



« THE GRAND TRADITION OF COOPERAGE SINCE 1873 »

With a presence in over forty countries,
Tonnellerie Saury today has imposed
itself as one of the most famous
cooperages in France.



Celebrating the grand traditions and expertise of artisan coopers since 1873, the Saury cooperage joined the Charlois Group in 2009 and today has imposed itself as one of the most famous cooperages in France. Every one of its barrels and vats is subjected to rigorous quality controls at every stage of production. In partnership with the Laboratoire Exact, it has developed an analysis protocol to eliminate any possibility of contaminants for every product.

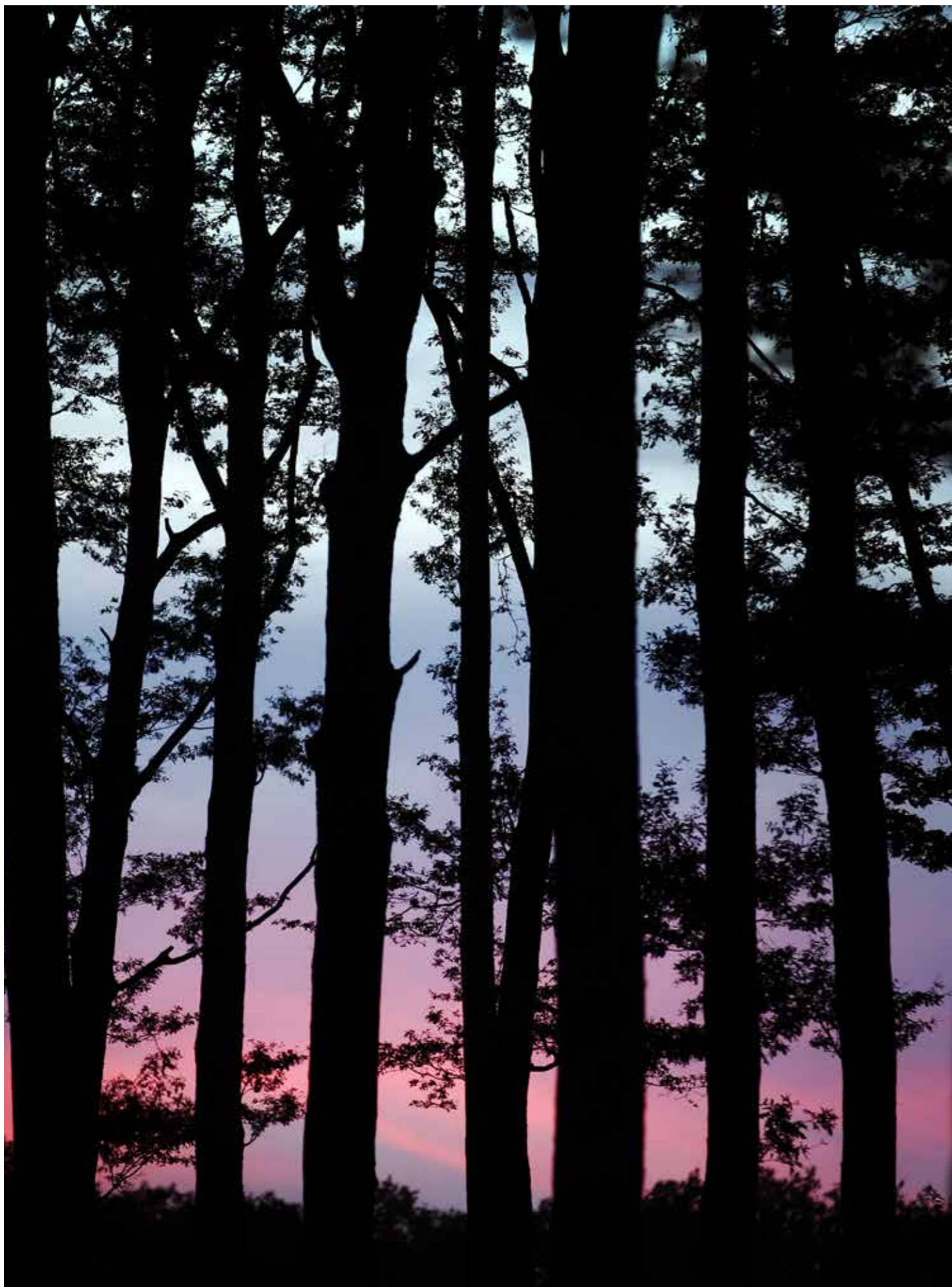
« Thanks to a completely independent supply of French oak and fully integrated production processes, Saury has total control of the raw materials for its manufacturing. »



BARRELS



www.saury.com



Since 1807, the Charlois family has enjoyed a priceless, natural heritage where oak reigns supreme. Based in Murlin in the Nivernais countryside and within the Bertranges Forest, the Groupe Charlois has access to groves where the most beautiful oak specimens in France thrive.

Founded in 1928 by Eugène Charlois, Maison Charlois specialised in selecting oak trees, splitting and naturally seasoning the staves. It became the premier forestry operator in terms of volume in France and the unrivalled leader on the French stave market.

Since 2004, Groupe Charlois is committed in the respect for the raw material and for its traceability by the certification PEFC (Programme for the Endorsement of Forest Certification). It is mainly with the Office National des Forêts, the French National Forest Bureau which manages the forest ecosystems and preserves biodiversity, that merranderies stocks up by selecting the best oak for the staves. Every taken tree is identified to certify the origin. A traceability which makes all the added value of Groupe Charlois and its stave mills.



80% of the wood is purchased from the office National des Forêts, (the French National Forest Bureau which manages the forest ecosystems and preserves biodiversity) we made a commitment in the sustainable management for several decades.

With a completely independent supply of 100% French oak and a fully integrated staves manufacturing, Tonnellerie Saury has total control of the quality of the raw materials.

After the selection of trees in forest, the most important in oak work is wood splitting.

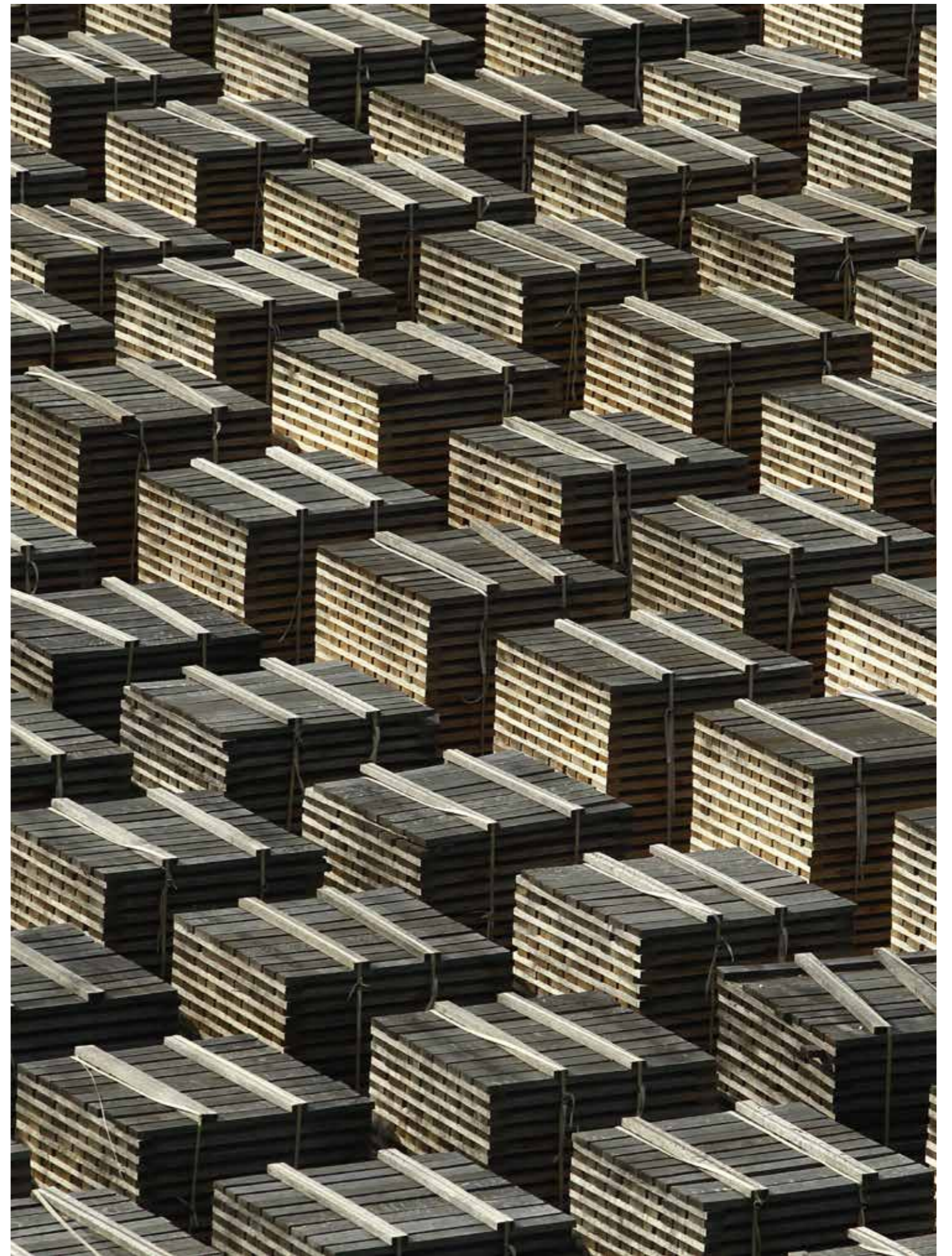
A know-how and a traditional technique, transmitted from generation to generation, which require from the merrandier an infallible eye to read well the thread of the wood, split the billon in segments (quarters), eliminate the heart, the sapwood and the bark to extract from some noble wood of the staves of straight-thread.

Craftsmen merrandiers follow precise technical specifications, including in particular the sharpness of grains, appropriate to the elaboration of the products of Tonnellerie Saury. The stave is open air ageing during 24 months minimum. The natural ageing combines dehydration and refining of oak staves. The long ageing period is essential to achieve three objectives for the future barrel's quality:

- Mechanical: to obtain a high-end construction material
- Oenological: to increase the wood's porosity and thus ensure gas exchanges that will improve the wine
- Organoleptic: to reduce certain undesirable aspects of the wood and develop the required aromatic element.

The staves are subjected to very strict tests and wood controls at each stage of its manufacturing. This process enables to control continuously the absence of sanitary risk and organoleptic abnormality. These controls are included in HACCP process certified by Bureau Veritas.

**Only 2% of oak volume in France
is stave quality oak.
This quality represents
30% of the volume purchased
by Groupe Charlois.**





Our coopers are true artisans, crafting the high quality barrels our clients have come to expect from Saury.

A Saury barrel is subjected to very strict tests and controls at each stage of its manufacturing. From the beginning of its journey in the stave mill to the cooperage where the origin and blend of woods used to make the barrel are recorded. The general manufacturing processes and toasting time and temperature are also noted. These procedures ensure optimum reproducibility for the future.

Saury barrels are pre-fired traditionally over oak to ensure perfect aromatic uniformity. When the temperature of the brazier is optimal, the craftsman cooper positions the barrel for bending. It will stay approximately twenty minutes on the fire, and then the time of natural firewood toasting is coming. This time is adapted to the request and to the profile of the invaluable nectar which will be ageing into the barrel.

For wines that are more sensitive to woody flavours, the immersion process is recommended. This procedure is unique to Tonnellerie Saury.

Immersion, other process of pre-fired oak, involves submerging the barrel in water maintained in temperature.

The water in our Immersion process is continuously checked for any possible contaminants.

The finishing operations are all done by hand. Finally, each barrel is identified with a unique tracking code identifying wood source, aging, toasting date and other information.

After toasting, the barrels are left to cool naturally.

After the barrel has received its two heads, it is checked to ensure the perfect watertightness then time takes on its familiar role in ageing the most prestigious wines.

TONNELLERIE SAURY

SPECIFICITIES

Created in 1873, Saury cooperage, is more particularly characterized by two applied and proven know-how, at the same time on the ground and scientifically, in various stages of the production of its barrels :

1/ THREE STAVE QUALITIES

Saury Premium - Premium barrel is exclusively made with certified French oak, selected for the perfect finesse of its grain, whom staves will be dried for more than 36 months, Premium barrel is an exceptional barrel for exceptional wines. Because it is rigorously and patiently crafted by the finest of our craftsmen coopers, the Premium barrel enjoys an unrivalled elegance which will be found in the breeding of your high-class wines with strong added value.

Saury Classic - Classic barrel became a world reference for all the demanding wine growers whose quality remains the Master word. Made with certified French oak exclusively and selected for the finesse of its grain whom staves will be dried for 24 months minimum. Qualitive obsession and the care of our craftsmen coopers make of it a barrel of a very large constancy which will always respect the personality of the wine, its fruit, thus contributing has its future generosity. It is particularly intended for the long traditional breedings and will give the best of its expression at the end of the breeding.

Saury Aromatic - Aromatic barrel is exclusively made with certified French oak, selected for the perfect finesse of its grain. The staves will be dried from 20 to 24 months minimum, Aromatic barrel develops its flavours quickly, helping to bring out the

fruity qualities and the flexibility of the tannins. Ideal for demanding wine growers, Aromatic barrel is particularly adapted to 9 to 12 months breeding.

2/ TWO METHODS OF PRE-TOAST

Traditional Pre-toast - The barrel is drawn in, after it is raised, using a natural oak fire for heat and water for surface humidification. This delicate step illustrates and respects the artisanal know-how of the cooper.

Traditionally coopered barrels bring structure, weight and depth to wine. Furthermore, in terms of aromatics, wines develop in complexity and elegance.

Immersion Pre-toast - This technique, a first for the cooperage world, was developed by Tonnellerie Saury in 2000. The raised barrel (rose), is fully immersed in a vat of near boiling water, and then drawn in (bent). The barrel is then toasted according to the desired profile, using time honored toasting techniques.

During the immersion process, the near boiling water penetrates deep into the wood, softening greatly the tannin profile. This process further reduces the overall tannic impact, essentially continuing what began in the natural air seasoning of the rough-cut staves.












In tasting, wines aged in Immersion bent barrels show a balanced and harmonious mouthfeel – soft, with a pleasing sweetness, and a gentle tannic profile

Outside of the bending technique employed, wood origin, the selection of grain, the maturation time in barrel and toast level, is all important criteria that determine the nuanced profile of the barrel.





SAURY BARREL RANGE

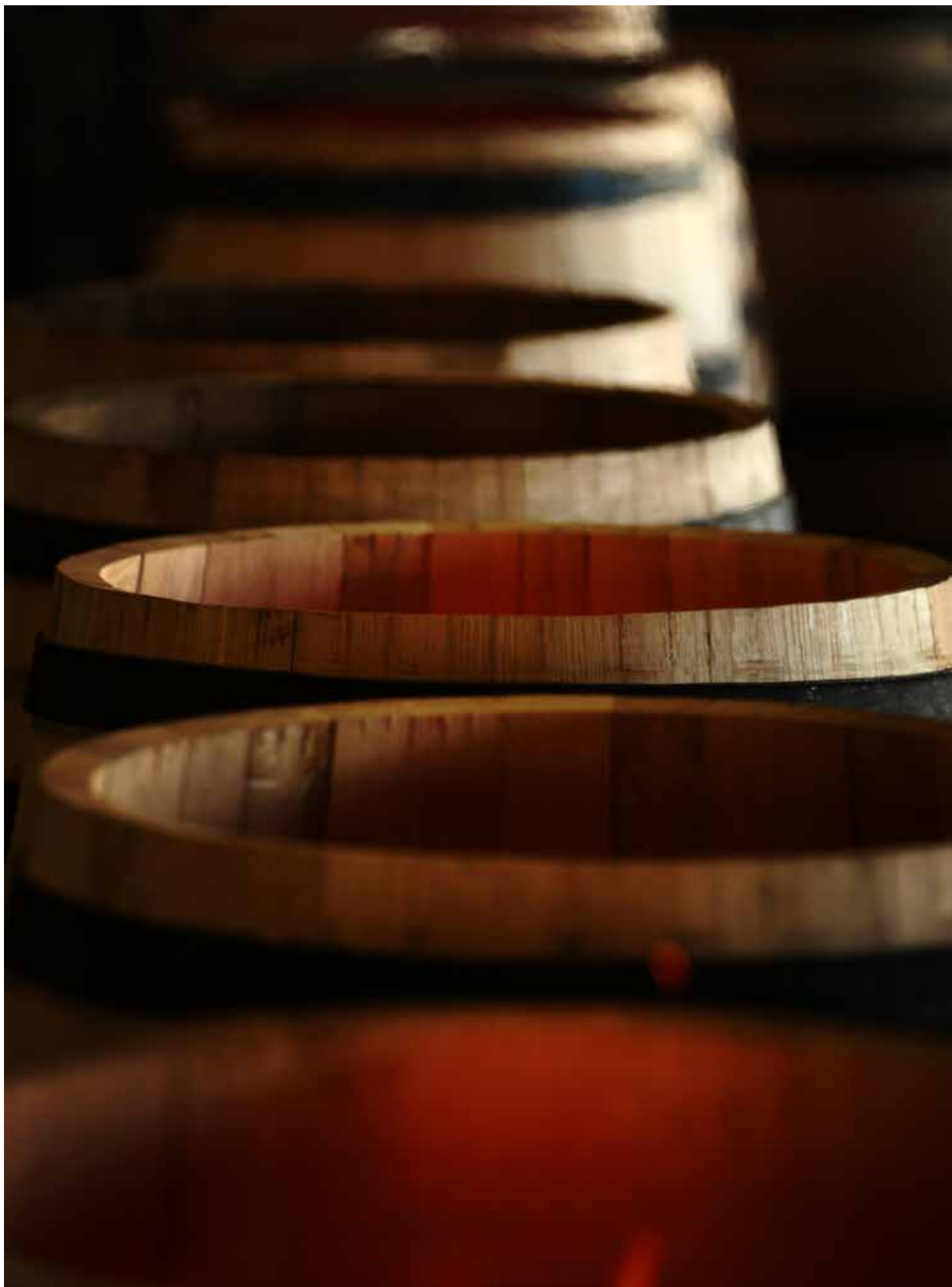
	BORDEAUX EXPORT	BORDEAUX EXPORT THIN STAVES	BORDEAUX CHÂTEAU FERREE	BORDEAUX CHÂTEAU	BURGUNDY EXPORT	BURGUNDY TRADITION	300 L	350 L	400 L	500 L	600 L
											
Capacity (Litres)	225	240	225	225	228	228	300	350	400	500	600
Staves thickness (mm)	27	22	22	22	27	27	27	27	27	27	41
Galvanised hoops	6	6	8	6	8	6	8	8	8	8	10
Chestnut hoops	-	-	-	4	-	8	-	-	-	-	-
Weight (kg)	45	40	40	40	45	45	60	60	70	80	170
Height (cm)	95	95	95	95	82	82	102	106,5	105	110	117
Head diameter (cm)	56	56	56	56	60	60	62	65	72	78	86
Bilge diameter (cm)	70	70	70	70	72	72	78	79	87	93	102
Pegged bar	-	-	•	•	-	-	-	-	-	-	-

OAK QUALITY	
Origin	Selections and assembly of blend of french forests
Ageing	Natural open air ageing 24 months minimum
Quality Control	Control of no contaminating agents by a certified laboratory;
CERTIFICATIONS / GUARANTEE	
ISO 9001 / ISO 14001 / HACCP PEFC/10-34-107 Certificate of Recognition of the management of the French Origin and open air ageing by Bureau Veritas Attestation «Origine France Garantie»	
Packaging	
Identification	Single identification number
Packaging	Heavy shrink-wrapped plastic

MANUFACTURE SEPCIFICATIONS	
Toasting	Traditional wood fire Light toasting (L), Medium toasting (M), Medium + toasting (M+), Heavy toasting (H)
Bung hole	Burned - Diameter 48/52 mm
Heads	Assembled with pins stainless marked with our mark + identification
Check water tightness	Water at high pressure - Emptied and dried without sulfur
Options	36 months+ air ageing oak (upon availability) Toasted heads Black painted hoops Special laser marking Esquive Wooden or silicon bung



Tonnellerie Saury
Chemin des Escures - 19600 Saint-Pantaléon de Larche - France
Tél : +33 (0) 555 860 845 - Fax : + 33 (0) 555 869 134 - email : comptabilite@saury.com
SAS au capital de 518 174,21 euros - RCS Brive 323 221 762 - N° TVA FR45 323 221 762 - APE 1624Z



With a presence in over thirty countries, Tonnellerie Saury has been at the forefront of developing control and analysis criteria for the industry.

From selection of the wood to delivery in wine cellars, every manufacturing stage is accredited with Tonnellerie Saury certifications.

Through its partnership with the COFRAC- certified Exact Laboratory, Saury and its barrels benefit from a fully integrated and complete contaminant analysis system. The wood, the environment, the transport containers, water, air and more are all analysed.

SAURY QUALITY

100% PEFC

100% integrated wood supply

ISO 9001

HACCP since 2008

Complete traceability from the forest to the barrel

Products «Made in France Guaranteed»

Bureau Veritas recognition of the French origin of oak trees

Bureau Veritas recognition of the natural ageing period for the staves

ISO 14001

HA/HP analyses

Analyses of all shipping containers





VINIFICATION INTÉGRALE®



www.saury.com



**In October 2013,
the Charlois Group signed
an exclusive contract for the
installation and distribution
of the Vinification Intégrale®
system for its barrels.**

Tonnellerie Saury has chosen to offer you the Vinification Intégrale® system which has proven itself over a period of ten years.

Under test since 2002, this technique has been highly developed, improved and simplified to the point that it has become a benchmark. All users have agreed that it results in wines that are rounder, more voluminous, bolder, more complex and with greater aromatic accuracy and a silky finish.

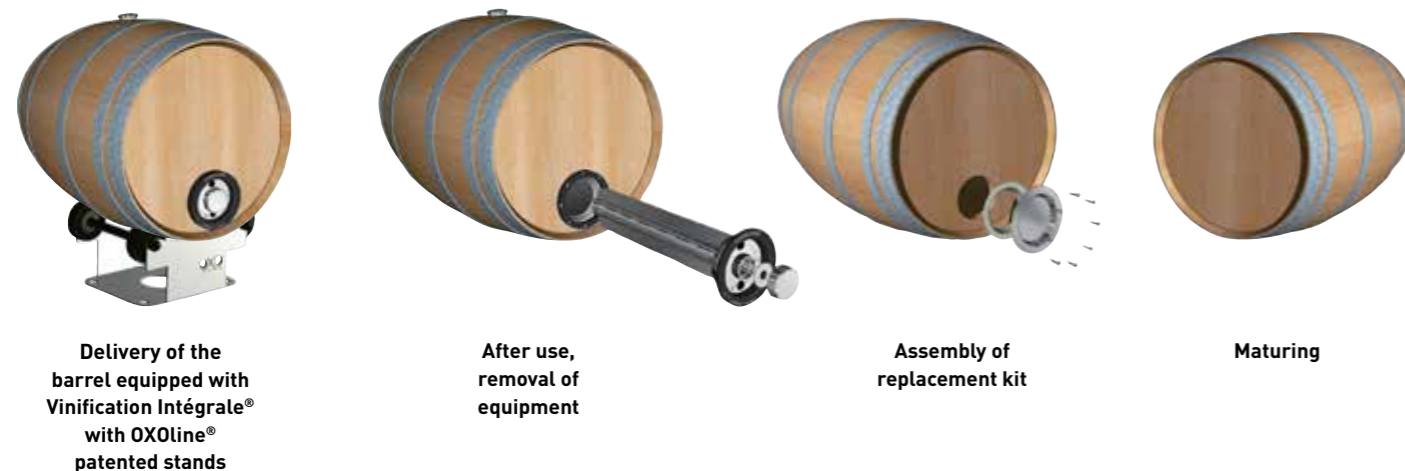
A set of accessories has been developed to simplify this type of winemaking and reduce costs.

Barrels equipped with the Vinification Intégrale® system are easily transformed into traditional maturing barrels (easy to disassemble the equipment and to install a replacement kit). The high-quality stainless steel winemaking equipment can then be re-installed in a new barrel to create a new Vinification Intégrale® system.

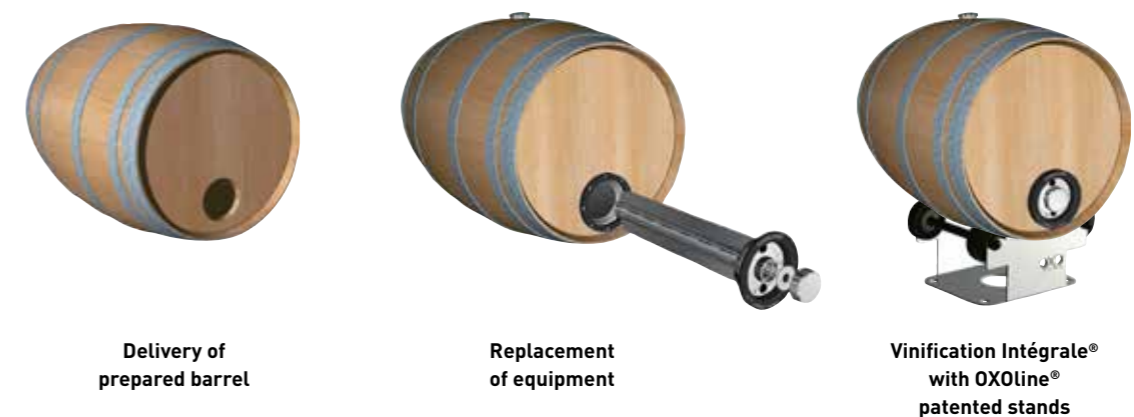


The Vinification Intégrale® system allows the grape crop to be casked under good conditions and for all traditional wine-making operations to be performed without costly transfers between the winery and the barrels, or movements of the same.

Vinification Intégrale® and the life cycle of equipped barrels



Re-use of Vinification Intégrale® equipment on a new barrel



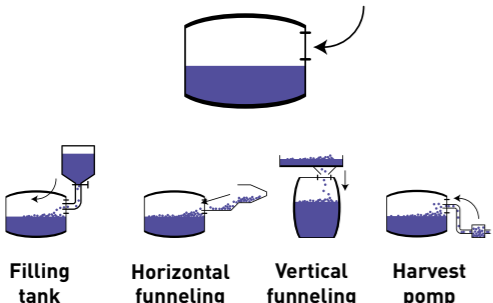
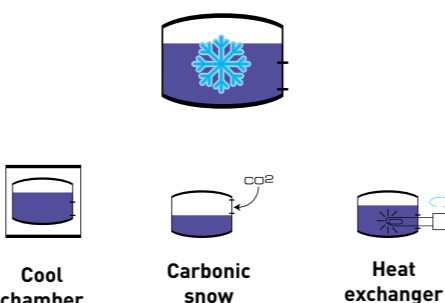
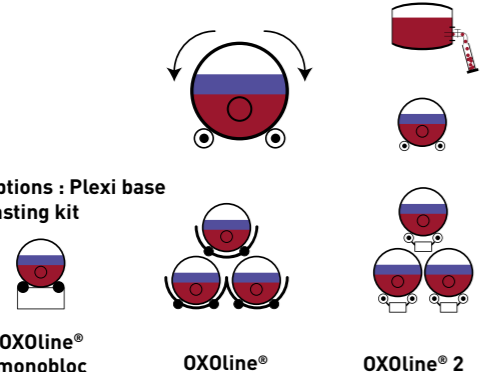
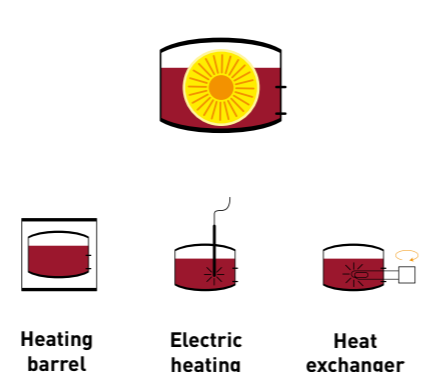
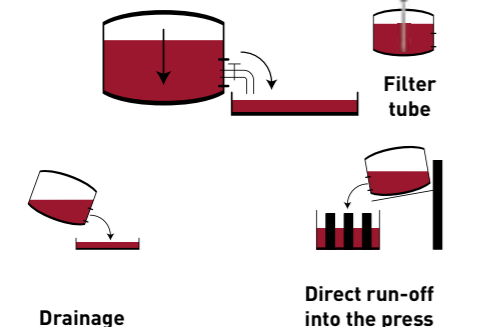
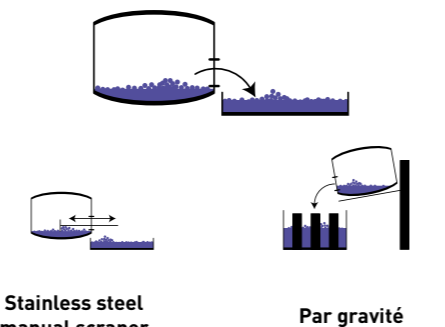
Vinification of red grapes in barrels gives very good results but has never been developed on a large scale because of the difficulty of implementation and the costs involved. Vinification Intégrale® meets all your expectations.

In addition to the simplicity of use of the Vinification Intégrale® system, the combination with OXoline® stands allows barrels to be rotated independently. The entire winemaking process takes place in the barrel and the aromatic potential of the grapes is fully preserved.

Vinification Intégrale® Solutions

Many winemakers around the world have had the opportunity try out the Vinification Intégrale® system.

Whether creating a new winery or special wines, selecting plots or simply creating richness through the set-up, this system is ideal. The Vinification Intégrale® system can be used in a variety of scenarios (gravity filling after sorting, pumping, non air-conditioned cellars etc.)

CASKING	 <div><div>Filling tank</div><div>Horizontal funneling</div><div>Vertical funneling</div><div>Harvest pump</div></div>	<div>Solutions</div>  <div><div>Cool chamber</div><div>Carbonic snow</div><div>Heat exchanger</div></div>	MACERATION COLD TEMPERATURE CONTROL T
ALCOHOL FERMENTATION	<div>Options : Plexi base Tasting kit</div>  <div><div>OXoline® monobloc</div><div>OXoline®</div><div>OXoline® 2</div></div>	<div>Solutions</div>  <div><div>Heating barrel</div><div>Electric heating</div><div>Heat exchanger</div></div>	TEMPERATURE CONTROL T
RUNNING OFF	 <div><div>Drainage</div><div>Direct run-off into the press</div></div>	<div>Solutions</div>  <div><div>Stainless steel manual scraper</div><div>Par gravité</div></div>	DRAWING OFF

Vinification Intégrale® accessories

A set of accessories has been developed to simplify this type of winemaking and reduce costs.



Saury

Tonnelier depuis 1873

TANKS



www.saury.com



We select our supplies of French and Sessile Oak mainly from State-owned forests, managed by the ONF (Office National des Forêts). For each wood auction we visit the great French forests to select and estimate the cuts that the best trees will produce, on average 50% of the trunk. These trees are at least a hundred years old and are mainly found in PEFC certified forests. The staves are then seasoned naturally in the open air for at least 48 months.

The Saury cooperage has been making traditional barrels since 1873 as well as running a unit dedicated to the design and production of oak casks and tanks for over thirty years.

The knowledge and experience acquired over the decades ensure skill in the artisanal practices and tradition of excellence that are required in the manufacturing of casks and tanks.

Based in Cognac, in the cradle of French cooperage, where skills are passed down from father to son, craftsmen coopers have all the necessary skills to meet the most demanding client specifications.

From the choice of raw materials to assembly of these prestigious products, nothing is left to chance.

The design of Saury tanks is adapted to each individual order, both for fermentation and the maturing of wines or spirits, thanks to a very wide range of specific and unique accessories.

Our reputation and experience in wood procurement means that we have the necessary access to purchase the very best batches of wood from the best French forests.



For every project a complete analysis is made of technical parameters on site and accessories are specifically defined, depending on the future usage of the tank. Complete specifications can then be drawn up, along with a detailed plan of the project and a price quote. After validation, production of the tank can begin.

Heating is still the most important part of the production process; it combines the ancestral skills of master coopers with the very latest oenological knowledge. It is also the mechanical means by which to curve each stave under the combined action of heat and water. Using the same process as that used for barrels, craftsmen coopers toast the wood for several hours, after slowly increasing the temperature.

It is during this stage, when aromas are truly brought out, that heating penetrates to the heart of the wood to extract its most subtle aromas.

Each tank is a unique product through which the personality of the user will express itself. Whether intended for wine, spirits, fermentation or maturing, closed or open top, for French or foreign vineyards, our master cask makers are able to meet our clients' expectations perfectly, with all the right accessories.

The excellent heat transfer of Saury tanks is guaranteed by the quality of the wood we use.

Our extensive wood stock is the best guarantee of ideal ageing and consistency in your production



Traceability of wood lots is checked by our quality control staff who perform a visual and analytical check at every key stage in production.

We are committed to an HACCP process (a system which identifies, evaluates and controls significant dangers in terms of food safety). We are LRQA certified for our HACCP process.

We are Bureau Veritas Inspection certified for our control of the French origin of our oak raw materials and for our control of «the length of open air ageing» of the wood used in our vats (certification N°BV/102-1/RE).

Since 2008, we have held certification for our Quality Management System ISO 9001 Version 2008 from LRQA. To complete our commitment to quality and respect for the environment, we have just started the ISO 14001 certification process.



MATURATION AND FERMENTATION TANKS

Volumes	Litres	Height (m)	Top diameter (m)	Bottom diameter (m)
10 HL	1 000	1,26	1,13	1,26
20 HL	2 000	1,55	1,40	1,55
30 HL	3 000	1,75	1,58	1,75
40 HL	4 000	1,91	1,72	1,91
50 HL	5 000	2,05	1,85	2,05
60 HL	6 000	2,17	1,95	2,17
70 HL	7 000	2,28	2,05	2,28

1T	1264	1,36	1,22	1,36
2T	2544	1,67	1,50	1,67
3T	3809	1,88	1,70	1,88
4T	5059	2,06	1,86	2,06
5T	6337	2,23	2,00	2,23

Stainless accessories included	
Stainless steel hatch Ø 600 mm standard closing	Racking port - Valve with ball Ø 40
Hydratation bung 4,5 L	Drain port - Valve with ball Ø 40
Stainless steel taster	Alimentary varnished
Stainless steel thermometer	Black painted hoops

OPEN TOP TANKS

Volumes	Litres	Height (m)	Top diameter (m)	Bottom diameter (m)
10 HL	1 000	1,26	1,13	1,26
20 HL	2 000	1,55	1,40	1,55
30 HL	3 000	1,75	1,58	1,75
40 HL	4 000	1,91	1,72	1,91
50 HL	5 000	2,05	1,85	2,05
60 HL	6 000	2,17	1,95	2,17
70 HL	7 000	2,28	2,05	2,28

1T	1264	1,36	1,22	1,36
2T	2544	1,67	1,50	1,67
3T	3809	1,88	1,70	1,88
4T	5059	2,06	1,86	2,06
5T	6337	2,23	2,00	2,23

Stainless accessories included	
Stainless steel taster	Drain port - Valve with ball Ø 40
Stainless steel thermometer	Alimentary varnished
Autoclave oval door	Black painted hoops
Racking port - Valve with ball Ø 40	Oak Tain 15 x 15 cm





Tonnellerie / Administrative and financial department

Chemin des Escures - 19600 Saint-Pantaléon-de-Larche - France

Tél: +33 (0) 555 860 845 - Fax: + 33 (0) 555 869 134

email: comptabilite@saury.com

Sales department

241, boulevard Maréchal Leclerc - 33000 Bordeaux - France

Tél: +33 (0) 556 936 936 - Fax: +33 (0) 556 936 939

email: contact@saury.com

