



# BEP Replacement Facility Quarterly Newsletter

## October 2024

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<https://go.usa.gov/xtC2Q>  
Email: [BEP-updates@usace.army.mil](mailto:BEP-updates@usace.army.mil)

### This Quarter's Focus: How Money is Made

This quarterly newsletter is a collaboration between the U.S. Department of the Treasury's Bureau of Engraving and Printing (BEP) and the U.S. Army Corps of Engineers (USACE), Baltimore District, with the intent to keep the community informed of the progress on the BEP replacement Currency Production Facility (CPF) at the Beltsville Agricultural Research Center (BARC). USACE signed an interagency agreement with BEP in March 2019 to coordinate this replacement effort, including environmental assessments and design and construction oversight for the Main facility and supporting structures, parking and stormwater management facilities, roadway access and improvements, utility connections, security systems and access control.

### How Money is Made @ The Bureau of Engraving and Printing

#### STEP 1: Design & Engraving

U.S. currency is designed to address security concerns and stay ahead of counterfeiting threats. The process begins with finalizing the currency design and engraving the design into steel plates via traditional techniques and cutting-edge digital technology. Once engraving is completed, the steel plates are polished and prepared for printing.



#### STEP 3: Intaglio Printing

After Offset printing, the paper is laid on top of the inked engraving plate and the two are pressed together under pressure. In intaglio printing, the ink from the recessed areas is pulled onto the currency sheets, creating a raised finished image. After the printed ink is dry, the faces of the notes are printed with black ink. The currency sheets will dry again for another three days before going to inspection.



#### STEP 5: Letterpress Printing

The final printed layer of U.S. currency is letterpress printing. During this process, the press prints currency note serial numbers, the Federal Reserve seal, the Department of the Treasury seal, and the Federal Reserve identification numbers.

#### STEP 2: Offset Printing

Multiple layers of colored ink patterns and background images are printed to the currency paper notes in the offset printing process. Currency printing ink and paper are both proprietary to the BEP and are specially formulated to meet US Currency security needs. The BEP designed currency uses combinations of inks to enhance the currency design and security features.

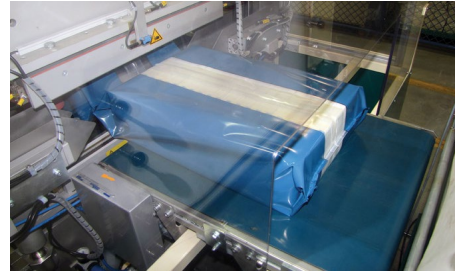
#### STEP 4: Inspection

Currency sheets are thoroughly examined using a state-of-the-art computer system integrated with cameras and sophisticated software. The system completely analyzes for quantity and quality of untrimmed printed sheets inspecting both sides of the currency sheets.



#### STEP 6: Packaging

Notes are cut from the currency sheets, banded, packaged, shrink wrapped, and bar coded. Then the packaged notes are combined into a final currency brick containing 4,000 notes, packaged together in four bricks in a 16,000 note 'cash pak'. From there, these 'cash paks' are placed into the vault to await pick-up by the Federal Reserve.



More Information can be found at: [The Buck Starts Here: How Money is Made | Engraving & Printing \(bep.gov\)](https://www.bep.gov)

## What is the Bureau of Engraving and Printing?



BEP is the bureau within the U.S. Department of the Treasury responsible for designing and printing U.S. currency notes issued by the Federal Reserve Board. BEP currently operates currency production facilities in Washington, D.C. and Fort Worth, Texas. BEP's current Washington, D.C. facility is more than 100 years old and limits BEP's ability to modernize its operations. So BEP, in coordination with USACE, is planning the construction and operation of a more efficient, modern facility at BARC to meet currency production needs.

## Project Status Updates



### Environmental

BEP completed an Environmental Impact Statement (EIS) in accordance with the National Environmental Policy Act (NEPA), with the Record of Decision (ROD) signed in October 2021. The Supplemental Environmental Assessment (SEA) was completed with a Finding of No Significant Impact (FONSI) signed 09/12/2024. The EIS and the SEA are available on the Project's Website.



### Small Business Spotlight :

Throughout the CPF project, USACE and BEP aim to develop small businesses and maximizing their opportunities to participate in federal projects. Each quarter a small business is spotlighted for their participation in the CPF design and construction.

#### Spotlight's on: SES CIVIL AND ENVIRONMENTAL LLC

SES Civil and Environmental (SCE) is an 8(a) small business who provided hazardous material abatement/disposal, existing building demolition and tree clearing services. SCE offered proactive insights during each project stage. SCE provided clear and consistent communication, enabling it to meet project milestones ahead of schedule.



### Upcoming Events & Milestones

- Fall 2024: Complete Project Permitting
- Early 2025: Construction Start



## Estimated Project Schedule



Permitting: CPF Site permitting and Utility Coordination.

CPF Construction Acquisition

Construction Start

Construction End

Fully Operational

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