

How are sweets wrapped?

From the sweeties.net wiki

Wrapping is the last step on most sweet lines. Why sweets are wrapped at all, to keep moisture in its place and hold in flavour, is its own story: see [why are sweets wrapped?](#) This page is about how it is done.

The twist wrap

The twist wrap is a square of paper or film twisted at each end. When Mackintosh's of Halifax launched Quality Street in 1936, it decided to wrap each sweet individually in coloured paper rather than separate them in a costly box, and it introduced the world's first twist wrapping machine to do it.

Wax paper for chews

Soft, chewy sweets are traditionally wrapped piece by piece in wax paper. American salt water taffy, for example, is pulled, rolled, cut into small pieces and then wrapped in wax paper, which helps keep it soft.

Wrapped while warm

Candy canes show how wrapping can be part of the making. On a candy cane line described by the American confectionery trade body, the canes are cut and wrapped while they are still warm, and the heat of the candy shrinks the wrappers around them. Only then does a machine called a crooker bend each wrapped cane into its hook: see [how are candy canes made?](#)

Sealed and stacked

- **Heat sealed.** Chupa Chups lollipops are individually heat sealed in the factory and are best opened by twisting the base of the wrapper: see [how are lollipops made?](#)
- **Tubes.** Love Hearts are sold in tubes of 20, a clear plastic wrap twisted at both ends inside a paper label: see [how are message heart sweets made?](#) Fruit Pastilles come in tubes of foil backed paper, paper on the inside and foil on the outside, with a paper wrapper over the top.

Paper, foil and film

Each material behaves differently. Cellophane, made from regenerated cellulose, keeps out air, oils and grease well, but lets water vapour through unless it is coated. Toffee, which draws in moisture, stuck to its cellophane wrapper in Quality Street's Toffee Penny until 1967, when a foil backed paper solved the problem, and in 2022 Nestlé announced that Quality Street would move to recyclable paper wrappers.

How fast?

Very fast. Spangler says each of its lollipop wrapping machines wraps about four Dum Dums a second, and the Wigan maker of Uncle Joe's Mint Balls has a high speed wrapping machine, bought from Italy, that can wrap up to 2,000 sweets a minute: see [what happens inside a sweet factory?](#)

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