

BSQ-290 Square Bottom Paper Bag Making Machine



BSQP-290 Square Bottom Paper Bag Making Machine with Printing



I. 袋子样品 Bag Samples



II. 产品介绍 Product Introduction

BSQ-290 型可调式卷筒方底纸袋机, 它具有速度快、生产效益高、调节范围大的优点。此设备是将原色或印刷好的卷筒纸由本机一次完成侧边上胶, 折叠成微、纸筒切断、底部涂胶、袋底成型、出袋, 整机由计算机中央控制系统控制、触摸屏显示, 伺服电机控制纸袋长短, 可生产多种规格纸袋, 是纸袋生产加工的首选设备。

BSQ-290 type adjustable roll-to-square bottom paper bag making machine has the advantages of high speed, high production efficiency, and wide adjustment range. It is designed to manufacture square bottom paper bags from paper rolls in blank or printed and can complete side gluing, tube forming, cutting, bottom impressing, bottom gluing, bottom forming, and final product output within one time. Controlled by a PLC system, equipped with a touch screen and servo motor for bag length control, this machine can produce a variety of specifications paper bags. It is a piece of ideal equipment for making paper bags for foodstuff or shopping bags.

III. 性能特征 Performance Characteristics

1. 原料装卸采用液压升降，放卷采用全自动张力控制。
2. 边胶采用意大利 ZATOR。
3. 纠偏采用意大利 SELECTRA，国内简称意大利 ST
4. 纸筒成型器包含拇指切功能（位于成型模板下方）。
5. 无料侦测自动停机。
6. 中心夹指，鼓轮夹具，和鼓轮机械指皆使用蛛式同步调整机械设计，可大幅减少更换尺寸的调机时间。
7. 采用德国 KEB 伺服搭配德国 SICK 光电，精确跟踪印刷材料。
8. 配备自动润滑供应系统，堵塞报警系统。

1. Use hydraulic lifting for material handling and an automatic tension control system for unwinding.
2. Side gluing uses Italy ZATOR.
3. Automatic error correction uses Italy SELECTRA.
4. Paper tube forming device with thumb-cut function.
5. Automatic stop for having no material.
6. Center clip, drum wheel clamp, and drum wheel mechanical finger all use spider synchronous adjustment mechanical design, which can significantly reduce the adjustment time for replacing size.
7. Use a German KEB servo with a SICK photoelectric eye, which can accurately track the printed material.
8. Equipped with automatic lubrication supply system and jams alarm system.

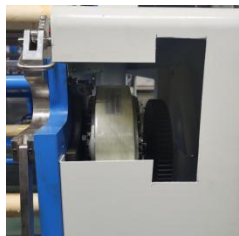
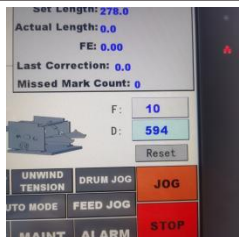
IV. 技术参数 Technical Parameters

机器型号	MODEL	BSQ-290	
纸筒长度	Paper tube length	260-530mm	
纸袋面宽	Paper bag width	120-290mm	
纸袋底宽	Bottom width of paper bag	60-180mm	
纸张克重	Paper thickness	60-150gsm	
纸袋速度	Bag making speed	30-200pcs/min	
纸卷宽度	Paper roll width	320-960mm	
卷芯内径	Core inner diameter	φ76mm	
放料最大直径	Paper roll diameter	φ1300mm	
气压	Air pressure	0.4mpa	
总功率	Machine power	3phase 4line 380V, 15 kw	
机器重量	Machine weight	7000kg	
机器外形尺寸	Machine dimensions	9200 × 2700 × 2000mm	

V. 设备配置单 Machine configuration

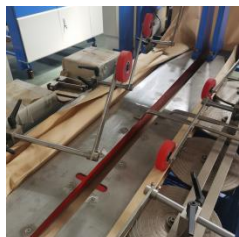
放料装置 Unwinding device	1 套/set
袋子成型装置 Bag forming device	1 套/set
理袋装置 Bag collection device	1 套/set
电控装置 Machine Electric control device	1 套/set
胶水部位（选配） Gluing device (Optional)	1 套/set

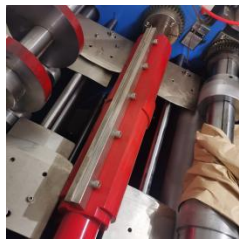
V.1 放料装置 Unwinding device

No.	Item.C	Item.E	Specification	Photo
1	气涨轴	Air shaft	Diameter $\phi 76\text{mm}$ ORIGIN:CHINA BRAND:FEIXIANG	
2	液压上料和控制系统	Automatic loading by hydraulic pressure cylinder and Hydraulic pressure control system 3 phase IC	ORIGIN:CHINA BRAND:BOKEMA	
3	磁粉张力器	Magnetic powder tensioner	ORIGIN:CHINA BRAND:RY	
4	张力控制系统 手动	Tension controller Manual	ORIGIN:CHINA BRAND:BAOJI	
5	张力控制系统 电控	Tension controller Computer	ORIGIN:CHINA	
6	纠偏控制器	Correction system	ORIGIN:CHINA BRAND:ARISE	

7	纠偏伺服电机	Correction servo motor	ORIGIN:CHINA BRAND:ARISE	
8	纠偏传感器	Correction Sensor	ORIGIN:CHINA BRAND:ARISE	
9	预警和自动停止单元	Warning and auto-stop unit		

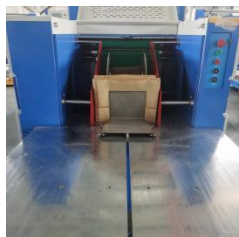
V.2 袋子成型装置 Bag forming device

No.	Item.C	Item.E	Specification	Photo
1	袋子成型装置	Bag forming device		
2	模板和导向轮	Bag width mould and Wheel	ORIGIN:CHINA	
3	模具放置装置 - 2 根梁	Mold placement device - 2 beams	ORIGIN:CHINA	

4	袋宽调节装置	Adjust bag width device	ORIGIN:CHINA	
5	插边结构	Insert structure	ORIGIN:CHINA	
6	印刷跟踪电眼	Printing sensor	ORIGIN:GERMANY BRAND:SICK	
7	拇指扣	Thumb Knife	ORIGIN:CHINA	
8	牵引辊	Traction roller	ORIGIN:CHINA	
9	点齿刀	Sawtooth	ORIGIN:CHINA	
10	上料辊	Feeding roller	ORIGIN:CHINA	

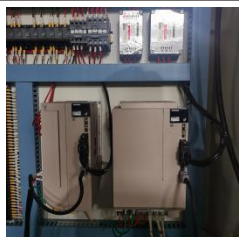
11	压痕滚	Creasing roller	ORIGIN:CHINA	
12	轮毂	Drum	ORIGIN:CHINA	
13	底胶装置	Bottom glue device	ORIGIN:CHINA	
14	触控屏	Touch screen	ORIGIN:TAIWAN BRAND:WEINVIEW	

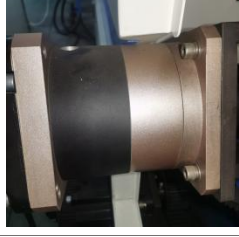
V.3 理袋装置 Bag collection device

No.	Item.C	Item.E	Specification	Photo
1	理袋方式	Collection method		
2	主电机	Main motor	ORIGIN:JAPAN BRAND:YASKAWA	

3	牵引电机	Traction motor	ORIGIN:JAPAN BRAND:YASKAWA	
4	传动同步带 同步轮	Synchronous belt Synchronous wheel	ORIGIN:CHINA BRAND:GUANGHE	
5	轴承	Bearing	ORIGIN:GERMANY BRAND:BEM	
6	导辊	Guide Roller	ORIGIN:CHINA BRAND:FULV	

V.4 电控装置 Machine Electric control device

No.	Item.C	Item.E	Specification	Photo
1	电气柜	Electric cabinet		
2	伺服驱动	Servo drive	ORIGIN:JAPAN BRAND:YASKAWA	
3	运动控制器	Motion controller (CPU)	ORIGIN:UK BRAND:TRIO	

4	可编程逻辑 控制器	PLC	ORIGIN:CHINA BRAND:INOVANCE	
5	电子元器件	Electrical element	ORIGIN:FRANCE BRAND:SCHNEIDER	
6	继电器	Relay	ORIGIN:FRANCE BRAND:SCHNEIDER	
7	伺服电机减 速器	Servo motor retarder	ORIGIN:GERMANY BRAND:	
8	传感器	Sensor	ORIGINAL:JAPAN BRAND:PANASONIC	
9	开机无线操 作控制	Powerup wireless operation controller	ORIGIN:CHINA BRAND:CHANGYIN	

V.5 胶水装置 Gluing device (Optional)

No.	Item.C	Item.E	Specification	Photo
1	热熔胶机	Hot melt glue machine	ORIGIN:CHINA BRAND:HUANGSHANG	

2	热熔胶管	Hot melt adhesive pipe	ORIGIN:CHINA BRAND:HUANGSHANG	
3	热熔胶喷枪 环保型	Hot melt gun	ORIGIN:CHINA BRAND:HUANGSHANG	
4	自动上胶系统	Auto gluing system	ORIGIN:CHINA BRAND:CHANGYIN	
5	边封水性喷胶枪	Edge sealing water-based spray glue gun	ORIGIN:CHINA BRAND:CHANGYIN	
6	水性白乳胶 气动喷胶桶 (不锈钢)	Pneumatic high pressure hydrolysis glue tank (Stainless steel)	ORIGIN:CHINA BRAND:CHANGYIN	



VI. 备品和易损件清单 List of spare and wearing parts

Item.C	Item.E	Photo	Quantity
工业胶带	Industrial tape		1 pcs
边夹座	Side clamp seat		1 pcs left 1 pcs right
铝托板	Aluminum support plate		12 pcs
导向轮	Forming paper pressing wheel		5 pcs
闭合尼龙	Closed nylon		1 set
挑袋片	Bag picking tablet		6 pcs
拇指扣切刀	Thumb buckle cutter		2 pcs
压线模具	Crimping die		1 set
齿刀	Sawtooth		1 pcs

压线刀	Crimping knife		2 pcs
开底夹扭簧	Bottom opening clamp torsion spring		2 pcs left 2 pcs right
滑块弹簧	Slider spring		4 pcs
拇指扣拉簧	Thumb buckle tension spring		5 pcs
边夹座拉簧	Side clamp seat tension spring		5 pcs
挑袋心轴弹簧	Bag picking mandrel spring		4 pcs
压袋扭簧	Bag pressing torsion spring		1 pcs left 1 pcs right
前后夹 中心夹	Front and rear clamps Center clamps		8 left torsion springs 4 right torsion springs
成型挡板 大、中、 小	Forming baffle, big, medium and small		Each one set
开底挡杆	Bottom opening lever		random

开底挡板	Bottom opening baffle		random
继电器 8 角 24v	Relay 8 angle 24V		2 pcs
扳手加 700 长	Wrench extension 700 long		3 pcs
气管接头	Tracheal connector		Adjust 2 add / drop
底上胶海 绵	Rubber sponge for the bottom		1*1m
开底拇指 夹片	Opening bottom thumb clip		1 pcs left 1 pcs right
边夹片	Side clip		1 pcs left 1 pcs right
插刀	Knife insertion		Random
刀座	Knife holder		1 pcs
扶纸挡杆	Paper retaining rod		1 pcs

链条接头	Chain joint		Full joint and half joint 4 points and 5 points each 2pcs
美工刀	Art knife		1 box
生料带	PTFE tape		1 pcs
汽枪 汽嘴	Steam gun Steam nozzle		1 pcs each
干燥粉	Dry powder		1 box
工具	Tool		1 set
工具箱	Tool box		1 pcs