a jeopardy to the revenue until the pro-
duction of the spirits is completed. The
distiller may, in the course of produc-
tion, convey the product through as
many distilling or other production op-
erations as desired, provided the oper-
ations are continuous. Distilling oper-
ations are continuous when the spirits
are conveyed through the various steps
of production as expeditiously as plant
operation will permit. The collection of
unfinished spirits for the purpose of re-
distillation is not deemed to be a break
in the continuity of the distilling pro-
cedure. However, the quantity and
proof of any unfinished spirits pro-
duced from distilling materials, the
quantity of which was ascertained in
the manner authorized in §19.732(c) for
such materials, shall be determined
and recorded before any mingling with
other materials or before any further
operations involving the unfinished
spirits outside the continuous system.
Spirits may be held, prior to the pro-
duction gauge, only for so long as is
reasonably necessary to complete the
production procedure.

(Sec. 201, Pub. L. 85–859, 72 Stat. 1353, as
amended, 1362, as amended, 1365, as amended
(26 U.S.C. 5178, 5211, 5222))

§ 19.317 Treatment during production.
Spirits may, in the course of original
and continuous distillation, be purified
or refined through, or by use of, any
material which will not remain incor-
porated in the finished product. Jun-
iper berries and other natural aro-
matics, or the extracted oils of such,
may be used in the distillation of gin.
Spirits may be percolated through or
treated with oak chips which have not
been treated with any chemical. Mate-
rials used in treatment of spirits, and
which do not remain in the spirits,
shall be destroyed or so treated as to
preclude the extraction of potable spir-
its therefrom.

(Sec. 201, Pub. L. 85–859, 72 Stat. 1356, as
amended (26 U.S.C. 5178, 5211, 5222))

§ 19.318 Addition of caramel to rum or
brandy and addition of oak chips to
spirits.
Caramel possessing no material
sweetening properties may be added to
rum or brandy on bonded premises
prior to production gauge. Oak chips
which have not been treated with any
chemical may be added to packages
prior to or after production gauge;
however, notation to that effect shall
be made on the record of production
gauge as provided in §19.319.

(Sec. 201, Pub. L. 85–859, 72 Stat. 1356, as
amended (26 U.S.C. 5201))

§ 19.319 Production gauge.
(a) General. All spirits shall be
gauged by determining quantity and
proof within a reasonable time after
production is completed. Except as oth-
erwise specifically provided in this sec-
tion, quantities may be determined by
volume or by weight, by approved
meter, or, when approved by the appro-
priate TTB officer, by other devices or
methods which accurately determine
the quantities. If caramel is added to
brandy or rum, the proof of the spirits
shall be determined after the addition.
Spirits in each receiving tank shall be
gauged before reduction in proof and
both before and after each removal of
spirits therefrom. The gauges shall be
recorded by the proprietor in the
records required by §19.736.

(b) Tax to be determined on produc-
tion gauge. Tax may be determined on
the basis of the production gauge if:
(1) Spirits are weighed into bulk con-
veyances:
   (2) Spirits are uniformly filled by
   weight into metal packages; or
   (3) Spirits are filled by weight into
packages for immediate withdrawal
from bonded premises and the details
of the gauge for each package are re-
corded on a package gauge record ac-
cording to §19.769.
Transaction records shall be marked
Withdrawal on Production Gauge.

(c) Tax not to be determined on pro-
duction gauge. If spirits are drawn from
the production system into barrels, drums,
or similar portable containers of the
same rated capacity and the containers
are filled to capacity, and the tax is
not to be determined on the basis of
the production gauge, the gauge may
be made by:
(1) Weighing in a tank, converting
the weight into proof gallons, and de-
termining the average content of each
container; or
(2) Measuring volumetrically, in a
calibrated tank, converting the wine
§ 19.320 Identification of spirits.

At the time of production gauge, containers of spirits shall be identified by the proprietor in accordance with subpart R of this part. When the proprietor desires to enter spirits into bonded storage for subsequent packaging in wooden packages, he may identify such spirits with the specific designation to which they would be entitled if drawn into wooden packages, followed by the word “Designate,” for example, “Bourbon Whisky Designate.”

§ 19.321 Entry.

Pursuant to the production gauge, the proprietor shall make appropriate entry for (a) deposit of the spirits on bonded premises for storage or processing, (b) withdrawal of the spirits on determination of tax, (c) withdrawal of the spirits free of tax, (d) withdrawal of the spirits without payment of tax, or (e) transfer of the spirits for redistillation. Entry for deposit on the bonded premises of the same plant premises shall be made on a gauge record, prepared according to §19.768. When spirits are entered for deposit on another plant premises or are entered for withdrawal or redistillation, the applicable provisions of subpart K or subpart P of this part shall be followed.

§ 19.322 Distillates containing extraneous substances.

(a) Use in production. Distillates containing substantial quantities of fusel oil, aldehydes, or other extraneous substances may be removed from the distilling system prior to the production gauge for addition to fermenting or distilling material at the distillery where produced. Distillates removed from the distilling system under the provisions of this paragraph shall be added promptly to the fermenting or distilling material.

(b) Use at bonded wine cellar. Distillates containing aldehydes may be removed, without payment of tax, to an adjacent bonded wine cellar for use therein for fermentation of wine to be used as distilling material at the distilled spirits plant from which the distillates were removed. The gauge and removal of distillates to an adjacent...