

IOWA PRISON INDUSTRIES BOARD MEETING
June 19, 2020





History of NCCF Correctional Release Facility housing approximately 500 low risk incarcerated individuals.

92 staff are at the facility that opened in 1982. Bob Johnson is the warden for this and the Ft Dodge facility.

IPI's presence began with wood working as a woodworking shop satellite of Ft Madison's wood division.

As the distance logistics of material between those facilities and less capacity needs occurred, the shift to metal working because in 2006 with production of steel detention cells.



Main Building is 100' x 200'



Our powder coat area is mainly for our refurbishing work but also do park furniture, fire rings.

Assist Anamosa Metal Furniture Division at times.

Galaxy Wash System
Prodigy Paint system

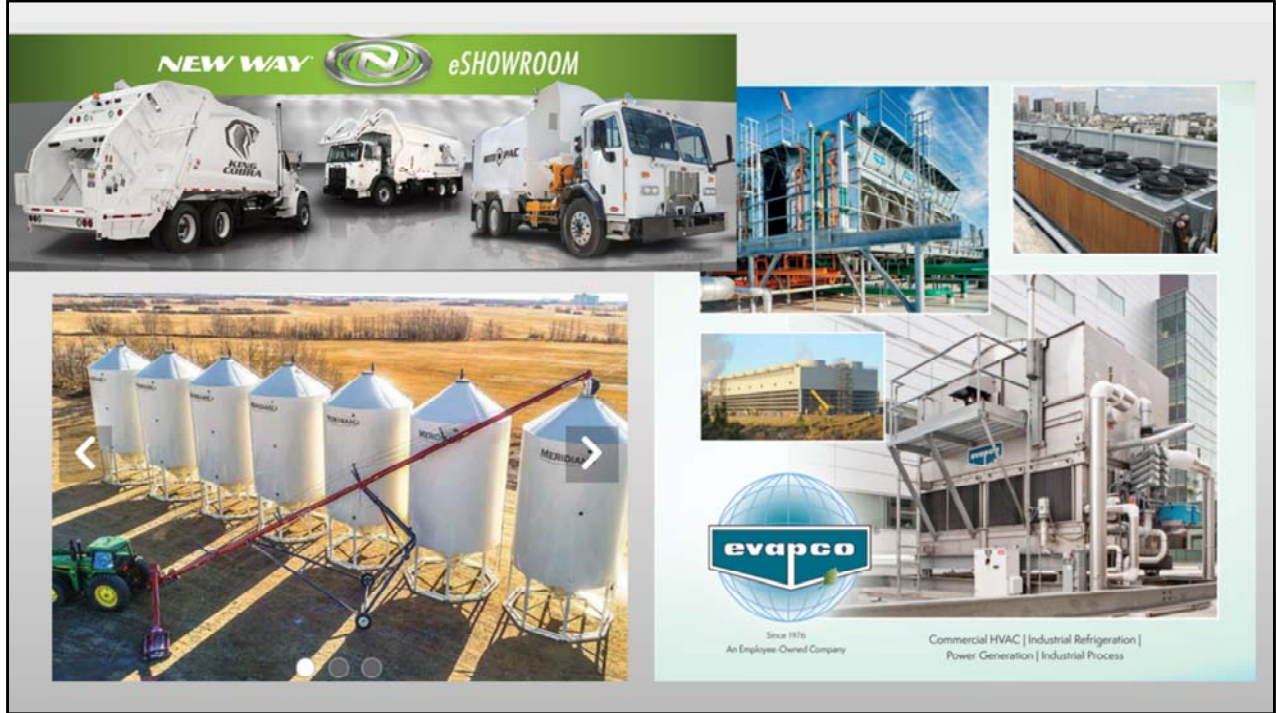


The economic conditions of 2008 decreased demand of those items and the metal fabrications shifted to refurbishing products with Dept. of Transportation snow plows, trailers and dump truck boxes.

While the metal working of these items provided value to the DOT and metal working and paint finishing skills to our incarcerated individuals, the volume of work was seasonal.

Boat docks for Dept. of Natural Resources and other agencies was moved to NCCF and provided larger amounts of work but that was typically ordered every other year and seasonal also.

So the sustainability for IPI at NCCF was one of our main challenges.



With the development of Private Sector opportunities, the program is increasing valuable work skills for our program associates.

Scranton Mfg. (also known as New Way Mfg.) is a worldwide manufacturer of refuse and garbage trucks. We began with several components of the truck which included end gates, cylinder kits, and ram weldments and now includes over a dozen items.

In January of this year we began working with EVAPCO out of Lake View that produces industrial evaporators and refrigeration equipment mainly around the food processing industry. Again, a worldwide organization they had a need for component assembly.

Meridian Mfg. out of Storm Lake, also began working with us in February of this year and produces agricultural industry equipment. We have provided welding and painting of auger components and grain tank weldments.



Typically the parts arrive in precut kits and with the associated drawings and jigs to hold everything in place, the welder then fabricates the part. They are palletized and prepped for pick up by Scranton Mfg.



What we provide.

These companies are quickly learning that they can depend on IPI and that we will provide a quality product and quickly adjust to their production scheduling changes.

With the COVID pandemic we began kit pick-up and delivery for EVAPCO as there distribution was curtailed with the virus.

Wages for the incarcerated individuals vary by job and are determined by IWD for the prevailing wage in the area. A welder currently can earn \$13.37/hour. Welders in our traditional IPI program would earn at the most, \$1.92/hour.



EVAPCO products.

There is some welding on the cat walks, but currently the majority of this work is assembly of kits that are pre-cut and delivered to us.

Once we have completed the assembly we build pallets for the large finished product and it is picked up by EVAPCO.

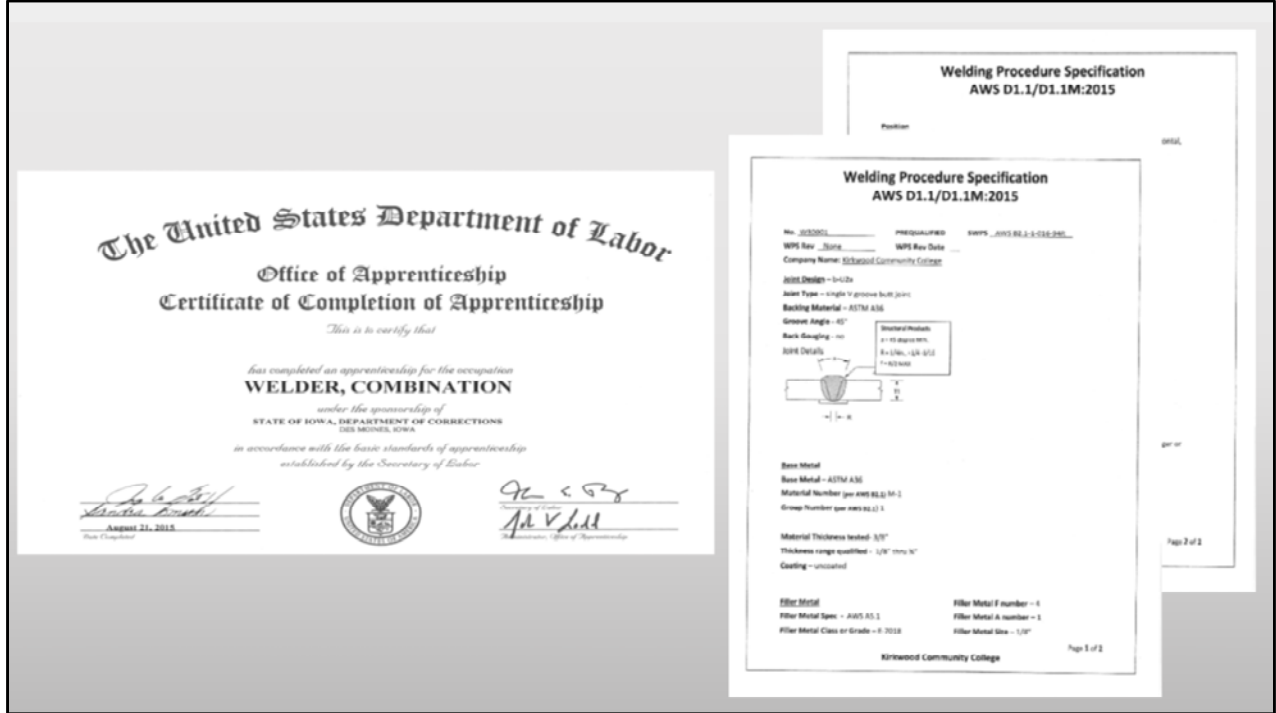


Kelly Goodman is our Production Coordinator and Bill Schumacher is the Senior Technician.

They both have been with IPI since March of 2019 and have made this program work and grow.

We have a good relationship with these companies and it mainly due to the work that Kelly and Bill along with their team have done to accommodate the customer.

Regular feedback from the customers on the good quality and meeting their schedule.



We have worked to align our apprenticeship hours with the types of work they are actually doing. Regardless if they complete the total 6000 hours in a welding apprenticeship.

Approximately 12 welders in the Private sector work and 8 in the traditional IPI program.

In 2019 apprenticeship hours with the majority being the welding apprenticeship.
 2,939 Curriculum hours
 28,191 on the job training hours.

They will accumulate hours and be able to transfer those to any future employers if they also have apprenticeship programs.



We have upgraded our equipment to have the durability to meet this pace of production.

MIG and Pulse MIG welders are used to produce the long welds that are clean and consistent.

Identical to the equipment that these companies use on their production floor.

Hopefully, it will help the incarcerated individual in being familiar and settle in quickly.

Station/Cell #		Plant	RCO	Process Name	Doc #	No	Date	Change	Name
Disassemble Large Plow		Department	Fab/Weld	Disassemble Large Plow	RCO S/CAP	1	07/11/16	create original	Acron Lester
Standard Work Sheet		Workstation	Disassemble Large Plow	Product Year	2016	Task Time	0	Cycle Time	0
No.	Step	Visual	Time	Key Point	Comments				
1	Contact material management specialist & advise him that your area is open and ready for a plow								
2	Get the number off the plow and get the paperwork from the office								
3	Weld # on plow body radius nut & truck nut								
4	Place empty pallet in area and put plow # on it & use it for parts that come off plow								
5	Remove all plow accessories & place on submer pallet								
6	Place stand under front of main plow body			X					
7	Remove pins from top spring nuts			X					
8	Remove pin bottom spring nuts								
9	Remove spring from top and bottom nuts								
10	Remove pins from rear track light nuts			X					
11	Remove both track rod and braces			X					
12	Remove pins bottom radius nuts								
13	Remove radius nut from main plow body			X					
14	Remove both holding truck nut to frame								
15	Separate truck nut from A frame								
16	Remove both holding A frame to radius nut								
17	Separate A frame from radius nut			X					
Weighted Work Time		Totals		0	0	0	0	0	0
Weighted Walk Time		Totals		0	0	0	0	0	0
Weighted Total Cycle Time		Totals		0	0%	0%	0%	0%	0%

TOOL BOX

WELDING BAY

The team has also continued to move forward in our PIMMS development. The involvement in PIMMS has benefited the shop in a couple ways.

First it demonstrates to potential customers we have a system in place to develop value in what we want to provide to them. Most of these companies have similar systems and this is familiar to them.

Secondly, the associate in our work program are developing problem solving skills and better preparing them for the job market. This will also help them in familiarity of the work environment they will encounter going forward.

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