Vibes Fruit Punch, 21 liters sugar syrup, 4 liters Season Bitters and 800 squeezed limes. The 1,000-liter Punch bowl was able to serve more than 5,000 festival-goers. George Frost, Duppy Share's Founder, told Spirit Business "We've always believed rum Punch is the ultimate sharing serve and what better way to bring people together than with the biggest bowl of rum Punch the world has ever seen." In other celebrations, Duppy Share celebrated its first decade in business with a spiced rum aged for up to 10 years. Duppy Share Legacy Edition was crafted from a blend of rums from Jamaica and Barbados that were aged up to 10 years in ex-Bourbon barrels. The blend was then infused with carefully selected spices, which the brand says has created a rum of 'depth and sophistication'. Its notes include Jamaican molasses, vanilla, honey, salted caramel and raisin. Frost said: "I started Duppy Share with a simple belief: rum deserves better, and this bottle marks a decade of our mission to do rum justice. Blending a selection of rums aged up to 10 years, infused with spices and bottles with craft, care and passion. I couldn't be prouder of what we've created with Legacy Edition and I hope you love it as much as I do." The brand was founded by Frost, the son of famous broadcaster Sir David Frost, in 2015.

<https://www.theduppyshare.com/>

## MOUNT GAY

Mount Gay now offers an expanded collection of experiences at both the Distillery and the Visitor Center.

At the Visitor Center in Bridgetown, St. Michaels, the following experiences are offered (NOTE: These events do not include a distillery tour):

- **SIGNATURE TASTING EXPERIENCE** - In this 1-hour session, visitors will learn a short history of Mount Gay Rum, followed by a tasting of four of their blends from their Signature Collection. This group friendly Tasting Experience is the perfect introduction into the world of Mount Gay Rum.
- **COCKTAIL WORKSHOP** - This 2 ½ -hour session is a fun afternoon activity of Rum tasting and learning techniques in Cocktail Making, From Mixing and Muddling to Shaking and Stirring. Have a tasting of 4 rums, and craft 2 of your own cocktails.
- **LUNCH AND RUM TASTING EXPERIENCE** - This 2 ½ -hour event features a Gourmet Lunch after an informative rum tasting. Enjoy their signature rums as you learn about Mount Gay's

history dating back to 1703. Then follow it up with lunch prepared by their in-house chef.

- **AN EVENING AT MOUNT GAY** - In this 4-hour experience you will learn the history of the World's Oldest Rum as you enjoy a guided tasting of 4 Signature Blends. Next, their skilled Mixologist Team will teach you the art of cocktail making. End your night with dinner, prepared by their resident chef.

At the Distillery in St. Lucy, the tours and experiences include:

- **SIGNATURE DISTILLERY TOUR** - This is a two-hour tour that will take you around the grounds and inside the Distillery, where you will learn about the history and the Process of Mount Gay Rum followed by a tasting of 3 of their Signature Blends.
- **COCKTAIL MASTERCLASS** - This 4-hour, rum filled afternoon takes you through the history of classic cocktails and techniques to craft your own delicious drinks from locally sourced ingredients while competing against the others at the end to create the best cocktail. During the break, guest will take a peek at the stills.
- **RUM AND CHOCOLATE PAIRINGS** - During this two-hour experience, attendees will enjoy four expertly chosen pairings to please the palate, while being guided through the History and Heritage of Mount Gay Rum.
- **SIP AND PAINT** - Every Saturday afternoon, you can relax and unleash your inner artist at their fun and laid-back painting event. Grab a brush, sip on a cocktail, or two, and let your creativity flow. This tasting experience does not include a Distillery Tour.
- **MOUNT GAY DISCOVERY EXPERIENCE** - This 3-hour experience starts with a tour of the World Oldest Running Rum Distillery, followed by a more in-depth tasting of four signature rums. It is recommended to eat a large breakfast the day of this tour
- **THE CONNOISSEUR TOUR** - A Rum Lovers delight, this is a 3 ½ hour, deep dive into Mount Gay's finest liquids. This behind-the-scenes tour takes you deep into the rum making process, from grass to glass, tasting their core range and some of their Exclusive rums. It is recommended to eat a large breakfast the day of this tour.
- **STORIED DINNER** - Embrace the history of rum, its production, and its pairing with a four-course plated dinner. Participants will be exposed to an elevated understanding of the flavor profiles of rum and the harmonious balance that enhances culinary creations. This experience does not include a Distillery Tour.

<https://www.mountgayrum.com/>



# The Sweet Business of Sugar

THE **Rum**  
UNIVERSITY





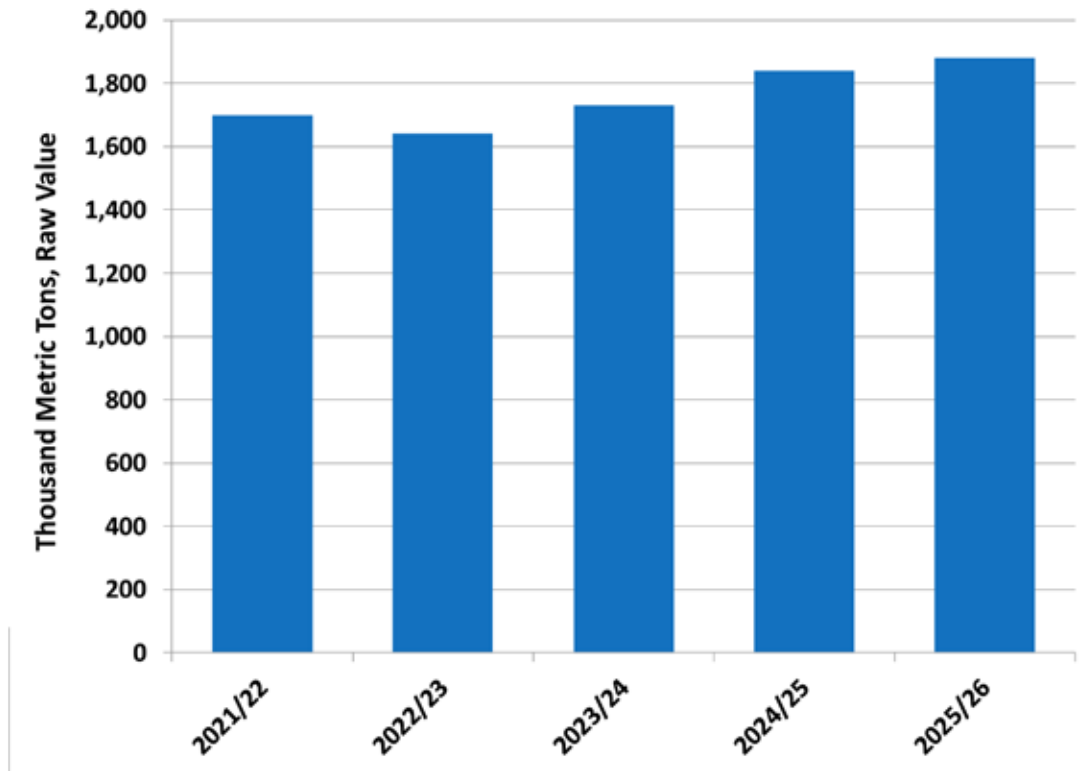
# WORLD REPORT

Regardless of distillation equipment, fermentation method, aging or blending techniques, all rum producers have one thing in common: **sugarcane**.

Without sugarcane we would not have sugar mills, countless farmers would not have a profitable crop and we would not have rum!

# Sugar: World Markets and Trade

## Argentina Sugar Production on the Rise



Sugar production in Argentina is forecast at 1.88 million tons (raw value) in marketing year 2025/26, up 2 percent from the previous year and nearly 15 percent higher from 2022/23, driven by higher domestic demand and increased sugarcane harvested for producing sugar. Freight, labor, and energy expenses continue to rise, pressuring producers, but Argentina remains the 17<sup>th</sup> largest sugar producer in the world.

Sugarcane area harvested is forecast up 2 percent to 418,000 hectares in 2025/26. The share directed toward sugar production is projected to slip 1 percent to 74 percent of total cane volume, with the remainder dedicated to ethanol production due to favorable domestic demand. Area expansion is concentrated mostly in Tucumán, where returns for sugarcane have been better than alternative crops such as soybeans.

Sugar exports are projected to decline due to lower beginning stocks and higher consumption. Domestic sugar consumption is projected up to 1.4 million tons due to an expected 5-percent recovery in gross domestic product. Top markets include the United States where, exporters have the 6<sup>th</sup> largest U.S. tariff rate quota (TRQ) allocation of 46,260 tons raw value, and Chile. Argentina is the 17<sup>th</sup> largest sugar exporter in the world.

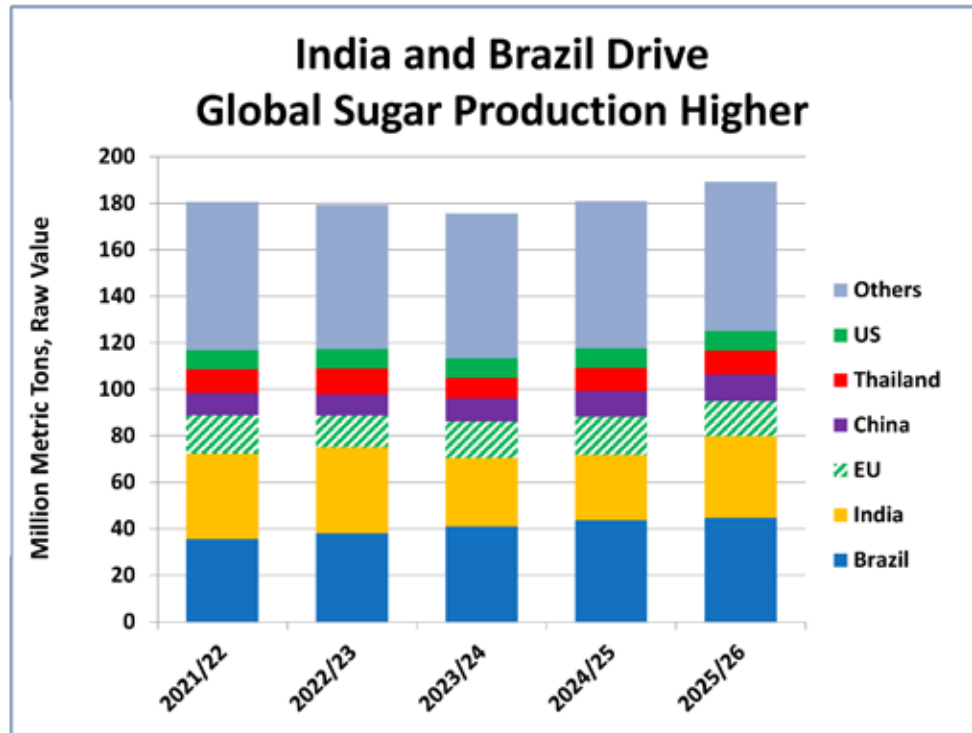
For more information, see the Argentina Sugar Annual Report in the FAS Global Agricultural Information Network (GAIN) at: [Sugar Annual Buenos Aires\\_Argentina\\_AR2025-0008](#).

**\*\*Please note that the measurement unit is metric tons (tons) raw value\*\***



## 2025/26 Sugar Overview

**Global** sugar production is forecast up 8.6 million tons to 189.3 million with higher production in Brazil and India expected to more than offset lower European Union production. Exports are down with lower shipments expected from the European Union and Thailand. Ending inventories are forecast to rise due primarily to India and China.



**U.S.** production is forecast down slightly to 8.4 million tons. Imports are forecast lower based on projected quota programs set at minimum levels consistent with World Trade Organization and free-trade agreement obligations, and on projected imports from Mexico, re-exports, and high-tier tariff imports. Consumption is unchanged while stocks are reduced mostly due to lower imports.

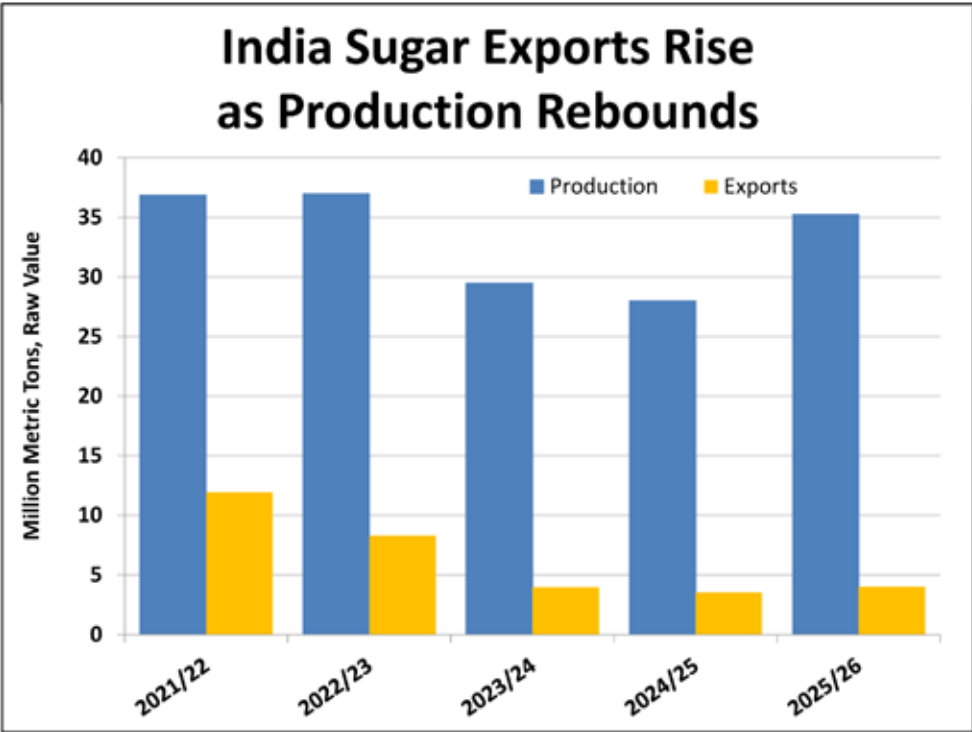
**Brazil** production is forecast up 1.0 million tons to a record 44.7 million with expected higher sugar yield due to favorable weather. The sugar/ethanol production mix is expected to favor ethanol relative to the previous season, falling from 51 percent to 49 percent for sugar and rising from 49 percent to 51 percent for ethanol. Consumption is forecast to fall slightly while exports are up with higher production.

**European Union** production is forecast to fall 9 percent to 15.0 million tons as sugar beet area is expected to be down 10 percent mainly among top producers such as France and Germany. Consumption and ending stocks are relatively unchanged from the prior year. Imports are up with lower production while exports are forecast down.

**Thailand** production is forecast up 2 percent to 10.3 million tons due to increased sugarcane production and cane sugar yield. Consumption continues to rise but at a slower rate due to lower

demand from export-oriented food processors. Exports are forecast to drop due to competition from other large exporters such as Brazil while stocks are expected to be flat.

**India** production is estimated to jump over 25 percent to 35.3 million tons on favorable weather and increased area. Consumption is anticipated to rise, driven by food service sector growth, while exports and stocks are both up with the increase in supply.



**Australia** production is forecast to decrease 50,000 tons to 3.8 million (the lowest level in over a decade) due to unfavorable weather which hindered sugarcane development and replanting. Consumption is forecast to increase in line with population growth while exports are forecast higher while drawing down stocks.

**China** production is forecast up 500,000 tons to 11.5 million as sugarcane area is expected to rise and sugarbeets are expected to benefit from favorable weather. Imports are forecast to rise to help fill the gap between supply and demand, despite higher domestic production. Consumption and exports are unchanged. Stocks are forecast up as consumption continues a slow rebound.

**Mexico** production is forecast 300,000 tons higher to 5.4 million due to favorable weather and increased sugarcane production and area. Imports are forecast down with increased production. Consumption and stocks are forecast unchanged with ending stocks now expected to include 159,000 tons of below 99.2 polarity sugar intended for export into the United States in the first quarter of the fiscal year. Exports to the United States are expected to be set by the amended Suspension Agreements while overall exports are forecast lower with less going to other world markets.



**Indonesia** production is forecast up 200,000 tons to 2.6 million due to higher sugarcane area harvested and yields. Consumption is expected to be up in line with population growth and an expected increase in demand from the food and beverage industry. With higher production, imports are forecast to decline.

**Turkey** production is forecast unchanged at 3.1 million tons. Consumption is flat on stable household and food and beverage industry demand while stocks are forecast to be unchanged.

**Guatemala** production is forecast unchanged at 2.6 million tons. Consumption is forecast to rise slightly due to growing demand. Exports are up with the United States as the largest market. Stocks are forecast down with higher exports.

**South Africa** production is forecast up 150,000 tons to 2.1 million due to improved weather and sugar recovery rate. Imports are forecast to drop on increased domestic supply while exports are forecast higher.

***Selected MY 2024/25 Revisions from November 2024 Forecast:***

- Global production is down 5.9 million tons to 180.8 million.
  - o The European Union is increased by 919,000 tons to 16.5 million with strong sugarbeet production in Poland and Germany.
  - o Brazil jumps 700,000 tons higher to 43.7 million due to a rise in area.
  - o India is revised down 7.5 million tons to 28.0 million due to unfavorable weather and limited available water for irrigation.
- Global imports are flat at 56.6 million tons.
  - o The United States is raised 330,000 tons to 2.7 million on increased high-tier imports.
  - o Algeria is up 305,000 tons to 2.2 million on higher imports from Brazil.
  - o European Union is lowered 450,000 tons to 2.0 million on higher production and lower imports from Ukraine.
  - o Sudan is reduced 499,000 tons to 855,000 due to lower imports from India.
- Global exports are raised 1.3 million tons to 68.0 million.
  - o The European Union is raised 1.0 million tons to 2.1 million on higher production and strong export performance early in the year.
  - o Pakistan is revised up 550,000 tons to 700,000 due to higher-than-expected shipments to Afghanistan.
  - o Australia is lowered 543,000 tons to 2.7 million due to a delayed harvest.
- Global ending stocks are lowered 7.1 million tons to 38.3 million.
  - o Thailand stocks are up 768,000 tons to 7.6 million due to lower exports.
  - o United States is raised 515,000 tons to 1.8 million on increased high-tier imports.
  - o Pakistan is lowered 1.7 million tons to 2.0 million on lower production.
  - o India drops 7.9 million tons to 5.7 million due to a drop in production.

For further information, please contact Tony Halstead at [Tony.Halstead@usda.gov](mailto:Tony.Halstead@usda.gov)

Please note that the measurement unit is metric tons (tons) raw value using Harmonized Tariff Code contained within 1701.

#### Harmonized Codes and Conversion Rates

Sugar – Metric Tons (Raw Value)		
HS code	Description	Conversion Rate
170111	Cane sugar, raw, in solid form, not containing added flavoring or coloring matter	1.00
170112	Beet sugar, raw, in solid form, not containing added flavoring or coloring matter	1.00
170113	Raw cane sugar specified in subheading note 2 to this chapter	1.00
170114	Cane sugar, raw, in solid form, not containing added flavoring or coloring matter, nesoi	1.00
170191	Cane/beet sugar, refined, solid, containing added flavoring coloring	1.07 cane 1.087 beet 1.06 for Mexico
170199	Cane/beet sugar chem pure sucrose refined nesoi	1.07 cane 1.087 beet 1.06 for Mexico

#### Future Releases and Contact Information

The next release of this circular is scheduled for November 20, 2025. To receive the circular via email, go to: <https://public.govdelivery.com/accounts/USDAFAS/subscriber/new>. Please visit <https://www.fas.usda.gov/data/sugar-world-markets-and-trade> to view archived and future releases.

The *Sugar: World Markets and Trade* circular is based on reports from FAS Overseas Posts and on available secondary information. The individual country reports can be obtained on FAS Online at: <https://gain.fas.usda.gov/Pages/Default.aspx>.

#### PSD Online

The entire USDA PSD database is available online at: <https://www.fas.usda.gov/psdonline>.

#### Additional Resources

Please refer to the USDA-FAS Sugar website at: <https://www.fas.usda.gov/commodities/sugar> for additional data and analysis.

Situation and outlook information on U.S. sugar and sweeteners can be obtained from the USDA-Economic Research Service at: <http://www.ers.usda.gov/topics/crops/sugar-sweeteners.aspx>.

#### Sugar Marketing Years -

Countries are on a May-April Marketing Year with exceptions noted below.



**April-March – Brazil**

**July-June – Australia**

**September-August - Philippines**

**October-September – Barbados, Belarus, Belize, Bolivia, China, Colombia, Costa Rica, Cuba, Dominican Republic, Egypt, El Salvador, European Union-27, Guatemala, Guyana, Honduras, India, Iran, Mexico, Morocco, Nicaragua, Pakistan, Panama, Russia, Serbia, Sudan, Turkey, United Kingdom, Ukraine, United States, Venezuela, and Vietnam**

**December-November – Thailand**

(Report continues on next page)

# World Centrifugal Sugar: Production and Consumption

1,000 Metric Tons, Raw Value

	2020/21	2021/22	2022/23	2023/24	2024/25	May 2025/26
<b>Production</b>						
Brazil	42,050	35,450	38,050	41,000	43,700	44,700
India	33,760	36,880	37,000	29,500	28,000	35,250
European Union	15,216	16,577	13,811	15,642	16,498	15,007
China	10,600	9,600	8,960	9,960	11,000	11,500
Thailand	7,587	10,157	11,059	8,808	10,040	10,250
United States	8,376	8,307	8,391	8,449	8,447	8,424
Pakistan	6,505	7,560	6,860	6,560	5,860	6,660
Russia	5,625	6,000	6,100	6,600	6,500	6,500
Mexico	6,058	6,556	5,537	4,986	5,100	5,400
Australia	4,335	4,120	4,300	4,100	3,850	3,800
Egypt	2,780	2,855	2,885	2,600	3,100	3,180
Turkey	3,100	2,650	2,900	3,400	3,100	3,100
Guatemala	2,565	2,575	2,608	2,621	2,621	2,621
Indonesia	2,130	2,300	2,400	2,300	2,400	2,600
Colombia	2,240	2,300	2,180	2,000	2,250	2,300
South Africa	2,106	1,906	1,996	2,075	1,940	2,090
Argentina	1,830	1,700	1,640	1,730	1,840	1,880
Philippines	2,143	1,800	1,799	1,922	1,850	1,850
Iran	1,535	1,600	1,550	1,620	1,800	1,800
Ukraine	1,240	1,450	1,330	1,820	1,800	1,490
Vietnam	750	820	1,015	1,125	1,350	1,350
Peru	1,197	1,260	1,185	1,220	1,290	1,300
United Kingdom	985	1,025	805	950	1,100	1,000
Nicaragua	756	804	751	806	766	840
Japan	815	810	755	630	750	750
Other	13,978	13,638	13,380	13,239	13,802	13,671
<b>Total</b>	180,262	180,700	179,247	175,663	180,754	189,318
<b>Human Dom. Consumption</b>						
India	28,000	29,000	30,000	30,288	29,500	31,000
European Union	16,700	17,000	16,500	16,400	16,400	16,400
China	15,500	14,800	15,500	15,500	15,700	15,700
United States	11,032	11,314	11,471	11,349	11,022	11,022
Brazil	10,150	9,500	9,500	8,800	9,000	8,900
Indonesia	7,445	7,600	7,800	7,500	7,600	7,700
Pakistan	5,750	6,000	6,200	6,350	6,600	6,800
Russia	5,804	6,350	5,828	6,234	6,148	6,150
Mexico	4,171	4,342	4,475	4,284	4,400	4,400
Egypt	3,340	3,430	3,320	3,570	3,750	3,850
Turkey	2,914	3,020	3,362	3,438	3,370	3,350
Thailand	2,350	3,000	3,370	3,641	3,000	3,100
Iran	2,551	2,600	2,468	2,535	2,739	2,990
Philippines	2,275	2,300	2,000	2,200	2,200	2,200
Algeria	1,937	1,888	1,946	1,945	2,137	2,164
Japan	1,883	1,827	1,807	1,775	1,960	2,004
Malaysia	1,823	1,675	1,890	1,611	1,856	1,905
Bangladesh	2,419	2,767	2,237	2,045	1,890	1,863
Colombia	1,850	1,865	1,800	1,800	1,810	1,800
United Kingdom	1,615	1,736	1,722	1,728	1,854	1,785
Vietnam	2,046	1,922	1,961	1,631	1,667	1,700
Nigeria	1,610	1,600	1,650	1,620	1,500	1,700
Canada	1,399	1,356	1,400	1,505	1,654	1,693
South Africa	1,670	1,710	1,750	1,641	1,550	1,580
Peru	1,389	1,389	1,389	1,355	1,380	1,430
Other	33,491	33,501	35,136	35,360	34,748	34,723
<b>Total</b>	171,114	173,492	176,482	176,105	175,435	177,923



# World Centrifugal Sugar: Imports and Exports

1,000 Metric Tons, Raw Value

	2020/21	2021/22	2022/23	2023/24	2024/25	May 2025/26
<b>Exports</b>						
Brazil	32,150	25,950	28,200	32,500	34,890	35,800
Thailand	3,739	7,012	6,871	4,641	10,000	7,000
India	8,406	11,927	8,303	3,966	3,504	4,000
Australia	3,400	3,120	2,950	3,147	2,717	3,115
Guatemala	1,395	1,651	1,427	1,184	1,291	1,325
European Union	1,278	1,217	868	2,073	2,106	1,006
United Arab Emirates	793	1,209	1,115	798	945	945
Saudi Arabia	370	583	706	838	900	920
South Africa	1,007	548	722	870	645	790
Morocco	636	731	656	677	700	720
Mexico	1,235	1,777	1,072	473	766	707
Ukraine	61	70	465	755	731	700
Colombia	669	663	676	565	600	640
Nicaragua	508	526	473	528	491	565
Russia	429	431	601	552	551	551
Eswatini	634	524	488	561	462	540
Argentina	243	327	190	102	600	515
El Salvador	529	546	505	430	427	506
Nigeria	300	350	350	365	385	375
Egypt	300	300	430	300	300	300
Mauritius	369	320	339	312	298	300
Korea, South	320	280	270	277	275	275
Malaysia	329	316	193	265	260	260
Cambodia	179	95	52	167	192	200
China	132	160	183	168	200	200
Other	4,656	4,489	3,857	3,402	3,714	2,978
<b>Total</b>	64,067	65,122	61,962	59,916	67,950	65,233
<b>Imports</b>						
China	6,379	5,000	3,800	5,000	5,200	5,300
Indonesia	6,124	5,466	5,800	5,000	5,200	5,100
India	1,245	340	1,393	3,558	2,350	2,550
European Union	1,792	1,998	3,107	2,092	1,950	2,400
United Arab Emirates	1,785	1,563	1,779	2,121	2,271	2,290
Algeria	2,258	2,245	2,039	2,034	2,245	2,250
United States	2,922	3,308	3,279	3,483	2,671	2,245
Malaysia	2,142	1,961	2,128	1,818	2,164	2,175
Nigeria	1,880	1,930	1,950	1,930	1,820	2,030
Saudi Arabia	1,488	1,517	1,860	1,982	1,980	1,985
Bangladesh	2,351	2,805	2,105	1,971	1,820	1,825
Morocco	1,407	1,531	1,639	1,701	1,778	1,803
Canada	1,389	1,314	1,359	1,465	1,638	1,660
Korea, South	1,934	1,983	1,819	1,759	1,625	1,640
Iran	1,067	1,045	971	1,017	1,020	1,300
Iraq	1,109	1,278	1,363	1,365	1,270	1,280
Japan	1,051	1,004	1,034	1,151	1,257	1,267
Egypt	830	830	930	1,960	1,260	1,060
United Kingdom	680	777	974	852	900	910
Yemen	941	473	859	872	885	885
Sudan	1,130	1,597	1,676	999	855	855
Somalia	821	880	931	760	770	775
Ethiopia	1,462	1,737	1,238	789	735	740
Sri Lanka	626	547	625	536	675	675
Chile	532	654	593	618	625	635
Other	12,878	12,404	13,440	13,086	11,627	11,752
<b>Total</b>	58,223	56,187	58,691	59,919	56,591	57,387

# World Centrifugal Sugar: Ending Stocks

1,000 Metric Tons, Raw Value

	2020/21	2021/22	2022/23	2023/24	2024/25	May 2025/26
<b>Ending Stocks</b>						
India	13,213	9,506	9,596	8,400	5,746	8,546
Thailand	9,067	9,212	10,030	10,556	7,596	7,746
China	5,374	5,014	2,091	1,383	1,683	2,583
Pakistan	2,752	3,812	3,472	3,392	1,952	1,762
Indonesia	2,653	2,370	2,330	1,950	1,750	1,600
United States	1,547	1,652	1,672	1,933	1,843	1,304
Egypt	135	90	155	845	1,155	1,245
Mexico	1,116	1,022	885	1,503	1,146	1,146
Philippines	1,196	931	1,465	1,273	1,068	1,035
Australia	135	294	784	853	1,079	837
Iran	638	650	618	651	692	756
Russia	565	624	580	624	655	704
Ukraine	369	504	490	636	801	675
Japan	475	460	440	444	489	500
Algeria	387	377	389	398	426	432
Vietnam	412	384	392	408	417	426
Costa Rica	299	325	314	387	400	411
Malaysia	365	335	380	322	370	380
Bangladesh	482	550	448	409	377	377
Zimbabwe	82	186	178	139	300	374
Korea, South	405	420	395	381	345	342
Guatemala	364	333	334	434	414	340
Canada	280	271	278	301	330	337
United Arab Emirates	190	91	126	242	260	322
Ecuador	324	359	385	392	372	295
Other	7,471	7,849	7,986	6,842	6,644	6,701
<b>Total</b>	<b>50,296</b>	<b>47,621</b>	<b>46,213</b>	<b>45,098</b>	<b>38,310</b>	<b>41,186</b>





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The background of the entire page is a photograph of a historic stone mill. The mill is constructed from rough-hewn grey stones and features a large, circular, dark metal gear or opening on its side. The mill is situated outdoors, surrounded by lush green trees and foliage. A metal fence with a chain is visible in the lower-left foreground. The text is overlaid on a semi-transparent white rectangular box in the upper half of the image.

**THE Rum**  
**UNIVERSITY**

Presents

# The Sugar Mill: Origins and Evolution







## Introduction

Sugarcane (*Saccharum officinarum*) is a perennial grass of the family *Poaceae*. It is primarily cultivated for its juice, from which alcohol (through fermentation and distillation) and sugar (through dehydration and refining) can be obtained. Most of the world's sugarcane is grown in subtropical and tropical areas.

It is commonly accepted today that sugarcane originated in Papua, New Guinea, where it was initially domesticated. The plant was then taken to other lands by traders, where its sweet virtues quickly made it a sought-after commodity.

It is also commonly accepted that around 10,000 years ago, the original inhabitants of Papua did not have tools to process the cane, meaning that they likely chewed it raw to extract the juice, which was consumed as-is (Noël Deerr, *The History of Sugar: Volume One*).

Not much written history exists that documents the early extraction of the juice for the purpose of dehydration and formation of sugar crystals until the publication of *De Materia Medica*, a pharmacopoeia of medicinal plants and the medicines that can be obtained from them, which was written between the years 50 and 70 of the current era by Pedanius Dioscorides, a Greek physician in the Roman army. This is the oldest record documenting the existence of crystalized sugar, which was used at the time to "treat indigestion and stomach ailments."

How did people manage to extract the dissolved sugar from the juice? The answers to this question are at the core of this series. So join us, as we explore this fascinating topic!





## Part 9: Rollers, More Rollers, and Battling Corrosion

In Part 8 of this series, we explored Eugene Powell's and G. H. Laub's inventions. Powell's invention consisted of five small rollers that exerted pressure on a larger, central cylinder. Taking the concept of "*more is better*" to the next level, T. Grundmann (from Stephenson, Illinois) designed an invention that incorporated a total of eight rollers, laid out in four sets of two rollers each, placed in a square frame affixed around a large, central cylinder (see diagrams on page 44). Grundmann applied for, and was granted US Patent number 27,900 on April 17, 1860.

Up to this point, all the inventions featured in this series have been aimed at increasing the *quantity* of extracted sugarcane juice and to reducing the amount of *time* needed for said extraction. Both of these conditions were driven by the large market demand for sugar.

### Oxidation and Corrosion

When sugarcane juice is squeezed out of the cane (when it is "expressed"), the juice comes into contact with the surfaces of the instruments being employed to express it: gears, rollers, pans, etc. Cast iron is very susceptible to corrosion and the pH and Brix (sugar content) of the cane juice make it an excellent corrosive agent. The downside of the corrosion is twofold: first is the damage to the equipment involved (reduced operating life) and second is the damage to the expressed



Fig: 1.

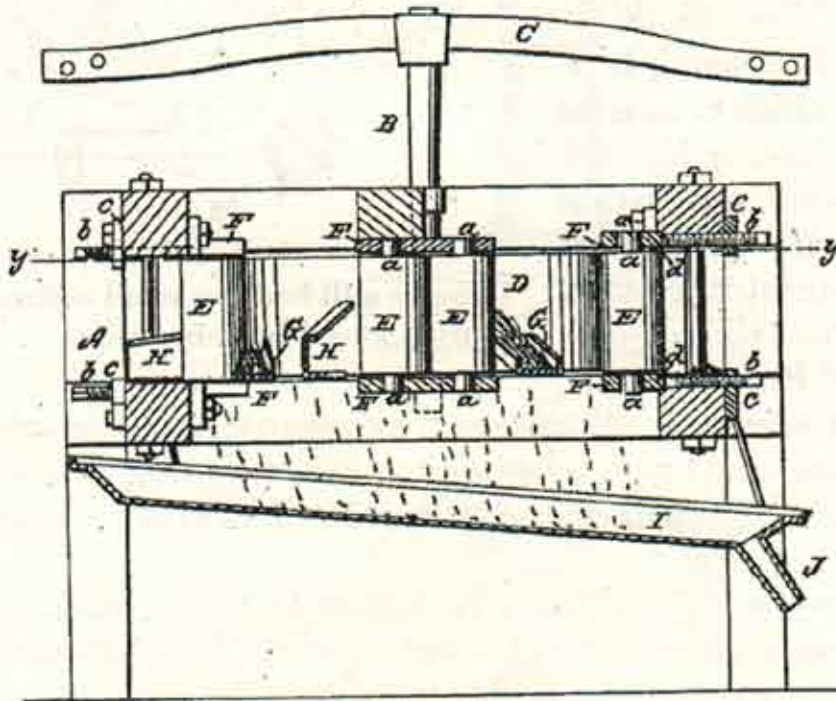
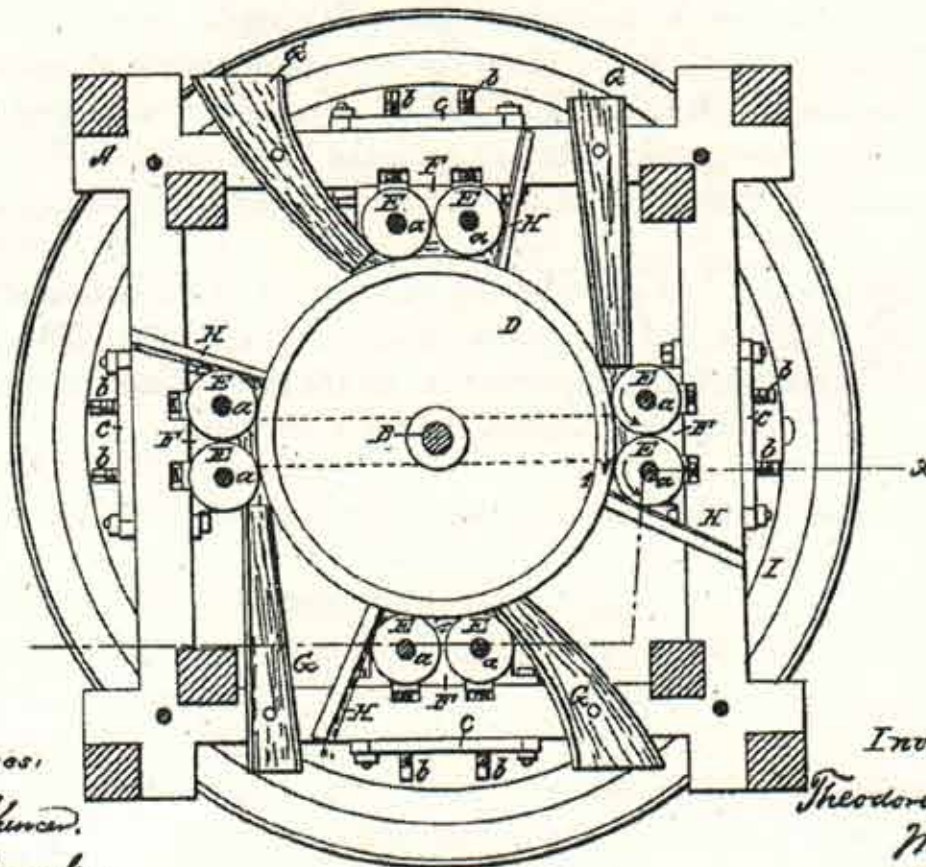


Fig: 2.



Witnesses:

R. E. Spencer.  
J. W. Coombs.

Inventor:

Theodore Grandmann,  
Mumf. & Co.  
Attorneys.



# IMPROVEMENT IN SUGAR-CANE MILLS.

Specification forming part of Letters Patent No. **22,711**, dated January 25, 1859.

*To all whom it may concern:*

Be it known that I, WILLIAM T. DENNIS, of the city of Richmond, county of Wayne, and State of Indiana, have invented a new and useful Improvement in Sugar-Cane Mills; and I do hereby declare that the following is a full and exact description thereof, reference being had to the accompanying drawing and the letters of reference marked thereon.

The nature of my invention consists in covering or plating the iron rollers of the sugar-cane mill with tin or other anti-corrosive metal or substance, so as to prevent the corroding of the iron, and thereby discoloring the juice of the cane.

To enable others skilled in the art to make and use my invention, I will proceed to describe its construction and operation.

I construct my sugar-cane mill in any of the usual forms, with cast-iron rollers.

The drawing, Figure 1, represents one of the cast-iron rollers with journals A A of wrought-iron. The face B and ends of the rollers I plate or cover with tin or any other suitable anti-corrosive metal or substance, so as to insulate the iron, prevent corrosion, and the discoloring of the juice.

What I claim as my invention, and desire to secure by Letters Patent, is—

The plating or covering of the iron rollers of sugar-cane mills with tin or other anti-corrosive metal or substance, for the uses and purposes herein described.

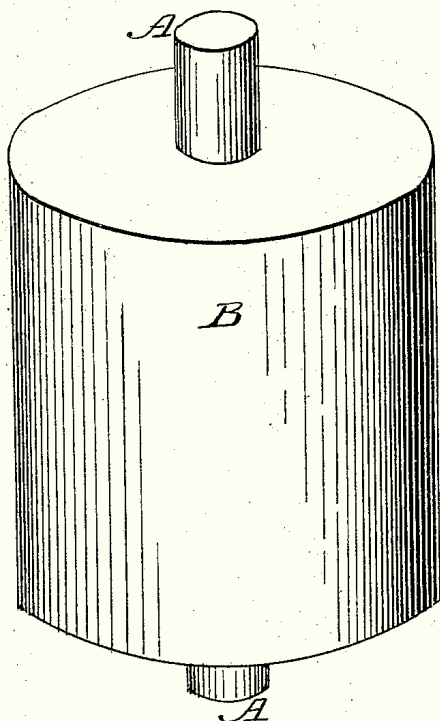
December 29, 1858.

WILLIAM T. DENNIS.

Witnesses:

JAS. JORDAN,  
OLIVER BUTLER.

*Fig. 1.*



juice, which is now contaminated with the by-products of the iron oxidation.

Quality-centered innovations speak to strong economies with “premium” consumption tiers that are willing to pay more for better or more refined goods than those that are already available at a lower price.

## William T. Dennis

The first patented invention to address this issue comes from inventor W. T. Dennis of Richmond, Indiana. It consisted of rollers plated or covered “*with tin or any other suitable anti-corrosive metal or substance*”. The full description of the patent application can be seen above, and the accompanying diagram is shown to the left. William Dennis was awarded US Patent 22,711 on January 25, 1859.







## Sugar Mill Spotlight

Former sugarcane factory at the Mariënburg Plantation in Suriname, South America. Mariënburg was founded as a sugar plantation by Maria de la Jaille in 1745. The plantation was later abandoned and was purchased by the Netherlands Trading Society (NHM) in 1882. The NHM operated the plantation in part with Javanese indentured laborers from the then Dutch East Indies.

Join us again next month, as we continue to explore this fascinating topic!

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# CIGAR & RUM PAIRING

by Philip Ili Barake







**M**y name is Philip Ili Barake, Sommelier by trade. As a result of working with selected restaurants and wine producers in Chile, I started developing a passion for distilled spirits and cigars. As part of my most recent job, I had the opportunity to visit many Central American countries, as well as, rum distilleries and tobacco growers.

But my passion for spirits and cigars did not end there; in 2010 I had the honor of representing Chile at the International Cigar Sommelier Competition, where I won first place, becoming the first South American to ever achieve that feat.

Now I face the challenge of impressing the readers of "Got Rum?" with what is perhaps the toughest task for a Sommelier: discussing pairings while being well aware that there are as many individual preferences as there are rums and cigars in the world.

I believe a pairing is an experience that should not be limited to only two products; it is something that can be incorporated into our lives. I hope to help our readers discover and appreciate the pleasure of trying new things (or experiencing known things in new ways).

Philip  
#GRCigarPairing



## Pairing #150

A few months have passed since I started managing a new restaurant, an iconic concept in Punta Arenas. Many generations have enjoyed this *alcazar*, filled with history and good memories. At closing time, after everyone left, I stayed at the bar and pulled out a cigar I had brought from home. I planned to prepare a Rum Old Fashioned, most of you know that it is one of my favorite rum cocktails.

The dilemma was, which of my rums from the house to use? The one that was up to the challenge was El Dorado 15, from Guyana. This rum and I go back a long time, and recalling all those memories made it the ideal choice.

Regarding the cigar, not too long ago I met with an industry colleague, and he gifted me several cigars. This is one of them, one I've smoked before, a Rigoleta from Fuller Cigar (6 x 54). It is primarily a Dominican Republic, box-pressed cigar, with some Nicaraguan leaves in the blend. My appreciation for this format grew the more I smoked it, I really enjoyed its draw. This one was no different. I would categorize the cigar's intensity at a Medium, with some stronger hits during the second third, but can be very well-rounded with the right pairing.

El Dorado 15 is the perfect rum for an Old Fashioned, it has plenty of character that endures in the cocktail, the rum profile has notes of dark woods and tanned leather. The rum is not designed to satisfy the masses, but rather it is blended for those looking for heavier, more



Photos credit: @Cigarili





Photo credit: @Cigarili

intense, yet well-rounded rums. It allows for the perfect balance in this cocktail recipe, when mixed with the brown sugar and the Angostura Bitters. The pairing brings a smile to my face, just thinking about it!

During the first third of the cigar, the cocktail dominates the pairing, something I fully expected, especially since I didn't stir the drink in order to appreciate the rum even more. After a few puffs, as we enter the second third of the cigar, the brown sugar notes from the cocktail come into play, providing a sweet aftertaste that is very well-received, as it smooths out the experience.

This is a special pairing, which celebrates 150 articles written for "Got Rum?" magazine over the past 15 years, filled with pleasant memories shared with all our readers. This is definitely a cocktail to enjoy after a long's day work and I really hope that you can recreate it at home. Pair it with a medium intensity cigar in a format that will not exceed 40 minutes of smoking time. A simple, yet perfect pairing for special occasions, such as this one.

Cheers!  
Philip Ili Barake  
#GRCigarPairing



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