



Chichibu Farmers Factory Co., Ltd.

Chichibu Usagida Winery

■ Wine Production Start Year ——— 2015

■ Total Area of Own Vineyard ——— Approximately 2 ha

<https://www.chichibu-ff.com/en/>



– Main Activities of the Winery –

1. Collaboration Among Farmers

Our president has been working with local farmers to produce wine for nearly 30 years, and thanks to these long-standing relationships, we continue to receive approximately 30 tons of Chichibu-grown grapes each year.

As you may know, Chichibu is a popular tourist destination, and its local agricultural products are often purchased by tourists, contributing to stable income for the farmers.

Our contracted farmers not only cultivate wine grapes, but also grow and sell a variety of crops including table grapes, rice, and shiitake mushrooms. We believe this diversity in agricultural production has played an important role in ensuring stable income for farmers and maintaining their numbers—both of which have supported the continuation of our winemaking efforts.

Moreover, fruit cultivation is also thriving in the region. In addition to grapes, we produce wines using various locally grown fruits such as kabosu (a type of citrus) and strawberries.

We also make use of grape pomace (the solid remains after pressing) by providing it to local farmers for use as compost, further deepening our collaboration with the local agricultural community.



– Winery Introduction –

We are Chichibu Farmers Factory Co., Ltd., the operator of Usada Winery located in Chichibu City, Saitama Prefecture. Situated approximately 40 minutes from the Kan-Etsu Expressway Hanazono Interchange via National Route 140, our winery proudly produces wines under the motto: "Born and Raised in Chichibu – Usada Wine."

Our company president, who has been running a liquor store for over 30 years, had a long-standing desire to make wine using locally grown grapes from Chichibu. In collaboration with local grape farmers, we began producing wine from Chichibu grapes through contract winemaking while continuing to operate the liquor store.

We started submitting our wines to domestic wine competitions, and since around 2008, we've had the honor of receiving awards annually. With generous support from various sectors, we began cultivating our own vineyard in 2013 and launched in-house wine production in 2015. Since then, we have been committed to revitalizing the local community through agriculture and winemaking, while also promoting the effective use of farmland in Chichibu.

Today, we produce wines using grapes from our own 2-hectare vineyard as well as grapes grown by farmers in Chichibu. We also age some of our wines in barrels previously used for maturing whisky from a nearby whisky distillery, and create mixed fruit wines using domestically grown fruits.



2. Cross-Beverage Collaboration

Chichibu is a region known for its many shrines and frequent festivals. Deeply rooted in mountain worship, the local people have long cherished their spiritual traditions, and sake brewing for sacred offerings (omiki) has been practiced since the Edo period.

Influenced by this cultural heritage, Chichibu is now home to a diverse range of alcoholic beverage producers, including makers of sake, whisky, beer, wine, doburoku (unrefined sake), liqueurs, shochu, and mead—with several more producers expected to emerge in the coming years.

In Europe, countries are often known for specializing in specific types of alcohol, such as “whisky-producing countries,” “beer countries,” or “wine countries.” In contrast, Chichibu is unique in that producers of whisky, beer, wine, and sake are all located within just a five-minute drive of each other. This environment is not only rare within Japan, but even by global standards.

While wine-producing regions like Yamanashi and Nagano are known for active collaboration among winemakers, in Chichibu, a distinctive form of collaboration occurs across different types of alcoholic beverages. Here, it is common for producers of various kinds of alcohol to share ideas and resources.

One notable example is barrel rotation, a unique practice in Chichibu where barrels used for aging one type of alcohol (such as whisky) are reused to age another (such as wine). This kind of cross-industry partnership has become a defining feature of Usada Winery’s production style, and our “cross-beverage collaboration wines” represent one of our most unique and innovative offerings.



3. Agriculture–Welfare Collaboration

Unless operated by a major corporation, most winemaking involves a significant amount of manual labor. At our winery, this begins with grape cultivation, meaning that every step—from growing the raw materials to producing the wine—is done by hand, day in and day out.

However, as Chichibu is a rural area, our winery—where farm work is a major component—has faced challenges related to labor shortages.

To address this, around the year 2000, we partnered with Sakura Farm, a local support facility for people with disabilities with whom we had an existing relationship. They officially registered our winery as a workplace, enabling us to welcome individuals from Sakura Farm as part of their vocational training and independence support program. This marked the beginning of our agriculture–welfare collaboration.

Sakura Farm supports individuals with relatively mild disabilities, many of whom are energetic and eager to work. Until then, their tasks typically involved light work such as cultivating mushroom beds, assembling pens, or packing vegetables.

Interestingly, the detailed tasks at the winery and the outdoor farm work turned out to be quite popular among the facility users. They have shown great enthusiasm and a strong sense of motivation in taking part in winery-related work.

Looking ahead, we aim to continue producing “Chichibu Agriculture–Welfare Collaboration Wines”—born and raised in Chichibu—where winemaking also serves as a means of giving back to the community through partnerships between agriculture and welfare services.



4. Labels That Reflect the Spirit of Chichibu

Our wine labels are designed with the theme of "Capturing the Essence of Chichibu."

While many wineries in Japan today are focused on producing world-class wines that can compete internationally, Usada Winery places its greatest emphasis on creating wines deeply rooted in the Chichibu region. This commitment to local identity is the foundation of our winemaking philosophy.

In that sense, our approach may differ from the mainstream direction of the modern Japanese wine industry, but we take pride in branding ourselves as "Japan's No.1 Local Wine."

With the motto "Rooted in Chichibu, Loved by Chichibu, and Loved from Chichibu," we strive to create label designs that truly convey a sense of place.

One of the key features of our labels is the use of photographs of Chichibu's sea of clouds, a breathtaking natural phenomenon created by the region's unique climate. This scenery powerfully symbolizes the beauty of Chichibu and offers a visual experience that instantly evokes a sense of nature, seasonality, and regional charm.

We hope that seeing this design will inspire customers to visit Chichibu or choose our wine as the perfect local souvenir.

Since 2019, we have also adopted designs featuring Chichibu Meisen patterns—a traditional textile design native to the region—further reinforcing our dedication to expressing the identity of Chichibu through our branding.



Supplementary Information:

Sake Brewing, Festivals, Mountain Worship, and Shrines in Chichibu

Chichibu is a region rich in shrines and festivals, where deep-rooted spiritual traditions continue to thrive. The people of Chichibu place great importance on mountain worship, a belief system that honors sacred mountains as the dwelling places of deities. Since the Edo period, sake has been brewed in the region as sacred offerings (omiki) for the gods. To this day, this cultural heritage remains a living part of everyday life in Chichibu.

At Usada Winery, our wines are crafted with gratitude toward the mountains—offering a taste of wines that, in spirit, are blessed by the deities of the land.

Mountain Worship and Sake Brewing in Chichibu

Chichibu is home to many sacred mountains, such as Mt. Mitumine (Mitumine-san), long revered as spiritual peaks. This reverence gave rise to the tradition of brewing sake as an offering to the gods of the mountains, a practice that dates back to the Edo period.

Today, Chichibu is home to a wide variety of alcohol producers—spanning sake, whisky, beer, wine, doburoku (unrefined sake), liqueurs, and shochu—with a total of nine licensed producers operating in the area. Thanks to this rich and diverse brewing culture rooted in spiritual heritage, Chichibu has come to be known as:

“The Sacred Capital of Sake, Born from Mountain Worship.”



Mt. Bukō and Its Role in Viticulture

Mt. Bukō is a prominent mountain located on the border of Chichibu City and Yokose Town, situated on the southern edge of the Chichibu Basin. It is recognized as one of the “200 Famous Mountains of Japan” (Nihon Hyakumeizan + 100). The mountain is notable for its rich deposits of limestone, which has been extensively quarried over the years.

Limestone Soil and Winemaking
(Based on industry knowledge and research)

The limestone-rich soil of the Chichibu region, particularly around Mt. Bukō, offers significant benefits for grape cultivation and winemaking. Here are two key characteristics:

1. Excellent Water Retention and Drainage

Limestone soils possess an ideal balance of moisture retention and drainage capability. Primarily composed of calcium, these soils can hold moisture during dry periods while efficiently draining excess water during rainy seasons. This unique structure makes limestone soil highly suitable for grape growing, providing vines with a consistent and balanced water supply.

2. Naturally High pH

Limestone-based soils are also known for their high pH levels. While typical topsoil may have a pH of around 5.5 to 6.0, limestone soils can exceed pH 8 in some areas. This alkalinity contributes to the development of grapes with more structured acidity and can enhance the minerality and elegance of the resulting wines.

The presence of limestone-rich soil from Mt. Bukō is one of the reasons Usada Winery can produce wines with such refined character and balance, rooted in the unique terroir of Chichibu.



Sea of Clouds (Unkai) and Diurnal Temperature Variation

The sea of clouds (unkai) that often appears in Chichibu is a natural phenomenon caused by the significant temperature difference between day and night. This diurnal variation not only creates breathtaking landscapes but also has a profound impact on fruit cultivation, particularly grape growing.

Impact of Diurnal Temperature Variation on Grape Quality

Chichibu is home to many skilled fruit growers and is known as one of Saitama's top fruit-producing regions. Among its many agricultural strengths, grape production stands out, thanks in large part to the ideal climatic conditions, including the notable temperature fluctuations between day and night.

This temperature difference contributes directly to:

- Increased sugar content in the grapes
- Higher acidity retention

These effects are critical for winemaking, as the balance of sugar and acidity greatly influences the structure and flavor profile of the final wine.

Scientific Explanation: How Temperature Affects Sugar Accumulation

Plants accumulate sugars via photosynthesis during the day. At night, these sugars are consumed through respiration, which is more active at higher temperatures. When nighttime temperatures are lower—as is typical in Chichibu—the rate of respiration slows, meaning less sugar is consumed, and more is retained in the fruit.



Larger temperature differences between day and night help maximize sugar concentration in grapes, enhancing overall fruit quality.

Why Chichibu Is Ideal for Winemaking

A natural environment with significant diurnal variation

High-quality grapes grown by experienced local farmers

A popular tourist destination, making agritourism and direct-to-consumer fruit sales viable

A compelling story and terroir that enhances the appeal of local wines










Given these conditions, Chichibu is not only an excellent region for cultivating premium wine grapes, but also a place where winemaking can thrive as both a business and a cultural story.

Barrel Aging & Oak Chip Infusion

At Usada Winery, we age our wines in a variety of barrels, including French oak, American oak, and used whisky barrels from Chichibu distilleries—such as sherry, bourbon, peated, and mizunara casks.

We also create unique wines by infusing them with roasted mizunara oak chips, sourced from local cooperages. This technique adds elegant, spicy aromas and reflects the spirit of Chichibu craftsmanship.

Product Name	Type	Volume	Alcohol Content	Domestic Retail Price (Excl. Tax)	Product Image	JAN	Product Description
[2024 New White Wine] Chichibu Primeur Blanc 2024 Chardonnay harvested in the Usuda area of Chichibu City  OSAGIDA WINERY	"New" White	750ml	12%	¥2,500		4573342852928	A white wine made from Chardonnay harvested from the in-house vineyard of Chichibu Usada Winery. It features a lively acidity and refreshing citrus-like fruitiness. Carefully cultivated by hand, this white wine is crafted from estate-grown grapes, resulting in a fresh and mineral-rich finish.
Chichibu Usuda Fruit Wine (White) Apple, Grape, Mandarin Orange, Kabosu	"Fruit" White	750ml	10%	¥2,400		Sold Out	A fruit wine made from Chichibu-grown kabosu, Saitama-grown mikan, apples, and grapes. It features the rich fruitiness of apples and grapes, along with the refreshing aroma and vibrant color of two types of citrus. Light acidity and a fruity taste characterize this wine.
Chichibu Usuda Fruit Wine (Rosé) Apple, Grape, Strawberry, Blueberry, Mulberry	"Fruit" Rosé	750ml	10%	¥2,400		4573342852409	A fruit wine made from Chichibu-grown strawberries, blueberries, mulberries, apples, and grapes. The flavors of apples and grapes blend with the vivid colors and aromas of the three types of berries. It has a light and fruity taste.
Chichibu Blanc Harvested in Chichibu City	White	750ml	12%	¥2,400		4573342850740	A white wine made from "Seibel 9110" and "Kai Blanc" grapes harvested in Chichibu City. It features a rich fruitiness and a gentle acidity.
Chichibu Rouge Harvested in Chichibu City	Red	750ml	12%	¥2,400		4573342850733	A red wine made from "Muscat Bailey A" and "Merlot" grapes harvested in Chichibu City. It has aromas of red berries such as raspberries and framboise, along with a pleasant acidity.
Chichibu Rosé Harvested in Chichibu City	Rosé	750ml	11%	¥2,400		4573342852270	A rosé wine made using grapes harvested in Chichibu City. It has a rich fruit flavor with mild acidity, resulting in a light and charming taste.
Chichibu Blanc (Chichibu City Harvest) Mizunara Oak Chip Infusion Chichibu Unkai Label	White	750ml	12%	¥3,000		4573342852973	A white wine made from Seibel 9110 and Kai Blanc grapes harvested in Chichibu City, infused with roasted Japanese Mizunara oak chips. The subtle sweet aroma from Mizunara harmonizes with the wine's gentle acidity and deep flavor.
Chichibu Rouge (Chichibu City Harvest) Mizunara Oak Chip Infusion Chichibu Unkai Label	Red	750ml	12%	¥3,000		4573342852966	A red wine made from Muscat Bailey A and Merlot grapes harvested in Chichibu City, infused with roasted Japanese Mizunara oak chips. The delicate sweet aroma from Mizunara complements the wine's vibrant and smooth taste.
Chichibu Blanc (Chichibu City Harvest) Premium Cuvée Whiskey Barrel Aged & Mizunara Oak Chip Infusion Chichibu Unkai Label Includes Gift Box	White	750ml	13%	¥4,000		4573342852584	A white wine made from Seibel 9110 and Kai Blanc grapes harvested in Chichibu City, aged in whiskey barrels from a Chichibu distillery, and later infused with roasted Japanese Mizunara oak. The whiskey barrel imparts aromas and tannins, while the Mizunara adds an elegant sweetness, making this a limited-edition wine.

Product Name	Type	Volume	Alcohol Content	Domestic Retail Price (Excl. Tax)	Product Image	JAN	Product Description
Chichibu Rouge (Chichibu City Harvest) Premium Cuvée Whiskey Barrel Aged & Mizunara Oak Chip Infusion Chichibu Unkai Label Includes Gift Box	Red	750ml	13%	¥4,000		4573342852287	A red wine made from Muscat Bailey A and Merlot grapes harvested in Chichibu City, aged in whiskey barrels from a Chichibu distillery, and later infused with roasted Japanese Mizunara oak. The tannins and depth from the whiskey barrel blend with the delicate sweetness of Mizunara, making this a special limited-edition wine.
Toseki -Yuki- (Chichibu Rouge, Usuda Area Harvest, Chichibu City) Whiskey Barrel Aged & Mizunara Oak Chip Infusion Chichibu Unkai Label Includes Gift Box	Red	750ml	13%	¥4,500		4573342852232	A red wine made from Muscat Bailey A, Fuji no Yume, and Merlot grapes harvested in the Usuda district of Chichibu City. It was aged in whiskey barrels and then infused with roasted Japanese Mizunara oak wood chips. The contrast of the three grape varieties is enhanced by the whiskey barrel's volume and aroma, with Mizunara adding a refined sweet fragrance.
Chichibu Blanc 2021 Peated Whiskey Barrel Aged Harvested in Chichibu City Chichibu Unkai Label Includes Gift Box	White	750ml	13%	¥5,400		4573342852577	A white wine made from Seibel 9110 and Kai Blanc grapes harvested in Chichibu City, aged in peated whiskey barrels from a Chichibu distillery. The smoky peat aroma from the whiskey harmonizes with the wine's flavors, creating a unique Chichibu white wine.
Chichibu Rouge 2021 Peated Whiskey Barrel Aged Harvested in Chichibu City Chichibu Unkai Label Includes Gift Box	Red	750ml	13%	¥5,400		4573342852812	A red wine made from Muscat Bailey A and Merlot grapes harvested in Chichibu City, aged in peated whiskey barrels from a Chichibu distillery. The exotic smoky peat aroma blends with the wine's smooth acidity and deep flavor, making it a distinctive Chichibu red wine.
Torin -Rin- Chichibu Rosé (Usuda Area Harvest, Chichibu City) Muscat Bailey A Mizunara Oak Chip Infusion Chichibu Himehotaru Label Includes Gift Box	Rosé	750ml	13%	¥3,200		4573342852850	A rosé wine made from Muscat Bailey A grapes grown at Usuda Winery's own vineyard, infused with roasted Mizunara oak chips. The hand-cultivated vineyard grapes contribute to a charming wine with complex layers. The natural grape aroma intertwines with Mizunara's fragrance, creating an elegant rosé wine with a silk-like finish.
Chichibu Rosé Harvested in Chichibu Made with Chichibu Yama Ruby Chichibu Meisen "Arrow Letter and Snow Lantern" Includes Gift Box	Rosé	750ml	11%	¥4,500		4573342852324	A rosé wine made using "Chichibu Yama Ruby" grapes harvested in the Chichibu region. It features aromas of red berries such as strawberries and raspberries, combined with a fruity, fresh, and charming character unique to Yama Ruby. Label: Chichibu Meisen "Yabumi ni Bonbori" - Designed by Chichibu-based designer Yoshida. The design is inspired by the elegant patterns of Chichibu Meisen kimono.
Chichibu Blanc (Chichibu Harvest) Made with Shine Muscat Chichibu Meisen "Arrow Letter and Snow Lantern" Includes Gift Box	White	750ml	11%	¥4,500		4573342852874	A white wine made from "Shine Muscat" grapes harvested in the Chichibu region. It boasts the rich aroma and fruity taste of Muscat grapes, resulting in a refined and noble wine. Label: Features the Chichibu Meisen "Yabumi ni Bonbori" pattern, designed by Chichibu-based designer Yoshida. The design captures the splendor of traditional Chichibu Meisen kimono.
Tokyo -Yura- Chichibu Usuda Fruit Wine (Rosé) Whiskey Barrel Aged Apple, Grape, Golden Kabosu Includes Gift Box	"Fruit" Rosé	750ml	13%	¥4,000		4573342852652	A mixed fruit rosé wine made from apples, grapes, and golden kabosu, aged in whiskey barrels. It combines the fruitiness of apples and grapes with the refreshing aroma and acidity of kabosu, enriched by whiskey's aroma. The lingering finish is like a fleeting but delightful moment—please enjoy it.
Chichibu Rouge Eto (Zodiac) Label "Rabbit" 2018 Muscat Bailey A Harvested in Kamanoue Area, Chichibu City French Oak Barrel Aged for 48 Months Includes Gift Box	Red	750ml	12%	¥8,900		4573342852782	A red wine made from Muscat Bailey A grapes harvested in the Kaminoe district of Chichibu City, aged for 48 months in French oak barrels. The concentrated Muscat Bailey A fruit aroma blends with the complex fragrance of French oak, creating a sophisticated wine with a refined and elegant finish.

The minimum order quantity for this winery is one case (12 bottles).
Mixed items are allowed.

Winery Introduction Video

<https://www.facebook.com/chichibuff/videos>

Winery Work Process Images

<https://www.facebook.com/media/set/?set=a.2380092242278446&type=3>

Winery Scenery Images

<https://www.facebook.com/media/set/?set=a.2171365709817768&type=3>

OFFICIAL EXPORTER

池留本店

IKETOME.CO.LTD

Address : 20 Shimoshingashi Kawagoe-City Saitama 350-136 JAPAN

How to Work with Us

If you are interested in distributing **authentic, high-quality Japanese sake**, we would be delighted to discuss potential collaborations.

✉ [Feel free to Contact us today to learn more about our **export lineup details, pricing**, and how we can support your business..](#)

info@iketome.co.jp