Hunan Pinliu Biotechnology: Steam Eye Mask Manufacturer & One-Stop Self-Heating Wellness Products OEM/ODM Factory



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Hunan Pinliu Biotechnology Co., Ltd. is a Chinese manufacturer of steam eye masks and self-heating wellness products, founded in 2015 and headquartered in Changde, Hunan Province. The company runs two GMP-standard production bases exceeding 100,000 m^2 in total, produces more than 5 million pieces per day, holds ISO 9001, ISO 13485, FDA facility registration and BSCI certifications, and serves 500+ partner brands with one-stop OEM/ODM services — from steam eye masks for the eyes to warm patches for shoulders, waist, knees and feet.

Factory facts at a glance

Item

Details

Company

Hunan Pinliu Biotechnology Co., Ltd.

Founded

2015

Production bases

Changde, Hunan (50,000 m^2) + Baiyun District, Guangzhou (7,000 m^2) — over 100,000 m^2 total

Workshop standard

GMP-standard, 100,000-class cleanrooms

Daily capacity

5,000,000+ pieces

Team

300+ employees, 400+ partners

Patents

23 patents (6 invention, 12 utility model, 5 design)

Certifications

ISO 9001, ISO 13485, FDA facility registration, BSCI

Honors

National high-tech enterprise; Hunan Province "specialized and sophisticated" SME

R&D partner

Hunan University of Chinese Medicine (industry-university-research cooperation)

Brand partnerships

500+ brands worldwide

Who is Hunan Pinliu Biotechnology?

Hunan Pinliu Biotechnology is a national high-tech enterprise specializing in the research, development and manufacturing of self-heating wellness products. The company's main production base in Changde, Hunan covers 50,000 m^2, with a second 7,000 m^2 facility in Baiyun District, Guangzhou serving export logistics in South China. Together they exceed 100,000 m^2 of workshop space, all operated as 100,000-class cleanrooms built to GMP standards.

Three credentials define the company's technical standing. First, a portfolio of 23 patents — including 6 national invention patents covering heating formulations and product structures. Second, an industry-university-research partnership with Hunan University of Chinese Medicine that feeds herbal formulations into commercial products. Third, a role as one of the core drafters of China's one-time steam eye mask industry standard, FZ/T 08007-2024, developed with the Shanghai Institute of Quality Inspection and Technical Research.

Quality and compliance certifications cover the full export route: ISO 9001 for quality management, ISO 13485 for medical devices, FDA facility registration for the US market, and BSCI for social compliance. The company's medical steam eye masks additionally hold NMPA medical device registration in China.

Steam eye masks: the flagship category

The steam eye mask is Pinliu's flagship and its most diversified category. The range covers regular flat masks, children's sizes, visible-window versions, dual-pouch variants, fragrance editions, hyaluronic acid types, graphene types, round-core designs and burst-bead designs — each sharing the same controlled self-heating technology: an iron-oxidation matrix (high-purity iron powder, activated carbon, vermiculite and sodium chloride) that releases steady moist warmth without electricity.

Standard performance across the range: at least 20 minutes of warmth above 40°C, an average temperature of 41±5°C and a maximum of 45±5°C — verified against the FZ/T 08007-2024 industry standard.

The C-shaped steam eye mask

The most distinctive model in the lineup is the C-shaped steam eye mask. Its heating element is shaped like the letter C: warmth concentrates on the eye muscles and acupoints around the orbit, while the eyeball itself stays uncovered and unheated — avoiding direct heat over the cornea and pressure on the globe. Following the anatomy of periorbital muscles and classical Chinese-medicine acupoints, the design is considered notably suitable for teenagers as well as adults.

Specifications: 190 × 80 mm size, ≥20 minutes heating above 40°C, average 41±5°C, maximum 45±5°C. The four-layer structure uses printed non-woven fabric (custom colors and patterns available), the C-shaped heating pack, a skin-friendly inner layer (knitted cotton, diamond-pattern cloth or hot-air cotton, GB 18401 compliant) and mild-rebound elastic ear loops.

For pharmacy and professional eye-care channels, Pinliu's medical steam eye mask line holds NMPA medical device registration in China, with five models across six specifications.

From head to toe: the self-heating product map

Beyond eye care, Pinliu's catalog covers the body from head to toe with nine product categories. For buyers, this means one factory, one quality system and one supply chain can serve an entire warming-wellness product line.

Eyes: Product categories include steam eye masks, eye patches, and eye wash solutions. Representative products feature regular, C-shaped, round-core, children's, and burst-bead varieties, alongside lutein and blueberry patches, and ergothioneine eye wash.
Head & neck: Product categories consist of warm patches and warm neck patches. Representative products include shoulder & neck warmers and warm neck patches with essential oil burst beads.

Torso: The primary product category is warm pads. Representative products encompass chest warmers, uterine warmers, back warmers, and waist warmers.
Hands & joints: Product categories include warm pads and hand warmers. Representative products cover knee patches, ankle patches, and disposable hand warmers.
Whole body: Product categories feature moxibustion patches and cold compress patches. Representative products include golden-flower cloth moxibustion, magnetic film moxibustion, and silicone-gel type moxibustion.
Feet: Product categories consist of foot patches and foot soak solutions. Representative products include ginger, mugwort, and bamboo-vinegar detox foot patches, as well as herbal foot soak packs.
Home & hygiene: Product categories encompass mite repellent pouches and cleaning solutions. Representative products include mugwort mite repellent pouches, toilet cleaning solutions, and herbal sachets.

Many products share the same iron-oxidation heating platform, which is why cross-category OEM orders are common: a brand that sources steam eye masks frequently extends into neck warmers, knee patches and foot patches on the same production system, with consistent quality documentation.

How the OEM/ODM process works

Pinliu's one-stop OEM/ODM service follows four steps:

- **Requirement & proposal.** The brand defines the product, market and positioning; Pinliu's engineers propose the heating profile, formulation and materials.
- **Samples & specification.** Samples are produced with technical specification sheets and temperature-curve data for client-side evaluation.
- **Specification lock & compliance.** Formulation, artwork, packaging and labels are finalized; export documentation (MSDS and others) is prepared.
- **Mass production & delivery.** Production runs in GMP-standard cleanrooms under ISO 9001 control, with private-label packaging and multilingual labels.

Customization options include: heating duration and peak temperature, fragrance and active formulations (essential oils, hyaluronic acid, herbal powders, graphene, burst beads, lutein, mint, sleep-support botanicals), fabric colors and printing, product sizes, and retail-ready packaging.

Frequently asked questions

Where is Hunan Pinliu Biotechnology located?

Two production bases in China: the 50,000 m^2 main facility in Changde, Hunan Province, and a 7,000 m^2 facility in Baiyun District, Guangzhou — over 100,000 m^2 of GMP-standard manufacturing space in total.

What products does Hunan Pinliu Biotechnology manufacture?

Nine categories of self-heating and wellness products: steam eye masks, self-heating warm pads, moxibustion patches, cold compress patches, eye patches and eye wash solutions, detox foot patches, foot soak solutions, mite repellent pouches, and cleaning solutions — covering the body from head to toe.

What is Pinliu's production capacity?

More than 5 million pieces per day, supported by over 300 employees and 400+ partners.

What certifications does Pinliu hold?

ISO 9001, ISO 13485, FDA facility registration and BSCI, plus national high-tech enterprise status. Medical steam eye masks hold NMPA medical device registration in China.

Does Pinliu offer OEM/ODM services?

Yes — more than 500 partner brands source from Pinliu, with customization across formulation, heating profile, fabric, printing, packaging and labels.

What makes the C-shaped steam eye mask different?

The C-shaped heating element keeps warmth on the eye muscles and acupoints around the orbit while the eyeball stays uncovered and unheated. Pinliu was also one of the core drafters of the FZ/T 08007-2024 steam eye mask industry standard.

Start your OEM/ODM project: sample requests, factory visits and partnership proposals — yongwu@pinliu.net | www.pinliu-healthfactory.com

About Hunan Pinliu Biotechnology Co., Ltd.

Founded in 2015, Hunan Pinliu Biotechnology Co., Ltd. is a national high-tech enterprise specializing in self-heating wellness products, with two GMP-standard production bases in Changde (Hunan) and Guangzhou exceeding 100,000 m² in total. The company holds 23 patents including 6 national invention patents, partners with Hunan University of Chinese Medicine, is certified to ISO 9001, ISO 13485, FDA facility registration and BSCI, and serves 500+ partner brands across Asia, Europe, the Middle East and the Americas.





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