

"Give us this day
our daily bread"



**Rikers Island
Bakery**

One of the main concerns in the operation of correctional institutions is keeping the inmate population constructively occupied. This goes beyond the institutional academic and vocational education programs. All of our inmates do not fit in a structured academic program. Many of our inmates have never had to discipline themselves in attending a school regularly or in holding a job.

Beyond the production of bread in our bakery or in having the inmates learn to operate the modern machinery, is the idea of getting up in the morning and becoming involved in seeing that a strict baking schedule is carried out. In so doing, they tend to develop a work-habit pattern that has never been a part of their makeup.

If we must maintain certain industrial production units to maintain our system as economically as possible, then we want it to be the best in order to offer realistic training to our inmate population. We are proud of our new Rikers Island Bakery and in the contribution of the inmates in annually producing five million pounds of bread products.

George F. McGrath
Commissioner

DEPARTMENT OF CORRECTION



CITY OF NEW YORK

RIKERS ISLAND BAKERY

at the

NEW YORK CITY
CORRECTIONAL INSTITUTION FOR MEN

HON. JOHN V. LINDSAY
Mayor

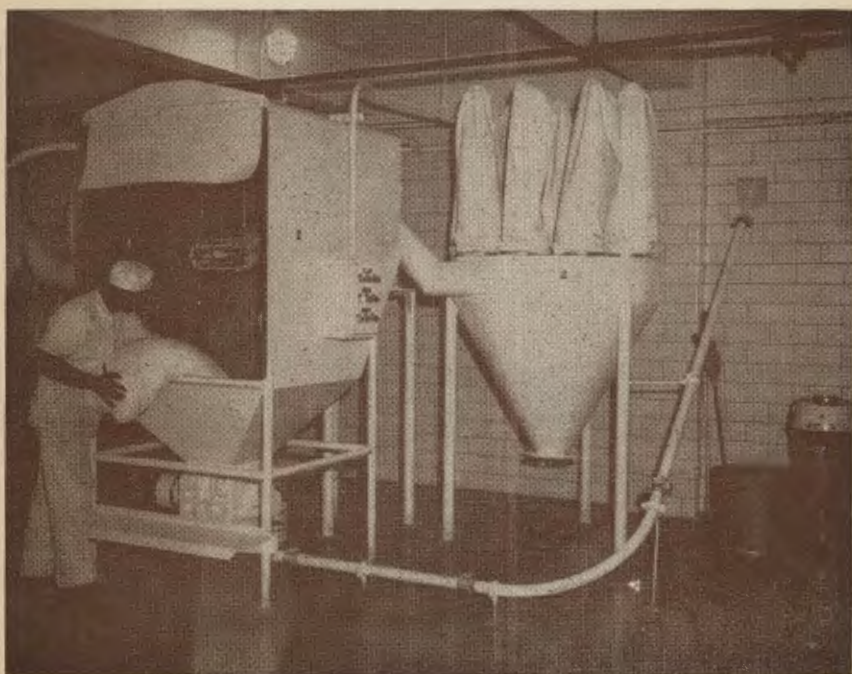
HON. GEORGE F. MCGRATH
Commissioner



The dough is placed in the proof box for 45 minutes. It is given time to rise before it is placed in the oven.

cially made bread had to be purchased at a substantially higher cost. In order to avoid the problem of constant breakdowns and the substantially higher cost of commercially made bread, the new Bakery was developed with a two line system. Each of these two separate lines are capable of producing 25,000 pounds of bread. While one line is

annum utilizing 2,000 one hundred-pound bags of flour a month. Approximately 8,500 loaves of bread are baked daily. Each loaf weighs two pounds two ounces, in contrast with the former three pound loaves. This size loaf is baked on equipment that enables the department to more readily operate, maintain and replace parts because it con-



The baking process begins here. An inmate is emptying a bag of flour into the sifter.



After dough has been mixed, a process lasting 18 minutes, it is placed automatically into a tub that can hold 1,600 pounds of dough.

forms with the baking industry's standards. The two pound loaf is also fluffier in substance, resulting in more slices per pound.

The Rikers Island Bakery not only bakes bread but also produces raisin buns, ginger bread and apple pie. These products supply the departmental needs for a daily population of 10,000 inmates and 3,100



Once the pans have lids placed on, by hand, they are placed on racks. Here Mr. Lloyd, Superintendent of the bakery, instructs an inmate new to the job.

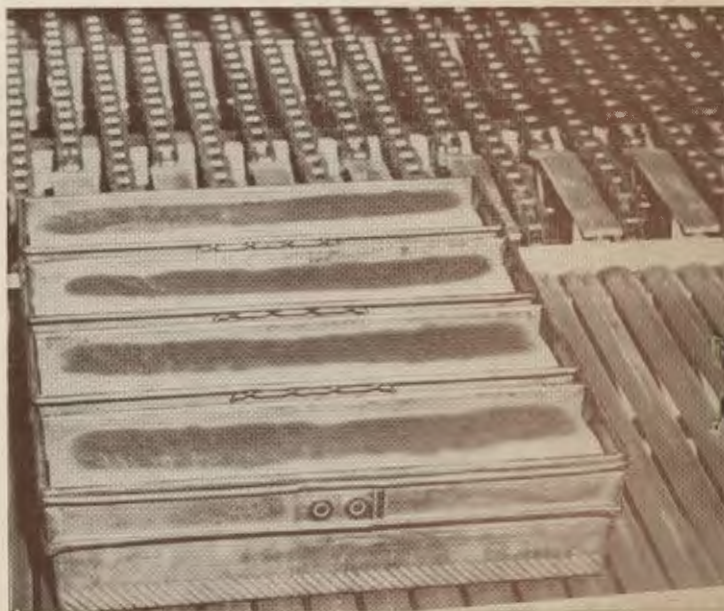
being used the other receives preventive maintenances. If a line breaks down, the other is quickly placed into operation and production continues unhampered. There is a full-time maintenance staff providing coverage from early morning to late at night.

LOCATION

The former bakery was located a con-



After being in the proof box for 45 minutes, the pans are placed in the oven. The oven holds eight pans across, each consisting of four units. At one time the oven can hold 275 of these pans.



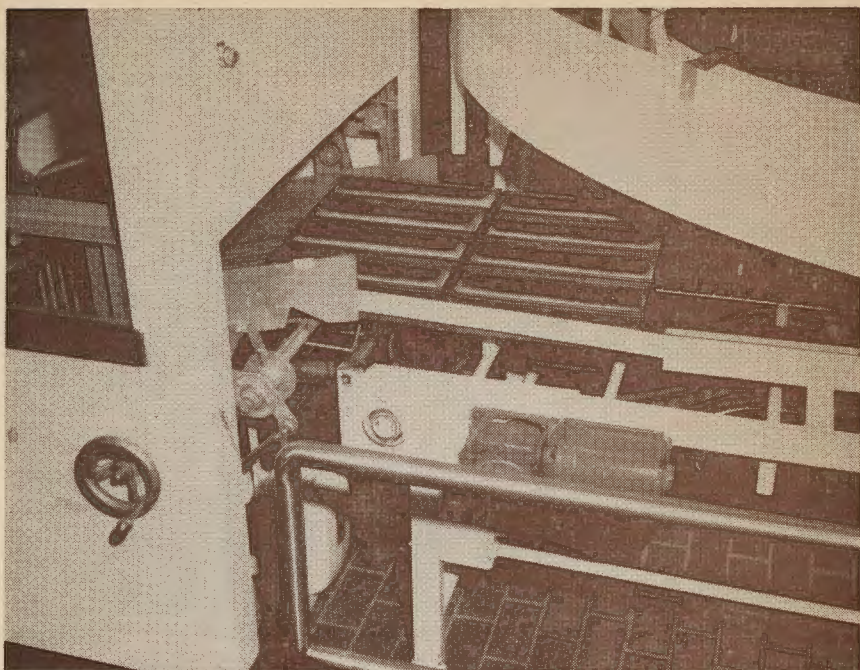
The pans leave the oven and slide onto a conveyor. The conveyor removes the lid. The lid is then sent back so that air jets raise the bread slightly out of the pans.



The balls of dough are moved along a conveyor belt. It is flattened and rolled into long cylindrical units. They are then dropped into pans automatically.



...r belt that carries it past a magnetic device that it can be reused immediately. Once uncovered, pans to prevent it from sticking to its sides.



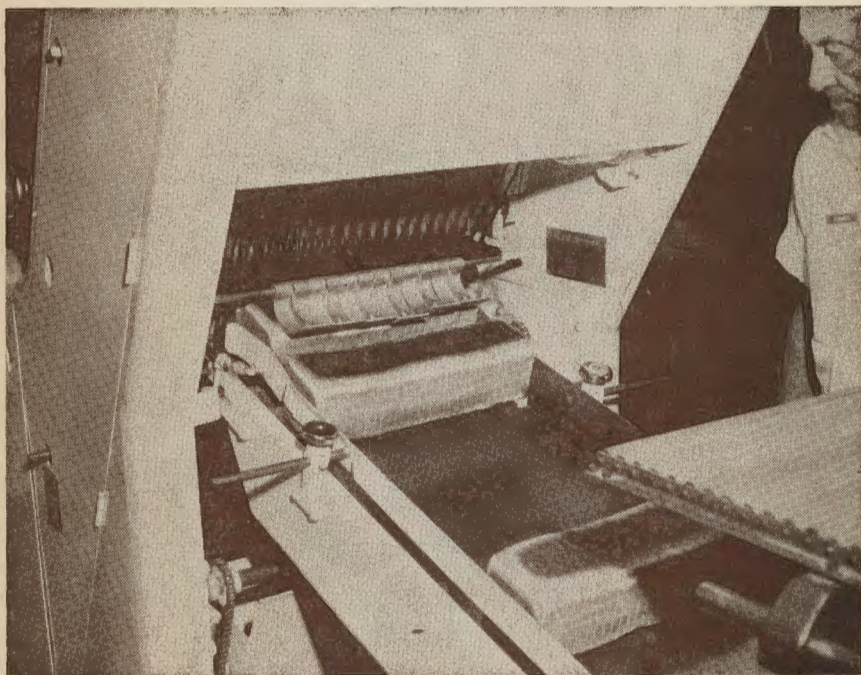
The pans are inverted so as to let the bread fall on a conveyor below, and the pan is sent back for reuse.

siderable distance from the main kitchen necessitating the bread to be shipped to the kitchen by truck. Now, the new Bakery is located adjacent to the main kitchen and both use common storage facilities.

SANITATION

In the administration of the Bakery, a superior level of sanitation is maintained.

bers of the custodial staff. The 105 inmates working in the Bakery come under the inmate wage incentive program and are paid three, six or ten cents an hour, depending upon their skills. The inmates, in general, are quite pleased with the work that they perform. Working conditions are much better than they were in the old bakery.



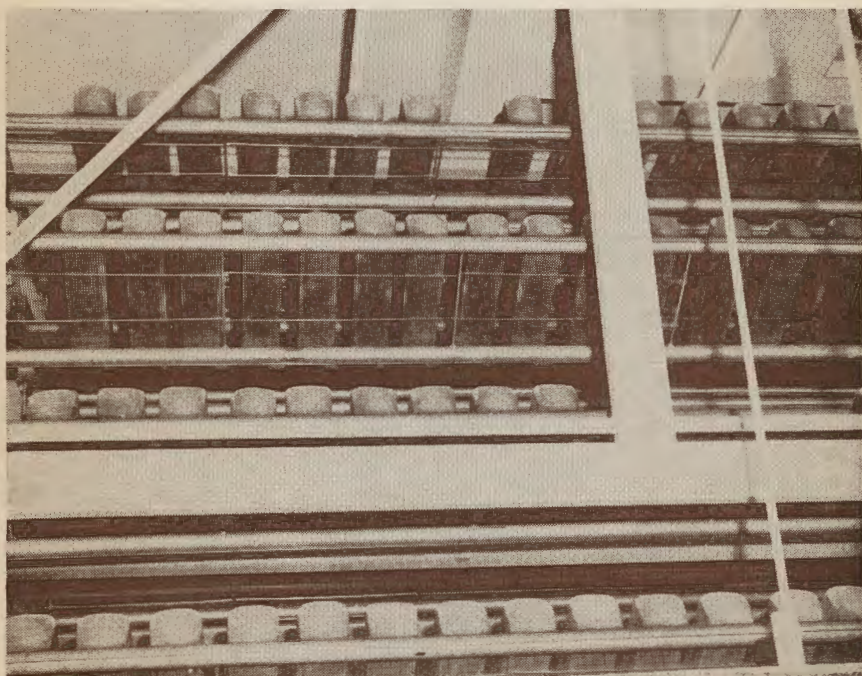
The sliced bread is being readied for the wrapping process.



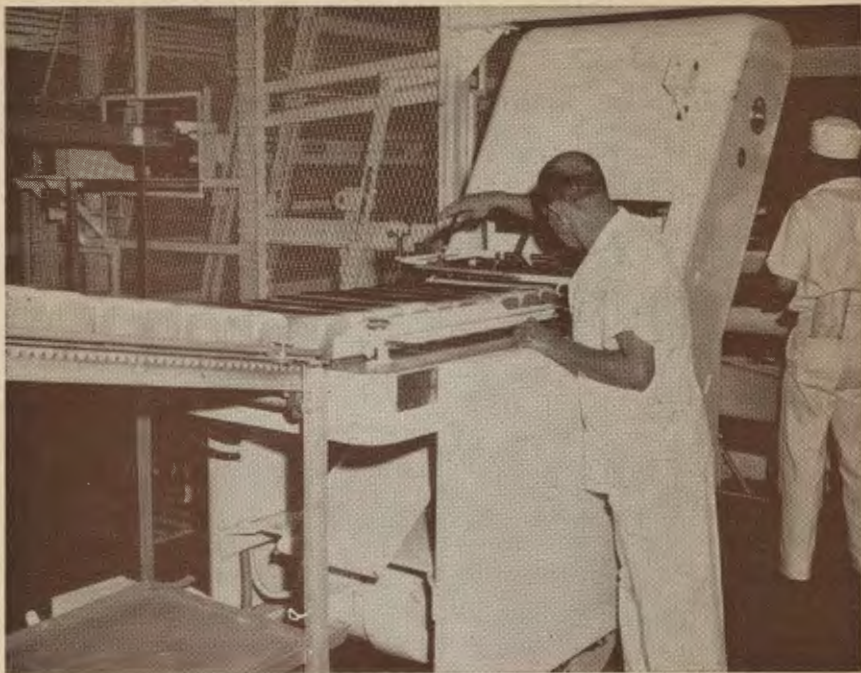
An inmate rolls a rack of fresh bread into the freezer in order to retain its freshness while waiting for shipment.

The Bakery uses the latest baking equipment and techniques thus enabling the inmate to learn the basic skills required for employment in a modern commercial bakery upon his release. Bakeries are willing to

This program includes continuous sanitation measures, including a general clean-up twice a day with soap and water. Before an inmate starts work in the Bakery, he receives a complete physical examination. Each inmate must shower every morning before he reports to work. The inmates are provided with a washroom and locker facilities. The



The bread moves along to the cooler. It stays on this constantly moving belt for approximately 70 minutes to allow it to cool for slicing.



The bread is brought from the cooler to the slicing machine.

baking process is arranged so that from the mixing of the dough until the finished loaf is sliced and wrapped, *the bread is not touched by human hands—the entire process is fully automated.*

INMATES AND SUPERVISION

The production in the Bakery is supervised by ten civilian bakers and three mem-

employ these inmates since they are trained and know how to operate modern baking machinery. The quality of training is reflected by the readiness with which the Baker's union will accept Rikers Island trained inmates.



Inmates load the packed crates into truck. Deliveries are made to all departmental institutions, Department of Parks and the Board of Education School Lunch Program.

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Urban Corp Project
D.C.N.Y. — Public Relations Unit

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*Printed at the Rikers Island Print Shop —
Inmate Vocational Training Program*

