



ANNUAL REPORT 2021



Message from the Secretary

The work of the Wisconsin Department of Corrections' Bureau of Correctional Enterprises (BCE) may never have been as vital to our state as it is at this moment in history.

The various recruitment and "Help Wanted" signs seen in cities and towns across Wisconsin are an easily-viable indicator of the worker shortages in our state, and many others. While Wisconsin's unemployment rate has dropped to a level we saw before the COVID-19 pandemic, worker vacancies keep rising in various industries in serious need of skilled workers.

The Bureau of Correctional Enterprises (BCE) helps justice-involved people learn the skills needed to help Wisconsin employers, in the current economy or any other. BCE helps its workers learn both technical skills and soft skills, connect with employers and identify community resources that will help them successfully transition back into the community.

I've always been a proponent of investing in people, all of whom have the capacity for positive change. Governor Evers and this administration continue to make an unprecedented investment in reentry and employment programs that supports those in our care as they prepare for a successful return to their homes. BCE plays a critical role in this work, ensuring its workers are able to financially contribute to their families and communities, post-incarceration. In addition, now more than ever, BCE workers are a skilled resource for Wisconsin businesses.

At the Wisconsin DOC, we believe "every person, every family and every community matters." Those in our care are no less valuable because of what they did in the past, and the skills they learn working with BCE ensure they will be valued in the future. I am proud to continue supporting BCE's mission and the workers on those teams. I encourage each of you to read this report to see the tremendous impact BCE is having on persons in our care and Wisconsin's workforce. Thank you.

Kevin A. Carr, DOC Secretary

Message from the Director



Thank you for investing your time and attention to the Bureau of Correctional Enterprises (BCE) Fiscal Year 2020-2021 (FY21) annual report. This report is an opportunity for me to share information about each BCE team, BCE activities during FY21 and the objectives that BCE teams will work on during Fiscal Year 2021-21 (FY22).

BCE employees and workers on our Custom Signs, Product Development Center (PDC) and Sign Sales teams collaborated and added to the services they provided. This resulted in additional business earned during 2021. Artistic designs, creative marketing material, and diligent sales helped BCE win a bid to design a year's worth of municipal event and activity promotional banners. Throughout the coming year, pedestrians and drivers will see beautiful boulevard banners that remind them of the assets and attractions of that Wisconsin village.

BCE teams worked and won together when we introduced our 1st BCE mobile advertising campaign. Employees and workers on our PDC, Industries Distribution Center (IDC) and Sign Sales teams brought our fleet of trucks to life with a customer's message. BCE trucks traveling thousands of miles across Wisconsin each month now show off creative, engaging messages about Department of Corrections career opportunities. BCE is glad to broaden its customers' employee recruiting efforts.

BCE outreach efforts with customers and employers came face-to-face with the COVID pandemic, so we used online meetings. This is the method we used to continue telling those audiences how they and Wisconsin win the more they and BCE work together. We are reaching out again to those who can buy from BCE and employers with whom we can partner to overcome workforce challenges. I'm looking forward to more outreach this year.

Our Badger State Logistics (BSL) team took the pandemic supply chain bull by the horns, working diligently to maintain inventories and fill customers' orders quickly. BSL employees and workers continued to meet customers' needs for products that were difficult to find, including cleaning supplies, personal protective equipment, food service supplies and rolls of toilet tissue. This team continues to partner with drivers on our IDC team to get complete orders to our customers on time.

We will continue partnering with the Department's Bureau of Technology Management (BTM) to advance BCE's online presence. Workers on our PDC team continue learning from and working with BTM team members to improve our e-commerce site, www.shopbce.com. Our site looks great, is interactive, regularly updated with new products, and uses a modern shopping cart so customers can buy online. We look forward to continuing our public engagement efforts with customers and those just seeking information about BCE through our website.

The Bureau's teams of employees and workers provide more information more conveniently to meet customers' needs. Our teams generate and deliver on new service ideas to help customers overcome their challenges. We actively share stories of BCE workers' successes to engage customers and employers as partners in those results. Look forward to more achievements by those on our teams and former workers who have returned to their families and communities. With our partners, we help the Department more fully meet its mission and make Wisconsin a safe, better place to live.

Sincerely,

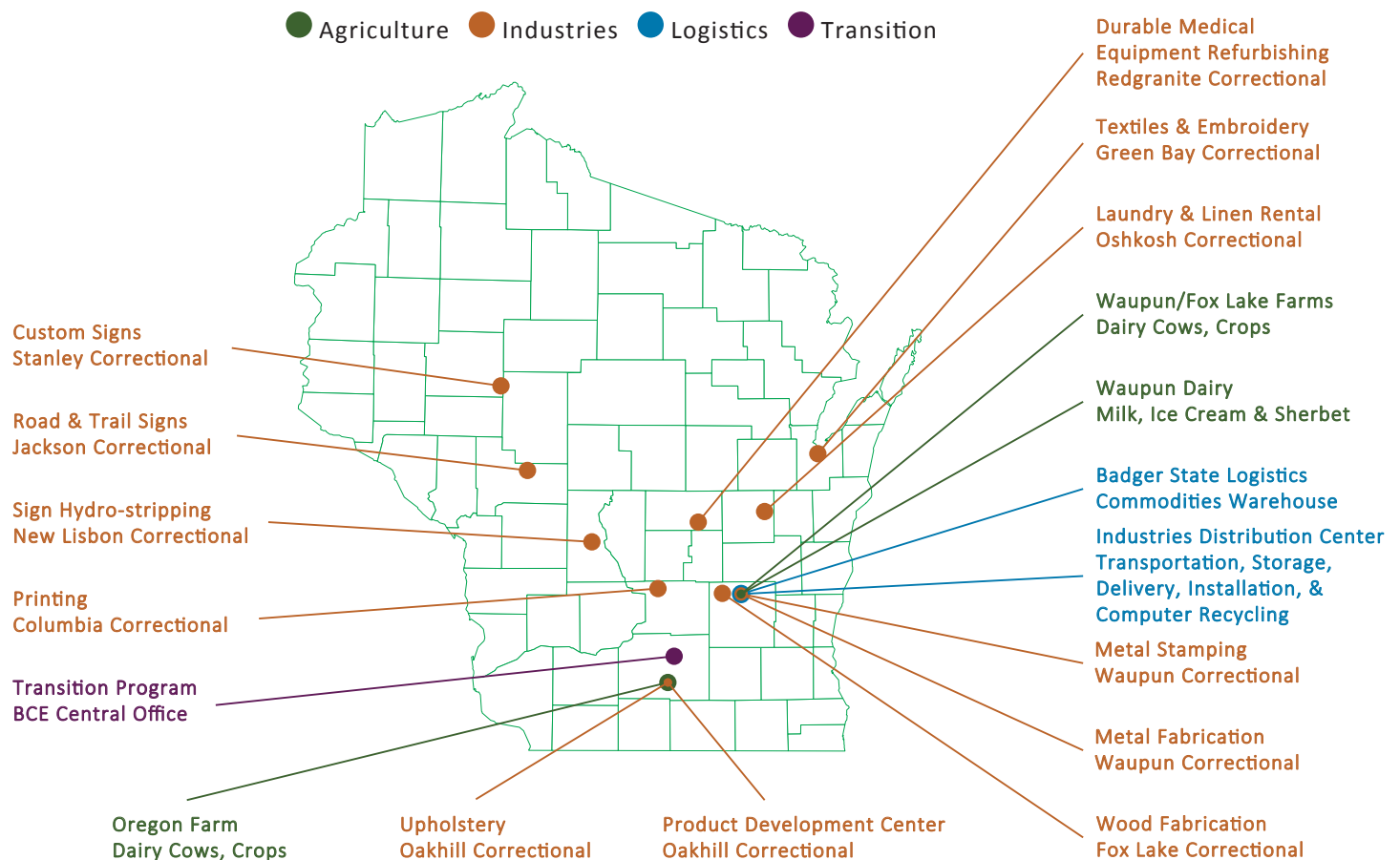
Wes Ray, Director

Bureau of Correctional Enterprises

Our Mission

The mission of the Bureau of Correctional Enterprises is to enhance public safety by providing jobs and training to persons in our care which develop marketable skills and experience in financially viable businesses while providing quality products and services to our customers.

Who And Where We Are:



These teams of employees and workers make products and provide services to government and non-profit customers.

71% of former BCE workers have not returned to DOC three years after returning to their families and communities.



Agriculture

Oregon Farm

This farm consists of approximately 530 acres. The primary crops are alfalfa, corn, soybeans, and wheat. These crops are grown primarily for herd consumption. It has a Holstein dairy herd of 180 milk cows and 170 replacement heifers. This team employs persons from Oakhill Correctional Institution.

Waupun Farm/Fox Lake Farms

These farms consist of approximately 1,650 acres. The primary crops are alfalfa, corn, soybeans, and wheat. These crops are grown primarily for herd consumption. It has a Holstein dairy herd of 470 milk cows and 390 replacement heifers. This team employs persons from the John Burke Correctional Center.



Waupun Dairy

This dairy produces milk in 5 gallon and half pint containers and ice cream and sherbet in individual serving containers. The dairy also sells the cream available as a byproduct from the production of the 1% milk it sells to customers. This team employs persons from the John Burke Correctional Center.



Only **\$50,000** of
Wisconsin tax payer dollars
appropriated in FY21 for
ALL BCE operations.



Industries

Product Development Center (PDC)



The employees and workers on this team create digital assets for the full BCE product lifecycle of design, support, and promote. Design services includes submittal and manufacturing drawings for custom furniture. Workers are trained to employ industry drafting standards, manufacturing processes, and document control while using market leading CAD systems such as AutoCAD and SolidWorks. Workers can enhance their 3D CAD drawings using Visualize to create photo realistic representations. Support services includes creating digital assets for catalogs, brochures, price lists, and maintenance and updates to our www.shopbce.com website using web development tools inside NetSuite and programming languages HTML and CSS. Promotional services allows workers to learn

to use the computers equipped with sophisticated applications such as the Adobe Creative Suite, which includes Photoshop, InDesign and Adobe Illustrator. Workers sharpen their business acumen by working with BCE's enterprise resource planning (ERP) system in an environment that is as similar to a private sector company as possible. These responsibilities include deadlines and time management. Workers also heighten their skills by mentoring peers on the team. This team employs persons at Oakhill Correctional Institution.

Wood Fabrication

BCE Wood Fabrication is a manufacturing team that provides professional, high quality wood working furniture. Wood Fabrication focuses on office furniture, including desks, tables, bookcases, files, and credenzas. This team works with BCE's Product Development Center as its design partner. The shop includes manual and CNC wood working equipment using modern CAD software to add greater flexibility in our design and production of wood furniture. This team employs persons from Fox Lake Correctional Institution.



Upholstery

BCE Upholstery's team provides professional, high quality upholstered products for use in offices, dorms, lounges, and a variety of open seating areas. Upholstered furniture is offered with a large variety of fabric choices which include many colors, styles, patterns, textures, as well as moisture barriers and self-sanitizing materials. The team also provides re-upholstery services. This team employs persons at Oakhill Correctional Institution.

88% Percent of former BCE workers have earned jobs within 3 years of returning to their families and communities.





Industries

Metal Stamping

Since 1921, BCE Metal Stamping has produced license plates for the State of Wisconsin. This team makes license plates for cars, trucks, motorcycles, and trailers used for personal and commercial vehicles. The license plate products include 70+ specialty plates (including personalized) and 10+ cycle plates. The team also produces 15+ hand-screened license plates for Native American tribes. This team employs persons at Waupun Correctional Institution.

Metal Fabrication

BCE Metal Fabrication is an industry that sells metal products such as files, laterals, shelves, sit stands, and monitor arms. This team currently does not fabricate or assemble any products, but sources products from vendors to meet customers' needs.

Sign Hydrostripping

BCE Sign Hydrostripping produces new signs and promotes environmental stewardship. Hydrostripping transforms outdated and weathered aluminum signs that no longer meet reflectivity standards into clean, reusable sign blanks. The hydrostripper applies high-pressure water to strip vinyl sheeting off decommissioned signs so the aluminum blank can be used again. The stripped blanks are then re-sheeted to make new signs. With our 100% Green Hydrostripping technology, the entire process is done without damaging the environment. This team employs persons at New Lisbon Correctional Institution.

Road and Trail Signs

BCE Road and Trail Signs produces signs for use on interstate, state and local roads, and trails used for snowmobiles, ATV's, UTV's, bicycles, and hiking. Those signs are made on new and recycled aluminum blanks provided by BCE's Sign Hydrostripping team. This team employs persons at Jackson Correctional Institution.



workers learning
with BCE on
an average day.



Industries

Custom Signs

BCE Custom Signs produces traffic, street and trail, architectural and informational signs, banners, name badges and name plates. The team uses modern materials, equipment and digital design, photography and silkscreen methods. Painted surfaces, heat activated and pressure sensitive reflective sheeting materials are utilized in the production of signs. Signs are fabricated in various sizes, shapes, colors and textures. This team employs persons at Stanley Correctional Institution.



Printing

BCE Printing products and services include typesetting, graphic design, color and black and white copying, one and two-color printing, folding, drilling, cutting, envelopes, spiral bound books and much more. Other services include state park maps, brochures, posters and newsletters. Printed material is produced for any nonprofit organization and federal, state or local government agency, including universities and K-12 schools. This team employs persons at Columbia Correctional Institution.



Durable Medical Equipment Refurbishing

BCE Durable Medical Equipment (DME) Refurbishing prepares power and manual wheelchairs, bath equipment, and other miscellaneous mobility equipment for sale to customers. Most items are received as donations. Collected equipment is assessed, sanitized, and repaired to like-new condition. The sale of BCE's refurbished DME is on the www.wisconsinAT4ALL.com website with substantial savings passed on to customers compared to purchasing new. BCE partners with Includa, a Wisconsin based non-profit to help those with mobility challenges obtain equipment. This team hires persons at Redgranite Correctional Institution.

Computer Recycling

Computers and select other electronic products that are obsolete or designed as non-repairable are received from the DOC. These items are de-manufactured down to the salable commodities in each device. The commodities are sold in a bidding process to electronic recyclers. This service occurs at BCE's Industries Distribution Center (IDC) and employs persons from John Burke Correctional Center.

655,000

Hours of workers' time used to learn and earn with BCE during FY21.





Industries

Laundry & Linen Rental Services

BCE Laundry provides laundry services to state agencies and universities. Linen rental services are offered to federal, state and local government agencies and campuses, as well as nonprofit organizations. Laundry services sold to facilities operated by the Departments of Corrections, Health Services, and Veterans Affairs include the picking up of dirty items and the delivery of clean items on a regularly scheduled basis. Items include clothing, bedding and coats for persons in our care, and a facility's rags and mops. This team employs persons at Oshkosh Correctional Institution.

Textiles/Embroidery

BCE Textiles produces items sold to the full range of government and non-profit customers, including K-12 schools. Products include, but are not limited to detention clothing, mattresses and pillows, linens, and towels. This team also provides embroidery and heat transfer enhancements to a wide range of products. This team developed and produced more than 40,000 cloth face masks to help reduce the spread of COVID-19 in step with CDC guidelines. This team employs persons at Green Bay Correctional Institution.



Logistics

Badger State Logistics (BSL)

BSL is team working at a BCE warehouse that serves as the sales and delivery point for a number of consumable products sold to BCE customers. Products include, but are not limited to toilet paper, hand towels, food service supplies, can liners, motor oils, ice melting salt and softener salt. Workers on this team are persons at John Burke Correctional Center.

Industries Distribution Center (IDC)

IDC serves as the central hub for transportation, storage, delivery and installation of BCE products. IDC transports state-wide ranging from 24' straight trucks to 53' tractor-trailers and provides transportation services to other state agencies. IDC's installation team delivers and installs BCE furniture products, repairs furniture on-site and offers project management for large scale installations. Workers on this team are persons at the John Burke Correctional Center.



\$28.7 million

in sales to government & non-profit customers.



Transition

The BCE Transition team works to help BCE workers who choose to participate to better prepare themselves for the job search and to connect them with employers and community service providers upon return to their families and communities. Transition participants are assisted with preparing a resume' and obtaining forms of identification needed to earn employment. Transition team members assess participants by providing job leads near their approved release addresses, information about local social service agencies and providing short-term supplemental funds for work-related items like tools, special clothing, transportation, and rent.



Financial Report 2021



	AGRICULTURE	INDUSTRIES	LOGISTICS	TOTAL
REVENUES	\$ 5,708,126	\$ 16,289,330	\$ 5,905,964	\$ 27,903,421
EXPENDITURES	\$ 4,467,343	\$ 12,412,136	\$ 5,480,301	\$ 22,359,780
PROFIT (LOSS)	\$ 1,240,784	\$ 3,877,194	\$ 425,663	\$ 5,543,641

BCE paid



to workers in 2021,
increasing their
ability to pay
financial obligations.



— Bureau of —
**Correctional
Enterprises**

MAIN OFFICE / SHOWROOM
3099 EAST WASHINGTON AVE.
MADISON, WI 53708

608.240.5200

ABOUT BCE

BCE is the Wisconsin Department of Corrections' manufacturing enterprise. BCE operates 13 industries in 11 different correctional facilities, providing vocational training and work skills development to a willing prison population. BCE provides a variety of products and services to a limited market of federal, state and local government, universities, and state agencies.

For more information visit:
www.shopbce.com