

BREAKING AWAY

Every step in the development of successful racehorses is important, but few are as crucial as the education they receive during breaking and early training. With the yearling sales season in full swing, buyers are looking for the outfits that can put the best mental and physical foundation under their purchases to transition them into talented runners.

Training centers around the country boast top-notch facilities, not only for tuning yearlings into ready-to-run 2-year-olds but also for rehabilitating runners when they come up sore or injured or simply need a freshening from the rigors of the racetrack.

Many of these expert centers and the experienced people who run them are profiled in the following pages.

AIKEN TRAINING TRACK

Aiken, S.C., is true horse country, and the Aiken Trials and the Aiken Training Track are a large part of the rich history. In 1941 renowned horsemen Fred H. Post and his son, William, came to Aiken to play polo. The comfortable climate of mild winters and early springs combined with the sandy soil was ideal for the pursuit of a variety of equestrian activities.

Impressed with the town, Post decided to build the Aiken Training Track to condition his flat racers. He found the perfect location along Two Notch Road where his track would be surrounded by the established polo fields, quiet dirt

roads, and Hitchcock Woods, which comprises more than 2,000 acres of forest. The Aiken Training Track was soon considered one of the finest training centers in the country when horses began earning their championship laurels in 1942. The first, Elkridge, was a champion steeplechaser.

Soon, famous racing outfits with names such as Greentree, Vanderbilt, Rokeby, and Claiborne Farm started sending horses to winter in the South under the care of future Hall of Fame trainers Mackenzie "Mack" Miller, John Gaver, William Burch, Woody Stephens, and many others. The Aiken Trials began

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in 1942 as a way to give young horses in training the enlightening opportunity to experience every aspect of live racing. The Trials has become a time-honored tradition for Aiken and the surrounding communities.

Since its opening in 1941, the Aiken Training Track has produced 39 national champions, hundreds of stakes winners, and five winners of the Kentucky Derby (gr. I), five consecutive Belmont Stakes (gr. I) winners from 1982-86, and several Preakness Stakes (gr. I) winners.

The 73rd Aiken Trials will be held Saturday, March 14, 2015. The event is the first leg of Aiken's Triple Crown. Aiken Trials treasurer, Nikki Bargeloh, encourages the public to come out to the Aiken Trials to witness future champions.

"It is a wonderful opportunity to see a young Thoroughbred working to reach that level. The Aiken Training Track is proud to claim Palace Malice as one of its own. The event is a wonderful time for everyone who comes out," Bargeloh said.

For more information, visit aiken-trainingtrack.com or call 803-648-4631.

BENCHMARK TRAINING

Benchmark Training Center—a facility that offers a European-style foundation for horses due to the background of Wales, Great Britain, native and veteran horseman Gerwyn "Taffy" Jones—has been developing solid runners since its inception in North Texas 10 years ago.

The 100-acre Southwestern operation

assists clients, not only in conditioning young horses but in selecting and purchasing the right runners for a particular program. Benchmark also offers rehabilitation services for older horses, race-track and medical/surgical layups, and sales preparation for horses of any age.

Due to its location near Quinlan, Texas, about 40 miles east of Dallas, Benchmark provides easy access to all the racetracks in Texas, Louisiana, Oklahoma, and Arkansas.

Jones, who is the owner and head trainer at Benchmark, started his racing career nearly 30 years ago in Wales. He worked throughout the East Coast before venturing to Texas 15 years ago. The European foundation and Eastern experience that Jones brings to the table have helped Benchmark thrive in the Texas market.

Other key members of Benchmark's staff include veterinarian Dr. David Stephens, who operates Weems and Stephens Equine Hospital near Aubrey, Texas; and farm manager Mark Brennan, also a longtime member of the industry who hails from Ireland.

Benchmark's features are highlighted by its five-eighths-mile training track and starting gate, which enable young horses to become accustomed to racing life. The farm also has two large, modern-style barns with ample amenities, a EuroSizer exercise machine for conditioning, and spacious, three-acre paddocks that allow layups to return to the

track in top condition.

Jones estimated horses that receive early training at Benchmark have an 80-90% win rate on the track. He believes the training center's stellar results are the reason it attracts major clients from all over the country, including McKenna Thoroughbreds, Long Odds Racing Stable, and trainers Donnie Von Hemel, Bret Calhoun, and Steve Asmussen.

"Our percentage rate of winners has been a key to our success," said Jones. "By word of mouth about the successful way we turn out horses, clients send them to us from all over the country. We get them ready to go to the track, and once they show up, they're close to ready to start running. We have a reputation of doing a good job and producing a good product."

BRIDLEWOOD

Legendary Bridlewood Farm in Ocala, Fla., has been raising stakes winners for five decades. Now under the new ownership of John and Leslie Malone, Bridlewood is stepping up its breaking and training division.

"We've always trained horses for outside clients, but we're amping up that facet of the business now, and it will be a big part of the new Bridlewood," said George Isaacs, who has served as the farm's general manager for nearly 20 years. "The goal is to re-establish our brand one good horse at a time graduating from our training program."

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Travis Durr



Webb Carroll



ing division, Bridlewood has hired life-long horseman Jonathan Thomas as its farm trainer. Thomas brings racetrack experience with him, having worked for five years as an assistant to Christophe Clement, and another five years assisting leading trainer Todd Pletcher. Thomas has been on the job for about a year and is already drawing business from owners and trainers he met while at the racetrack.

In Bridlewood he has an easy facility to sell prospective clients. The 800-acre farm offers every horse the opportunity to be turned out comfortably. There are 138 training stalls with an additional 30 stalls for layups and horses getting R&R from the rigors of the racetrack. The barns are open and afford the horses views of the property. They were designed to let air flow through and keep horses comfortable even through the Florida summer. Trees are everywhere.

The seven-eighths-mile dirt training track is one of the biggest ovals in the area, and it lets young horses get accus-

tomed to going over a large surface. Ocala track builder Matt Rudnianyn manages the maintenance of the track.

“We’ve had great results with 2-year-olds and older horses coming out of here and winning races this year,” Thomas noted. “We had some very good turf horses that wintered here for the chance to be turned out. They get to rest up and then go back up north, and we’ve had 10 winners at Saratoga already.”

Thomas, who grew up on Paul Mellon’s Rokeby Farm in Virginia, said that Bridlewood’s emphasis is on attracting quality horses for quality clients. The farm can certainly boast its history of great horses coming off its grounds, with more than 100 stakes winners and dozens of graded stakes winners, including 12 grade I winners such as 2004 dual classic winner Smarty Jones, Jolie’s Halo, Wild Event, Forbidden Apple, Southern Image, David Junior, Ron the Greek, Eden’s Moon, and Turbo Compressor.

“We’ve developed a very good team in our first year,” Thomas said. “We have a

staff of about 40, and the Malones as well as George have built this up into one of the premiere places to train down here.”

WEBB CARROLL TRAINING CENTER

In business for nearly three decades, Webb Carroll Training Center continues to turn out top-quality runners under the supervision of Carroll, a third-generation horseman who founded the facility near St. Matthews, S.C.

Noted graduates include champions Solid Appeal, Fortune Pearl, Havre de Grace, and Preakness Stakes (gr. I) winner Shackelford, along with Santa Anita Derby (gr. I) winner Goldencents, and grade I winner Joyful Victory. In 2013 the center produced its best numbers to date: 449 winners, with an additional 28 stakes winners, with 13 graded victories.

Carroll, 68, is the hands-on impetus behind the success of a program best-known for breaking and training 2-year-olds, although the facility also rehabs injured horses. His training methods are measured and patient, designed to help young runners adapt to the racetrack. In 2012 alone the program produced 47 2-year-old winners.

“Giving them time to be the best they can be; that’s what it’s all about,” Carroll said. “Experience means everything. The more we can show them along the way, the better off they come out of here. I like to send out a sane, sound, fit, educated horse with a lot of bottom and leave something in the tank for someone else to carry on with.”

A simulated track environment at the 50-plus-acre training center prepares young horses for their careers: a seven-furlong irrigated dirt oval, three-quarters-mile irrigated turf course, starting gate with an experienced crew, small and large turn-out paddocks, a swim facility, and an eight-horse exerciser provide a broad range of conditioning opportunities.

“When I started out, I wanted to do some special things with horses that other people didn’t do,” said Carroll, who learned horsemanship from his father, W.W. Carroll. “I knew some things I got from my father and veteran horseman Odie Clelland, and applied them to my methods. We look out for the working man who has a few horses or the big operation that has a lot of horses—we treat them all the same.”

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- New 54-stall centerpiece training barn opening soon
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- 7/8 mi. racetrack maintained daily with state-of-the-art conditioner
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- All new paddocks and fields

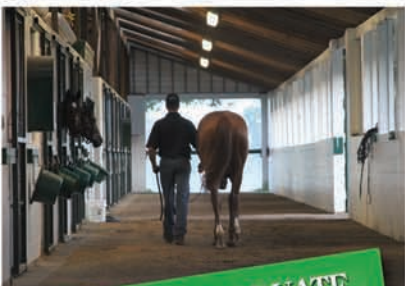
10 WINNERS AND COUNTING FROM OUR PROGRAM AT THE CURRENT SARATOGA MEET

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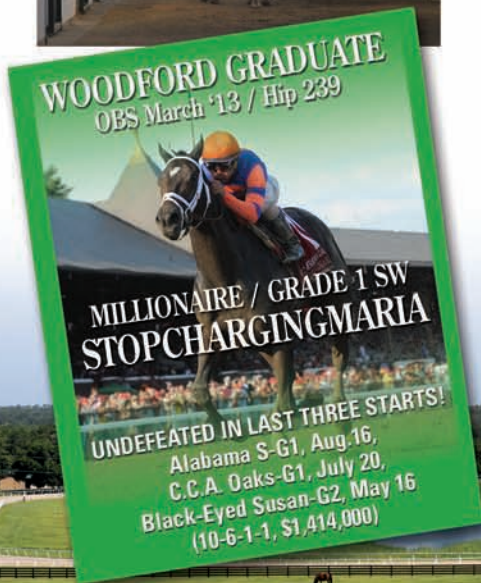
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The world-class Woodford training center is located near Ocala on 1,000 acres of the county's richest soil and boasts one of North America's only one and a half-mile turf gallops. The facility offers every amenity required to safely develop and maintain the highest level of performance.

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This is the breaking and training ground of dual Eclipse Award winner **BEHOLDER** (2012 champion 2yo filly and 2013 champion 3yo filly); and 2014 Graded SWs **CAIRO PRINCE** (G2) and **STOPCHARGINGMARIA** (G1).

In 2013 and 2014, yearling to 2-year-old pinhooks prepared and consigned by Woodford Thoroughbreds yielded an average of nearly 400% return above the purchase price. OBS March '13, Hip 120 sold for \$370,000, the highest price on day one and the second-highest priced horse of the session.



— 2015 STALLIONS —

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CURRENCY SWAP

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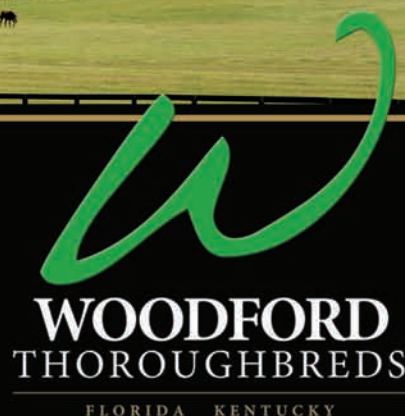
Proud Citizen - Pocho's Dream Girl, by Fortunate Prospect

SOLDAT

War Front - Le Relais, by Coronado's Quest

VINEYARD HAVEN

Lido Palace (CHI) - Princess Aloha, by Aloha Prospector



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Among Carroll's keys to success are a nearly 40-member staff, a sterling work ethic, and a preventative approach to conditioning.

"We stop with horses when they need to be stopped with," he said. "Before immaturity or little problems magnify into career-stopping or -threatening incidents, we try to nip them in the bud."

Carroll noted he is not a "one-man band," lauding the skills of his assistant trainer Travis Durr, who has been a strong part of the program for five years, and a capable crew that has been with him for 20-plus years. "Travis is an excellent horseman. Both of us live no more than four or five minutes from the center. It's something we take pride in. I know what to do with young horses and what not to do, and the latter's most important."

WES CARTER TRAINING CENTER

When working with young horses, Wes Carter prides himself on strong communication with the horse's connections to make sure each horse develops its full

potential.

With 30 to 40 horses at Wes Carter Training Stable near Bamberg, S.C., Carter said he can work with each horse.

"We're a small operation. We take personal care of them. We know each of them by their first name so to speak," Carter said. "We deal with each horse: mind, body, and spirit; the whole horse."

The 65-acre property boasts two barns, a swimming pond, a five-furlong track, and turf training. The training center works with young horses and with horses on layups. Carter said layup horses often fare well in the pond as they work back into racing shape.

Carter, who has owned the training center for 26 years, said his operation works to evaluate each horse and never wants to rush a young horse that is not prepared for more aggressive training. He said the goal is to have young horses race in their 2-year-old seasons, but each Thoroughbred is evaluated to make sure it is ready for that challenge.

Carter said horses that are not ready to race in their juvenile season are given

time to develop. He then makes sure the horse's connections are up to speed on the horse's progression.

"The main thing about me is that I'm honest," Carter said. "I will meet with clients and honestly tell them where a horse is. We have that integrity here to do the right thing for the horse."

"My philosophy is to do the best I can to get the horse to be the best that they can be."

The Wes Carter Training Stable also takes advantage of the Aiken training center, located about 45 miles away. Carter noted the experience of working at Aiken allows horses to receive more of a racetrack atmosphere early on in their training.

DERBY DAZE

When you send your young horse for early breaking and training, you want to look for a facility with a history of launching the careers of successful runners. Derby Daze Farm near Ocala, Fla., boasts a sterling track record.

Florida champion Hoooh Why learned her lessons at Derby Daze and learned them well. As a 3-year-old, Hoooh Why went wire-to-wire to win the Ashland

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SNEAKING UPONYOU - multiple stakes winner; Record: 10-8-8 in 48 starts (\$470,209, 2 to 8, SW in 2014).

GOOD BETTER BEST - stakes winner, SP winner at 2; Record: 4-7-1 in 17 starts (\$353,468, 2 to 5).

RUMBLING CLOUD - SP winner at 2, SW at 3 (\$314,416, 2 to 7).

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DERBY DAZE FARM

Stakes (gr. I) at Keeneland and a year later captured the Seaway Stakes (Can-III). Bred by Derby Daze's Gail Gee, Hooh Why has won or placed in 27 stakes and earned more than \$1.2 million. Stakes winner and multiple grade I stakes-placed Beautician, the winner of more than \$630,000, is also a graduate of Derby Daze, along with grade I stakes-placed Theregoesjojo and stakes winner Rumbling Cloud.

Their success is no accident. Derby Daze offers a complete array of services and facilities on its 77 acres, including a half-mile irrigated racetrack with starting gate, four barns with 70 stalls, round pens, turnout paddocks, and an indoor arena. Just as importantly, young prospects or layups benefit from the peaceful environment and the safe handling offered by Derby Daze's experienced staff.

Derby Daze has formulated a specific program to develop potential racehorses. Yearlings are introduced to tack and being backed in the familiar surroundings of their own stall. In the next step they visit the round pen to learn basics while bitted and saddled. Derby Daze does not rush its students to the racetrack. The farm takes the time to move young horses to an indoor track where they continue to learn lessons under saddle before going out to the main track. This extra time helps build confidence while also developing a horse's focus and ability to connect with its rider, promoting safety and soundness.

Derby Daze is also the place to prep a Thoroughbred for sales. Being located near the Ocala Breeders' Sales Co.'s auction site, Derby Daze is the perfect spot because it offers an ideal climate for winter and year-round training, plus horses can breeze at the nearby one-mile track in preparation for sales or races. Farm manager E.B. Gee Jr. and trainer Marcial Galan send Derby Daze graduates to the best sales throughout the country.

International bloodstock agent Anthony Goswell works closely with Derby Daze to assist clients in the public and private purchases and sales of bloodstock. Goswell has decades of experience as a sales inspector in Canada and New York.

Great climate, great staff, great facilities, and a program proven to produce top runners. Derby Daze has it all to ensure your horse reaches its highest potential.

DIAMOND D

Experienced riders and staff offer top-notch care at Diamond D Ranch in all phases of training, sales prep, lay-ups, rehabilitation, boarding, and foaling.

A full-service, year-round training center, the 185-acre farm near Lone Oak, Texas, about an hour east of Dallas, focuses primarily on the breaking of yearlings, 2-year-olds, and horses of racing age. Diamond D Ranch invites everyone to tour its website www.diamonddthoroughbreds.com to take a visual tour of the facility.

Its facility can handle about 180 horses and includes a five-furlong training track—which is watered and groomed daily—licensed by the Texas Racing Commission to record official workouts and gate cards. Diamond D Ranch also features seven pastures, 16 individual paddocks, and three barns with a total of 84 stalls. Each barn is equipped with an indoor walker, two indoor wash racks, and a covered round pen with shredded rubber footing. The barns have rubber paver block hallways, and each 12 x

12 stall has rubber mats and automatic waterers.

The training facility was established in 1981 by Ed and Caroline Dodwell. Today the facility serves customers from 14 racing states across the United States. With Ed having retired in 2004, and his passing in June 2010, Ed's son, Jimmy "Scooter" Dodwell, became the head trainer/general manager after serving 18 years as his father's assistant. Jon Newbold, the assistant manager/trainer, brings 38 years of training experience and oversees the day-to-day operations. Newbold is on the pony horse for every set that goes to the track to assist young horses. A staff of 20 people keeps the operation running smoothly.

The family's Diamond D program has produced 28 state-bred champions and several multiple graded stakes horses including Rachel Alexandra, Amie's Dini, Livi Makenzie, Shesakitty, Taptam, Chief of Affairs, Silver City, Baghdaria, Warrior Maid, Gran Lioness, Rapid Proof, Hey Leroy, Bahnah, Fiftyshadesofgold, Devious Intent, Magic Union, Donoharm, and Silverhill. Diamond D Ranch

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ANNE M. EBERHARDT PHOTO

...Rachel Alexandra Did

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has 167 stakes-winning graduates that have won 344 stakes races and 914 horses that have run third or better in stakes races combined through August 2014.

EVERGREEN TRAINING CENTER

The Evergreen Training Center might just be the best-kept secret in South Carolina. The 440-acre facility near Camden has everything an East Coast horseman would want in a place to put his or her youngsters through their early paces or give a horse in training a well-deserved rest.

Camden is home to several top-notch breaking and training centers that were built for high-quality racing operations, and Evergreen is a prime example. It was developed by the 1980s by C.N. “Connie” Ray, the founder of Sea Ray Boats, with design assistance from breeder/owner William S. Farish and renowned track superintendent Joe King. Ray owned back-to-back winners of the Breeders’ Cup Sprint (gr. I) in Lit de Justice (1996) and Elmhurst (’97).

“People come to Camden for the climate and the soil,” said Dr. Kurt Jaenicke, a Thoroughbred owner who bought the facility in 2005 and expanded the number of stalls from 60 to 90. “Here at Evergreen, it’s sandy; the horses don’t even need shoes, and your vet bills are non-existent because there are none of the those issues because of the sandy soils.”

The well water—better than bottled water—is another selling point for Evergreen.

Evergreen boasts a two-mile European turf gallop that is more than 100 feet wide in some spots and has a three-quarter-mile straightaway, lots of wooded trails, and a one-mile track that has drawn praise from a lot of horsepeople including top bloodstock agent Marette Farrell.

“I’ve been to a lot of racetracks and it far surpasses most of them; it is equivalent to Hialeah,” said Mike Rahaim, who runs Evergreen. “It has really good drainage, is elevated, and has banked turns.”

Jaenicke said that retired New York track super Don Orlando claimed the Evergreen track was among the best racetracks—not training tracks—on the East Coast.

“You can’t hear the horses hit the surface,” Rahaim said. “It should be a race-track; it’s good enough to run a 30-day

meet here.”

The amenities also move Evergreen up as an ideal location to get your babies ready.

“Kurt has put a lot of money in the place,” Rahaim said. “The facilities are second to none. If you come and see it, you’ll say, ‘Man, this is where I want to be.’”

“It has all the amenities you would want at a racetrack that you can’t get anymore. If you can’t get a horse ready here, you should get out of the business.”

HIDDEN BROOK

Hidden Brook Farm, a highly respected Kentucky operation famous for buying and/or raising horses such as Big Brown and Discreetly Mine, has opened a breaking and training division in Florida at Frank Stronach’s Adena Springs South in Williston, just north of Ocala.

Former racetrack trainer Mark Roberts, who managed Adena Springs South for 20 years, is heading up the new operation, which is already up and running. Hidden Brook, which has diversified into sales consignments and racing partnerships, will keep the new breaking and training division busy, but Roberts is seeking outside clients as well and is able to offer facilities unmatched in quality.

“We have a one-mile dirt racetrack that is 60 feet wide and is phenomenal,” said Roberts. “There is a starting gate with a starter that we’ll have access to. We have plentiful turnout space, and the paddocks are top of the line. The barns are airy and open and healthy for horses. There is a lot of air flow in there, and horses stay comfortable even in summer. The farm is set up for the horse, and it works well. It is absolutely the best place to break and train babies.”

Official workouts are clocked at the training track, and horses can enjoy spacious paddocks and top-shelf walking machines.

Roberts, who formed Hidden Brook 12 years ago with current partners Sergio de Sousa, Jack Brothers, and Dan Hall, said that the goal for this year is to have 30-40 horses in the breaking and training division. After that, he said, the top goal will be adding accomplished staff to grow the numbers up between 75 and 100 head.

“The partners have been talking about getting into this for awhile, and the timing was right to go ahead and get it started,” said Roberts. “This is what I was hired to do 20 years ago when Frank hired me

here in Ocala, and I had been breaking yearlings and doing layups for eight years before that. So it's a natural progression."

Adena Springs South sprawls over thousands of acres, giving horses all the space they need. Hidden Brook, which will be leasing stalls there, has been associated for years with Adena Springs.

"We view ourselves as a full-service operation, and this new breaking and training division is a continuation of providing services for our clients," noted Hall.

Hidden Brook has been successful in every facet of Thoroughbred racing and sales, in part because of its culture of partners who work together, get along, and add fun to their expertise.

"There is a go-to guy for whatever question comes up on any aspect of the industry," said Brothers. "It's what we do as a team that makes us strong."

Which makes Roberts the perfect man for the breaking and training operation.

MARGAUX FARM

Margaux Farm is a full-service Thoroughbred operation near Midway, Ky.,

that offers owners and breeders a special opportunity to have their horses raised and trained in one place. The 640-acre farm owned by Jim and Susan Hill has top-notch facilities, plenty of open pasture, and quality horsemanship as its cornerstones.

Besides plenty of space for mares, foals, and yearlings, Margaux has four training barns and three training surfaces. One training surface is a seven-furlong, all-weather, European-style gallop that rises and falls over hills in a broad figure-eight.

"It is fantastic for building a foundation," said general manager Michael Hardy. "In one circuit, they are jogging left and right while going up and down hills. They're learning while building muscle slowly."

The farm also has a straight, one-mile all-weather track for speed work and a one-mile turf track. The turf course is level with an uphill finish Hardy said is perfect for breezing young horses.

"It is a good surface that you can rely on," he said.

Another special feature of the Margaux program is that horses in training are turned out in groups of four or five rather than individually. While some may be concerned that horses running in a group might be more prone to hurting one another, Hardy said quite the opposite is true.

"It keeps them mentally strong because they have the social interaction they would get naturally; it is a reward," Hardy said. "It works particularly well with colts. They are allowed to behave the way a horse is supposed to behave. So when they come in to train, they are quieter and more relaxed. I find it much safer to turn them out in groups than individually."

The farm's facilities and its close working relationship with both Hagyard Medical Institute and Rood & Riddle Equine Hospital also make it an ideal spot for rehabilitation and freshening

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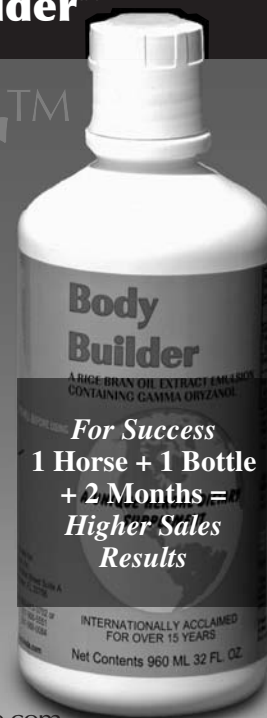
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PALMETTO THOROUGHBRED TRAINING CENTER

Aiken, S.C., has long been known as one of the major centers for horses in the United States, particularly during the winter months, when yearlings turn into 2-year-olds and 2-year-olds are turned into racehorses. This fine and lasting tradition is carried on with pride at the Palmetto Thoroughbred Training Center just six miles from downtown Aiken. The moderate year-round climate of the area and Palmetto's "the horse comes first" philosophy and environment combine to make Palmetto the perfect destination for owners looking to make racehorses out of the Thoroughbreds they've bought or raised.

Clients can choose from a variety of Palmetto programs, including renting stalls or choosing paddock layup. They can also take advantage of the training track by the day, where they can get pub-

lished workouts for their horses.

A new program offered by Palmetto lets owners run their horses right off the farm. Palmetto ships horses to around 10 racetracks that are within a 10-hour drive of the training center, allowing horses to run and then return to the su-



ANNE M. EBERHARDT

Gate work comes in the latter stages of the breaking and training process

perior environment of the facility, where horses can be turned out to graze, traverse trails, and enjoy freedom away from the racetrack. Of the first dozen

horses to take advantage of this, half of them finished in the money.

Owner Doris Tummillo opened the 500-acre Palmetto Training Center just a couple of years ago to give horses an environment in which they can thrive in a peaceful setting. This is critical for young horses getting their first lessons as well as for older ones that come to enjoy some rest and relaxation while getting away from the rigors of the racetrack. Tummillo, who owns horses as well, knows how important it is to handle horses in a safe and controlled atmosphere.

"We built Palmetto to control injury," she said. "We take pride in the safety of our track, whose surface is as similar to the one at Churchill Downs as we can make it. Our priority is to get horses to the races. We know how much ownership can cost, and we know how hard it is just to get (horses) there."

Palmetto boasts a one-mile dirt track but also offers a variety of grass and sand gallops that may include hill work. There are also sandy trails where horses can enjoy a pleasant change of pace from the track. Schooling and training gates help

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There are 72 stalls and more than 25 paddocks of various sizes as well as smaller turnout areas. Palmetto's stalls also vary in size, with some having extra space between them with windows to help young horses adjust. Others face each other, allowing them to keep each other company.

"It's all about the horse here," Tum-millo said. "We get the job done and it's fun. We have a passion for the horses."

WOODFORD THOROUGHBREDS

With top-notch facilities spanning more than 1,304 acres in Central Kentucky and Central Florida, Woodford Thoroughbreds offers a broad range of quality services and two safe environments for horses of all ages and training levels.

In Florida an 80-stall training center features a five-furlong dirt track complete with a six-stall starting gate. There is also a 1½-mile European turf gallop at the training division—a unique and well-maintained surface that allows young horses to take part in group training while aiding older runners in the recovery process after surgery. Ample turnout space and several round pens, along with a walker, provide youngsters and those undergoing rehabilitation with everything they need to get ready for the races.

The viewing stand at the Florida training track offers air-conditioned comfort for connections who want to watch their horses, and the 14-barn farm has a guest house for clients who come to visit. The farm also stands five stallions, and its training and yearling sales prep program has given a start to top contenders such as Cairo Prince and Stopchargingmaria.

Woodford Thoroughbreds general manager Matt Lyons said the program at the Florida branch has developed under the supervision of farm trainer John Gleason, who came to Woodford last season with more than 18 years in the industry. Prior to his Woodford engagement, Gleason spent 12 years breaking Overbrook's horses with Brian Rice at Woodside Ranch.

"I've been so impressed with John's level of horsemanship," Lyons said. "He tailors a training program for each particular horse, and he's very hands-on with the breaking and training."

Gleason puts extra emphasis on gate work with young horses as part of their solid foundation.

"They go to the gate most days, either walking through going to work or coming home," Lyons said. "When trainers get them, we get a lot of nice feedback about how good they are in the gate because it's part of their lives from when they start training."

In Kentucky, 304 acres with five barns and 92 stalls make up Woodford's main breeding operation. Small paddocks

keep foals safe and near their mothers, while larger fields allow yearlings to engage with each other as part of their vital development.

Lyons said the farm has continued its expansion into the 2-year-old marketplace, a foray begun in 2013.

"We had some very nice pinhooks this year, which were encouraging," he remarked. "Our training program also allows us to put the progeny of our stallions into the market and sell them as 2-year-olds." **BH**

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