

BSQH

Fully Automatic Portable Square Bottom Paper Bag Machine



Our company is one of the most specialized manufacturers and exporters of paper bag machines and printing machines in China. The wide range of products under manufacturing cover Adjustment type Roller Paper Bag Machine, High-Speed Food Paper Bag Making Machine, Middle Sealing Paper Bag Making Machine, Automatic Square Bottom Paper Bag Making Machine, Flexographic Printing Machine, Overlapping Type Synchronous Belt High Speed Printing Machine, etc.

The company takes a reputation in mechanical design and manufacturing advanced technology have nearly twenty years of experience with a professional technical team. The current team consists of more than 50 people, which have participated in the research and development, and obtained several model patent certificates and invention patent certificates. OEM or ODM projects are fully accepted, currently, the company is co-operating with a number of renowned international corporations for such projects.

Keep the mission and vision in mind, and strive to provide world-class quality products and services to customers.

I. 袋子样品 Bag Samples



II. 产品介绍 Product Introduction

BSQH-180/290/330/460 全自动手提袋纸袋机, 以卷筒纸为原料, 结合手挽纸片和纸绳, 用于生产带手挽的手提纸袋。本机采用 PLC 和运动控制器, 伺服驱动控制系统, 智能化操作界面, 生产速度快, 效率高, 是生产食品、化妆品、酒类、礼品及服装等手提袋的理想设备。

本机生产流程是: 卷筒进料、贴手挽、成筒、切断、底部压痕、底部涂胶、袋底成形、输出。

BSQH-180/290/330/460 Fully-automatic paper bag machine is used to produce hand-held paper bags by using roll paper as raw material, combined with hand-held paper pieces and paper ropes. The machine adopts PLC and motion controller, servo drives control system, intelligent operation interface, high production speed, and high efficiency, and is the ideal equipment for the production of food, cosmetics, wine, gifts, and clothing bags.

The production process: paper feeding, stick handle, tube forming, cutting, bottom indentation, bottom gluing, bag bottom forming, and output.

III. 性能特征 Performance Characteristics

1. 成型模板采用对称可调双模板结构（专利技术），不同尺寸纸袋的用户无需更换模板，可有效缩短纸袋尺寸调整时间，提高机器产量。
2. 特殊设计大大提高了制袋机的制袋范围，可满足客户生产特大型手持式纸袋的需求。
3. 采用日本进口电子控制系统，运行平稳、高速。
4. 放料采用液压自动升降结构，配备自动张力控制。
5. 材料放卷采用纠偏控制，减少材料对中时间。

1. The forming template adopts symmetrical adjustable double- template structure (proprietary technology), so that users of different sizes of paper bags no longer need to change the template, which can effectively reduce the time of paper bag size adjustment and increase the machine capacity.
2. The special design greatly improves the bag-making range of the machine, which can meet the customer's demand of producing extra-large hand-held paper bags.
3. The electronic control system from Japan is adopted to ensure stable and high-speed operation.
4. Material loading adopts hydraulic automatic lifting structure, with automatic tension control.
5. Material loading adopts ARISE EPC system, reduce material alignment time.

IV. 技术参数 Technical Parameters

机器型号	MODEL	BSQH-330	BSQH-460
纸筒长度	Paper tube length	260-430mm	260-430mm
纸袋面宽	Paper bag width	200-330mm	250-460mm
纸袋底宽	Bottom width of paper bag	60-180mm	80-180mm 100-200mm
纸张克重	Paper thickness	80-150gsm	80-150gsm
纸袋速度	Bag making speed	30-200pcs/min	30-200pcs/min
纸卷宽度	Paper roll width	320-1050mm	600-1350mm
卷芯内径	Core inner diameter	φ76mm	φ76mm
放料最大直径	Paper roll diameter	φ1300mm	φ1300mm
气压	Air pressure	0.4mpa	0.4mpa
总功率	Machine power	3phase 4line 380V 15 kw	3phase 4line 380V 15 kw
机器重量	Machine weight	15000kg	16500kg
机器外形尺寸	Machine dimensions	15000×8000×2600mm	15000×8000×2600mm
圆绳技术参数 Technical Parameter of Round Rope			
手把贴片长度	Handle paster length	152mm	190mm
手把贴片宽度	Handle paster width	50mm	50mm
纸绳间距	Paper rope spacing	76mm	95mm
手把纸绳直径	Handle paper rope diameter	3-5mm	3-5mm
手把贴片纸卷宽度	Handle poster paper roll width	100mm	100mm
手把纸卷直径	Handle paper roll width	1000mm	1000mm

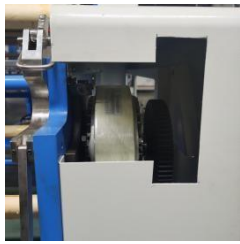
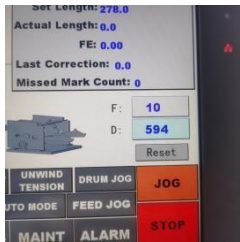
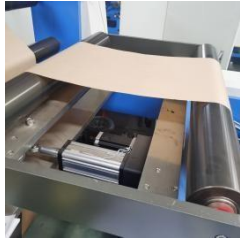
手把贴片纸克重	Handle paster gram per square meter	80-135gsm	80-135gsm
扁绳技术参数 Technical Parameter of Flat Rope			
扁绳间距	Flat rope spacing	76mm	95mm
扁绳宽度	Flat rope width	12mm	12mm
扁绳高度	Flat rope height	100mm	100mm
贴片宽度	Paster width	50mm	50mm
贴片长度	Paster length	152mm	190mm
放卷贴片宽度	Unwinding paster length	100mm	100mm
原纸克重	Paper gram per square meter	120gsm	120gsm
手把纸卷直径	Handle paper roll diameter	1000mm	1000mm
Photo			

V. 设备配置单 Machine configuration

放料装置 Unwinding device	1 套/set
手把成型装置 Handle forming part	1 套/set
把手装置 Handle 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

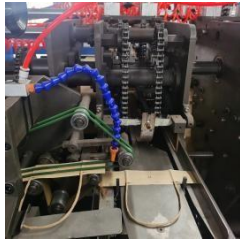
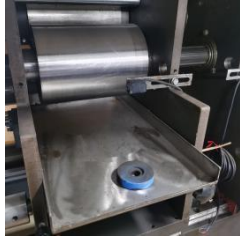
No.	Item.C	Item.E	Specification	Photo
1	气涨轴	Air shaft	Diameter $\phi 76\text{mm}$ ORIGIN:CHINA BRAND:FEIXIANG	
2	液压上料和控制系统	Automatic loading by hydraulic pressure cylinder and Hydraulic pressure control system 3 phase IC	ORIGIN:CHINA BRAND:BOKEMA	

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 手把成型装置 Handle forming part

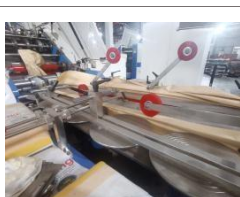
No.	Item.C	Item.E	Specification	Photo
1	手把成型装置	Handle forming part		
2	纠偏系统	Correction system	ORIGIN:CHINA	
3	贴把输送	Twist handle convey	ORIGIN:CHINA BRAND:CHANGYIN	
4	热熔胶机	Hot melt adhesive machine	ORIGIN:CHINA	
5	定位轮	Positioning wheel	ORIGIN:CHINA BRAND:CHANGYIN	
6	切割辊	Cutting roller	ORIGIN:CHINA BRAND:CHANGYIN	

V.3 把手装置 Handle device

No.	Item.C	Item.E	Specification	Photo
1	输送轮	Conveyance wheel	ORIGIN:CHINA BRAND:CHANGYIN	
2	切刀	Cutting knife	ORIGIN:CHINA BRAND:CHANGYIN	
3	上料	Feeding handle	ORIGIN:CHINA BRAND:CHANGYIN	
4	输送	Conveyor	ORIGIN:CHINA BRAND:CHANGYIN	
5	贴把上胶部分	Handle pasting part	ORIGIN:CHINA BRAND:CHANGYIN	

6	自动上胶压力罐	Auto glue feeding pressure tank	ORIGIN:CHINA BRAND:CHANGYIN	
---	---------	---------------------------------	--------------------------------	---

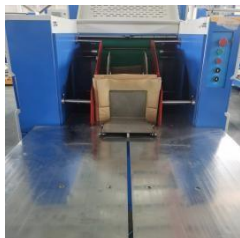
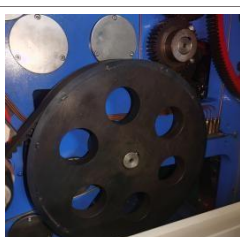
V.4 袋子成型装置 Bag forming device

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:JAPAN BRAND:MTSBSHSH	

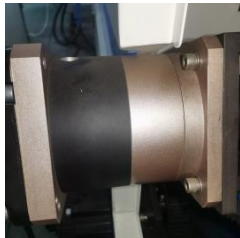
V.5 理袋装置 Bag collection device

No.	Item.C	Item.E	Specification	Photo
1	理袋方式	Collection method		
2	主电机	Main motor	ORIGIN:JAPAN BRAND:MTSBSHSH	
3	牵引电机	Traction motor	ORIGIN:JAPAN BRAND:MTSBSHSH	
4	传动同步带 同步轮	Synchronous belt Synchronous wheel	ORIGIN:CHINA BRAND:GUANGHE	
5	轴承	Bearing	ORIGIN:JAPAN	

			BRAND:NSK	
6	导辊	Guide Roller	ORIGIN:CHINA BRAND:FULV	

V.6 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:MITSUBISHI	
3	可编程逻辑控制器	PLC	ORIGIN:JAPAN BRAND:MITSUBISHI	
4	电子元器件	Electrical element	ORIGIN:FRANCE BRAND:SCHNEIDER	

5	继电器	Relay	ORIGIN:FRANCE BRAND:SCHNEIDER	
6	伺服电机减速器	Servo motor retarder	ORIGIN:GERMANY BRAND:	
7	传感器	Sensor	ORIGIN:JAPAN BRAND:PANASONIC	
8	开机无线操作按钮	Powerup wireless operation button	ORIGIN:CHINA BRAND:CHANGYIN	

V.7 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

成型压纸轮	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
裁断刀	Cutting knife		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
特氟龙胶带	Teflon tape		4 pcs
垫脚	Bedding		20 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
标准件	Standard parts		Random
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
扳手加长 700 长	Wrench extension 700 long		3 pcs
气管接头	Tracheal connector		
底上胶海绵	Rubber sponge for the bottom		1*1m
开底拇指夹 片	Open the bottom thumb clip		2 pcs left 2 pcs right
边夹片	Side clip		2 pcs left 2 pcs right
插刀	Knife insertion		Random
刀座	Cutterbed		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	Tools		2 sets
工具箱	Tools box		1 pcs
手挽分割圆 刀	Handle division round knife		1 pcs
手挽切刀	Handle cutting knife		1 pcs
手挽过绳器	Handle over rope device		1 set
主切刀	Main cutting knife		1 pcs

预切	Precutting sawtooth		2 pcs
工具推车	Tools cart		1 set

Warranty:

Warranty period for the delivered equipment will be 12 months after completion of manufacturing but not later than 18 months after shipment. In case any item proves to be defective and the damage is confirmed by seller's technicians within this period, the seller will at their choice either send engineer to repair.

The above item does not include the parts, which have regular spares or the parts damaged from normal wear, abnormal operation, improper maintenance and inadequate civil works. The seller is not liable for any production loss under any circumstances.

Packing: As per export standard, they will also be treated before delivery against damage and rust.