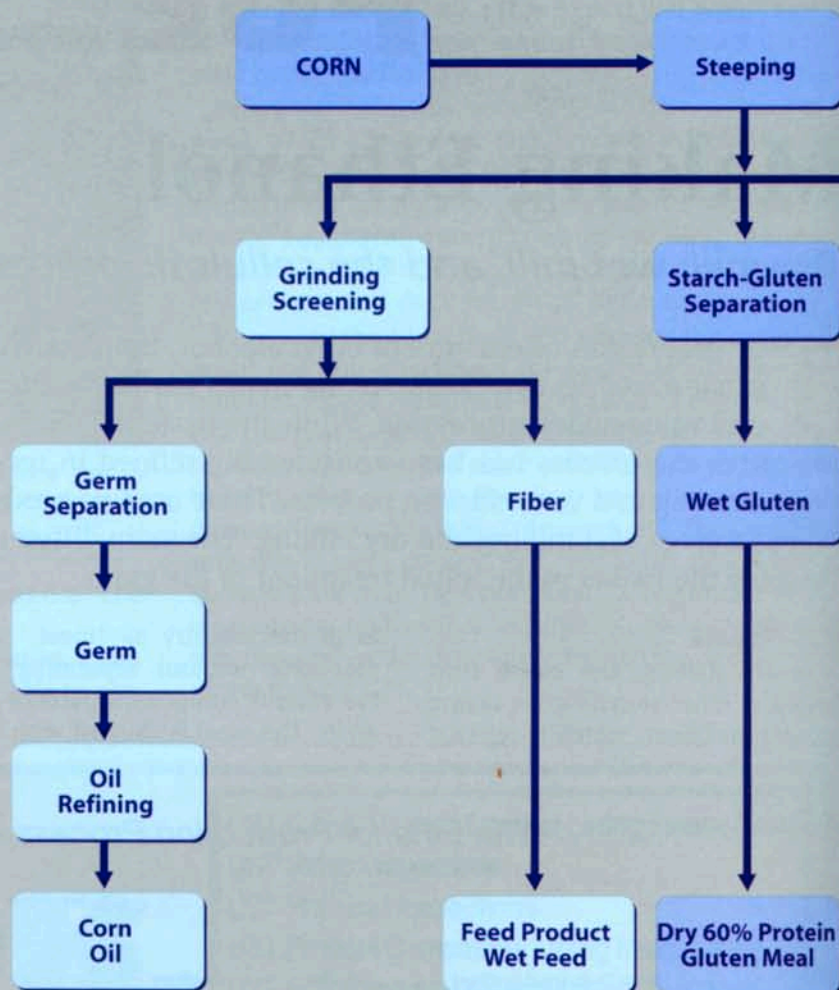


The fermentation process generally takes about 40 to 50 hours. During this part of the process, the mash is agitated and kept cool to facilitate the activity of the yeast. After fermentation, the resulting "beer" is transferred to distillation columns, where the ethanol is separated from the remaining "stillage." The ethanol is concentrated to 190 proof using conventional distillation and then is dehydrated to approximately 200 proof in a molecular sieve system.

The anhydrous ethanol is then blended with about five percent denaturant (such as natural gasoline) to render it undrinkable and thus not subject to beverage alcohol tax. It is then ready for shipment to gasoline terminals or retailers.

The stillage is sent through a centrifuge that separates the coarse grain from the solubles. The solubles are then concentrated to about 30 percent solids by evaporation, resulting in Condensed Distillers Solubles (CDS) or "syrup." The coarse grain and the syrup are then dried together to produce dried distillers grains with solubles (DDGS), a high-quality, nutritious livestock feed. The CO<sub>2</sub> released during fermentation is captured and sold for

### The Ethanol Production Process - Wet Milling



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