

CONFECTIONERY PRODUCTION

chocolate, sweets, snacks & bakery

APRIL 2022

Plamil vegan focus

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Sustainability

Easter round-up

Biscuit production





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chocolate, sweets, snacks & bakery

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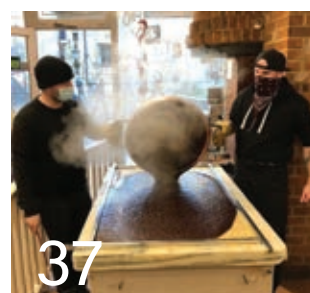
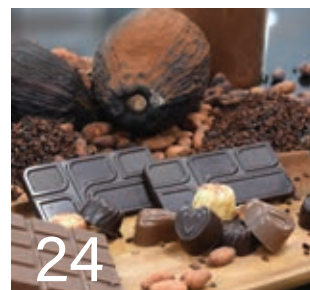
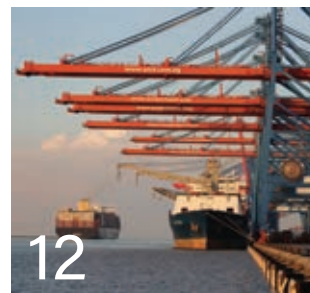
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Reflecting on testing times

The Easter season has traditionally been seen as among the most significant periods of the confectionery sector's annual calendar.

This year is clearly no different, as you'll see from our news pages, with a broad spectrum of new releases that are vying for prime space on retailers' shelves, as the industry continues its bid to pull away from pandemic times.

However, we're still yet to fully emerge from the lingering impacts of the past two years, and with key increases in raw materials, as well as ongoing logistics issues in many regions, there appear plenty of causes for reflection.

Not least of which are the global headlines charting the unfolding conflict in Ukraine, which began a little under two weeks after our last edition's focus on Russia's hopes for international exports. While that article was entirely accurate at the time of going to press, it demonstrates sadly how swiftly events can turn for the worse.

Significantly, you will also note from our news coverage, the CEO of Mars has been among those to issue a plea for peace in Ukraine, which has a number of global confectionery operations that have temporarily ceased operations.

The conflict's overall implications may not be fully felt for some while, but the rising costs of energy and ingredients for a range of core product lines is very much influenced by the concerning situation in Eastern Europe.

While these are undoubtedly testing times, there have in fact been some encouraging signs of innovation and investment occurring within the industry, including positives for businesses based in the UK.

Among them is this month's site visit at Plamil Foods in Kent, which has installed a new chocolate processing line for its latest vegan series that it hopes will have a notable impact within the segment.

Also in this edition, we turn our attention to topics including the ever-important issue of sustainability in the industry, as well as biscuit production and developments within emulsifiers. Here's hoping you enjoy our latest edition.

Neill Barston, Editor,
Confectionery Production magazine

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Tony's chief chocolate officer set to step down this autumn



Dutch ethically-led confectionery brand Tony's Chocolonely has confirmed that Henk Jan Beltman, its chief chocolate officer, is set to leave the business this October, writes Neill Barston.

The senior executive has played a significant role in the company that has strived for its 100% slave free mission targeting child labour within its key supply chains in West Africa.

However, the brand has conceded there remains significant work to be done, after its latest annual report last year found an increase in cases of young people illegally employed within the sector.

According to the company's own studies, there were 1,701 cases of child labour within its supply chain between 2020-2021, with the industry coming under renewed pressure within Ghana and Ivory Coast amid the pandemic.

Despite major challenges remaining, the company has claimed progress in its fight on the issue in terms of raising overall awareness levels.

Speaking on his departure, Henk Jan, said: "We're living in a crazy time. After a worldwide pandemic, we're now facing a horrible situation in Ukraine. What I want to share with you is nothing compared to this.

"After almost 12 years as Tony's chief chocolate officer, this coming October, I'll be handing over the baton and making way for Tony's Chocolonely to flourish in an exciting, new chapter. This new chapter outgrows what I've liked most in my role; hands-on making impact as an entrepreneur.

"It's been one heck of a rollercoaster – one I wouldn't have missed for anything in the world. Leading this bold, mission-driven impact business has been an absolute honour. Looking back, I feel privileged to have worked with the talented team Tony's."

Global cocoa supplies forecast for drop in 2022

The International Cocoa Organisation (ICCO) has unveiled its latest forecast for the 2021/22 global crop production year, which has revealed that bean supplies are expected to drop 5% to 4.955 million tonnes.

Its latest data is published as part of its quarterly bulletin, and comes as global market segment demand is in fact projected to increase by 3% over the next year, amid high growth in confectionery product ranges including premium chocolate ranges.

However, the cocoa sector has faced continued pressures from the ongoing global pandemic, which has created price instability for key producing regions, impacting on core supplier communities in Ghana and Ivory Coast, with 'farm

gate' prices being affected by turbulent conditions. The ICCO explained, the industry had been affected by supply chain bottlenecks, inflationary pressures, and added freight charges that threaten the hoped-for rebound of commodities including cocoa.

Beyond conditions relating to coronavirus, Ghana and Ivory Coast have also been significantly hit in environmental terms, with a recent study from non profit organisation Mighty Earth revealing that since 2019, notable amounts of forest are being lost due to cocoa farming, as well as illegal mining.

According to the ICCO, the current season witnessed a slow start in West Africa, with dryness proving a major factor.



CEO of Mars offers plea for peace in war-torn Ukraine



The CEO of Mars, Grant F. Reid has issued a heartfelt plea for peace in Ukraine, donating \$2 million in support of the nation, after Russian forces invaded its territory this week, writes Neill Barston.

As the company noted, it is seeking to assist in terms of humanitarian aid, with the business active in the country with facilities in the country's capital Kyiv, employing more than 170 associates, including within its confectionery operations.

However, the situation within the country has rapidly deteriorated, with the EU combining with the US and UK to place a raft of major economic sanctions on Moscow, along with the UN calling for Russia to withdraw troops from inside Ukraine.

Consequently, a raft of industries including the food manufacturing sector in the country have been seriously impacted, with media reports earlier this week revealing that Nestle, which employs a total of 5,000 in the nation, confirming it had temporarily closed its three factories.

Speaking on the humanitarian aid response from Mars, Grant F. Reid, CEO and office of the company's president, said: "We are appalled by what is happening in Ukraine and are striving to provide our courageous Ukrainian Associates with the support they need. Their safety is our absolute priority and teams of Mars Associates have been working diligently to provide shelter, financial security and aid.

"In addition to donations of food that have been provided by Mars business units, we're making an initial cash donation of \$2 million in support of this humanitarian crisis. Working with

Save the Children, we're committing \$1.5 million to help provide for the basic needs of children and their families in Ukraine and seeking refuge in border countries, as well as \$500 thousand to Humane Society International to give assistance to pets and pet owners. We join the world in supporting the innocent victims of this war and calling for a peaceful resolution immediately."

Manufacturing impact

Meanwhile, Mondelez, which owns major confectionery brands including Cadbury and Oreo, employing over 4,000 in the region, confirmed earlier this week that it would also close its own production facilities should conditions worsen further.

Tracey Noe, the company's Vice President, Global External Communications, confirmed that the situation within Ukraine had meant that the business was indeed among those that had temporarily halted its activities.

She said: "The safety of our colleagues is our number one priority, and we are focused on ensuring our colleagues in and around Ukraine are safe and cared for during this difficult time. We've paused our operations in the country and are supporting our people and providing humanitarian aid in the region.

"We are ensuring financial support by advancing salary and bonus payments for colleagues in Ukraine. We are also supporting rescue and shelter efforts at the border and beyond, in addition to our global 24/7 Employee Assistance Program for colleagues everywhere," adding that it is offering a \$500,000 donation through both financial and in-kind contributions.

High hopes of a seasonal treat for retailers this Easter

Mondelēz International has unveiled a bold line-up for its Easter product portfolio that it hopes will help retailers crack the market for key Springtime celebrations.

As the company noted, in 2021, stores saw sales in March increase by 11 per cent and this year, the season lasts two weeks longer, offering a further potential boost. Cadbury Creme Eggs will appear in an exciting new promotion this season, inviting shoppers to find one of 200 special promotional half white half milk chocolate Creme Eggs across the UK and Ireland for the chance to win £10,000.

Also available for the first time is a special mixed gift package containing five iconic filled eggs – two Cadbury Creme Eggs, two Caramel Eggs and one Oreo egg.

Cadbury Mini Eggs is a staple of Easter, with the 80g bag being the number one selling product across all Easter SKUs in 2021.

Launched last year, the Cadbury Mini Eggs Tablet was the number one NPD, turning one of the nation's favourite Easter brands into a popular snacking format. With the eye-catching staple yellow colours of the brand's aesthetic and stand-out packing across its range, they've proved highly distinctive on shelves.

This year Peter Rabbit also graces the front of the brand-new Cadbury Dairy Milk Hot Cross Bun Bar, which has its sights set on becoming a seasonal favourite in the sharing product category.

Cadbury's Twirl orange eggs are also expected to be big sellers for Easter



Cadbury's mixed eggs are among the company's key focus this month

Nestlé aims to take a big bite out of the Easter market

For its part, Nestlé has pulled out the stops for the Easter season ahead, which is traditionally one of the strongest periods in the calendar for the confectionery sector.

Among the latest products are KitKat Bites, offering an indulgent breaktime treat, consisting of a chocolate centre, wafer pieces and a milk chocolate shell, available in 90g sharing bags (RRP £1.59).

The series also includes Chocolate Caramel KitKat Bites (90g sharing bag RRP £1.59) that launched in February, exclusive to Tesco and Booker.

Meg Miller, brand manager for KitKat said, "This is a grown-up twist on our much-loved brand," that are "Perfect for a little evening indulgence, such as a family film night or after dinner."

Also new from KitKat this spring is the KitKat Chunky Lotus Biscoff Giant Egg.

This offers fans their first chance to try the anticipated KitKat Chunky Lotus Biscoff, which will be coming to the UK market later this year. The newest Chunky flavour features the brand's trademark crispy wafer topped with a Lotus Biscoff filling, covered in milk chocolate. The Giant Egg comprises a milk chocolate shell egg alongside three full-size KitKat Chunky Lotus Biscoff (41.5g) bars.

KitKat bites are among the mix for this year's top treats for the Easter season



Italian style and flair to the fore with Venchi's Easter offering

For this year's Easter season, Italian luxury chocolate manufacturer, Venchi, has focused its latest egg collection with a core emphasis on sustainable packaging using recycled PET (minimum 70%), cotton-blend fabric or FSC-certified paper.

As the company revealed, delivering on environmental goals is of significant importance to the business, with its latest lines being available at London boutiques in Covent Garden, Exhibition Road, King's Road, Hampstead, Richmond and Harrods, as well as its own online store.

Notably, the series latest egg cases are made from 70-100% recycled PET. Polyester ribbons have been replaced by cotton and paper, 90% of the surprises are contained in small bags and the egg wrapping is made from aluminium. As a result, the company reduced its consumption of virgin plastic by six tonnes compared to 2021.

Furthermore, all Venchi's naturally vegan dark chocolate eggs have gone from 56% to 60% in cocoa content, continuing its objective for more balanced recipes with less sugar. In addition, there's a 70 per cent less sugar (than standard recipe) series chocolate targeting 'guilt-free' indulgence.

The series includes a designer edition with Montezuma nibs, chocoviar eggs mixing milk and dark chocolate and pistachio, gourmet egg with caramel and salted almonds, as well as its 'brutto & Buono hazelnut option.



Vegan brand Moo Free is on a creative roll



Moo Free, the free from, vegan chocolate experts, has expanded its best-selling Easter collection with the launch of three new products.

This includes its very first, all-white hollow Easter egg – White Bunnycomb Crunch Easter Egg. Moofreesas Organic Egg and an Easter Egg Hunt Kit will also be joining the free from chocolate line-up.

Moo Free's full range is free from dairy, gluten and soya, and sources high quality, ethical chocolate.

The new lines are available from its website this month and the White Bunnycomb Crunch Easter Egg and Easter Egg Hunt Kit will launch this month. Each Easter Egg is presented in sustainable packaging, made from recycled materials and is fully recyclable.

Andrea Jessop, Moo Free CEO said "Easter can be a frustrating time of year if you suffer with allergies or follow a plant-based diet. We have set to change that. Without compromising on taste or product quality we sourced the highest quality cocoa to create our chocolate and crafted a range of eleven products that will bring excitement to everyone's Easter."



Easter goes upmarket

Meanwhile, for its part, for something a little different this Easter, UK firm The Popcorn Shed has released its latest gourmet series. Its latest tin gift offering promises a series of seasonal delights for customers eager to celebrate the occasion.

There are a total of three flavours to savour, including butterscotch, chocolate, and cheddar cheese. They come packed in separate bags to ensure freshness and the best possible taste, wrapped with a distinctive bow.

NEWS IN BRIEF

Ishida's Polish site

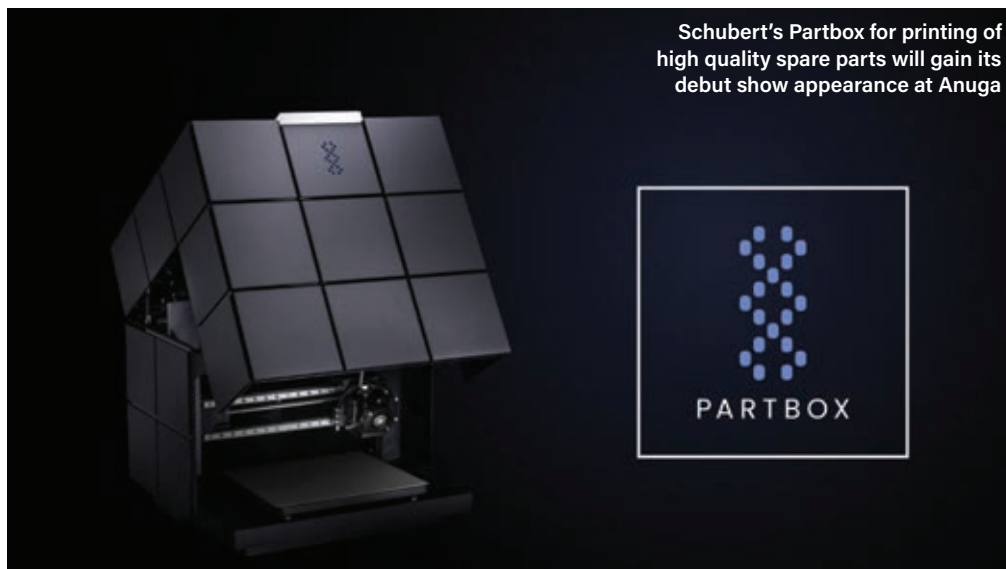
Equipment and systems group Ishida has made a strategic enhancement to its European operations in opening a new Polish office based in Katowice. As the company revealed, the region has proved a key growth zone for the business, and its expansion forms part of a wider element of its developments within the region. The firm has broad application for the confectionery and snacks sectors.

Olam's results boost

The Olam Group has reported its strongest ever annual results, posting a 31% year-on-year revenue increase to \$47 billion, in spite of wider market pandemic turbulence impacting on industries around the world. The business recorded profits that were nearly three times its previous level, standing at \$686.4 million, in the wake of the company splitting its structure into OFI and Olam Global Agri OGA.

Fairtrade backs report

Intergovernmental Panel on Climate Change (IPCC), highlighting the clear impacts that rising global temperatures are having on key agricultural crops, as the charitable body expressed concern over major issues including deforestation. Tim Aldred, head of policy for the non-profit organisation, said: "The IPCC report confirms what Fairtrade farmers and workers in low-income nations already know: that the climate crisis is here, threatening their livelihoods, their crops, their communities and our collective futures."



Schubert's Partbox for printing of high quality spare parts will gain its debut show appearance at Anuga

All set for Anuga success

Germany's Federal minister of Food and Agriculture, Cem Özdemir, is set to open this year's Anuga FoodTec, event in Cologne.

The sector showcase, being staged between 26-29 April includes a total of around 1,000 equipment and systems suppliers from over 40 countries.

There will be a number of businesses exhibiting that have strong links to the confectionery sector including AMP Automation, BCH, Agriflex, Capol, Capi and GEA to name a few, though its primary focus will be on the wider food and drink sector.

In addition to the physical trade fair, the digital platform, Anuga FoodTec@home, will extend the networking and information options, and also features a series of insight sessions.

Among prominent exhibitors within the packaging machinery segment at this event will be Germany's Schubert, which will be presenting a lightline carton packer which packs grated cheese pouches into cartons on site. For the very first time, Schubert Additive Solutions will be exhibiting its new 3D printer developed in-house for high-quality printing

of format and spare parts – the Partbox.

As the company noted, the theme of this year's trade fair is digitalisation, and it will be playing its part in Hall 7.1 at Stand C071.

An GS.Gate industrial gateway enables secure access to the machine and production data. "What this means is that we can carry out remote maintenance and use the data obtained to increase the machine's performance," explains Georg Koutsogiannis, Senior Sales Account Manager at Schubert.

"The more digital packaging machines become, the more data is generated during their operation," Koutsogiannis added. "With targeted digital services, this wealth of data is turned into hard cash for manufacturers and operators."

At the trade fair, the Schubert team will be presenting its new digital CARE services, which can be used to optimise packaging processes whilst saving resource and costs.

Schubert will also be providing information on the high-profile topic of sustainability, including switching to more eco-friendly packaging solutions. - see: anugafoodtec.com

New 3D printer to be presented

Schubert Additive Solutions will also be presenting a new development in Cologne. Using its subsidiary's virtual web platform, manufacturers can produce plastic parts in their own production facilities using 3D printing.

The company has developed a high-quality 3D printer for this purpose, which is connected to the platform via LTE and which ensures outstanding printing results. "The PARTBOX enables users to produce the parts they need directly on site," explains Marcus Schindler, division manager of supply play management at the company.

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Sugar markets face uncertainty in fresh EU and UK dispute



The EU is in a fresh dispute over sugar exports

Keith Nuthall casts an eye over the latest global regulatory developments including sugar and cocoa markets

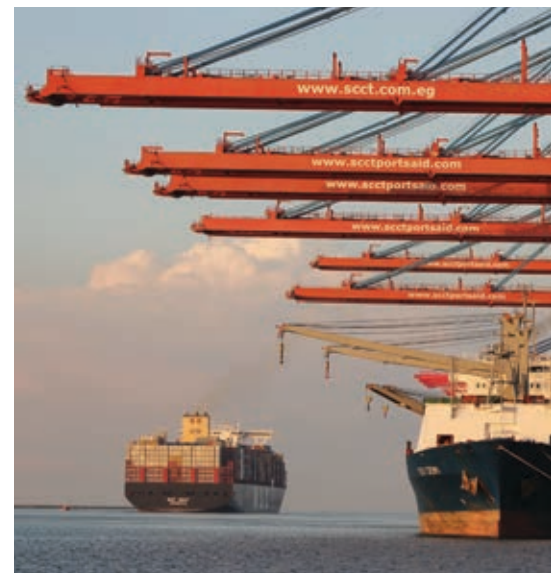
The European Association of Sugar Manufacturers (CEFS) has attacked the UK government for extending until December 2024 an import quota of 260,000 tonnes for raw sugar, claiming this could disrupt the European sugar industry and market.

“The UK’s approach is alarming, since it undermines existing concessions offered to sugar producers around the world,” said CEFS, notably European Union producers and those from African, Caribbean and Pacific (ACP) countries who usually have some special access to EU markets (and formerly UK markets prior to Brexit).

CEFS noted that since Brexit, sugar exports from the EU and least developed countries to the UK “have fallen substan-

tially,” creating opportunities for exports from major exporting countries, some of whom subsidise their producers. “Neither additional concessions, nor additional access to the UK market should be granted to new countries,” said CEFS, because EU, ACP and poor country producers would suffer sales losses.

The call comes as the World Trade Organization (WTO) has ruled that Indian subsidies to its sugar producers break global trading rules under WTO agreements on agriculture, and subsidies and countervailing measures (SCM). However, India has appealed this disputes panel ruling in a case brought by Australia, Brazil and Guatemala. As the US is blocking appointments to the WTO appellate body, the contested



subsidies are likely to remain in force. As a result, the International Confederation of European Beet Growers has called on the European Commission to “take adequate measures and at least suspend all sugar imports from India” to the EU.

Cocoa performance

Meanwhile, international cocoa bean stocks have been growing back to exceed pre-Covid 19 levels, according to the International Cocoa Organisation (ICCO). It has estimated that there were 1.92 million tonnes of cocoa in stocks worldwide last September (2021). This compares with 1.73 million tonnes in September 2019 and 1.71 million tonnes in September 2020.

For its part, the ICCO said that early indications for 2022 suggested continued strong demand for cocoa, with production in Ivory Coast the world's largest source, up 1.5 per cent by January, comparing the 2021/22 cocoa season with the previous year - 1.34 million tonnes compared to 1.32 at that time in the 2020/21 season.

This increase in activity was reflected by grind statistics released by the European Cocoa Association (ECA) in January (2022), which said 365,826 tonnes were ground in 2021's fourth quarter, up from 344,151 tonnes the same period in 2020.

The French government has announced it is drafting a national action plan to boost sustainable cocoa production. It said it would include a commitment to ensure no French-made chocolate uses cocoa grown on deforested areas by 2025.

Elsewhere, The European Food Safety Authority (EFSA) has declared it wants to impose an effective EU ban on using plas-



Cocoa supplies in West Africa

tics containing the ingredient bisphenol A (BPA) as confectionery contact materials.

It is consulting on reducing a tolerable daily intake by consumers of BPA to almost zero – 0.04 nanograms per kilogram of body weight per day, following studies indicating BPA can harm the immune system.

Dispute proceedings

The EU has launched WTO disputes proceedings against Egypt, claiming that chocolate and other cocoa exports to this key north African market are being impeded illegally through overly tough import licensing requirements.

Consequently, the EU argues these break global trading rules. Egypt requires foreign factories or trademark owners to submit legal entity certificates, lists of products being produced and exported, trademark and quality control certificates. These must be submitted by a legal agent in Egypt in Arabic and English, approved by the exporting country's chamber of commerce and/or consulate. The EU has requested formal talks and will seek WTO arbitration if the problem is not resolved.

Furthermore, European Commission competition officials are reviewing a planned takeover by France's Biscuit Holding SAS of the Netherlands-based biscuit manufacturer Continental Bakeries, checking if the deal complies with EU competition rules.

The US Food & Drug Administration (FDA) has announced that it plans to include acacia gum, a widely-used confectionery ingredient, as a naturally beneficial dietary fibre. This would enable manufacturers to include acacia gum on their label declarations about fibre content.

Also in the States, the American Farm Bureau Federation (AFBF) has approved a “no-cost sugar policy,” designed to enable US sugar producers to compete against imports, “while ensuring a safe, reliable and affordable supply for consumers.”

The food producers' association said that should the American sugar market tighten, the US government should allocate sales quotas to sugar from domestic cane or beets rather than increase import allocations.

In addition, the International Sweeteners Association (ISA) has pushed back against a new study – based on animal experiments – which concludes that when mothers consume low/no calorie sweeteners during both pregnancy and lactation, babies gain weight. The ISA argued that “there are several issues and limitations that need to be considered when interpreting the study results and especially their biological relevance to humans.”

In Europe, Germany's BDSI confectionery has predicted a significant increase in national sales of vegan ice cream in 2022, pointing out that sales rose from €57 million in 2019, to €75.5 million in 2020, and €80.7 million in 2021.

The BDSI said the UK declined significantly as an export market for its confectionery following Brexit withdrawal in January 2021. Consequently, sales to Britain fell by 3.7 per cent in volume and six per cent last year.

Within the UAE, the Saudi Food and Drug Authority (SFDA) has announced it has fined an (unnamed) honey trader Saudi Arabian Riyals \$133,333 for promoted honey products on social media through misleading medical benefits claims. ♦



Another key trade disagreement has surfaced as the EU has taken its grievances to the WTO over imports to Egypt

Exploring industry insights



Exploring industry trends forms a key element of this year's World Confectionery Conference. Editor Neill Barston quizzes one of our keynote speakers, Will Cowling, of insights group FMCG Gurus, on his hopes for 2022

The past two years have been especially eventful around the world in dealing with the pandemic. What has been the most significant trends you have observed?

The pandemic impacted the world to a scale we could never have imagined and is still impacting people across the globe today. One of the key trends which has significantly impacted the confectionery sector was consumers actually increasing their consumption of confectionery goods as comfort foods. Consumers wanted an escape from the reality they were facing and in lockdowns turned to comfort foods and indulgent products such as chocolate and confectionery, something in which FMCG Gurus data highlights. However, as the pandemic slowly fades, we

are now seeing consumer turning to a trend we call conscious indulgence, as consumers seek out better-for-you products as they feel as if they have put weight on over the past two years.

What drew you to working with FMCG Gurus, and how has the company evolved since its creation?

I was drawn to working for FMCG Gurus for multiple reasons. Firstly, I understood they were a great team with a lot of potential for me to grow my skills. Secondly, market research and understanding consumers is something which has always been of interest to me, while looking into trend frameworks and how consumers change over time.

WORLD CONFECTIONERY CONFERENCE

chocolate, sweets, snacks & bakery

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Finally, I am very much into my health and nutrition as I track my macro nutrients for the gym, and this role has given me an opportunity to understand the market and express my knowledge further to others.

How much are you looking forward to joining this year's World Confectionery Conference as a keynote speaker?

I am extremely excited to be speaking at this year's *World Confectionery Conference* as a keynote speaker. Public speaking is something I have always felt confident in and being able to share our research and expertise is a real honour for me. People will be in for a treat as we will have launched our new confectionery and chocolate surveys

prior to the event, and will be able to share some brand new 2022 consumer data.

For a number of market analysts, 2022 is a year of continued focus on sustainability within industry – will this be the case with the confectionery sector too?

Yes, I completely agree, 2022 will have a continued focus on sustainability. Sustainability is an area of focus not only for the confectionery industry but for the whole supply chain within the FMCG markets and needs to be addressed by brands and the individual if we are to sort out the environmental issues we are facing. The idea of being more sustainable has also created the opportunity to launch products around the concept of ethical luxury which in turn allows brands to better target an adult audience through better quality products that are deemed better for the individual and planet.

To your mind, what types of products within the sweets and snacks category are likely to be most popular in 2022?

Our research showed as the peak of the pandemic consumers turned to comfort foods more often. As consumers are coming out on the other side of the pandemic, they will now look to seek out better-for-you options. Our research highlights a number of consumers state they have actually switched from traditional snacking options such as chocolate and confectionery to higher protein/fibre goods. Therefore, I believe these sports nutrition inspired products will continue to grow in popularity as consumers look for functional ingredients which can offer great health benefits. However, taste is still the key factor as consumers state they will not be willing to give up moments of indulgence and must be taken into consideration when providing health related products.

As Confectionery Production has recently reported through you, the clean label product segment in particular is proving popular – what has driven this?

Clean label is of course a key trend relating to naturalness and is something consumers are actively seeking, eg, fewer ingredients and easy to read nutritional labelling. I would say this trend has not been driven by the pandemic as prior to the pandemic we had seen this trend growing. However, the pandemic has accelerated this trend as more consumers have looked to seek out naturally formulated food and beverages.

The research has also shown us that consumers find 100 per cent natural claims

appealing and are likely to seek out these products more often, something that will continue throughout 2022 and beyond.

What are some of the most surprising consumer trends you've witnessed within our sector?

One trend within the confectionery sector which does surprise me is the increase in consumers seeking out functional ingredients within candies. As consumers are adopting a holistic health approach to life recognising all aspect of health are inter-linked, they want ingredients that offer health benefits. One category they are looking to is candies and confectionery that offer great taste and ingredients which can aid immune health, cognitive health, digestive health and so on.

Outside of work, what are you most proud to have accomplished?

Outside of work, I am very active whether this be hiking, going to the gym, or playing football. One thing I am very proud of is managing and founding a football club under my mother's maiden name. Therefore, my weekends are not so relaxing as managing a team can be very stressful, but very rewarding when you win.

The recent ISM and ProSweets proved live events are returning – how optimistic are you of market recovery this year?

I am optimistic about the coming year and so forth regarding the recovery of events within the sector. The virtual shows have been great and have allowed us to stay connected in a time of isolation without travel, however, the live shows present a great buzz and energy for people to connect. As the world recovers from the pandemic, I also believe live events will also follow suit.

- For WCC enquiries, editorial, contact nbarston@bellpublishing.com or tickets and sponsorship, Chris Seldon, chris@bellpublishing.com ♦



Will Cowling joins the WCC as a keynote speaker

Living the vegan dream by the sea

With a million-pound investment in new chocolate processing equipment and latest vegan product lines, Plamil Foods is facing wider production challenges of recruitment and navigating Brexit fallout with genuine optimism, as editor Neill Barston reports

Folkestone in Kent, UK, has proved a successful base for Plamil as it expands its operations

“It was a lightbulb moment in creating the World Vegan Day, as it seemed to fit very well into the end of Veganuary,”

Adrian Ling, CEO, Plamil Foods



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Plamil CEO Adrian Ling shows off the latest vegan chocolate series, including its Carami!k bar variety

Take a stroll round any high street supermarket or specialist food store and you'll notice that vegan and plant-based segments have become noticeably more prominent in the past couple of years.

The confectionery sector is certainly part of this pattern, with a number of high profile launches amid the pandemic adding further to the rapidly-rising market considerably.

This was reflected in the fact more than 600,000 people signed up to taking part in this year's global Veganuary challenge to trial a vegan-based diet, which was promoted by a range of major companies, from motor manufacturers to high street retailers.

As a result, market analysts have asserted that the wellbeing and healthier eating movement has been far from a short-lived consumer trend, kick-started by the Covid-19 pandemic, rather it has been a longer-term evolution in global eating habits.

Indeed, one such prominent example in the UK is Kent's Plamil Foods, which stands as a pioneer of the vegan movement, established in the 1950's to deliver dairy

alternatives (its name stemming from a combination of plant and milk). From those early origins, it went on to extend its focus to include an array of seasonal specialties, eventually leading to its chocolate series from the early 1980's.

Today, the business employs a dedicated team at its site in Folkestone, operating from a converted dairy that has served the business well as it has gradually evolved. It is now embarking on a million-pound investment to double its production to 2,000 tons of chocolate per year, amid considerable category growth.

As the company explains, it may have been a relatively long journey, but it has continually refined its offerings, with the ethically-minded company is gaining increasing market share within Britain and further afield, enjoying export gains in Europe until recent challenges of Brexit impacted on overseas markets.

However, the creation of its So Free brand several years ago now being extended this month in releasing its latest oatmilk varieties, marking another key step forward for its product development.

It's a milestone CEO Adrian Ling is assuredly proud of, revealing there has been an encouraging industry response to his decision to establish the first World Vegan Day on 31 January of this year.

"It was a lightbulb moment in creating it, as it seemed to fit very well into the end of Veganuary. I've supported other chocolate days, but I didn't feel they were necessarily focused on where we wanted to go, with bringing in some nuance on having concern for farmers, and that if you are buying these products, please buy them with a certified cocoa source," he reflects of the new annual celebration, adding that his ambition is to encourage a 'broad church' of like-minded businesses within the sector.

He hopes the vegan day will encompass environmental and social concerns, as well as offer an opportunity to address key issues such as developing far clearer product labelling standards across the sector, which he felt required considerable improvement.

As far as the market is concerned, research has unearthed that Google searches for food within the category rose 5,000 per cent during 2021. This was supported by

Innova Market Insights studies revealing an annual growth in global food and beverage launches with vegan and plant-based claims grew 21 per cent and 58 per cent between 2015-2019 respectively.

Equipment investment

As Adrian reveals, the company's major decision to install its new MacIntyre chocolate processing system has involved reducing its overall portfolio, and focusing on core lines to effectively double production capacity to 2,000 tons in response to heightened demand.

While this represents a significant initial capital outlay at a time of wider market challenges, the business is confident that amid sustained market growth, its ambitions will pay off.

"We've had MacIntyre's here at the business for a long time – when I originally joined in the 1980s, the first piece of equipment we had was a small second hand refiner from the company.

"That's how I cut my teeth in chocolate making, so gradually over the years, we've moved towards having new lines, and now we have six units and so it was always the one type of refiner to go to, particularly for its flexibility for our types of products.

"If you look after these machines well, they last a long time, so we decided to step up production in two phases, which was a significant increase for us. So we went for MacIntyre's latest model that is capable of handling three tons," explains the CEO of the newly-installed refiner/conche sourced from the Scottish-based business that sits proudly within a new processing room.

He adds that the decision for its latest machine was also based on strong environmental consideration, with the system using considerably less power than previous generations of equipment. The line has also been set up so it does not use additional ground-water water in the cooling process, delivering a further considerable eco-benefit.

While the CEO believes that they've weathered the uncertainties of the past two Covid-hit years relatively well, there remain Brexit hangovers that have thrown up fresh trading and logistics obstacles.

This includes challenges relating to the fact that the UK's 'equivalence' status placing its ranges on a par with those on the continent, is no longer the case, as well as the physical cost of exporting and its additional administration costs proving prohibitive.

"I think one of our biggest challenges now is to get European customers to have our products when we're no longer in the trading bloc. There's a big psychological issue there. Why purchase from a third country from their perspective, when they can do so from within the EU? It's a question of convincing customers, but with spiralling costs at the moment, it is a challenge."

As Adrian reflects, there are a number of other tests the business is engaged with, including recruiting skilled staff across its production operations against a backdrop of a tough jobs market.

He says there are also hurdles in terms of customer requests for rapid turnaround times on specific projects, yet he feels recently implemented planning improvements within the business means they're able to adapt to peaks in demand.

On its new vegan Caramilk, series, he adds: "I'm really proud of our latest range, and I think that it will do well for us," explaining there had been considerable amount of development work into delivering its paper packaging, ensuring it is doing more than just talking a good game on delivering sustainable and environmentally mindful product ranges amid a highly competitive market. ♦



Taking the covers off the new MacIntyre, as it undergoes final testing in new sound-proofed facilities

Brilliance in production resilience

The global biscuit market has made gains despite pandemic challenges, driven by innovative processing solutions paving the way for a smart and sustainable future, reports Daisy Phillipson



The global biscuit market is valued at over \$106.2 billion and is set to rise considerably over the next several years, according to analysis by Mordor Intelligence. A number of factors have driven sales in this ever evolving sector, from the rising demand for convenience snacking to the increased development of healthier options.

Alongside changing consumer demands, much like the wider food industry, manufacturers of biscuits, crackers and wafers have had to grapple with the impact caused by the coronavirus pandemic. As outlined in the market research firm's report, factory closures and limited staff have resulted from disrupted supply chains.

Concurrently, the market has demonstrated resilience, with frequent launches containing healthier ingredients or free

from options pushing growth in recent months. This runs in parallel with FMCG Gurus' latest top ten consumer trends study on shopper behaviour, which found that consumers are taking a holistic approach to health, seeking out products and ingredients with active claims.

Beyond healthier and free from food, shoppers are recognising the importance of emotional wellbeing, as well as conscious indulgence. Taking a debit-and-credit approach to this factor, buyers want to improve their eating and drinking habits but without feelings of compromise and sacrifice. They also seek adventure and a genuine experience from the products they purchase, a trend that has been matched by the release of numerous premium biscuit products.

A number of major players within the segment witnessed growth despite challeng-

ing conditions, including pladis. The firm, which is behind brands such as McVitie's, Flipz and go ahead!, revealed biscuit sales increased by 7.4 per cent for 2020, reflecting a broader global trend for increased snacking amid the Covid-19 crisis. In November 2021, Mondelez International announced a goal of adding \$1 billion in Oreo sales by 2023 after beating earnings and revenue expectations.

Smart cookie

Continuous changes within the biscuit segment has prompted a reaction from machinery manufacturers in terms of their approach to the market, with a heavier development of smart solutions and automated systems to further boost agility and efficiency. "Naturally the coronavirus pandemic and the continuous supply bottleneck is an ongoing challenge for



Walterwerk has devised a number of smart solutions for its biscuit and bakery operations

the wafer producers and for Walter as a machine supplier,” says Markus Bartels, general manager, Walterwerk Kiel. “Nevertheless, we are optimistic that this year will be successful for both sides.”

Bartels went on to explain how digitalisation has become an important part of its daily work with customers, including the Walter Smart Services App, which allows the wafer equipment firm to carry out installations remotely. The company also offers an OEE (Overall Equipment Effectiveness) solution for an improved and digitalised overview of the effectiveness of production, as well as a new electronic spare part catalogue and client portal for 24/7 access to documents such as manuals, project files and troubleshooting tutorials.

For its part, Reading Bakery Systems, which provides a range of bakery equipment including for the production of cookies, biscuits and crackers, recently announced the expansion of capabilities and services offered by RBSCconnect, the firm’s proprietary Industrial Internet of Things (IIoT) platform. With the ability to collect and analyse data, the system allows manufacturers to monitor real-time information while providing preventative maintenance information, key performance indicators, alarm history and trends.

Robotics in food manufacturing also address a number of challenges accentuated by the pandemic, ranging from labour shortages to thinning margins. Discussing this topic is Interbanket, a Dutch bakery that chose sorting and packaging line supplier Tehama with the help of ABB Robotics to help remain profitable and flexible. With around 85 per cent of its products being exports, the firm needed to speed up

its process by automating the packaging of its cookies.

“Every year profit was going down due to thinning margins, so we had to find a way to increase profits to stay viable,” says Wilco Roelse, Owner, Interbanket. Without wanting to compromise on product quality, the firm opted for robotics with the help of machine builder Tehama. “I first looked at it in the traditional way of making machines, but there were so many different packaging styles and cookie combinations, it couldn’t be done. We needed incredible flexibility to transform the line quickly between batches of cookies, and the only way it could be built was with robots,” adds Ron Haaring, sales director, Tehama.

Since this was Tehama’s first foray into the world of robotic automation, the company turned to ABB Robotics BeNeLux for some advice, eventually going with seven IRB 140 six axis robots for the line instead of six four axis delta robots. ABB also

“In the past it was six or seven people that did the job, and now there is one operator,”
Ron Haaring, Sales Director, Tehama

A key area of specialism for Walter has remained its distinctive ice cream cones

helped Tehama with a number of RobotStudio offline virtual computer trials to determine the best positions for the robots, as well as gripper attachment configurations.

In addition to delivering a bit better output, the biggest benefit has been the lowering of labour costs in the packaging process. “In the past it was six or seven people that did the job, and now there is one operator who looks at the line and keeps the line filled with empty trays and other jobs, but the robots do the work,” says Haaring. “It allows Interbanket to continue operating in the era of small margins and still turn a profit.”

Another typically labour-intensive process in biscuit production is decoration, particularly where distinctive or intricate ▶



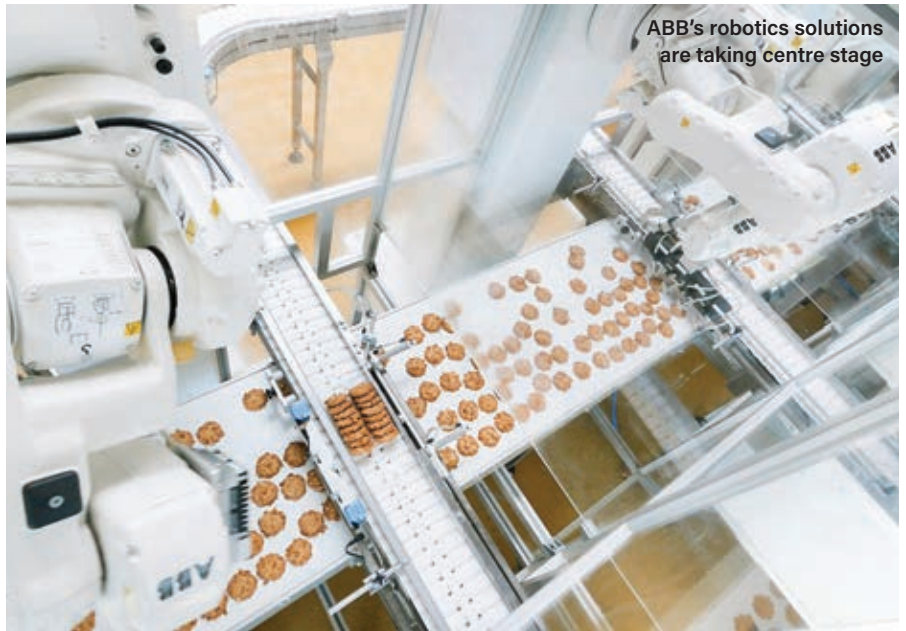
Walter has focused on bringing notable technology advancements to the sector



Walter has focused on bringing notable technology advancements to the sector



ABB's robotics solutions are taking centre stage



Interbanket, a Dutch bakery, chose sorting and packaging line supplier Tehama with the help of ABB Robotics to develop new solutions

Aasted, which supplies a range of processing solutions including systems for biscuit and cracker manufacturers, recently announced a greater focus on the upgrades of existing lines and equipment.

The company highlights how its newly created 'Upgrades and Aftermarket' team forms part of its transition to a circular economy, specialising in assisting with: production and operational efficiency; upgrading and retrofitting kits for lines and equipment; lifecycle management to extend lifetime; and securing future production while maintaining output.

In the context of sustainability, Walter's Bartels discusses the business's two core focuses: the machinery and its own factory. "We focus on reduced gas consumption and alternative heating," says the general manager. "Recently we even launched a retrofit for older machines minimising gas consumption."

The firm also incorporates sustainable practices into its own operations. Providing a number of examples, Bartels adds: "Last year, Walter doubled its production floor and installed photovoltaic panels on the roof. In our workshop our staff uses screens to show drawings and guides when assembling machines, reducing paper consumption significantly. Moreover, the premises of Walter are the home of 360,000 bees which are kept by the company owner Andreas A. Eule - our Walter honey is very popular with our customers."

With consumers increasingly thinking about the impact of their food choices on the environment, another contributing factor is waste reduction. For biscuit production, equipment group Baker Perkins notes how the tight control of cookie and frozen

designs are required. To automate this process without the need for hand-piping, frosting sheets or edible paper, specialty printing equipment firm Primera developed the world's first and only NSF/GMP-certified edible ink printer for printing onto cookies and other food products.

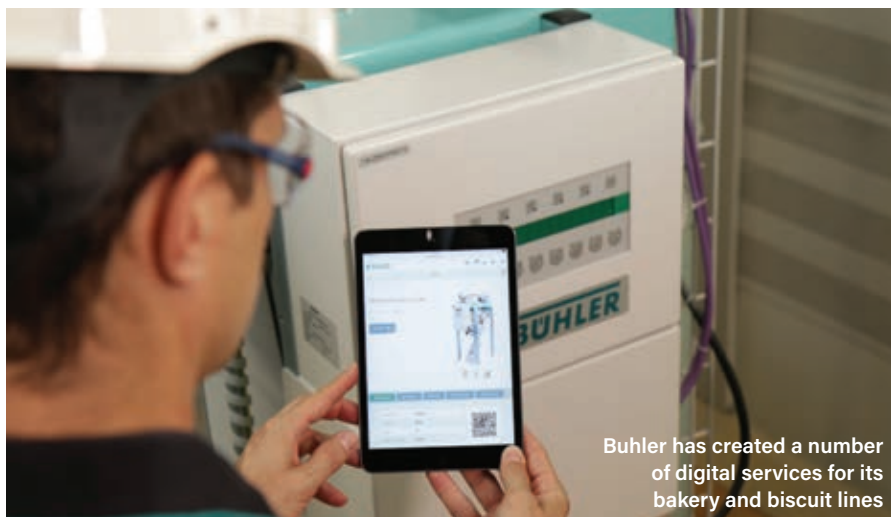
The company described how the Eddie printer is particularly useful in the age of personalisation, printing a dozen 89mm cookies or other similar-sized items in two minutes. The included carousel feeder rotates the cookies to the print position, the printer pulls in cookies one at a time, prints and sends them back to the carousel, without the need for manual intervention.

The future is green

Alongside smart solutions for increased efficiency, sustainability continues to be at the forefront of innovation, with Bühler Group

addressing the topic during its annual press conference in February. The company, which offers a range of solutions for the industrial production of various baked goods including biscuits and crackers among its expansive portfolio, revealed that key systems innovation and applications were behind improved financial performance in spite of pandemic-related challenges.

Noting a rising demand for sustainable solutions, driven by the change in consumer requirements and enabled by new technologies, Bühler increased its spending into R&D over the last three years to more than CHF 400 million. This includes its enhanced digitalisation and cloud-based services, which the firm said acted as key enablers to improve performances of existing assets of customers all over the world, addressing the need for improved sustainability and CO₂ emission reductions.



Buhler has created a number of digital services for its bakery and biscuit lines

dough piece weight can reduce giveaway and bring significant cost savings.

The firm addressed the issue through the new patent-pending TruWeight system, which uses die configuration adjustments coupled with an integrated scale and weight collection feature to identify dough weight inconsistencies and adjust the machine accordingly. This leads to reduced waste and giveaway, not only resulting in cost savings but also in satisfying demand for eco-friendly processes. ♦

Danish-based Aasted has continued to expand its bakery portfolio, which includes biscuit production machinery



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Making and maintaining a difference

Ensuring sustainability within business operations and responding to consumer demands for responsible sourcing and production poses a number of industry tests. Neill Barston reports

Sustainable sourcing of confectionery ingredients including cocoa for chocolate series is a key industry concern



With a raft of environmental and economic issues facing many areas around the world, it is little surprise that sustainability is continuing to top the agenda of many businesses across sectors.

It remains a huge subject area, spanning everything from cocoa supply chain responsibility, through to delivering energy savings with manufacturing equipment, systems and technology in order to be more environmentally responsible and efficient.

As far as the confectionery and snacks sectors are concerned, consumers are increasingly aware of the value of sustainable production methods and the implications for their everyday purchasing patterns.

This has been shown from key research by Cargill has revealed that consumers have placed an increasingly high value on sustainability considerations on their purchasing habits of foods including crisps and cookies.

The company conducted its recent global FATitudes survey that found 55 per cent of shoppers indicate they're more likely to purchase a packaged food item if it includes environmentally mindful claims – representing a four-point jump since its previous research three years ago.

In response, the business has continued to drive its own sustainability measures including sourcing oils from regenerative agriculture initiatives for row crop oilseeds, as well ensuring its palm oil is certified by the Roundtable on Sustainable Palm Oil (RSPO).

As *Confectionery Production* has previously reported, the key ingredient is used widely with confectionery, yet has attracted criticism from campaign groups over delivery of high environmental standards surrounding its processing.

Delivering on sustainability has been at the core of many other segments, including for colouring foods business GNT, which has worked with a dynamic array of businesses within confectionery and snacks.

Its core Exberry series to notable effect in showing that responsibly sourced ingredients and colouring is entirely possible with the right planning and product development.

Subsequently, the company was among those exhibiting at this year's ProSweets event in Cologne, highlighting the potential of delivering clean label food colouring.

Petra Thiele, managing director for GNT Europa, said: "Today's consumers are paying more attention than ever before to ingredient lists and even taking the time to research products' sustainability and

ethical credentials. Exberry Colouring Foods give brands the opportunity to tell a really positive story about the colours in their confectionery while delivering powerful shades from across the whole rainbow.

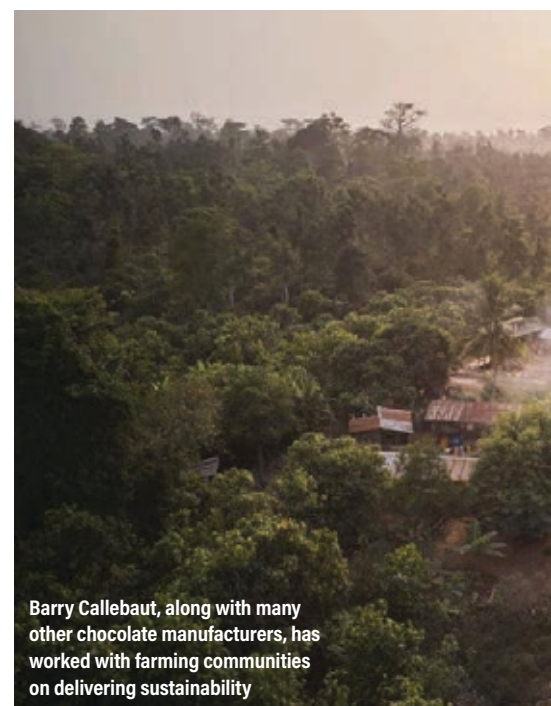
Industry response

During the past few years, sustainability has clearly gained a pivotal place on many other businesses within our sectors.

Among them, the Swiss-headquartered Barry Callebaut group has attained a fourth straight achievement of gaining a place on not-for-profit CDP's prestigious Supplier Engagement Leaderboard for its progress on tackling environmental matters.



GNT is among businesses that have had sustainability at its core development, providing clean label colouring solutions



Barry Callebaut, along with many other chocolate manufacturers, has worked with farming communities on delivering sustainability

“It’s our belief at Puratos that plant-based diets are inextricably linked with sustainability,”

Youri Dumont, Puratos

Similarly, flavours and fragrance group Symrise recently received the Sustainability Heroes Award for the second year running, with judges praising the company’s programme of engagement with communities within its supply chains.

For the Holzminden-based group, this includes making jobs in agriculture attractive for young people again. “With the Bridging the Gap initiative, Symrise is focusing on further developing cultivation and harvesting methods, increasing income and establishing learning partnerships between suppliers, farmers, Symrise and its customers in Brazil and Madagascar, among other places.”

Plant based diets

For its part, confectionery and bakery ingredients business Puratos has placed a core emphasis on engaging with environmentally responsible production, in response to consumer dietary demands.

As recently reported, the company has made notable major investment into expanding its Belgian site at Erembodegem, devoted to its Belcolade sustainable chocolate series.

Youri Dumont, the company’s chocolate business unit director, explained responsible production remains of critical importance, both in terms of its own goals and consumers’ product expectations.

He said: “It’s our belief at Puratos that plant-based diets are inextricably linked with sustainability, and the latest findings from Taste Tomorrow, our global research program, bear this out. The number of people buying plant-based foods has nearly doubled to 60 per cent in just three years, with the number of frequent buyers (ie weekly or more) highest in South America and Europe.

“The motivations behind plant-based diets are different now to the early years of vegetarianism and veganism, when animal welfare was by far the biggest driver. Consumers today see flexitarianism, and/or completely plant-based diets as a key contributor to their own health and that of the planet. 60 per cent say they believe plant-based food is better for the planet, compared to 56 per cent saying it’s healthier than animal-based food. Both are of extremely high priorities, and long-term ones, so plant-based eating will, in our view, continue to grow in popularity.”

He added that more consumers than ever are experimenting with plant-based living.

“In this digital age, we see a real online community being built, including the sharing of ideas and recipes, for instance. Our Taste Tomorrow research has shown a prevalence of consumer conversations around creating vegan versions of their favourite recipes. To balance “good” with “bad,” people are seeking plant-based versions of indulgent treats like chocolate and cakes.”

As he added, the company sees its role as offering ingredients enabling bakers, patisseries and chocolatiers to deliver exceptional foods responding to market requirements, as well as sharing insights on product development. It also advises on features like packaging, which plays a core role in catching the eye and communicating the benefits of plant-based foods.

This also extends to the chocolate segment, with Innova Market Insights who recently found that one in four consumers



Puratos has developed a number of sustainable chocolate lines

would like to see more plant-based treats like chocolate in stores.

Dumont added: “The chocolate market is still dominated by the sweeter, creamier milk chocolate, so the big opportunity lies in developing plant-based alternatives that have a similar taste and texture. This is quite the challenge because milk contributes so much to a chocolate product.” Therefore, in addition to keeping their fingers on the pulse, confectioners can and should leverage the expertise of their ingredients providers to identify plant-based alternatives to traditional animal-derived ingredients,” he enthused, noting that it is multifunctional products that can offer strong alternatives to animal-derived fats, egg and milk that are key factors in taste, texture and visual appeal that are likely to be most successful. He cited its Belcolade Selection M. Plant-Based Cacao-Trace plant-based chocolate as a core example of this, which was achieved after extensive research and development.

Sustainable packaging

In addition to product ranges, the delivery of greater levels of sustainable packaging is also fast taking centre stage.

This has notably been the case with German-based business Syntegon, as it showcased at this year’s ProSweets event in Cologne. ►





The past few months have seen development of Puratos's Belcolade chocolate production in Belgium



Syntegon's packaging machines have been created with a core focus on delivering sustainability gains

Among its diverse portfolio of systems, including its Makat confectionery processing lines the company showcased its vertical baggers produce bend- and tear-resistant stand-up bags made of paper.

Customers are using this technology for example to package chocolate in multi-packs, which is considered to be less environmentally impactful than conventional plastic wrapping.

"The paper stand-up bags are an environmentally friendly alternative to secondary packaging made of plastic and a real eye-catcher," explained sales representative Oliver Maier.

"The smooth structure and stability of the paper bags not only creates a special look and feel, but also highlights the quality of the packaging." Moreover, the vertical bagger scores with its flexibility, as it can be adapted to process different packaging materials and styles. This makes it suitable for producing bags made of recyclable mono-material film in addition – at speeds of up to 60 paper or 80 mono-material bags per minute.

As for finished products themselves, manufacturers are also recognising the clear benefits of going the extra mile to engage



Guylian has devised its latest range with sustainable packaging

with producing in a responsible manner.

Chocolaterie Guylian, is among those making clear strides, having set out a clear ambition to be a leader of sustainability within the chocolate industry.

"After almost 60 years, the Guylian brand is in need of a metamorphosis, and "By changing our design and brand, we also want to introduce a broader target group to the unrivalled taste of our premium Belgian chocolate," said Tom Snick, CEO of Guylian.

"The packaging will have a more contemporary and fresh design, while retaining the luxurious look."

"We want to set the tone for all chocolate brands with these developments," added Snick. "Guylian consciously chooses a pioneering role by going completely for sustainability in terms of raw materials, packaging, CO₂ emissions and Fairtrade," adding that the business has committed to working only with certified ethically sourced cocoa and offering suppliers a guarantee of a fixed cocoa price.

Fairtrade certification

As Fairtrade USA noted, third-party certifications are increasingly one of the most

effective ways to quickly communicate to shoppers that products are good for you, as well as being climate-friendly and produced responsibly.

For example, in 2021, 41 per cent of American consumers recognised the Fairtrade Mark, an increase of 46 per cent from 2019.

Retailers are also recognising this trend and creating programs and in-store signage, and digital tools that make it even easier for consumers to find products that match their values.

"No matter what grocery store or aisle, there is a label to look for that will help the conscious shopper feel good about their purchase having a positive impact on our food system," shared Hans Eisenbeis, director of mission and messaging at the Non-GMO Project. "We are honoured to partner with the MSC and Fairtrade America to share compelling reasons why brands should lean into trusted certifications to give consumers confidence in their purchases."

Trust in the Non-GMO Project, Fairtrade America and the MSC is rising, as in the US, 57 per cent of consumers trust the Fairtrade Mark (up from 48 per cent in 2019), and 73 per cent of MSC aware consumers report that they trust MSC claims. ♦



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Charting China's confectionery growth

China continues to weather the coronavirus storm, driving key investment and innovation in the confectionery segment, as Daisy Phillipson explores



Beijing has a strong confectionery market, with its residents especially fond of pastry ranges

Over two years since the coronavirus pandemic started, there's no denying the ongoing impact it's had on the global economy. One region that has weathered the crisis better than most is China, having taken a zero-tolerance approach to prevent the virus from spreading. However, whether this has undermined the country's economy has been widely debated. According to GIS Reports, food and beverage consumption saw annual declines in August, November and December 2021, significantly due to restrictions on dining out to curb the pandemic.

Nonetheless, China's economy expanded 8.1 per cent last year, with the GDP for 2021 coming in at RMB 114.4 trillion (\$17.7 trillion), an increase of about RMB 13 trillion (\$3 trillion) compared to 2020, reports China Briefing. The business intelligence outlet explained that the outlook for the rest of 2022 will depend on the performance of exports, the pace of recovery in struggling industries and whether domestic consumption can bounce back.

The food and drinks sector will certainly play a part in this, with a number of local and international businesses in the confectionery and bakery arenas making notable moves in the region. Speaking at its annual press conference in February, industry solutions group Bühler revealed that China represented the single largest market for the firm in 2021, with order intake increasing by eight per cent, and momentum is set to continue in 2022.

Growth is also set for Gerhard Schubert packaging machinery group. Bernd Göhringer, general manager, Schubert Robotics Shanghai, tells *Confectionery Production*: "After two long years of pandemic-related restrictions, we are now stepping up our activities in the Asian region in 2022.

"Schubert will be taking part in international trade fairs, including those in Shanghai, Bangkok and Tokyo. Our clear focus on the pharmaceutical and cosmetics industries is a timely development. Projects such as these require highly complex packaging machines with integrated processes, and this is one of our key strengths. We intend to further exploit this expertise, especially in light of the current Chinese economic growth of 8.1 per cent."

Even in the midst of the pandemic, major projects were implemented in China, including by global Symrise flavour and fragrance group, which invested €50 million into opening a new production site for its operations in Nantong, eastern China, in 2020. As the company – which produces a broad range of products including for the confectionery and bakery sector – revealed, the decision to build at this location allows it to serve key areas of China, as well as being comparatively close to other markets such as Taiwan and Japan.

As for market performance, according to data provided by Euromonitor International research group, retail sales of bakery, confectionery and chocolate were estimated at approximately \$38.9 billion, \$15.3 billion and \$3.5 billion respectively in 2021, and are forecasted to grow by 9 per cent, 2.7 per cent and 3.6 per cent between 2022 and 2023.

A number of growth areas have been identified by recent developments, including in premium chocolate. As reported by data and insights firm Mordor Intelligence, while chocolate sales in China have more than doubled over the past decade, the market is still largely untapped, meaning there's significant potential for NPd.

In its overview for 2021, premium chocolate group Lindt & Sprüngli noted China as one of numerous regions that demonstrated particularly good growth and great sales potential. Elsewhere,

premium chocolate business Läderach continues its programme of opening facilities around the world, including most recently in Shanghai, China.

The sugar confectionery segment is another area where the varied demands of consumers are creating new opportunities in the industry. A notable business paving the way for innovative candy products is Amos Sweets, which has become one of the strongest Chinese candy companies across the globe. The brand has earned a reputation as an innovator in this segment with its flagship 4D Gummy Blocks, a Lego-like candy that allows buyers to build them into shapes. More recently, an updated version of the blocks became available in Japan, with a number of new flavours including Cola, Soda, Pineapple Soda and Melon Soda.

Health and wellness

Amid the health and wellness boom, functional confectionery is also gaining momentum, a trend in which Amos Sweets has established itself with its brand Biobor. The firm's product portfolio comprises a range of soft candies featuring active ingredients that are known to boost the immune system and promote gut health, including Biobor's Active Probiotic 3D Gummy Bears, which come in peach, blueberry and yoghurt flavours and contain no artificial colours or flavours.

Catering to the demand for functional candy, BuffX was born amid the pandemic in 2020, focusing on delivering food supplements to young buyers in China. The company's range includes a variety of candy products with unique properties and medicinal functions, from Vitamin C gummies to promote immune health to GABA gummies for better sleep.

The number of confectionery companies continuing to innovate despite pandemic challenges run alongside the international brands investing in new facilities and witnessing increased sales in China. All of these factors combined suggest that the world's second largest economy will continue to be viewed as an ideal location for launching a wide range of confectionery products, as well as an area with huge growth potential for premium and functional brands. ♦

Navigating challenging markets

Global cocoa markets are facing challenging times in 2022 amid forecasted pressure on supplies. However, recent processing investments could make a notable impact, as Neill Barston explores

Cocoa processing faces potential challenges of weak supply in 2022

As the International Cocoa Organisation (ICCO) unveiled its latest forecast for the 2021/22 global crop production year, bean supplies are expected to drop five per cent to 4.955 million tonnes.

This unwelcome news, published as part of its quarterly bulletin, comes as global market segment demand is in fact projected to increase by three per cent over the next year, amid high growth in confectionery product ranges including premium chocolate ranges.

However, the cocoa sector has faced continued pressures from the ongoing global pandemic, which has created price instability for key producing regions, impacting on core supplier communities in Ghana and Ivory Coast, with 'farm gate' prices being affected by turbulent conditions.

The ICCO explained the industry had been affected by supply chain bottlenecks, inflationary pressures, and added freight charges that threaten the hoped-for re-

bound of commodities including cocoa.

As recently reported by *Confectionery Production*, beyond conditions relating to coronavirus, Ghana and Ivory Coast have also been significantly hit in environmental terms, with a recent study from non-profit organisation Mighty Earth revealing that since 2019, sizeable amounts of forest equivalent to the size of a city such as Madrid, Seoul or Chicago are being lost due to cocoa farming, as well as illegal mining activity.

Despite such major hurdles facing the global sector at large, there have been some positive moves at company level that have seen breakthroughs for the sector.

This includes the Cargill group confirming completion of \$13 million expansion of its cocoa processing facility in Tema, Ghana, marking a notable expansion of grinding capabilities within the region. Its creation is seen as critical for developing the country's industry infrastructure.

As the company noted, its latest investment comes in response to an increase in

consumer demand for cocoa powder, with an increase in premium chocolate ranges in particular showing continued resilience within many global markets. The Cargill scheme saw the president of the Republic of Ghana, His Excellency Nana Addo Dankwa Akufo-Addo attend the ceremony as the Special Guest of Honour and was received by a team led by Harold Poelma, President of Cargill Cocoa & Chocolate.

The multi-million-dollar investment took sixteen months to complete and increased the plant's grind capability by 20 per cent, bolstering its annual production capacity to 90,000 tonnes.

The initial capacity of 65,000 tonnes was pushed to 75,000 tonnes through the efficient management by the Ghanaian team, giving room for this expansion.

Further investment

An even larger sum totalling \$100 million has been made by the business in recent months to upgrade its cocoa processing

Cargill's cocoa facilities in Tema, Ghana, recently had multi-million investment into upgrading its capabilities



“With the new technology installed at our Yopougon plant, we’re now better equipped to supply the full range of our customers’ needs,”
Niels Boetje, Cargill

Cargill's key Yopougon location in Ivory Coast, also had a major \$100 million enhancement for cocoa handling



facilities in Yopougon, Ivory Coast, which is believed to be the largest grinding plant of its kind in Africa.

According to the company, its investment aims to deliver transformational change for the region's industry, and allows the company to significantly enhance its processing capabilities, increasing production capacity by a projected 50 per cent.

It will also enable significant infrastructure and safety enhancements, and has been undertaken in response to heightened global demand for its product ranges for the global chocolate and confectionery sector.

The move also creates nearly 100 full-time local jobs, as well as hundreds of indirect jobs linked to its activities. Notably, a significant share of the plant's additional

processing capacity will supply high demand, dark brown cocoa powders.

Notably, the business has been present in Ivory coast for over 20 years, opening its Yopougon plant in 2000, with its upgrades now processing cocoa powder, cocoa butter, liquid cocoa liquor and solid cocoa liquor, as high-quality ingredients that are exported around the world.

“Consumers, especially in Eastern European, Middle Eastern and African markets, are increasingly drawn to bakery and confectionery products with the strong, chocolatey visual appeal made possible by rich, deep brown cocoa powders,” said Niels Boetje, managing director for Cargill's cocoa and chocolate business.

“With the new technology installed at our

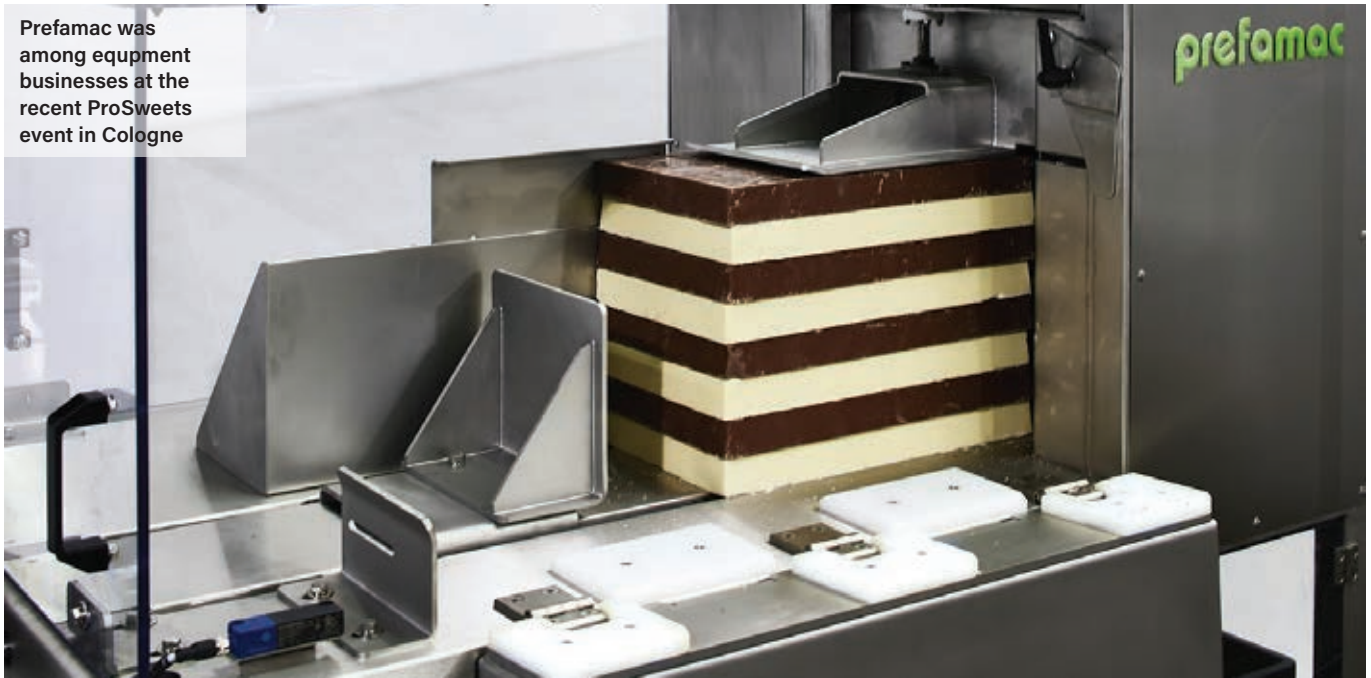
Yopougon plant, we’re now better equipped to supply the full range of our customers’ needs, from delicate light to intensely dark Gerkens cocoa powders.”

Meanwhile, in Europe, premium chocolate group Lindt & Sprüngli recently embarked on a major investment of €74 million into expanding capacity at its Swiss production base in Olten.

The facility manufactures cocoa mass for its EU operations, with construction work starting to progress on the venture, which stands as part of its wider development strategies.

Having amassed a total of 175 years history in Switzerland, Lindt & Sprüngli is deeply committed to its core home as a business location and invests continuously ►

Prefamac was among equipment businesses at the recent ProSweets event in Cologne



in the expansion of its three sites in Kilchberg, Olten and Altendorf.

Cocoa mass has been manufactured in Olten for the Lindt brand since 1991, initially exclusively for the production facility in Kilchberg near Zurich. Since then, the significance of the plant in Olten for the group as a whole has increased steadily, and it has evolved into the largest and most important cocoa mass plant within the global production network.

ProSweets equipment

As previously covered, ProSweets attracted a broad line-up of equipment and systems for the confectionery sector – including for the cocoa processing category.

Among machinery businesses exhibiting at the event was Belgium's Prefamac, which

displayed a number of systems representing its full range of production competence, including processing lines.

Managing director Myriam Schepers expressed concern about the event's reduced attendance, yet the business still managed to showcase its latest developments.

She said: "For the show, we introduced a new Temper meter, which we believe has a high level of quality and range of functions, as well as our first bean to bar machine, the Prefanibs, a grinder/mixer machine, starting from cocoa nibs, to produce chocolate. The resulting chocolate will contain less than 22 micron particles so the machine creates a top quality product. With the same machine also nut creams, ganaches, spreads can be produced. It's an ideal way to increase the variety of end products for our customers."



Olaf Schepel, sales director, of Caotech, tells Confectionery Production about hopes for 2022

In addition, she added that the company also offered a first-time showcase of its Quick Melter QM40, melting 500 kg of chocolate blocks per hour, working with cocoa butter, cocoa cream and fats, as well as displaying its Turbo Block Flaker. As she explained, the machine is the fastest of its type produced by the company, flaking eight blocks of 5kg together, as well as larger blocks to enable a broad degree of potential applications.

Moreover, Netherlands-based cocoa and chocolate machinery business Caotech made a return to the show after an absence of several years, demonstrating its key lines.

Olaf Schepel, sales and marketing manager explained it was pleasing to be back after three years since it last exhibited, though noted it had been challenging to prepare for the show.

But he believed showcasing the company's CAO B3000 lines had been worthwhile in having the chance to re-engage directly with customers from around the world. ♦



A number of mixing and processing systems from Prefamac were on display in Germany

Creating the *perfect* blend



Creating clean label product solutions is a key priority for industry, including for Ulrick & Short

Confectionery Production speaks to leading ingredients suppliers on tackling rising costs and recipe reformulation with the help of innovative emulsifiers. Daisy Phillipson reports



As Ulrick & Short note, delivering healthy reformulation is another major topic

There's no denying the impact the Covid-19 pandemic has had on buying behaviour, driving an increased focus on convenience, health and sustainability. "Initially, the industry was unsure on what the impact of the pandemic would be – would a squeeze on incomes lead to economisation?" asks Robert Lambert, marketing and communications, Ulrick & Short. "Instead we have seen the opposite: consumers have placed more emphasis on the quality, nutritional profiles and sustainability credentials."

While NPD has remained strong within the confectionery, bakery and snack seg-

ments to satisfy consumer demand, there is increasing pressure on manufacturers who must contend with fluctuating ingredients prices and disrupted supply chains. As explained by Sue Allis, group technical leader at Thew Arnott, cocoa prices have risen by more than eight per cent since December. "Apart from cocoa, there are lots of other costs which contribute to the rising price of chocolate – sugar and sometimes milk or nuts, packaging, marketing, transportation, taxes and retailer margins."

This is where the latest innovations in emulsifiers can help by reducing the amount of cocoa butter required and ►



“Removing milk fat to create a plant-based alternative is not easy,” explains Palsgaard’s, Lasse Kolding Sørensen

Thew Arnott has made the switch to sunflower lecithin for its emulsifier lines

yield value. “Replacing cocoa butter with lecithin makes the entire process less expensive. For example, three per cent or four per cent of additional cocoa butter is needed to thin down a coating, whereas only 0.1 per cent of soybean lecithin would be needed to get the same result,” adds Allis.

“The chocolate becomes ‘thinner’, and its flow properties are improved. Chocolate with lecithin has a more workable consistency that makes it easier to temper and to mould.”

An additional benefit is that it reduces viscosity and subsequently energy costs by allowing easier flow through large pipes and machines. Alongside soy lecithin such as Thew Arnott’s LeciTAs 4631, the ingredients firm notes how many companies have chosen to switch to sunflower lecithin like its LeciTAs 5877, which has a ‘cleaner’ ingredient connotation in chocolate products. “Although several studies have determined that slightly more sunflower lecithin is needed as compared to soy lecithin, the use level of 0.5 per cent still leads to significant cost savings,” notes Allis.

Ingredients business Cargill also offers a range of plant-derived lecithin solutions, available in soy, sunflower and rapeseed. Describing the various applications of the label-friendly emulsifier, Elena Revenko, product line manager lecithin, Cargill Starches, sweeteners and texturisers Europe, comments: “In baked goods, it helps

to improve the machinability, the dough release and moisture retention. In dairy alternatives, it enhances the mouthfeel and in confectionery, it helps to adjust the viscosity and yield value while emulsifying and stabilising the ingredients.”

Powered by plants

Ulrick & Short’s Lambert went on to explain that along with healthy reformulation, the other macro-trend identified by the clean label ingredients supplier is a shift to plant-based products. “Consumers are increasingly concerned with the ethical and environmental impact of the food they eat. By their very nature, plant-based products are generally more sustainable than their conventional counterparts, and as a result fit into this shift narrative very nicely.”

This fits in with the latest research from emulsifier and stabiliser specialist Palsgaard, which revealed global demand for plant-based product ranges has increased notably since the beginning of the pandemic. The online survey of 1,307 participants from Mexico, France, Russia, USA and Vietnam found that nearly half (44 per cent) had purchased more of such products since the start, the number one reason being that they consid-



Cargill has also offered its own line of sunflower lecithins for use in confectionery

ered plant-based food to be better for health. Other drivers include taste preferences and sustainability credentials.

Suppliers creating plant-based alternatives may face further challenges. Removing the dairy components for milk chocolate, for example, can result in the over-use of cocoa butter in order to create the desired flavour and texture, leading to higher processing costs. "Removing milk fat to create a plant-based alternative is not easy," explains Palsgaard's senior application specialist for confectionery, Lasse Kolding Sørensen. "Removing the fat creates a harder product and you also lose the sensation of eating milk chocolate. Also, you can't just add any kind of fat because it has to be compatible with cocoa butter."

While incorporating two per cent or three per cent of additional cocoa butter into the recipe has historically allowed producers to create a non-dairy chocolate bar that best resembles traditional chocolate, Palsgaard offers a cost-saving alternative.

Orlando Ramírez Gómez, application specialist, confectionery, at Palsgaard Mexico, says one way to eliminate this additional cocoa butter is to remove lecithin from the recipe and replace it with ammonium phosphatide (AMP), which is based on sunflower oil.

"We have a wonderful system called Palsgaard AMP 4455, which is a phospholipid," he says. "AMP reduces viscosity, and the good thing about this is you therefore don't need to add that extra two per cent or three per cent of cocoa butter, which was only added in the first place to reduce the viscosity." AMP 4455 is said to be more than double the strength of lecithin, and is suitable for both plant-based and traditional chocolate formulations.

Sustainable solutions

For the bakery segment, Ulrick & Short provides a range of clean label solutions for sweet and savoury bakery applications, including ingredients for egg placement and plant-based NPD. "We're constantly developing new solutions for emulsification, binding and thickening," Lambert notes. "For instance, we launched ovaprox 5, which effectively replaces the functionality of egg in cakes and muffins, allowing fully plant-based bakery products to have a very similar taste, texture and crumb structure to more 'conventional' sweet bakery products."

Discussing the vegan trend, Lambert adds: "Consumers are increasingly con-



Walterwerk has devised a number of smart solutions for its biscuit and bakery operations

cerned with the ethical and environmental impact of the food they eat. By their very nature, plant-based products are generally more sustainable than their conventional counterparts, and as a result fit into this narrative shift very nicely."

All of Ulrick & Short's products are plant-based, non-GMO and are cleanly processed to only extract the natural functionality from the base crop, therefore carrying a clean and consumer friendly product declaration.

Another topic that has come under the spotlight, particularly amid the vegan boom, has been the use of palm oil. Although the edible oil is derived from plants, it has been a significant driver of deforestation of some of the world's most biodiverse forests. In order to cater to the conscious consumer and contribute to environmental targets, ingredients suppliers are creating solutions that are either free from palm oil or sustainably sourced, including Puratos, which provides a range of emulsifiers for bakery applications.

"Our Puratos Multec Emulsifiers feature high quality vegetable oil (palm oil, rapeseed oil or sunflower oil) as their primary raw ingredients," says Celine Laigle, bakery research and development manager, Puratos UK. "Through our RSPO membership, we ensure that our palm oil emulsifiers are sustainably sourced and produced and we have engaged with various RSPO initiatives to achieve Mass Balance and Segregated Certification. For customers looking for 100 per cent palm oil-free emulsifiers, we also offer a full range derived entirely from rapeseed and/or sunflower oil."

Helping hand

With both the bakery and confectionery sectors constantly evolving, NPD has been integral to growth. However, reformulating a recipe can be a complex process, which is why seeking a supplier that can assist at every step of the way is important. "At Palsgaard we can help chocolate and plant-based chocolate manufacturers make that switch from lecithin to Palsgaard AMP 4455," explains Gómez. "It might seem like a headache to change an existing recipe, but we can help make the transition seamless and straightforward."

For challenging recipe reformulations, Cargill starches, sweeteners & texturisers Europe recently launched Infuse, a service offering model that centres on tailoring ingredient blends to answer specific customer requests.

"As just one example of our competencies in challenging confectionery applications, Infuse by Cargill has created an ingredient blend (Lygomme PM 600), optimised for use in plant-based double layered marshmallows," says Hannah Keenan, business manager, Infuse by Cargill. "The functional ingredient blend is based on hydrolysed pea protein and pectin, designed to deliver great texture and fruity flavour release, while delivering ease of use and helping with production efficiencies."

Other solutions are available for the plant-based reformulation of jellies, wine gums and deposited marshmallows based on proteins, pectin, carrageenan and/or starch. Keenan concludes: "Add to that our reliable global supply chain and we give customers the tools needed to create winning plant-sourced confectionery products." ♦



Palsgaard has produced a wide range of industry solutions, including for the chocolate sector

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Traditional confectionery ranges including fudge and toffee have reportedly been enjoying strong sales during the pandemic, despite consumers' desire for healthier ranges, as Neill Barston discovers



Mr Stanley's fudge has progressed well this past year, despite pandemic challenges

A winning sweet streak

The events of the past two years amid the pandemic have thrown up some unexpected results in terms of food and drink trends that may appear contradictory.

While there has been an undeniable thirst from consumers for healthier option ranges – including within confectionery, it's equally notable that pretty much the entire sweets and snacks sector (with the exception of the on-the-go segment during lockdowns), has prospered, as consumers turned to familiar brands.

This has included premium lines including artisan fudge ranges, that have had their fair share of success in the market – particularly in locations such as the UK, which has traditionally strongly favoured this sweetest of dairy-enhanced treats.

As Jaime Waring, of British-based Mr Stanley's confectionery revealed, despite the significant challenges of the past couple of years amid Covid-19, the business has seen an upturn.

He said: "Our brand focuses on keeping things premium and indulgent in the fudge sector. We actively look to increase the contents of our fudges to make them richer and more luxurious to the consumer, in a world where sadly many producers are looking to strip out the goodness to make things cheaper.

"Our top selling Butterfingers Fudge, which is a classic crumbly butter fudge presented in a signature Mr Stanley's 'book style' gift box, is made with 18 per cent butter content, one of the highest on the market," noted Jaime, revealing it has

continued to extend its series even further with a new Tiffin fudge, featuring cherries, marshmallows and biscuit.

Furthermore, the business also responded to the demand for vegan options, delivering its own 150gram version late last year.

Another factor during the pandemic has been the development of its online store, which the company says is continuing to prove a critical tool to further its business.

Sales growth

Another business performing well in the region is the UK's Fudge Kitchen, which reportedly saw its online sales soar throughout the pandemic, despite having to close all six of its high street shops.

Even when retail began opening again, it recorded e-commerce sales remaining at ►

“We actively look to increase the contents of our fudges to make them richer and more luxurious,”
Jaime Waring,
Mr Stanley’s



There's plenty of hard work behind creating new batches at Fudge Kitchen

50 per cent higher year-on-year. As a brand, it invested heavily into the fulfilment infrastructure of the business to keep up with the high demand for online orders.

Heading into 2022, the firm underwent a rebrand of its confectionery range, with the intention of proving that luxury and sustainability really can go hand in hand.

Managing director, Sian Holt, said: “The branding change initially came about as we wanted to align the look & feel of our six high street shops with our e-commerce platform. As part of this review, we felt it was the perfect time to explore more sustainable packaging options, while maintaining the artisanal luxury we are known for.”

The packaging update has seen them moving to UK printed packaging, plant-based inks and water-based glues, and all packaging is now FSC certified and fully recyclable.

Additionally, the company has also reformulated its vegan toffee fudge, which is now made with a new homemade vegan spread recipe. The category accounted for 15 per cent of its total online sales, an increase of 6 per cent year-on-year.

Icing on the cake

For its part, Dawn Foods has expanded its range of easy-to-use fudge icings with two



Dawn Foods extends its fudge icing

vegan-suitable fudge icings, both made with natural fruit flavours and colours.

A vibrant purple colour, its new Blackcurrant Fudge Icing can be used to create stunning Instagram-worthy bakes.

The Blackcurrant Fudge Icing has a deep fruity flavour and pairs well with chocolate and vanilla as well as citrus flavours such as lime and lemon or other sweeter fruits such as apple and plum. A popular and ‘on trend’ flavour across bakery and desserts, blackcurrant is regarded as a ‘superfruit’, full of vitamin C with a slightly ‘tart’ taste profile appealing to health-conscious consumers with a less sweet palate. Also new from the business is a Banana Fudge Icing, developed with a rich colour for notable shelf appeal.

Caramel popularity

As we have covered over the past year, while traditional favourites such as fudge continue to hold their popularity, one of the biggest flavour trends of the moment remains salted caramel.

This Easter is no exception, with one example been natural confectionery brand Prodigy’s latest offering of its latest reduced-sugar egg being unveiled in the UK this month.

Launching as a retail exclusive with Holland & Barrett, the new product will be rolling out across over 800 stores.

The Salted Caramel Chocolate Egg contains less than half the sugar of a typical filled egg and no refined sugar. As with the rest of the Prodigy product portfolio, the egg is high in fibre to support gut health, contains zero palm oil and is vegan.

Furthermore, the brand recently gained its B-Corp accreditation and now joins a global community of businesses measuring their social & environmental impact and being a catalyst for change. In 2021, the firm became the UK’s first certified ‘plastic negative’ chocolate range (partnering with industry to help fund wider removal of plastic waste), as part of its ongoing commitment to making the future of chocolate not only healthier, but more sustainable. ♦

As UK confectionery brand Prodigy has found, salted caramel remains a key seller



Exploring chapters of confectionery's rich history

The art of traditional confectionery manufacturing has been served well down the generations with dedicated textbooks.

The confectionery sector has changed radically over the past century – editorial board member Andy Baxendale casts his eyes over some of the archives to discover some hidden gems from the past

For the dedicated student, industry professional or indeed home sugar confectionery enthusiast there are a number of relevant and absorbing published works, which provide a fascinating insight into not only the history and development of our craft, but also manufacturing methods, recipes and products.

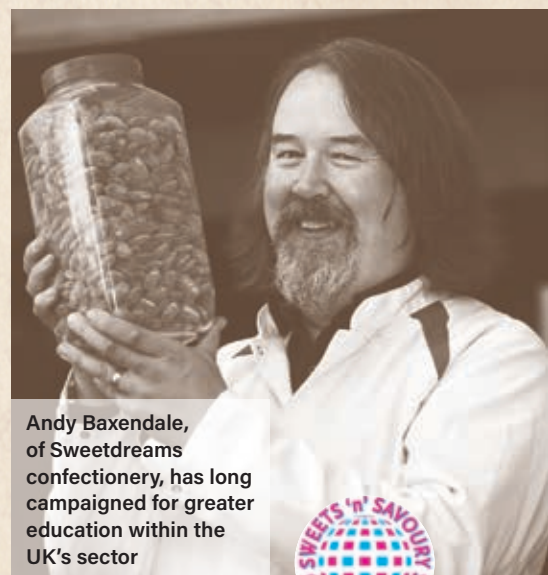
Unlike its sister flour confectionery, unfortunately, they are in nowhere near the abundance as the baking books that seem to smother bookshelves in every available shop.

However, as a firm believer in quality over quantity, maybe it is not such a bad thing. On a slightly less positive note, it reflects the fact the general “home cooking” brigade have to a large extent forgotten how to make even the most basic sugar confection.

The examples below represent, in my humble opinion, the best of the bunch that can be obtained from a variety of second hand sources – while some of them have been reproduced, the feel smell and general patina of a well thumbed confectionery manual cannot be replicated in a brand new reprinted edition.

Skuse Confectioner's Handbook / Complete Confectioner

Of all the historical works in existence, the 13 volumes published initially by E Skuse in the 19th Century as “The Confectioner's Handbook” and then in later editions by WJ Bush Flavour Company as “Skuse's ►



Andy Baxendale, of Sweetdreams confectionery, has long campaigned for greater education within the UK's sector





Victorian confectioner E Skuse produced one of the most comprehensive confectionery books that is still relevant today.

Complete Confectioner” are by far the most comprehensive, useful and still relevant recipes available.

E. Skuse was a manufacturing confectioner based at Praed Street in London, quite close to Paddington Station – according to his early books he started off at no. 36, by the time the later ones were published his address was 30, and when WJ Bush started publishing the work, Skuse’s address changed to Ashmore Works, Harrow Road, London.

E. SKUSE. MANUFACTURING CONFECTIONER, 30, PRAED STREET, LONDON, W. ABRIDGED PRICE LIST.	
<i>Bailed Sugar Drops.</i>	
Acid, Pear, Pine Apple, Raspberry, and a variety of other drops, in 2lb. or 4lb. tins, charged 3d. and 4d. respectively	0 5d.
<i>Cushions (4d. each).</i>	
Almond, Clove, Raspberry, Peppermint, Lemon, and Mixed Cushions	0 5d.
<i>Rocks.</i>	
French Almond Rock	0 4d.
Berry ditto ditto	0 4d.
Hardback ditto ditto	0 4d.
Eggs and Bacon	0 5d.
Acid Rocks, 4d. and 1d.	0 5d.
Raspberry ditto ditto	0 5d.
Mixed ditto ditto	0 5d.
4lb. Tin charged 3d. each.	
<i>Candies.</i>	
Cocoa Nut Candy, in 4lb. boxes	0 5d.
Cocoa Nut Ice	0 4d.
Chocolate Ice	0 4d.
Fruit Candy	0 4d.
Lemon Cream	0 4d.
Sugar Candy, Dutch ditto	0 5d.
<i>Comfits or Pan Goods.</i>	
Best London Mixture, 7lb. boxes	0 5d.
Biscuits ditto	0 4d.
Wife Tails all sizes, 4lb. parcels	0 5d.
Almond ditto	0 5d.
Hard Eggs	0 5d.
Ching Ching	0 5d.
Cocoa Tins	0 5d.
Sugar Almonds	0 5d.
Sugar Almonds	0 5d.
Sugar Almonds	0 5d.
<i>Bait Goods—Lard and Lard.</i>	
Bread Puddings, 4lb. boxes	0 4d.
Cherry	0 4d.
Chut Waffles	0 4d.
Cocoa Nut Chips	0 4d.
Cocoa Nut Fountains	0 4d.
French Biscuits Almonds	0 4d.
Raspberry Jelly	0 4d.
Raspberry Nougats, 1/2 lb. boxes	0 4d.
Victoria Ice Creams	0 4d.
Fruit Sandwiches	0 4d.
Chocolate Ice	0 4d.
<i>Gelatin Goods.</i>	
English Delight, 4lb. boxes	0 4d.
John Bull	0 4d.
Fruit Pastilles	0 4d.
Honey Dates	0 4d.
Pear Shapes	0 4d.
Lime Juice Tablets	0 4d.
Lemon & Rose Jelly	0 4d.
Crystallized Jelly, various sorts	0 4d.
<i>Lounges.</i>	
Peppermint Lounges, any size	0 4d.
Milk ditto	0 4d.
Rose ditto	0 4d.
Extra Strong Mince	0 4d.
Best Mince in Box	0 4d.
Mince Lounges, any shape	0 4d.
<i>Liquors.</i>	
Belgian Tins	1 10d.
Half-penny Biscuits	0 5d.
Farthing	0 4d.
Farthing Long Biscuits	0 4d.

Price lists from a second edition of Skuse’s work



Confiseur – Diderot.

According to the foreword by Sydney J Marks, CBE, president of Trebor Sharps Ltd in the mid 1970’s, the manuscripts which make up the reproduction of Diderot were in the possession of one Alfred T Handisyde, a successful 20th century London traditional confectioner and descendant of French Huguenots who more than likely brought the original with them.

The five fascimiles are presented in a limited edition A3 sized book which was published in 1975. Translations are also included in French, English and German and provide a fascinating insight into confectionery production in the mid 18th century, much of which is familiar to confectioners today. Copies regularly appear for sale and it is well worth acquiring one for the historical information that it provides.

Gunter’s Modern Confectioner and Biscuit Maker

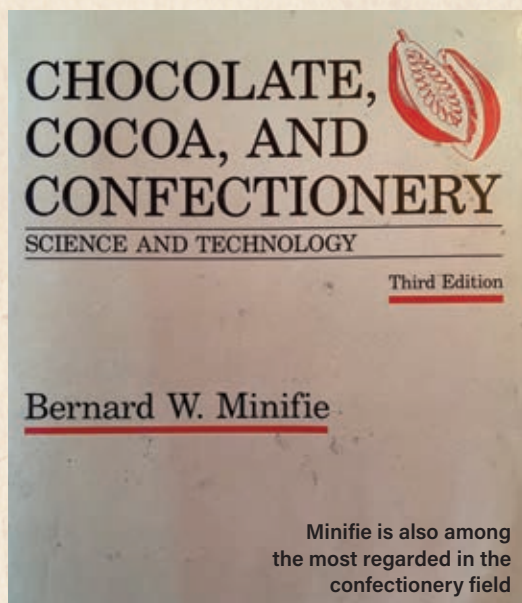
“That which sweetens life is quite as important as is that which renders it possible, otherwise life would hardly be enduring.”

This is the opening line from the preface of Gunter’s Confectioner 13th edition, published around 1900 and written by one William Jeanes, Chief Confectioner at Messrs. Gunter’s, Confectioners to Her Majesty.

While not as in depth as Skuse, it is still a fascinating representation of many of the recipes which were served in the Gunter shop in Berkeley Square.



Confiseur Diderot is another well respected classic confectionery tome



“It was with a feeling of extreme misgiving that I witnessed the loss of the older generation of skilled confectioners through retirements,”
Ernest J.Clyne

The first edition was published somewhere around 1860, which predates Skuse somewhat, and quite clearly appears that it may have served as the inspiration for some of his earlier works, in particular the second edition.

Gunter's was located at Nos. 7-8 Berkeley Square. When the east side of the square was demolished in 1936-7, it moved to Curzon Street. The tea shop closed in 1956, although the catering business continued for another twenty years.

Chocolate, Cocoa and Confectionery – Science and Technology

Published in 1989 by Bernard W.Minifie, this is probably the most comprehensive and desirable book for any confectioner to have at their disposal.

Within its 900 or so pages, is the answer to probably any question that could arise during confectionery, both sugar and chocolate, development, processing and production. As stated in the preface, the third edition is mainly concerned with science, technology and production. It is not a book of formu-

lations, which are readily available elsewhere.

As this was published in 1989, presumably a fourth edition is long overdue which would reflect the updates to the industry of the last 33 years. Bernard Minifie having had 50 years confectionery industry experience when he wrote the third edition, is unlikely to be contributor to a fourth edition.

A Basic Course in Confectionery – Ron Lees / Ernest J Clyne.

This volume by Ron Lees is an update of an earlier work by Ernest J.Clyne which was published in 1946 and 1955. In the preface by the original author is the following statement, which is as true now as it was then:

“It was with a feeling of extreme misgiving that I witnessed the loss of the older generation of skilled confectioners through retirements So much so that the present volumes were planned and during my years as Confectionery Production editor I fought strenuously for the formation of a school of confectionery.”

This vision was realised as Borough Polytechnic in London did implement a confectionery course – I have made enquiries and archives still exist from this time, even though the confectionery school is unfortunately long gone.

The Ron Lees volume was a rework of the 1955 edition and was published in 1979 – it is a very good grounding for anyone wanting to learn about confectionery, raw materials and manufacturing processes.

Other Volumes worth Looking at.

- The Complete Confectioner or The Whole Art of Confectionery Made Easy – Frederick Nutt 1807.
- Compleat Confectioner – Hannah Glasse 1742.
- Sugar confectionery Manufacture – Lees and Jackson 1985.
- Faults, Causes and remedies – Ron Lees 1981.
- Confectioner's Raw Materials – James Grant 1926.
- A Text Book on Candy Making – Alfred E Leighton 1952.
- Chocolate and Confectionery – C.Trevor Williams 1956.

Conclusion.

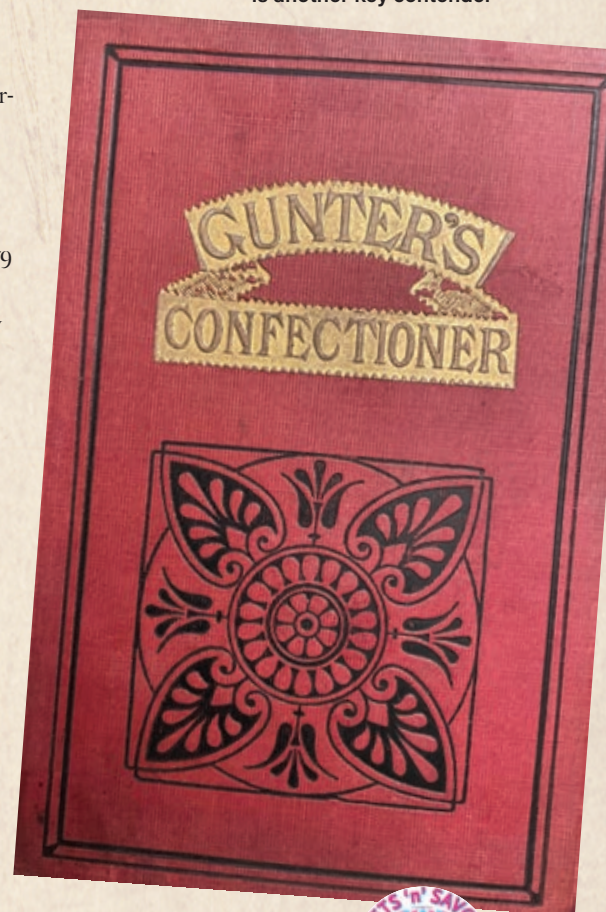
In my humble opinion, there can be no doubt that two names stand out as being the cream of the crop where confectionery texts are concerned: Skuse and Minifie.

Whether a student of the art or a dedicated long serving professional, there can be no doubt that being armed with the 13th Edition of Skuse and the third edition of Minifie will prepare the individual for any challenge that they may encounter anywhere along their confectionery journey.

The recipes provided by Skuse are all, even some 70 years on, still as relevant to-day as they were when WJ Bush published the final updated edition in the 1950's. Similarly with Minifie – the wealth of scientific and technical information concerning virtually the whole of confectionery production is astounding and a must have for any confectionery arsenal.

All the books above are in my personal collection and I would love to hear from anyone with any queries, suggestions for other volumes or just interested in confectionery generally. ♦

Gunter's modern confectionery book is another key contender



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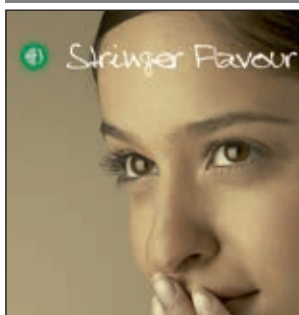
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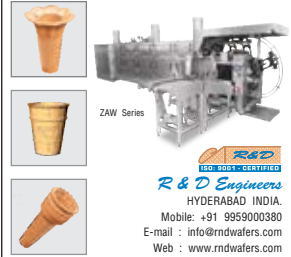


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