

## **(Original) Use and maintenance manual**

**Type: V-Guide notching machine**  
**Model: VGN-22**



### **IMPORTANT**

Read this user manual and follow the instructions and warnings before operating this device.

Any modification or transformation performed on this machine may cause loss of the manufacturer's guarantee and liability.

This manual must always remain near to the machine and visible to all the operating and maintenance staff, for any future consultation, forming part of the equipment.

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- **CE Declaration of conformity:**

**ERM Belting Engineering S.L.**  
**Joan Portabella 12,**  
**08358 Arenys de Munt (Barcelona) SPAIN,**

Declare under our responsibility that the automatic notcher machine:

- Type: Automatic V-guide notcher
- Brand: ERM Engineering
- Model: VGN-22
- Serial No.: 810181
- Manufacturer date: 2025

The machine complies with all the relevant provisions of this Directive and, where applicable, a similar indication declaring conformity with other Community directives and/or relevant provisions with which the machinery complies. These references must be those of the texts published in the Official Journal of the European Union.

**2006/42/CE Machinery Directive**  
**2014/35/UE Low Voltage Directive**  
**2014/30/UE Electromagnetic Compatibility Directive**

**EN 349 - EN 614-1 - EN 614-2 - EN 1005-1 - EN 1005-2 - EN 1005-3 - EN 1005-4 - EN 14118 - EN 12100 - EN 13850 - EN 13857 - EN 14118 - EN 14120 - EN 60204-1 - EN 11161 - EN 61310-1 - EN 13849-1 - EN 13849-2 - EN 60204-1**

Name, address of the person authorized the technical file:

**Eduardo Ramos Martínez (General Manager)**  
**Av. Del Turó 43**  
**08392 St. Andreu de Llavaneres (Barcelona)**



ermengineering  
belting fabrication equipment

Arenys de Munt (Barcelona)-SPAIN  
Date: 18 December 2025

- **Description:**

V-Guide notching machine cutter to facilitate turning in tight diameters.

Profile drilling by matrix guided hollow bit with swarf removal through expulsion rods.

Pneumatic forward vertical movement and brake tabs to maintain the step between operations.

- **Technical characteristics:**

Dimensions	1400x860x1795mm. (LxWxH)
Weight	257 Kg
Max- profile width	22 mm.
Lineal speed	186 Mt .x Hour
Tension	1x230 v.

- **Standard and optional equipment:**

**STANDARD**

- Matrix V-Guide 10x6 + pulley
- Matrix V-Guide 13x8 + pulley
- Matrix V-Guide 17x11 + pulley

**OPTIONAL**

- Matrix V-Guide 8x5 + pulley
- Matrix V-Guide 6x4 + pulley
- Matrix V-Guide 22x14 + pulley

- **Warning and safety:**

ERM Engineering recommends the users of this machine to fully read this user's manual prior to its use to guarantee safe work.

It also advises and recommends equipment not being used by unqualified staff who have not received prior training from ERM Engineering.

A copy of this manual delivered along with the machine must always remain at hand during its use, both for the production operators as well as the maintenance managers.

**NOTE:**

**ERM Engineering shall not be held liable under any case for damage caused by undue or improper use of this equipment.**

Any repairs or modification of the machine performed by personnel not qualified by ERM Engineering or use of non-original spare parts provided by persons unrelated to the company, shall give rise to loss of the manufacturer's guarantee.

During use of the machinery and industrial use, people are subject to the risk of damage or injury by mechanical elements in linear or gyrating movement, high voltage electric components and static components under high temperature, due to which, during design and construction of its equipment, ERM Engineering has aimed to reduce and minimise those risks by including protection devices and safety systems based on the European Community Council Directives.

Pay special attention to the following danger, prohibition and obligation signs located at different places on the machinery:



- **Installation and start-up.**

Place the machine where the staff will not be disturbed by the noise during operation.

Leave 1 metre free between the rear and the wall or any other installation, to feed in the profile reels.

Level the chassis using 4 rubber studs or legs.



### **Electrical connection**

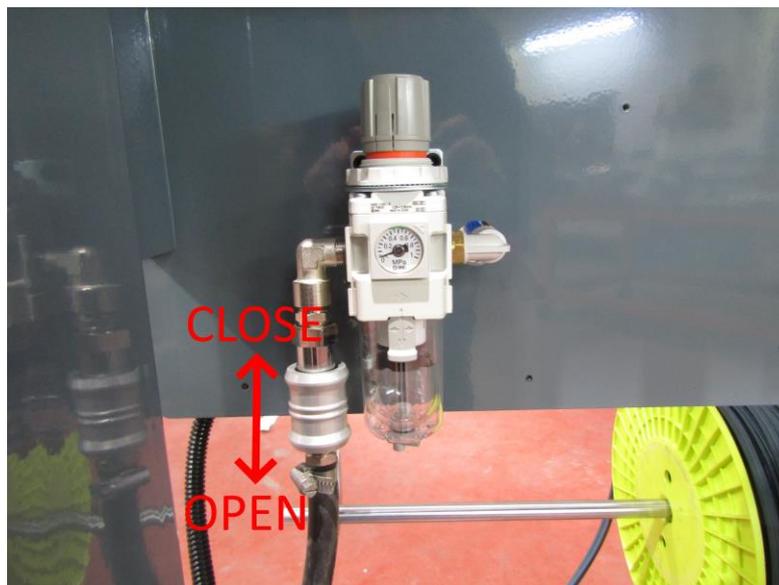
Connect the machine to the 1 x 230V. Monophase grid.



### **Air supply connection**

Compressed air is also fed through the pressure regulator intake on the left side of the machine, through a pipe with a minimum interior diameter of 8mm minimum and intake pressure tare between 0.5 and 0.7 MPa.

To close the system, up the sleeve of the hosepipe, before starting to work with the machine. Once the process is finished, you can disconnect it, downing to open it.



### - Preparation & Operation

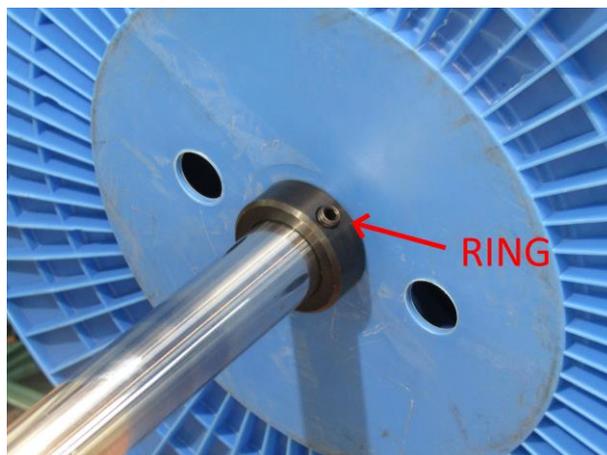
**NOTE:**

**Before preparation or change the matrix, always cut the electrical power and air supply.**

Place the profile coil at the rear of the machine, and center it with the upper input pulley, fixing it to a shaft to allow it to rotate and unwind freely:

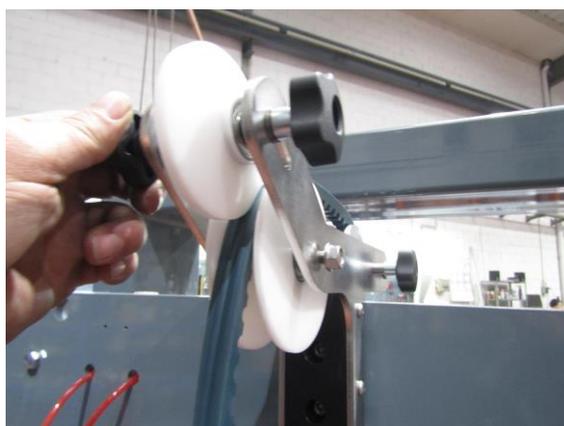


Fix the rings located in the axle in both sides of the coil, in order to avoid a longitudinal movement of the coil along the axle:

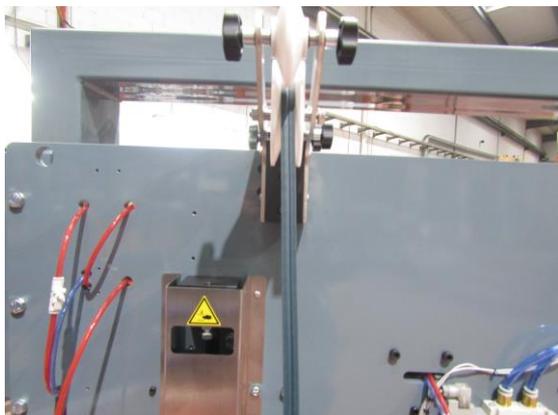


Then choose the corresponding intake pulley, according to the profile's size.

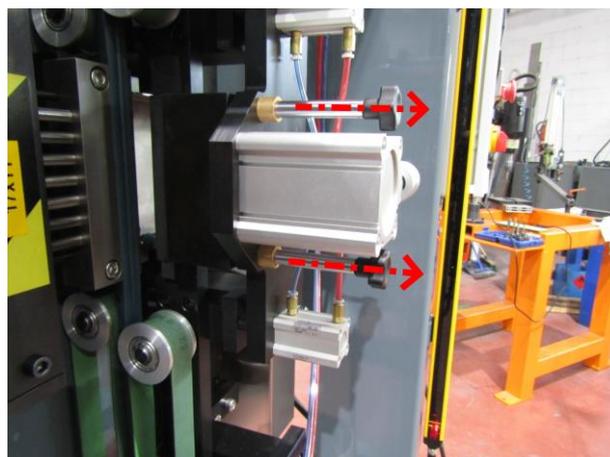
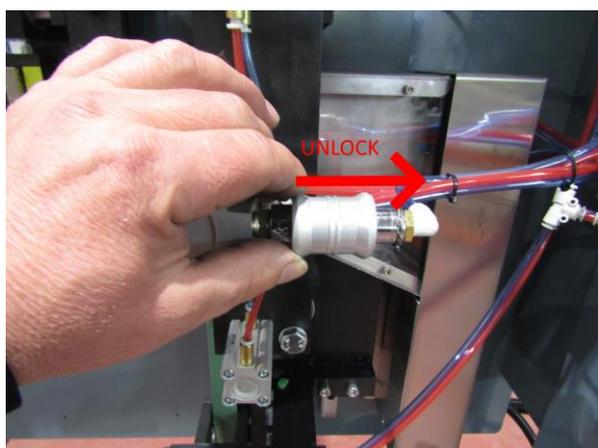
Begin to pass or insert the end of the profile through the intake pulley.



Take note that the axle over the pulley must keep a gap over the profile, to allow it to pass freely but helping it not to go out from the pulley.



Unlock this valve to up the tread plate, introduce the profile inside the matrix and to run it up to the bottom sandwich.



Close the pulleys with the manual valve and adjust the pressure suitable for each type and lock again the valve of tread plate.

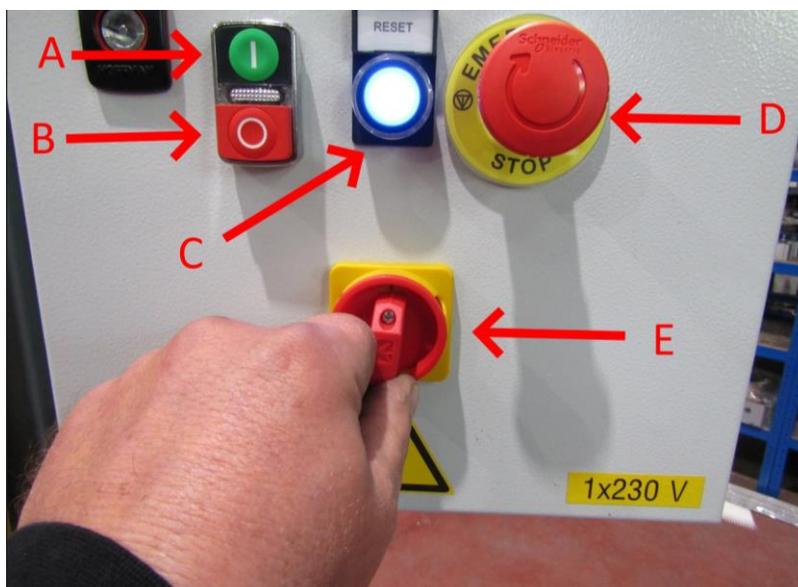


**NOTE:**

Is very important adjust the pressure for each kind of guide, other way the guide will be not in the centre position of sandwich belts.

Once the profile to process has been loaded and placed at the beginning, turn on the machine with the general switch **(E)** , and press the blue button **(C)** to restart the device.

Them, press **(A)**START to start the process.



- A- Start**
- B- Stop**
- C- Restart**
- D- Emergency Stop**
- E- General switch**

The STOP **(B)** button is used to halt the process.

**NOTE:**

**If the machine does not start, check the emergency stop is not locked (D).**

The machine is provided with two safety barriers located in both sides, that protect the operator STOPPING automatically the functioning of the machine in case that the operator crosses the space line between them.

To start after cutting the safety barrier, press START button again.



Adjust the pressure of sandwich belts according to the K type,

0.08 MPa for K8

0.08 MPa for K10

0.1 MPa for K13

0.12 MPa for K17

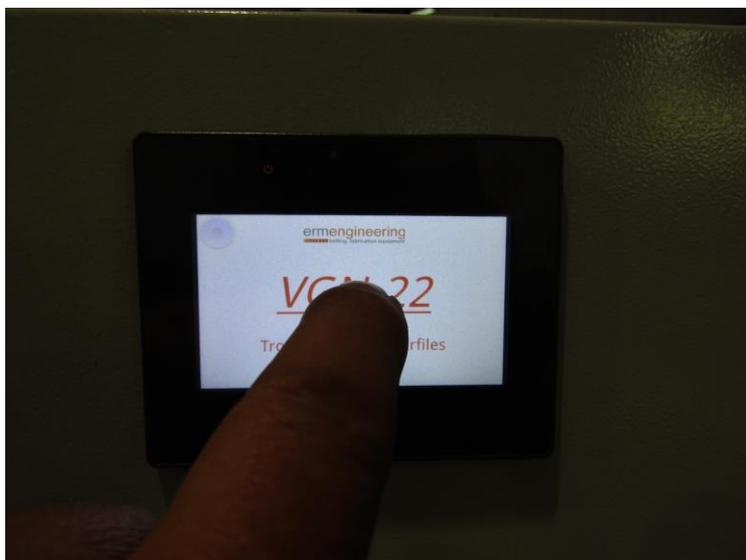


Other way we will have problems to keep the V-guide in the centre.

Also, we can adjust the stroke if the pitch is incorrect with the stopped of back cylinder.  
We use Key 19mm to modify this pitch.

- **Memories menu**

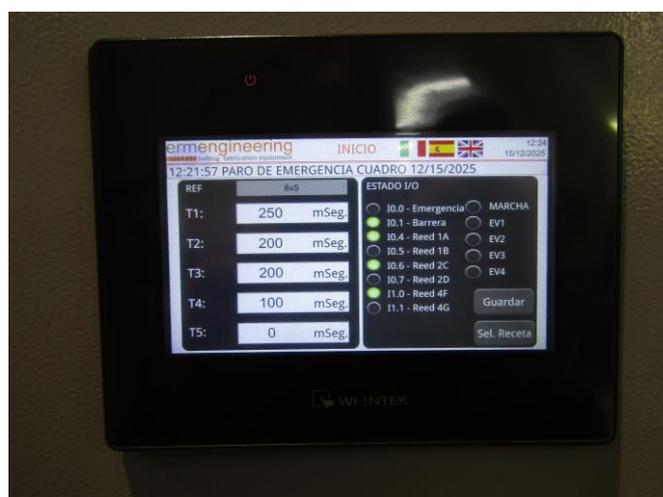
To begin, press in the centre of screen. This will activate the display system, it shows the memories for different kind of profiles  
This will enter different times (milliseconds) between operations, where you can set the operating times between the valves.



For example, if you want to configure new memory, click on the empty line and introduce the new memory name.



In each new memory, mut configure these new times between operations pressing the "Select" button located on the right side of the screen. A new screen will appear with the references and input/output information. In sections T1 through T5, you can modify the processing time in mSeg. To modify the time, we must press on the value we want to change and enter the new value.



Once you've made the changes, press the "Save" button located in the lower right corner to save the new data to the system memory. The screen also allows you to change the language between Spanish, English, and Italian, as well as display the date and time.



We can store up to 10 recipes in memory for different types of operations.

- **Replace the matrix:**

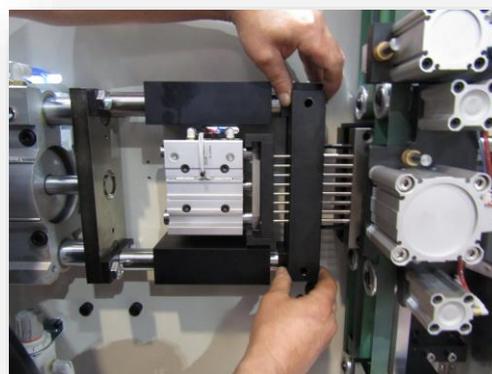
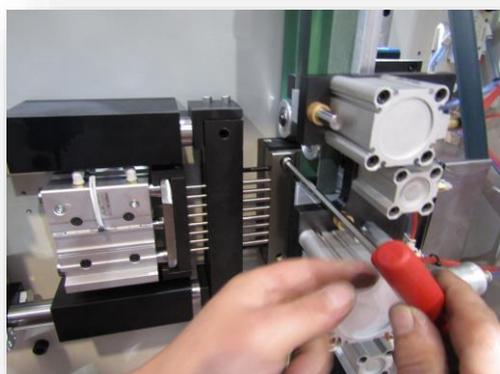
**WARNING:** To replace the matrix , it is essential to lock the emergency stop and cut off the compressed air supply with the input valve.



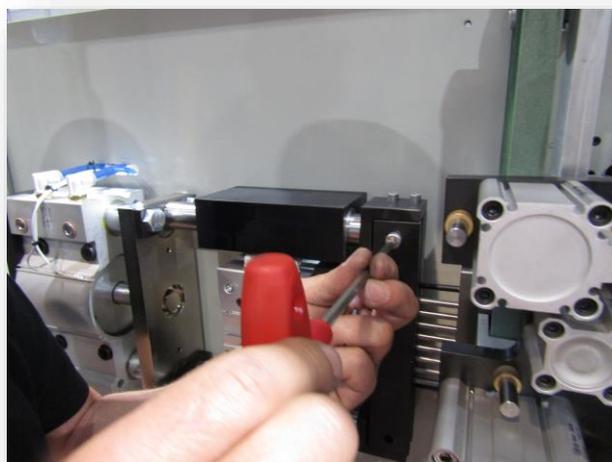
Before top shutting off the air compressed, open the sandwich belts.



Once this is done, we remove the four screws holding the matrix in place using the 6mm Allen key included with the machine and extract the matrix as picture bellow.



We will then proceed to insert the desired matrix. Once this is done, we tighten the 4 matrix bolts.



Also, is very important to assemble the right top pulley as profile type

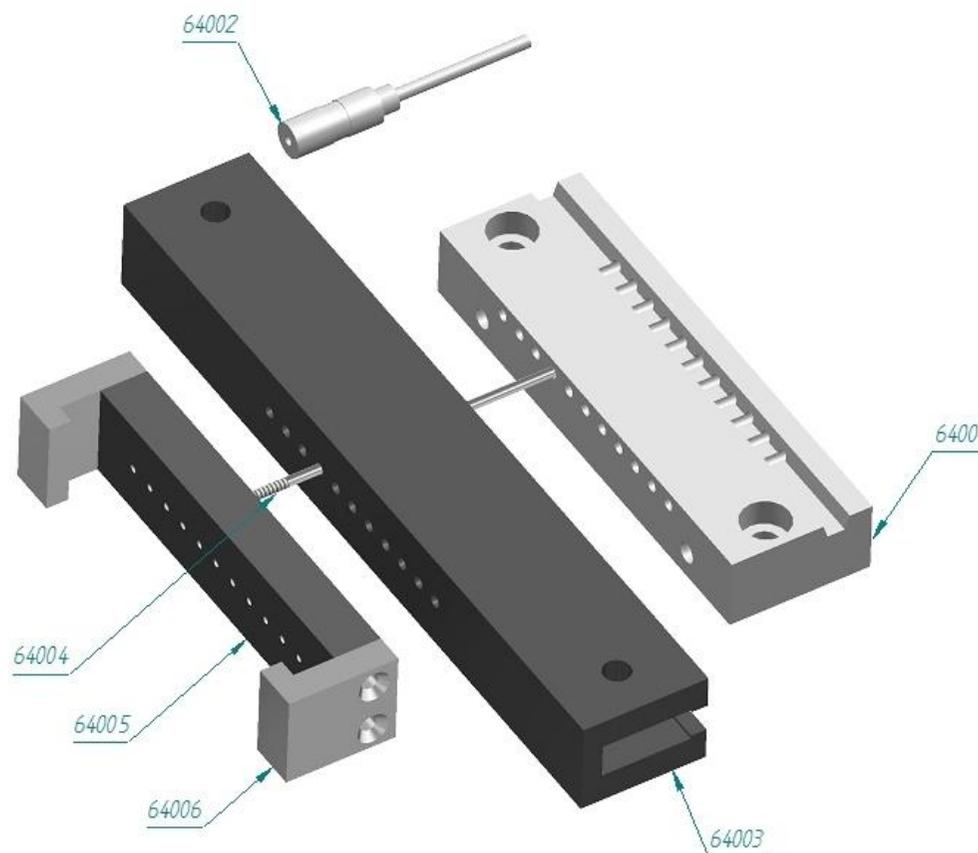
- **Maintenance and care**

- Check the matrixes periodically and keep them in places where they are protected from dirt and blows.
- If worn, replace the drills for a new ones.
- Clean the machine with pressurised air after each use. This prevents the moving parts locking due to swarf from the die cut metal.

- **Spare parts:**

Matrix 6x4

Matrix 6 x 4		
Number	Name	Units
64001	MATR 6x4.par	1
64002	BROCA-4.par	11
64003	ALIJAMIENTO BROCAS 6x4.par	1
64004	EXPUL-3.par	11
64005	PLACA EXP-6.4.par	1
64006	PESTANA EXPULSOR.par	2

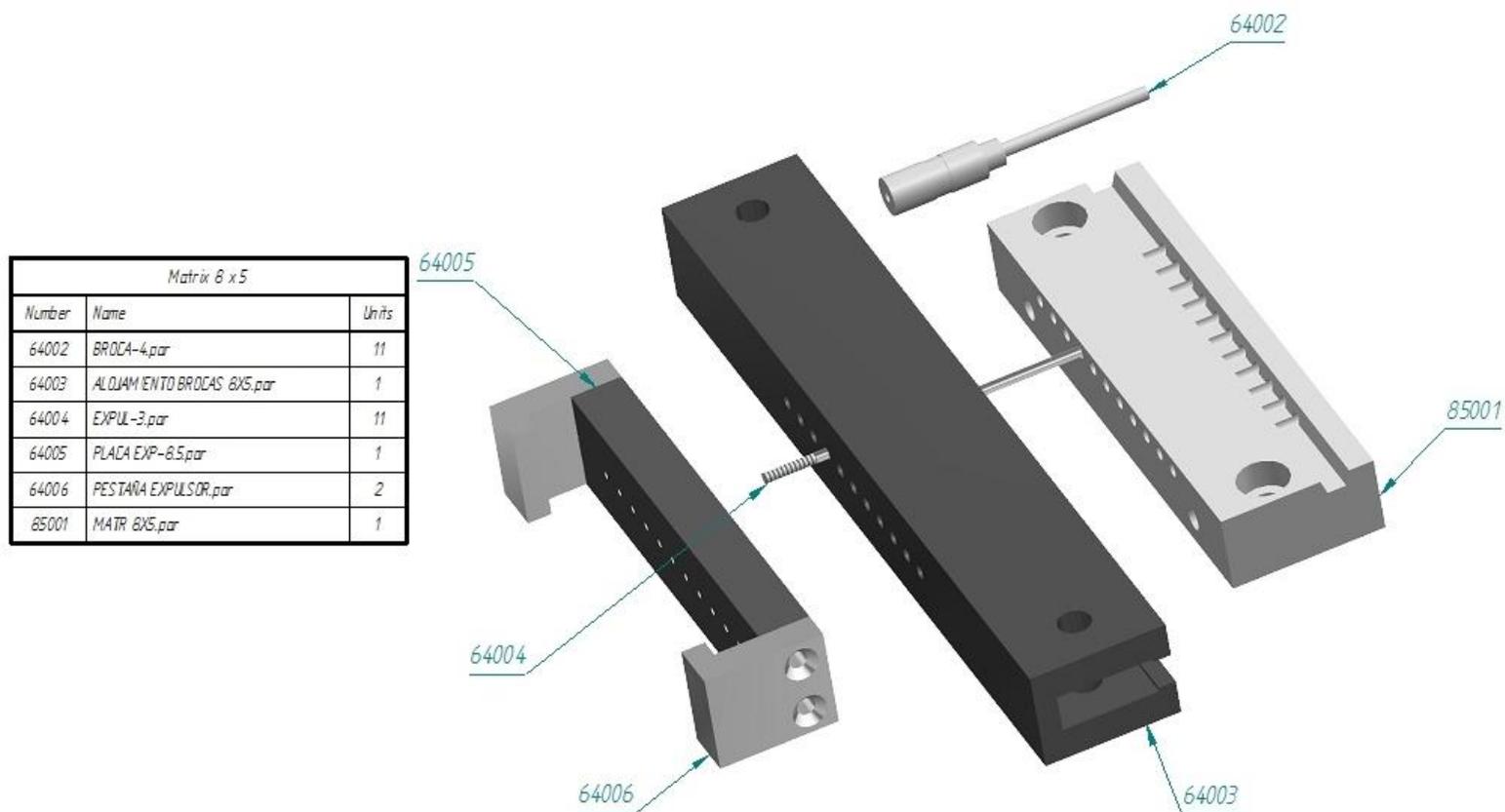


Matrix 8x5

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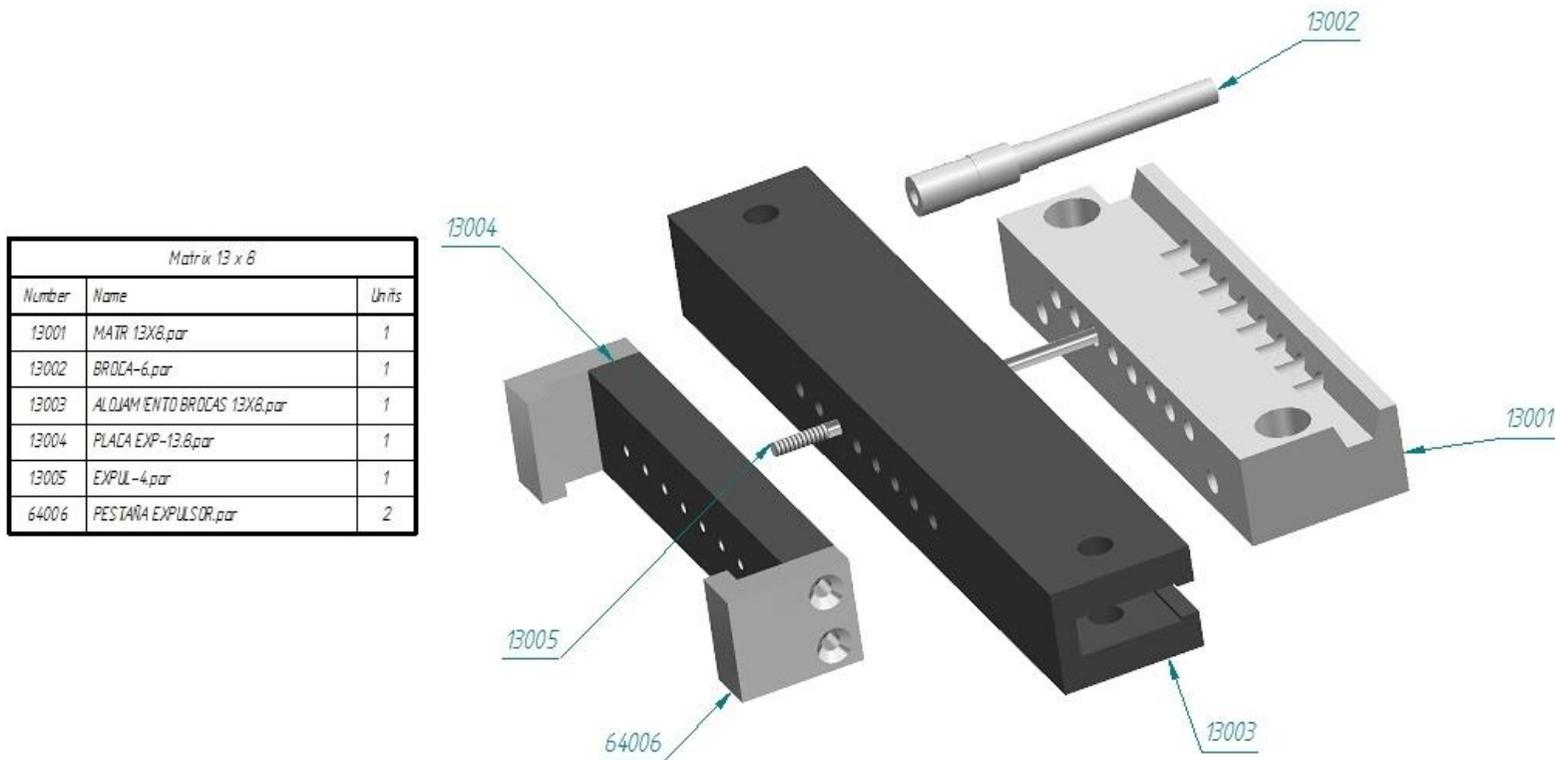
Matrix 10x6



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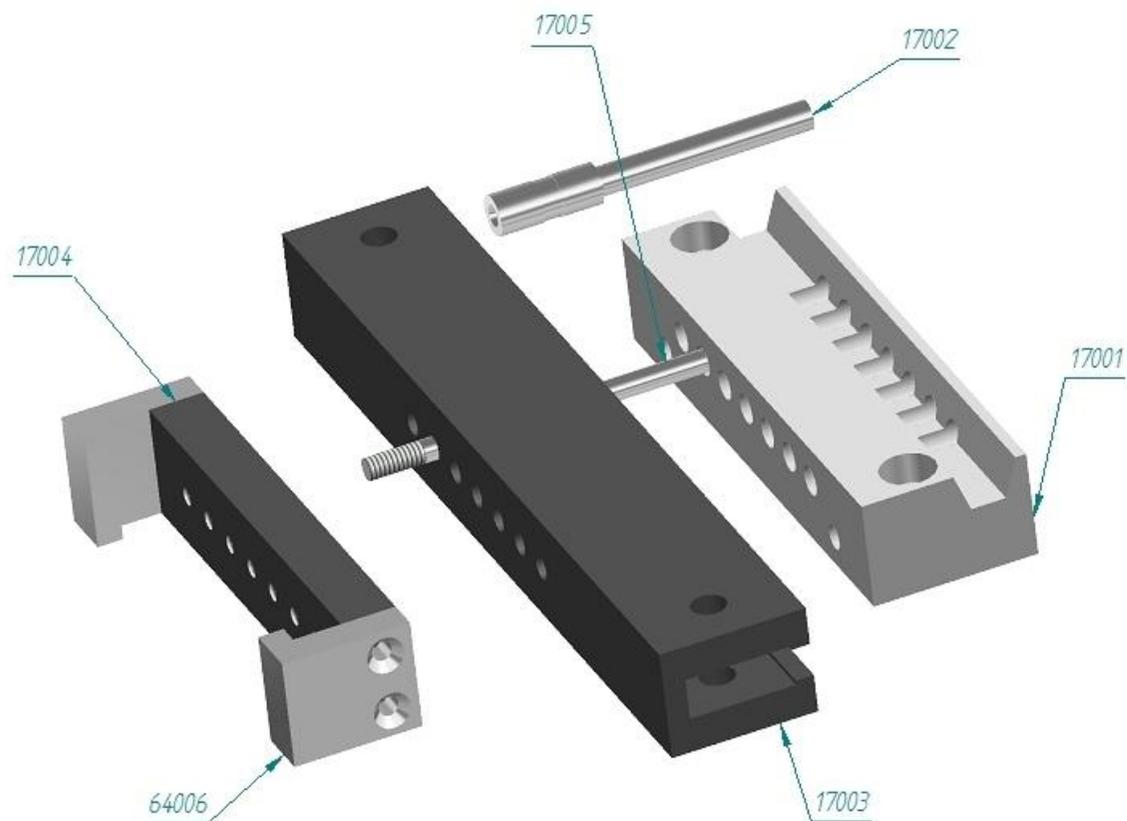
Matrix 17x11

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Number	Name	Units
17001	MATR 17X11.par	1
17002	BROCA-8.par	1
17003	ALOJAMIENTO BROCAS 17X11.par	1
17004	PLACA EXP-12X12.par	1
17005	EXPUL-6.par	1
64006	PESTANA EXPULSOR.par	2

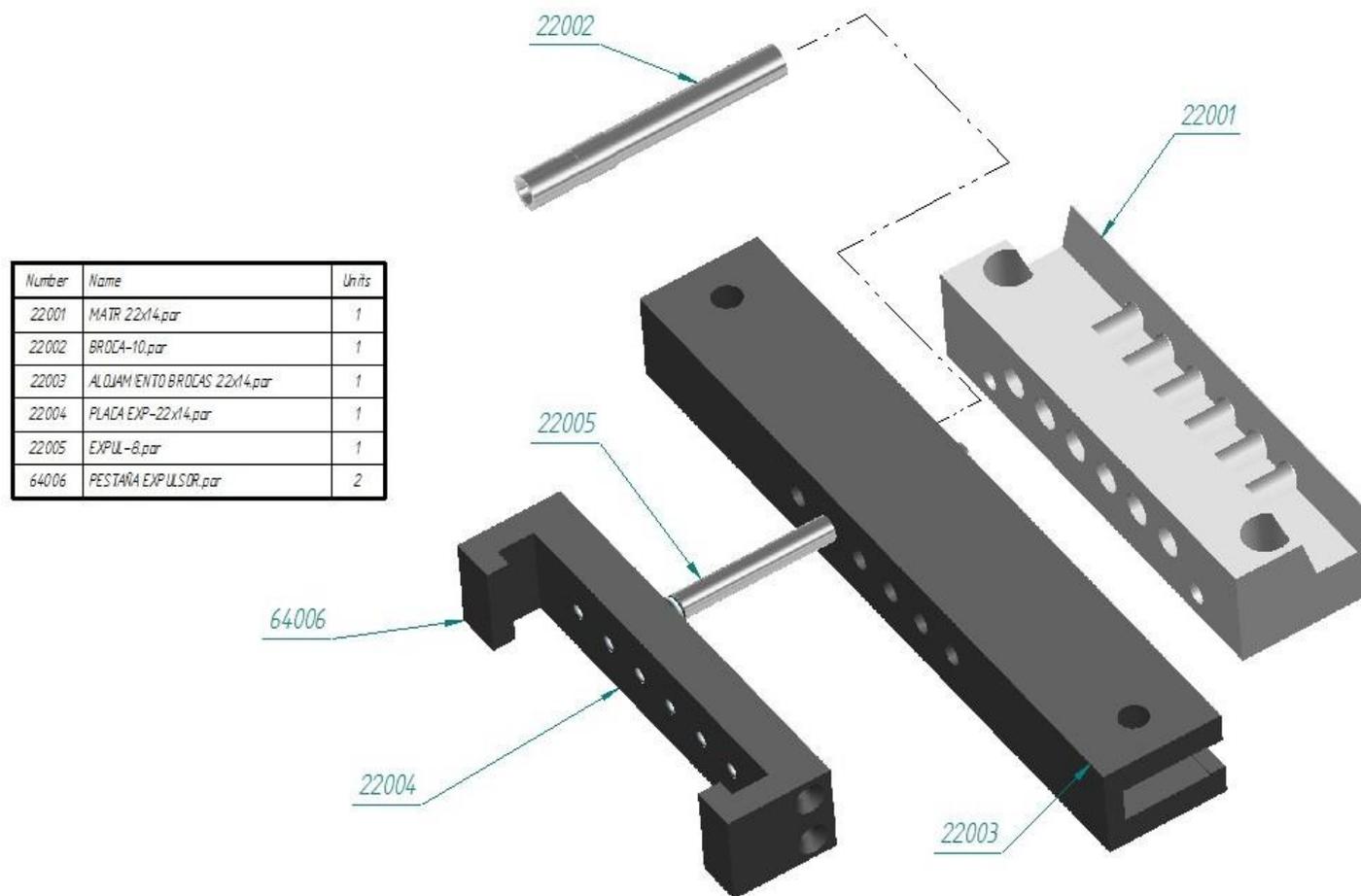


Matrix 22x14

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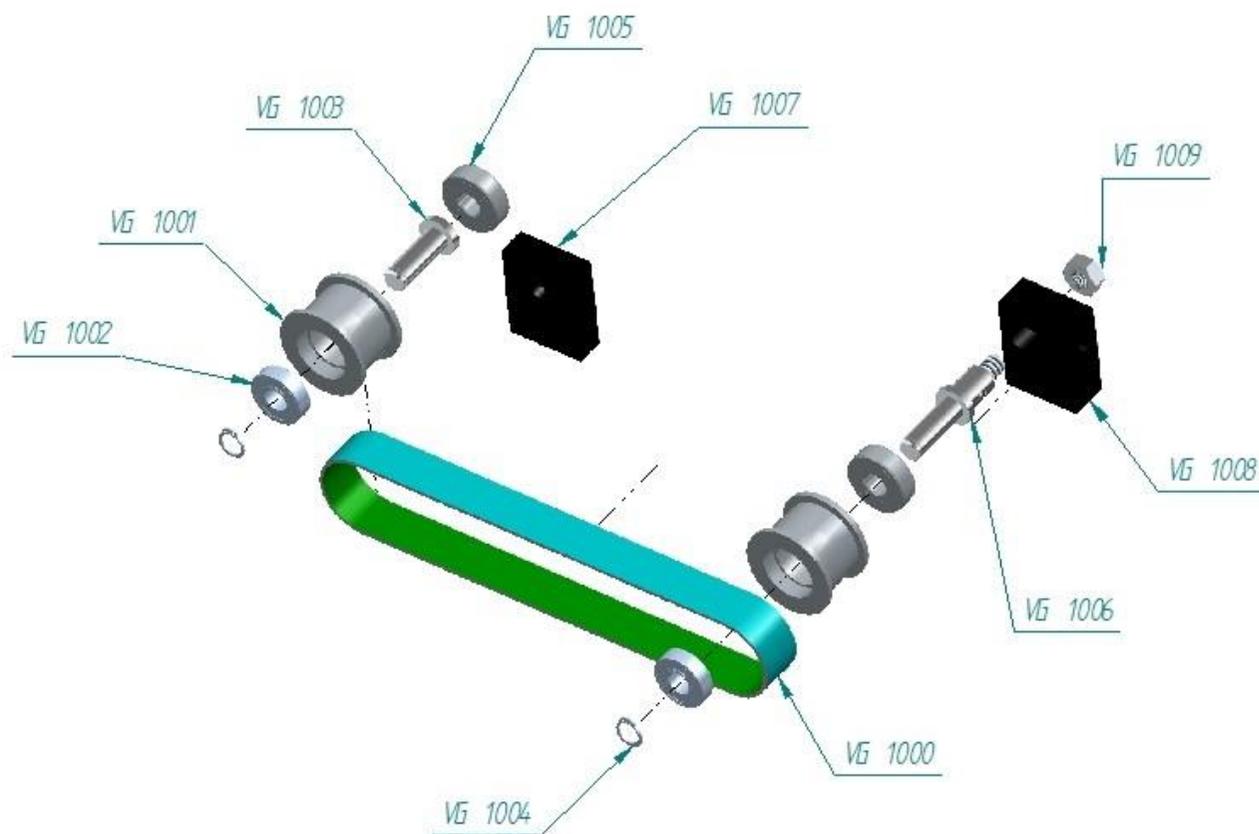


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Element number	Description	Units
VG1000	Correa avance 2	1
VG1001	Polea avance 1	2
VG1002	6001 12 28 8	2
VG1003	Eje polea avance inferior fijo	1
VG1004	12x1	2
VG1005	ESKP 12	2
VG1006	Eje polea avance inferior	1
VG1007	Óado polea avance interior	1
VG1008	Óado polea avance interior tensor	1
VG1009	934-M10	1



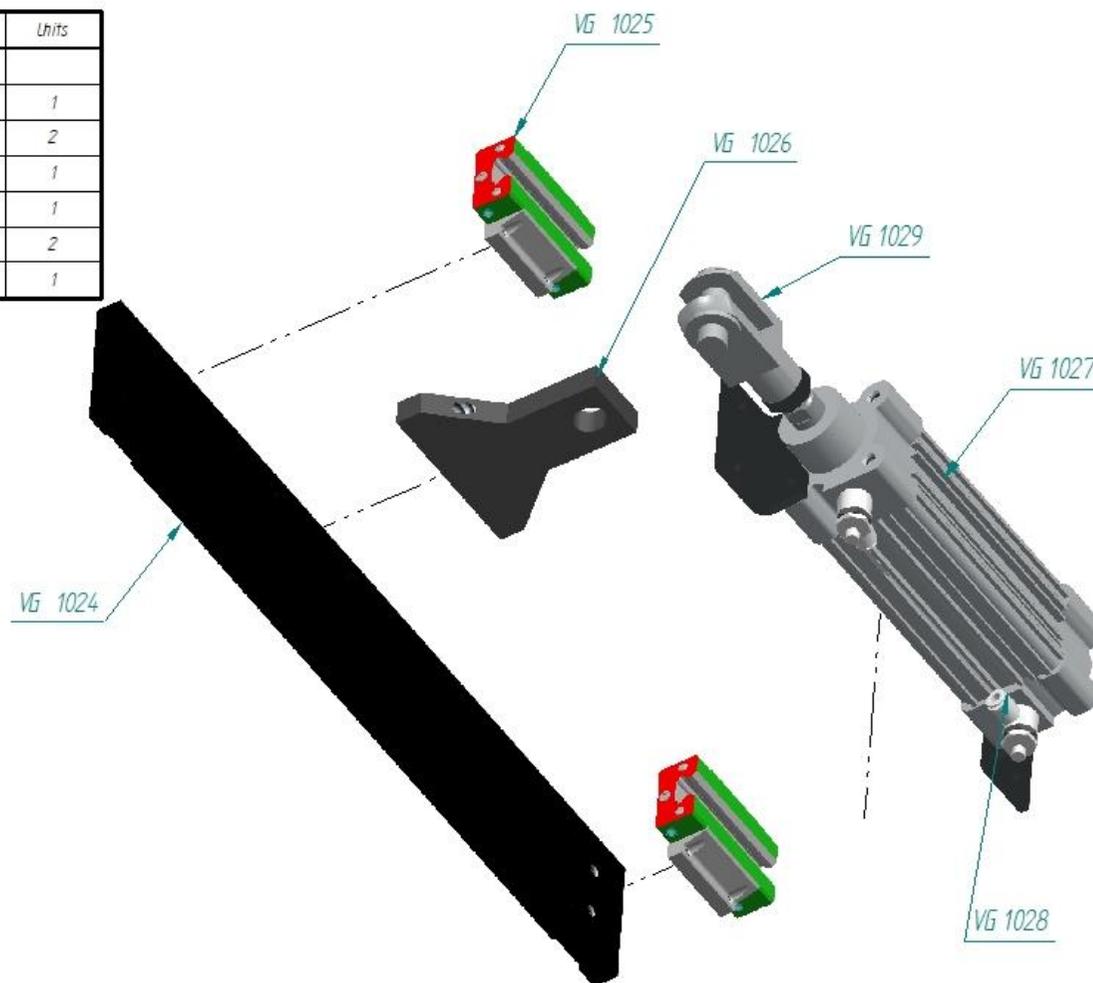


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Part Number	Description	Units
VG	Carro avance	
VG1024	Placa patines avance	1
VG1025	Patín Hiwin Z0	2
VG1026	ORQUILLA CP	1
VG1027	CP96SOL50-100C A931Q L 01	1
VG1028	AS220F-02-06	2
VG1029	GKM16-32	1

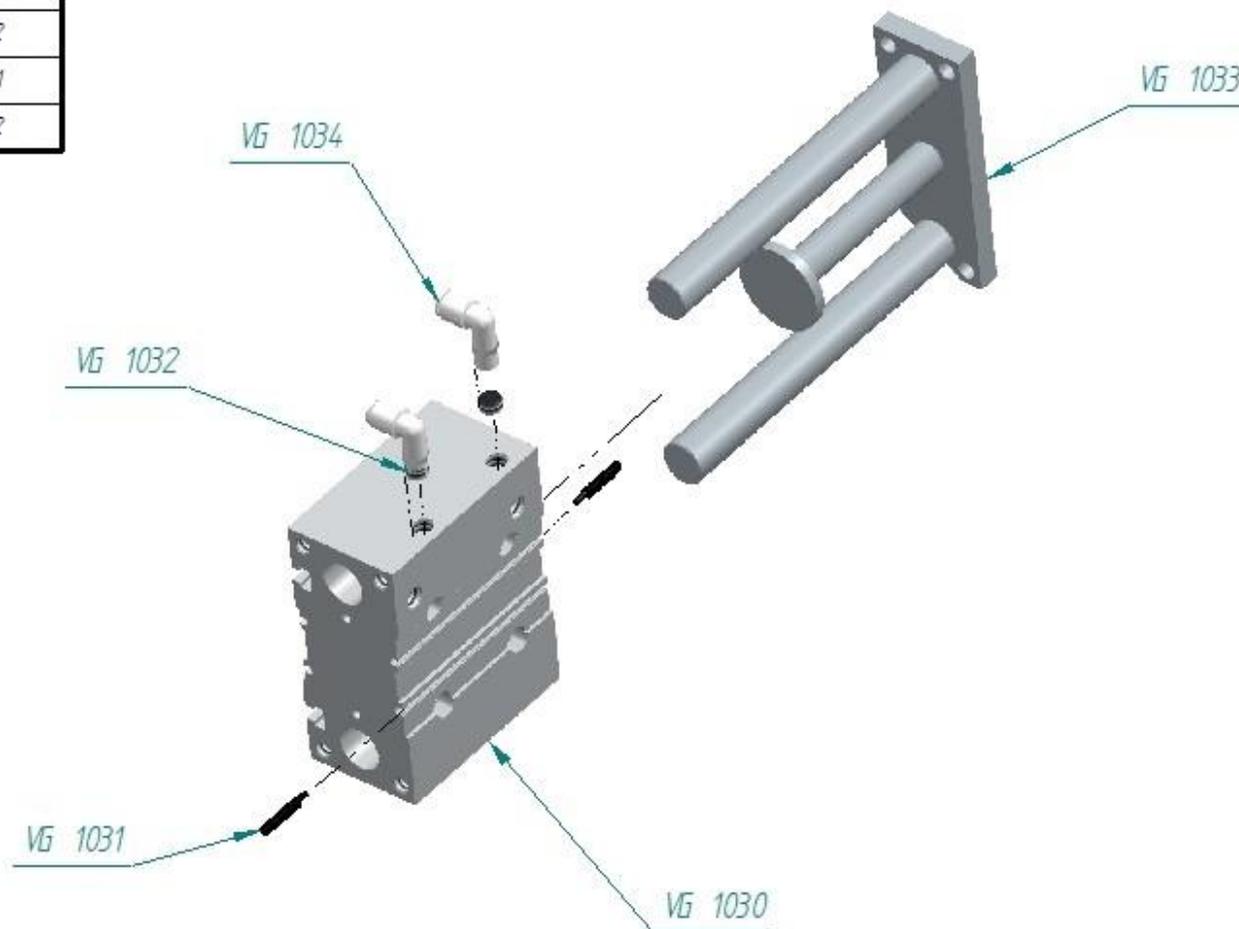


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Element number	Description	Units
VG 1030	MCPM40-50Z10L-800Y	1
VG 1031	D-A93-MGP-Z	2
VG 1032	MGP-Z-PLLE-40	2
VG 1033	MCPM40-50Astep-MGPRod-40M	1
VG 1034	K02L06-05	2

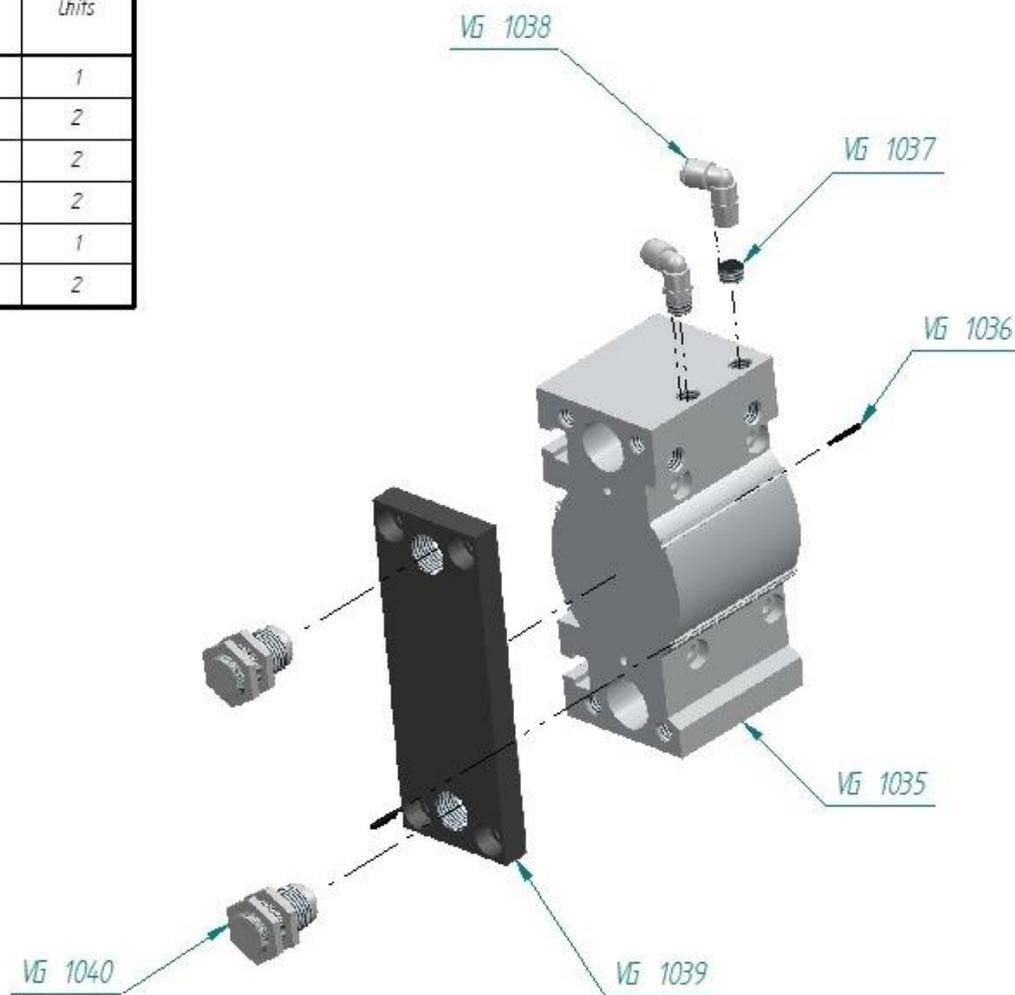


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Element number	Description	Units
VG1035	MGP100-50Z10L BODY	1
VG1036	D_A93_MGP_Z	2
VG1037	MGP_Z_PLLE_100	2
VG1038	K02L10_OBS	2
VG1039	PLACA AMORTIGUADORES	1
VG1040	RB03009	2

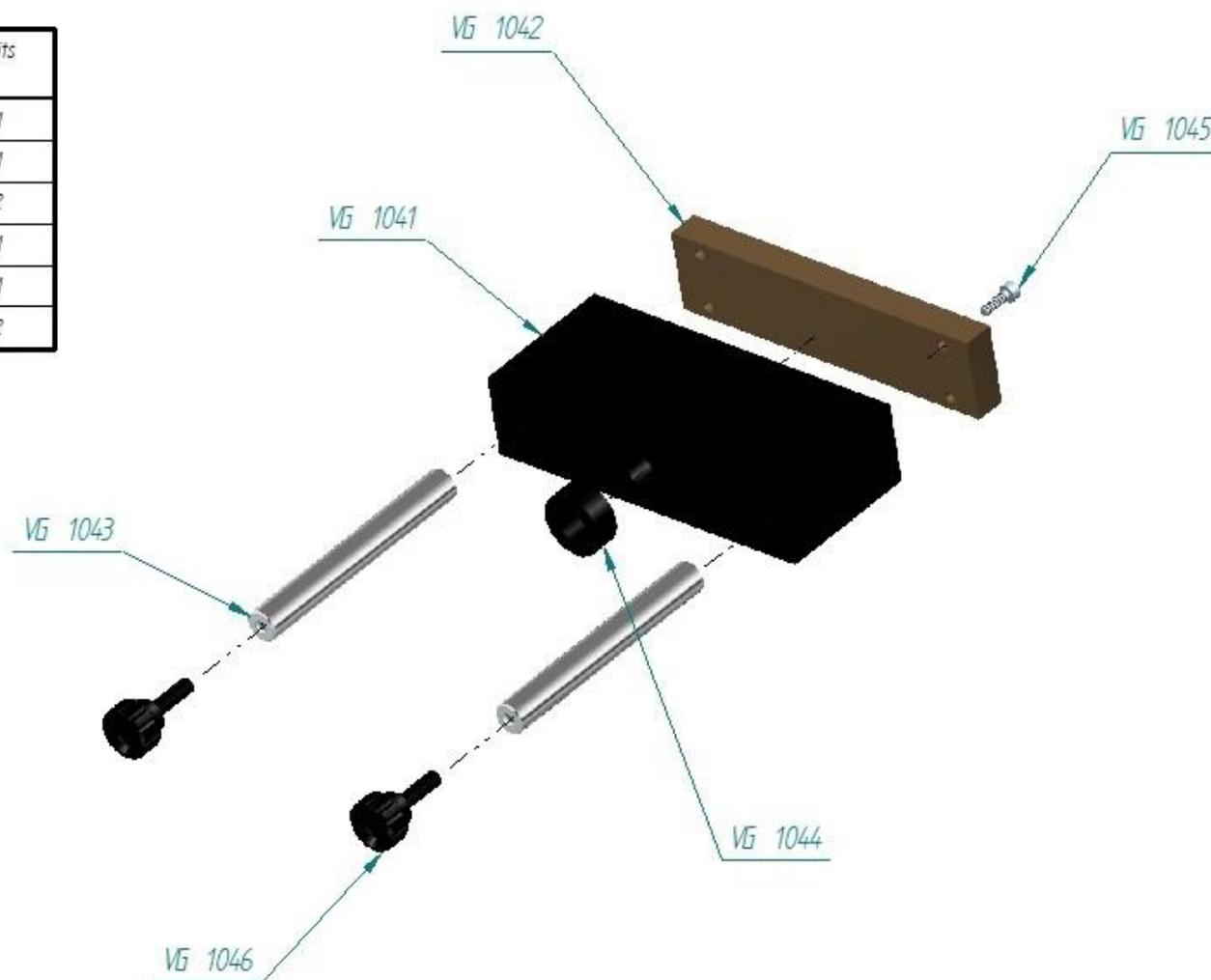


## Use and maintenance manual

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Element number	Description	Units
VG 1041	Pisador presion	1
VG 1042	Tapa pisador presion	1
VG 1043	Barra antigiro pisador	2
VG 1044	Casquillo presion	1
VG 1045	9 12M3x10	1
VG 1046	bt_16_p_m5x16	2

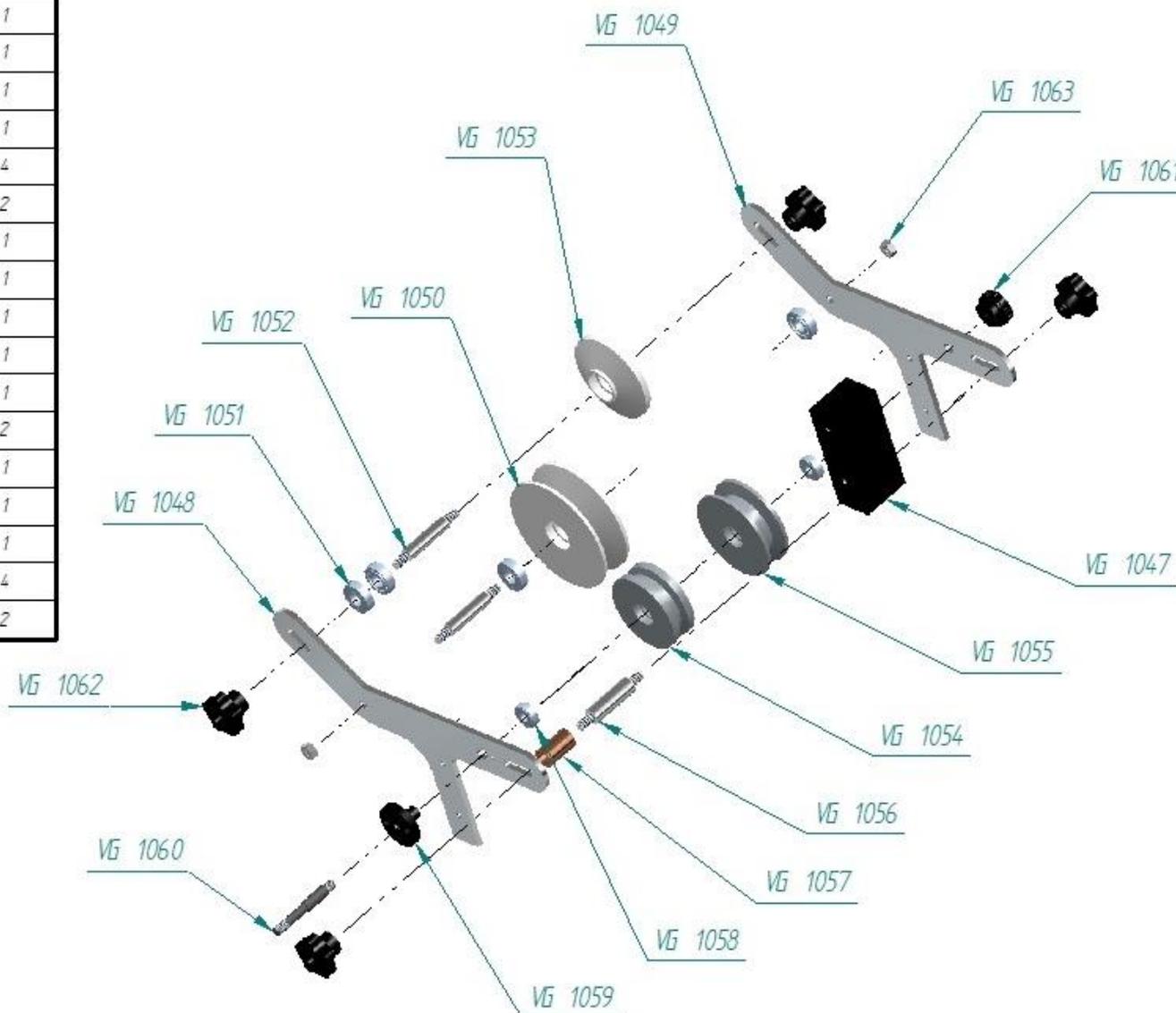


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Element number	Description	Units
VG1047	Dado entrada perfil	1
VG1048	Brazo poleas entrada 2	1
VG1049	Brazo poleas entrada	1
VG1050	Polea principal	1
VG1051	6001 12-28-8	4
VG1052	Eje polea guia Ajuste	2
VG1053	Polea guia	1
VG1054	Polea entrada 10	1
VG1055	Polea entrada 17	1
VG1056	Eje polea guia	1
VG1057	Sel 5-18-30	1
VG1058	608 8-22-7	2
VG1059	Brida polea entrada	1
VG1060	Eje polea superior	1
VG1061	b_193_30_fp_m8	1
VG1062	vc_254_40_b_m8	4
VG1063	934-M8	2

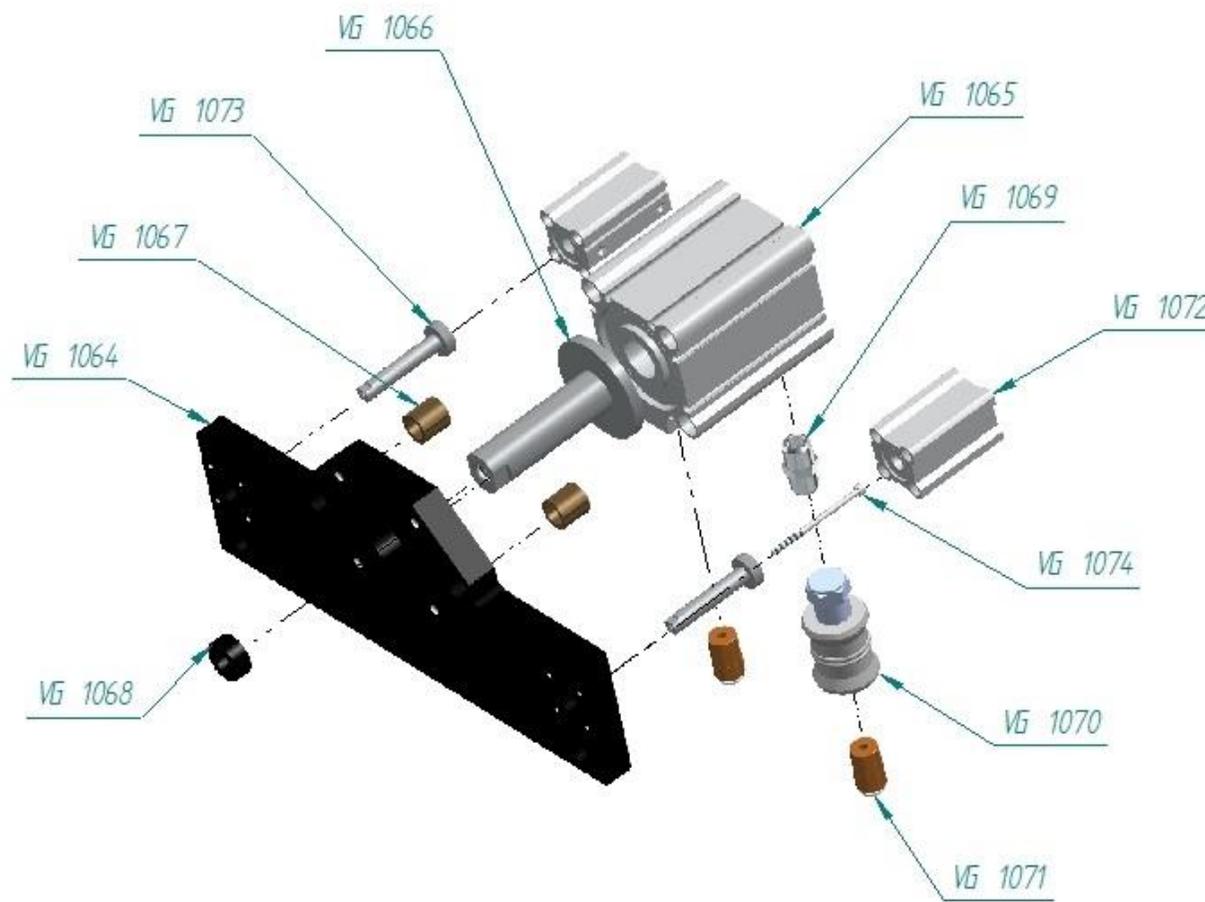


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Element number	Description	Units
VG 1064	Base cilindro presion	1
VG 1065	C02B50-5010_01_BODY	1
VG 1066	C02B50-5010_01_CYROD	1
VG 1067	SeA10-15-15	2
VG 1068	Casquillo presion	1
VG 1069	Machon 1-4	1
VG 1070	Valv corredera 1-4	1
VG 1071	K02S06-02S	2
VG 1072	C02B16-3010_01_BODY	2
VG 1073	C02B16-3010_01_CYROD	2
VG 1074	C0216_01_M3x50L	1

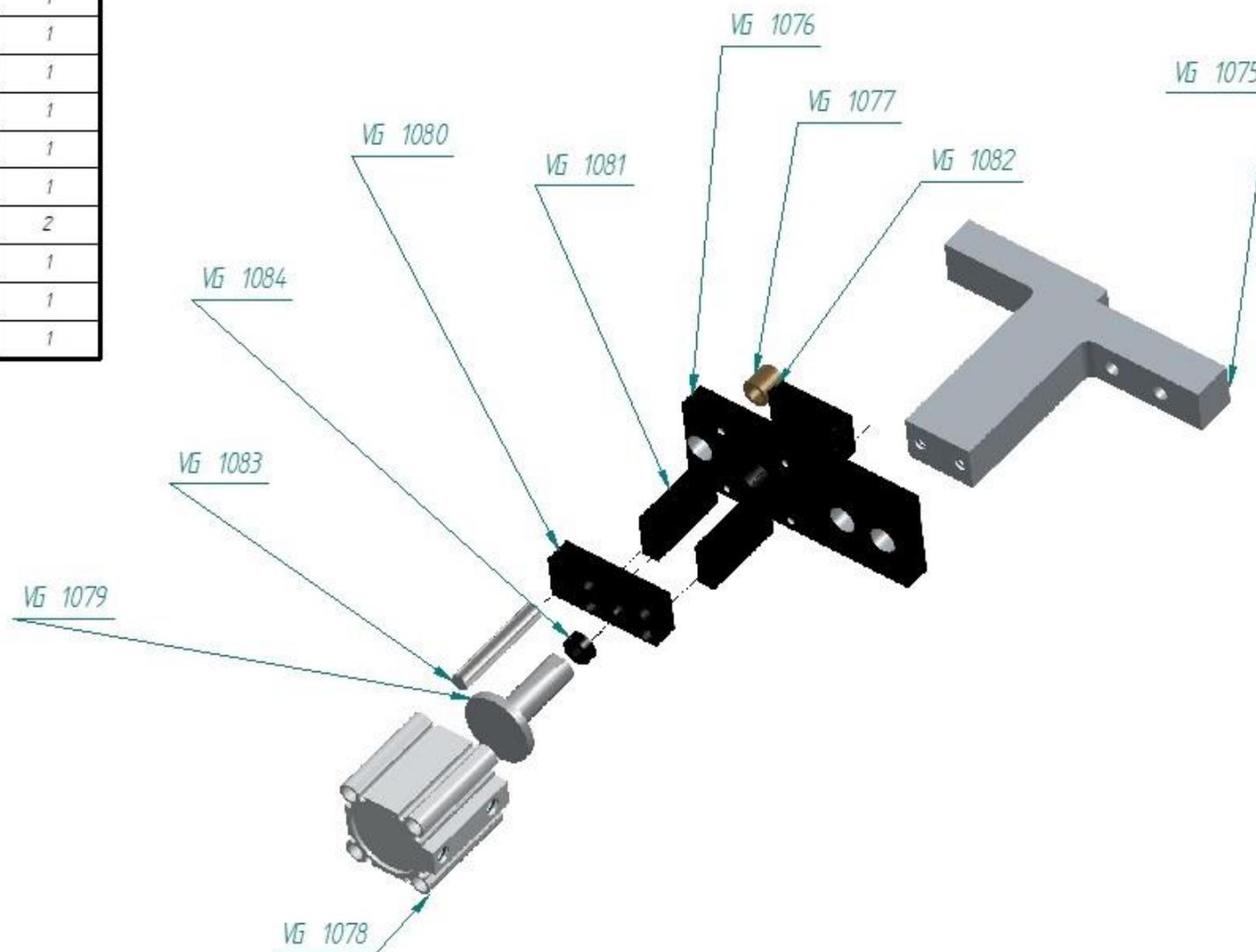


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Element number	Description	Units
VG1075	Lha inferior fija	1
VG1076	Base cilindro arrastre	1
VG1077	Seal 10-15-15	1
VG1078	C02B40TF-3010_OL_BODY	1
VG1079	C02B40-3010_OL_CYR00	1
VG1080	Base sup. mordaza	1
VG1081	Tabique mordaza	2
VG1082	Suelo mordaza	1
VG1083	Barra antigiro	1
VG1084	Casquillo avance	1

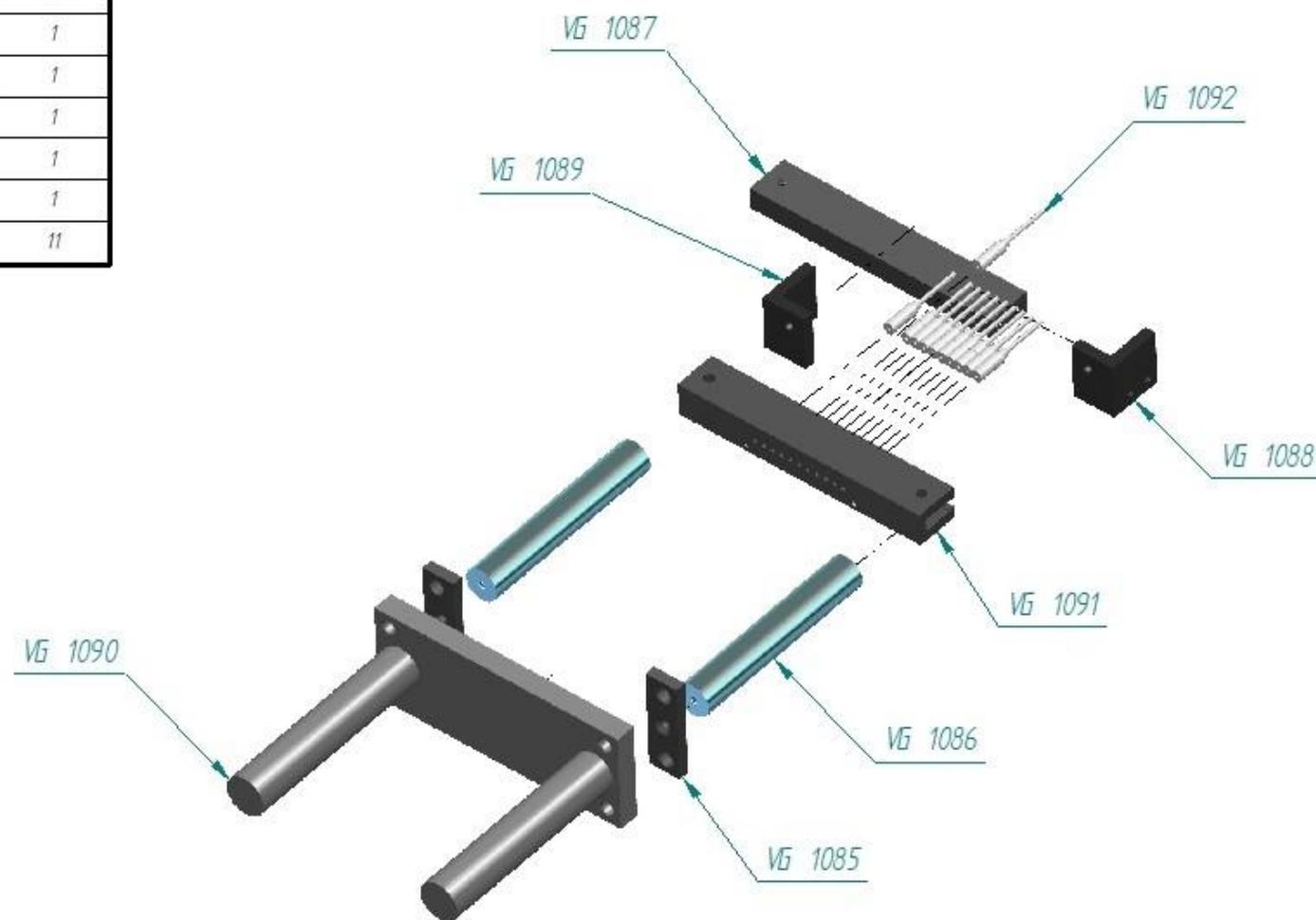


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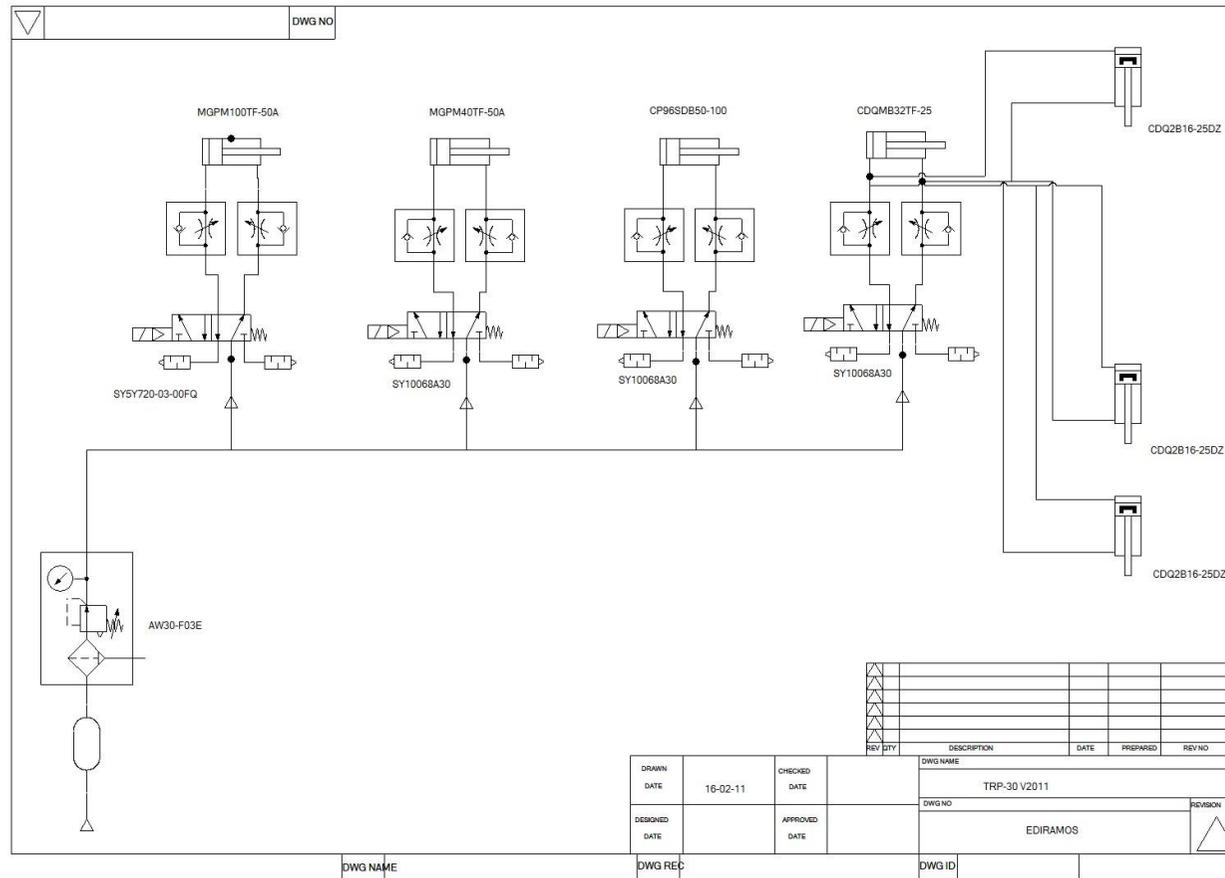
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Element number	Description	Units
VG1085	PESTAÑA GUIA	2
VG1086	VASLA GUIA	2
VG1087	DISTANCIAL VASLAS	1
VG1088	Apoyo TR	1
VG1089	Apoyo TR2	1
VG1090	MCPM100-50AZIOLROD	1
VG1091	ALCIAMENTO BROCA 8X5	1
VG1092	BROCA 4	11



- **Pneumatic drawing**



**Use and maintenance manual**

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**Automatismos Tecelmac S.L.**

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CLIENTE	:	ERMENGINEERING	
DENOM. INSTALACIÓN	:	TROQUELADORA PERFILES VGN-22	
NUM. PROYECTO	:	25643	
FABRICANTE	:	ERMENGINEERING	<b>CARACTERÍSTICAS TÉCNICAS</b>  TENSIÓN DE ALIMENTACIÓN : 230V TENSIÓN DE MANDO : 24VDC POTENCIA : 1 kW
TIPO ESQUEMAS	:	ELÉCTRICOS	
NORMATIVA	:	DIN	
FORMATO-VERSIÓN	:	EPLAN P8 2024	
LUGAR INSTALACIÓN	:	ARENYS DE MUNT	
RESPONSABLE PROYECTO	:	J.S.P.	
FECHA REALIZACIÓN	:	17/10/2025	CANTIDAD TOTAL PÁGINAS : 22
ELABORADO POR	:	BPUIG	

	Customer	Location	ARENYS DE MUNT	Creation date	17/10/2025		Page	PORTADA PROYECTO	Project Nº	= GEN
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	Version		Mod. date	20/10/2025						



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**ARMARIO -C1-**

=GEN+IND/2

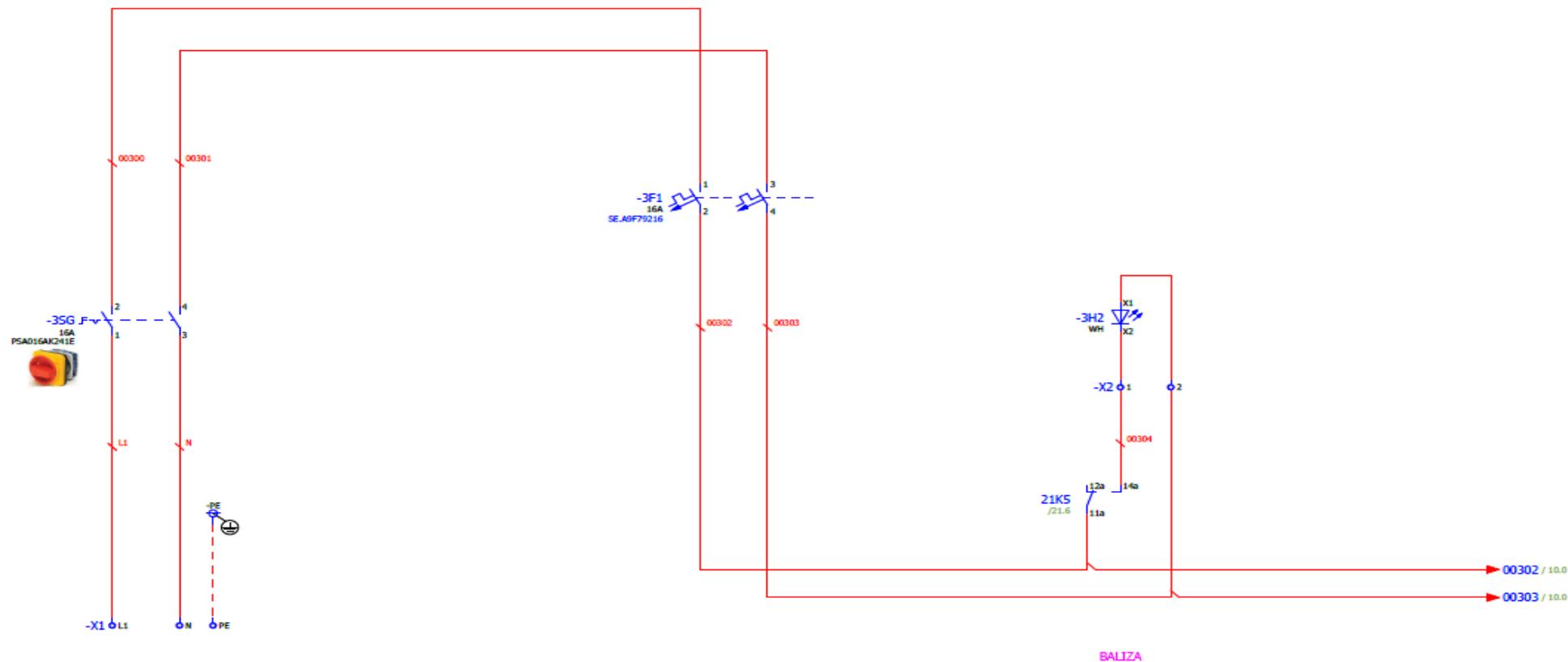
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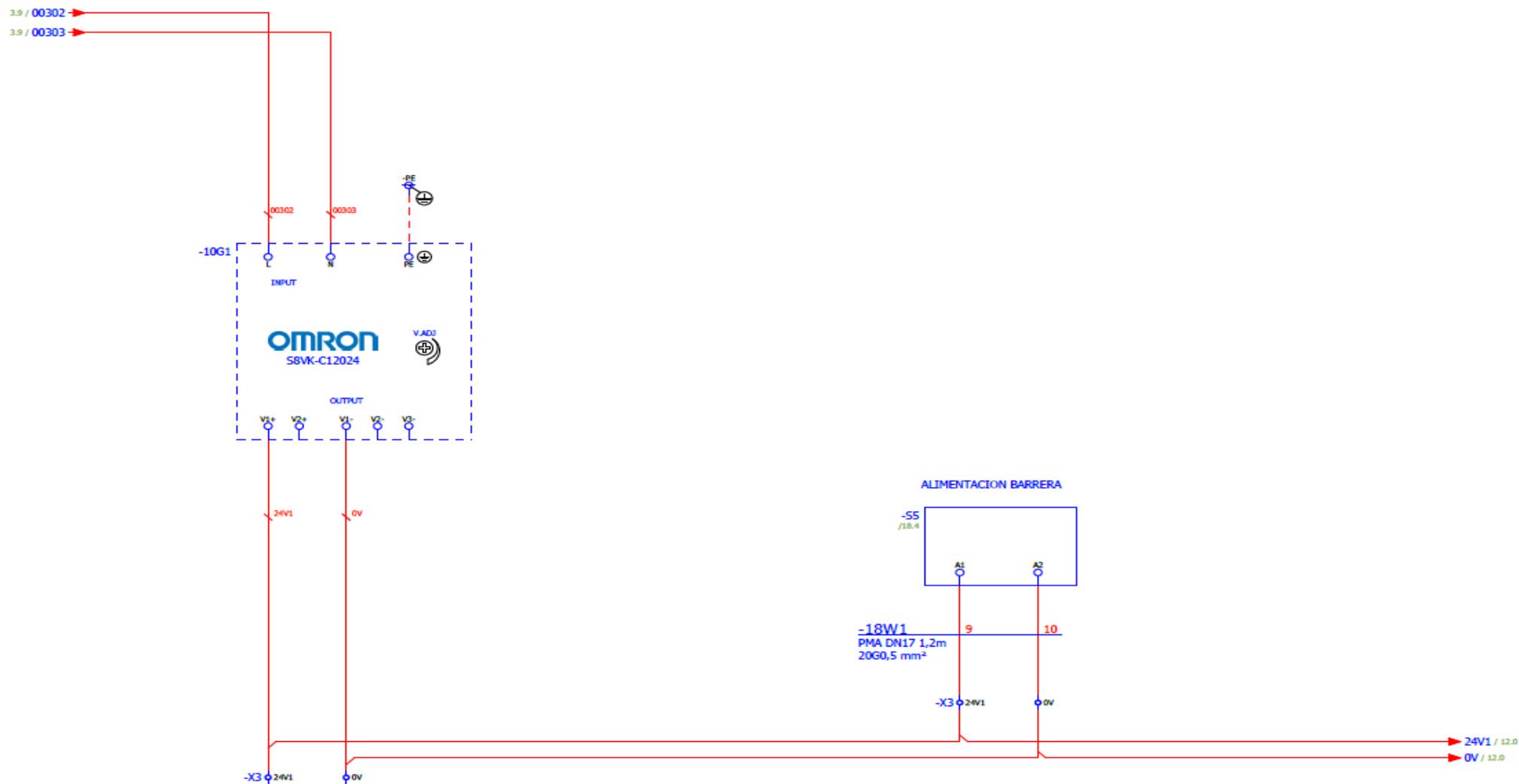
TENSIÓN DE RED:	230 V
FRECUENCIA DE RED:	50Hz
POTENCIA MÁXIMA:	1 kW
INTENSIDAD MÁXIMA:	16A

Customer	Location	ARENYS DE HUNT	Creation date	17/10/2025	Page	ENTRADA ALIMENTACIÓN	Project Nº	= ESQ	
ermengineering belting fabrication equipment	Country	España	Edited by		Project description	TROQUELADORA PERFILES VGN-22	25643	+ Ct	
	Maker		Approved by	J.S.P.				Page	3
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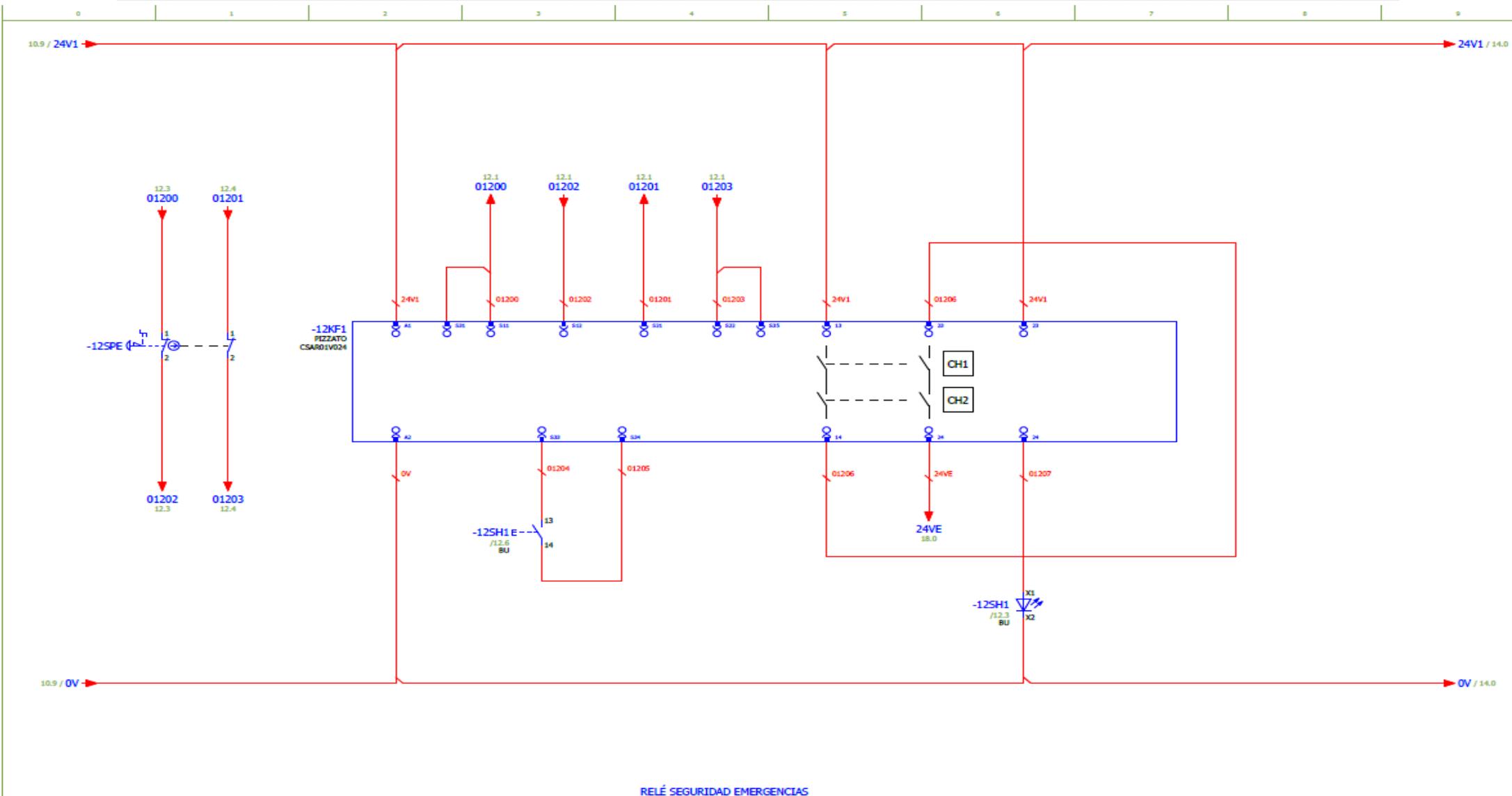
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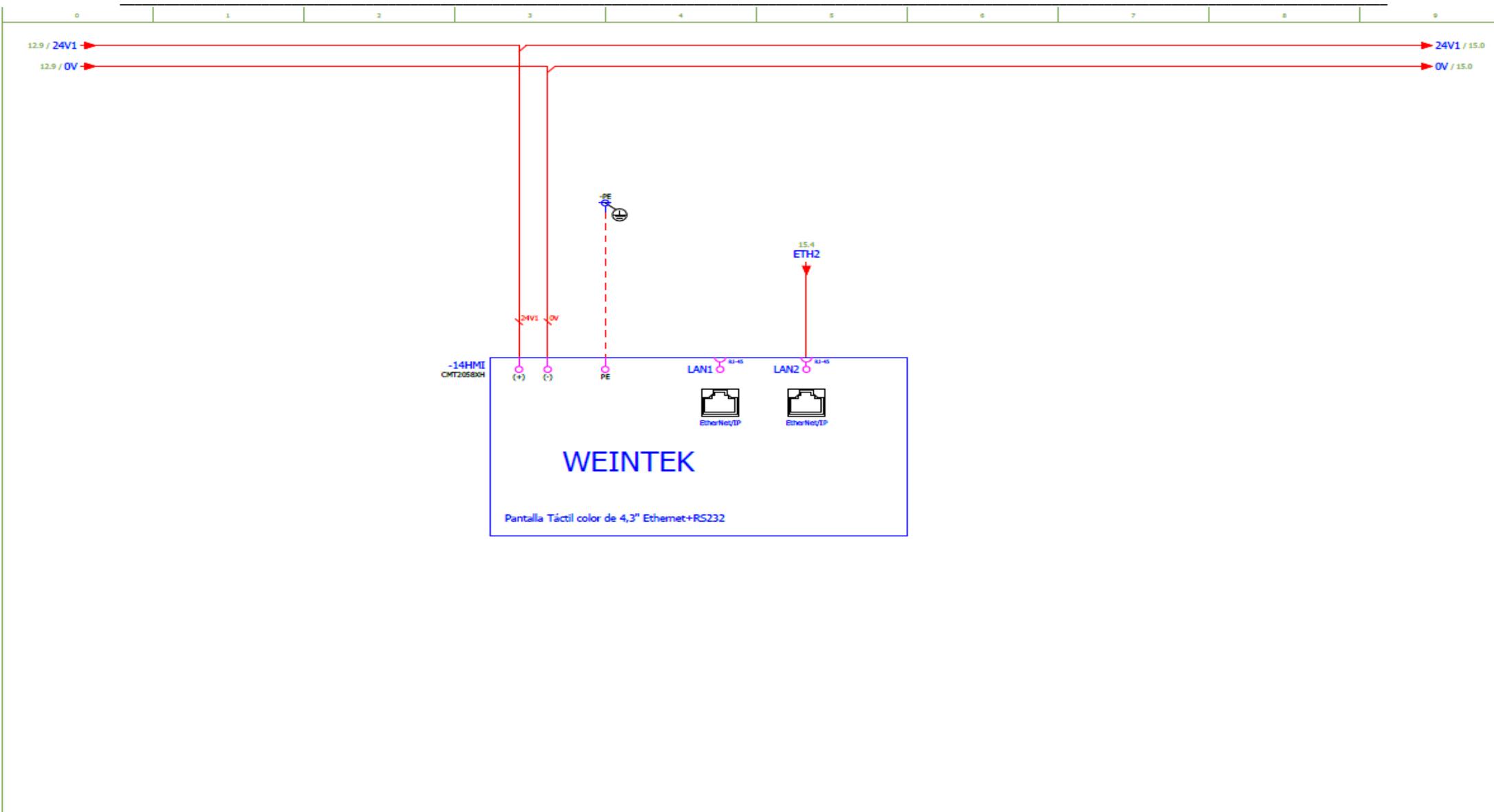
Automatic V-guide notcher

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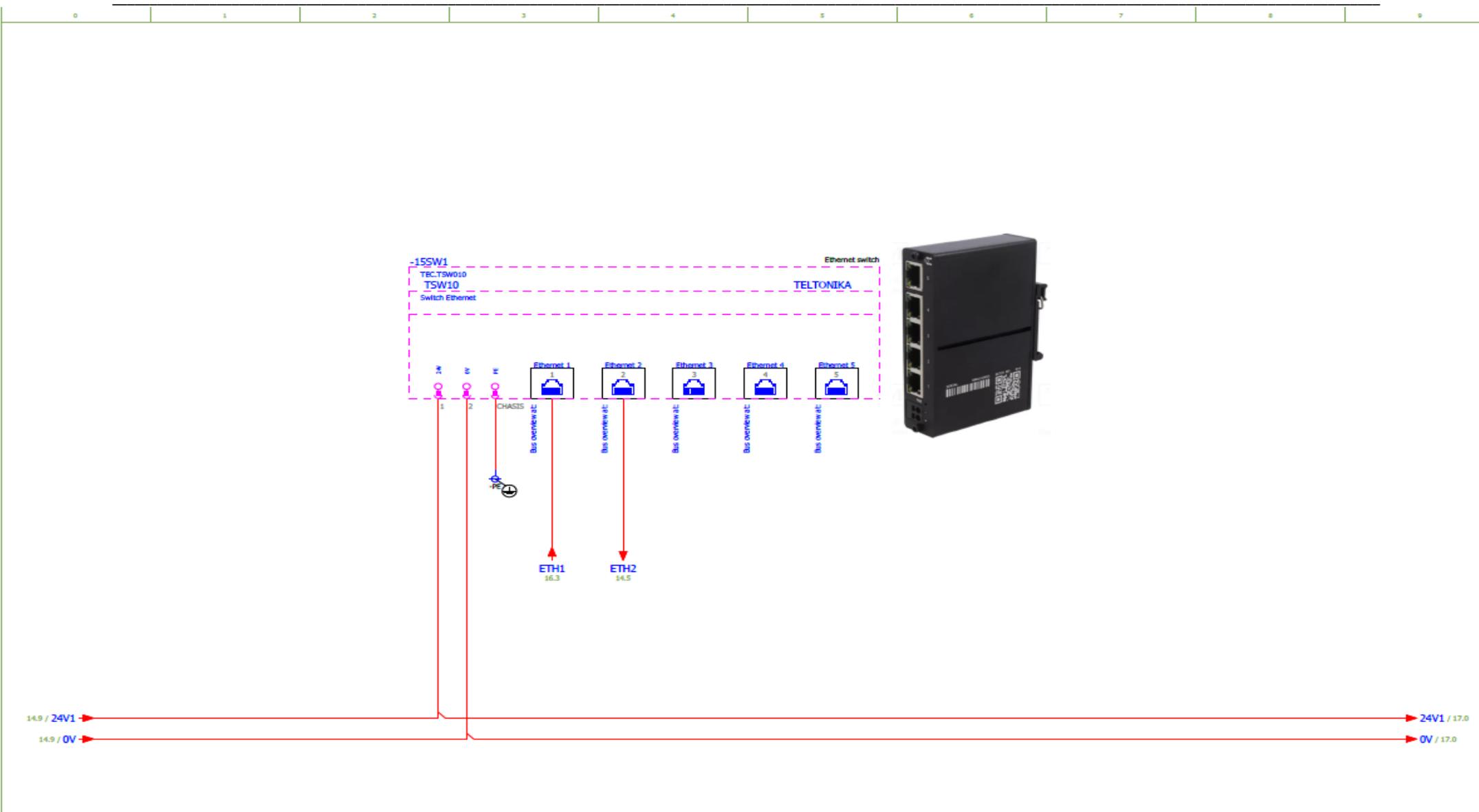


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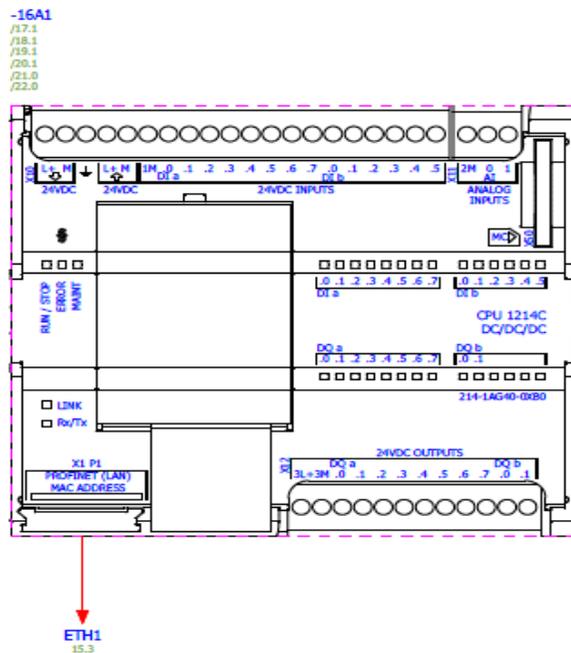
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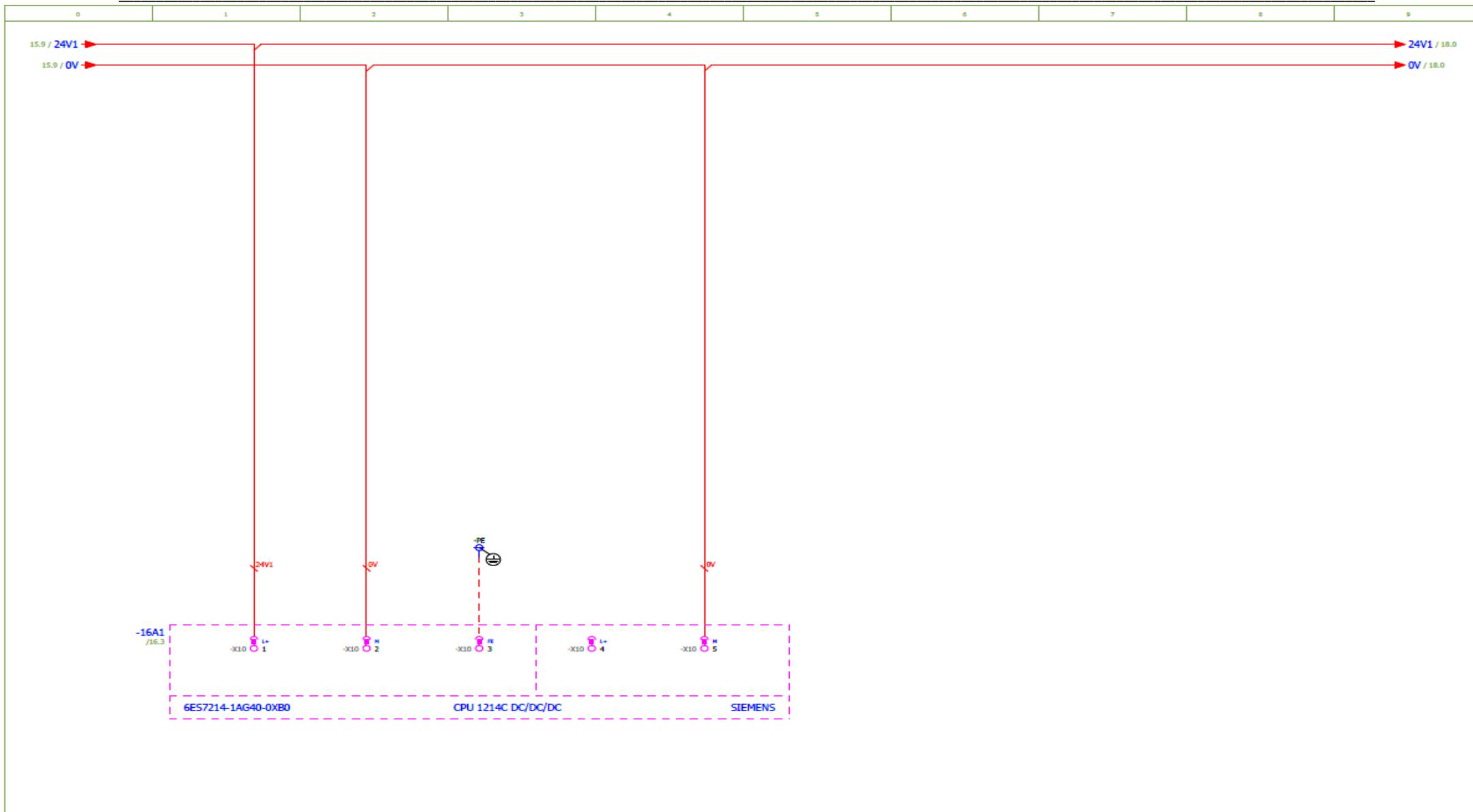
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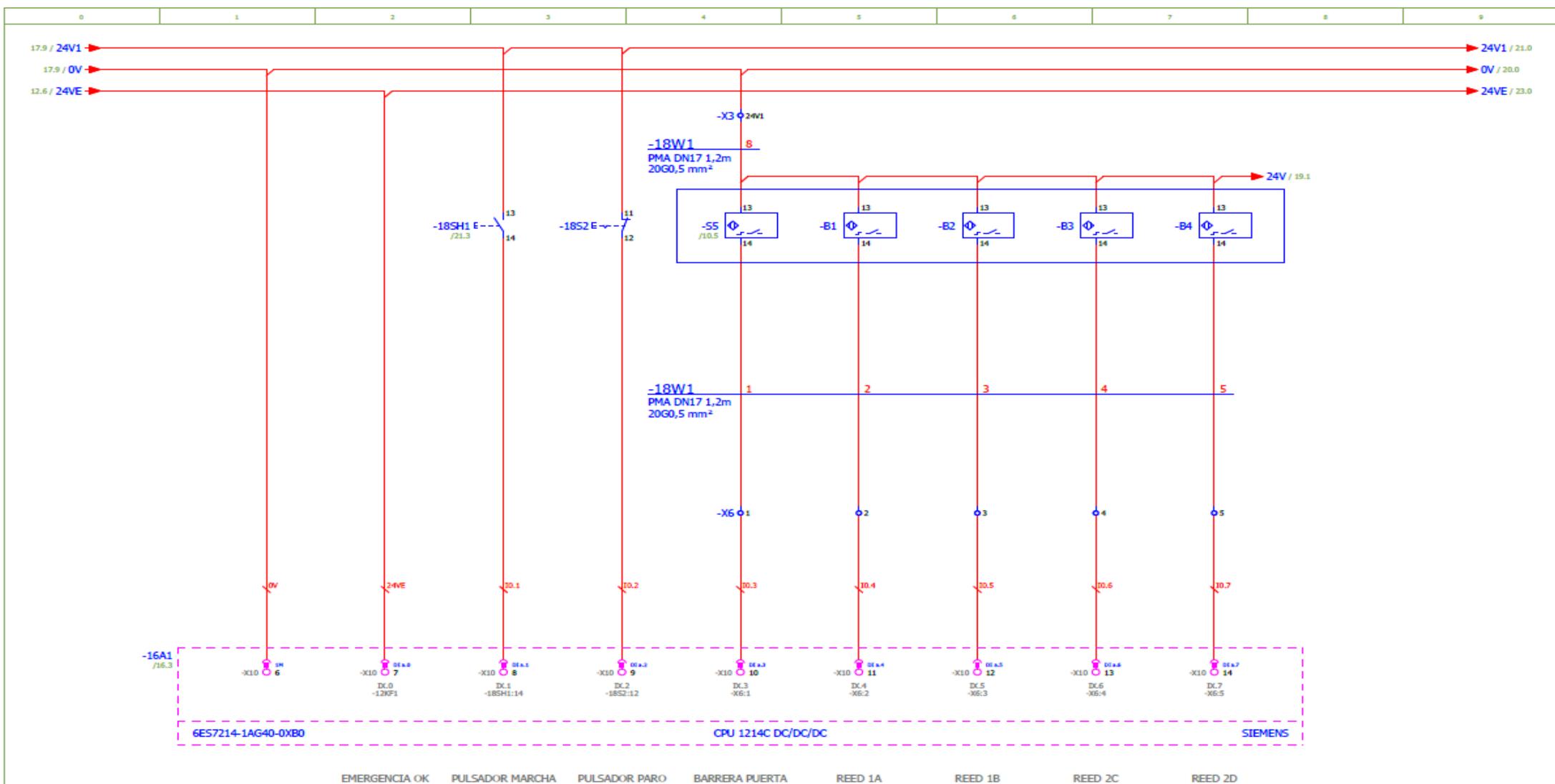
# Use and maintenance manual

Automatic V-guide notcher

Model: VGN-22



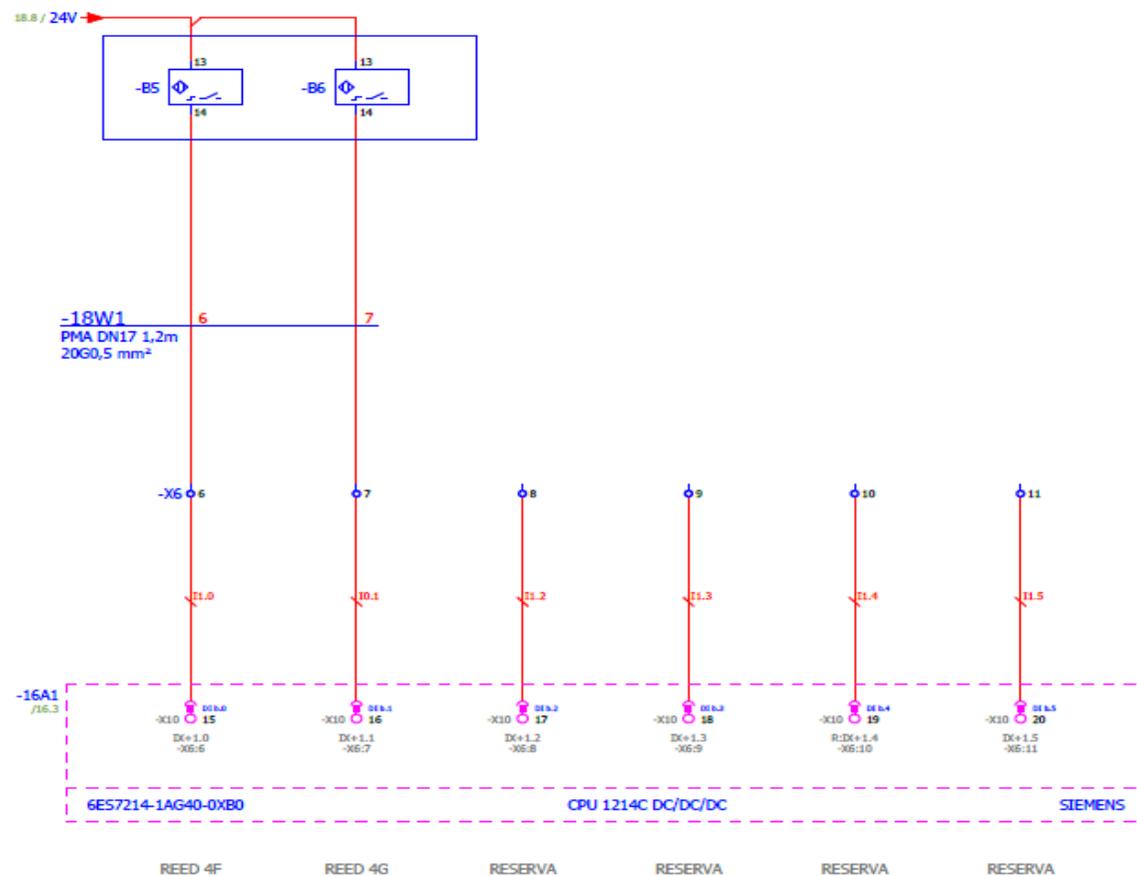
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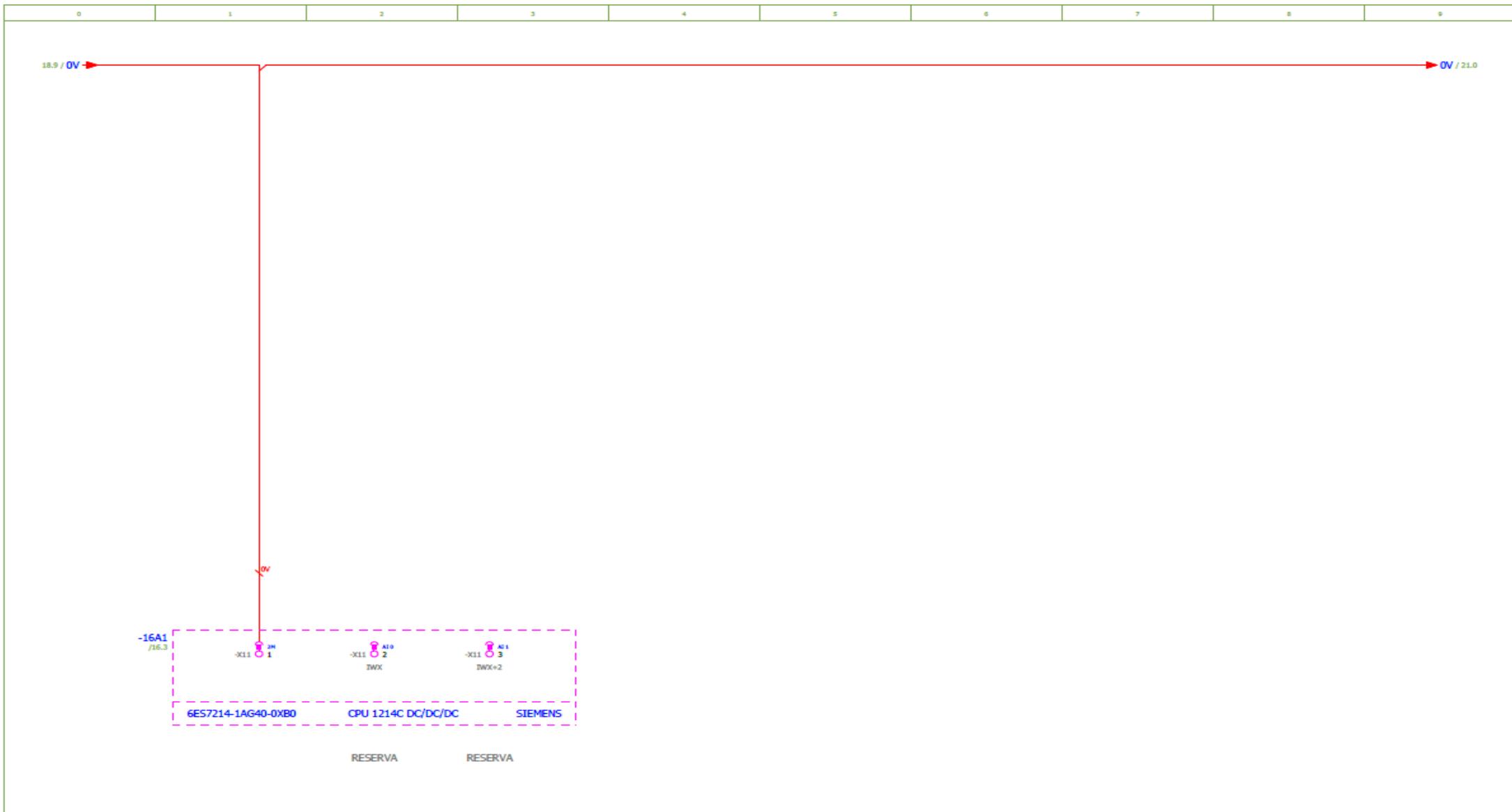
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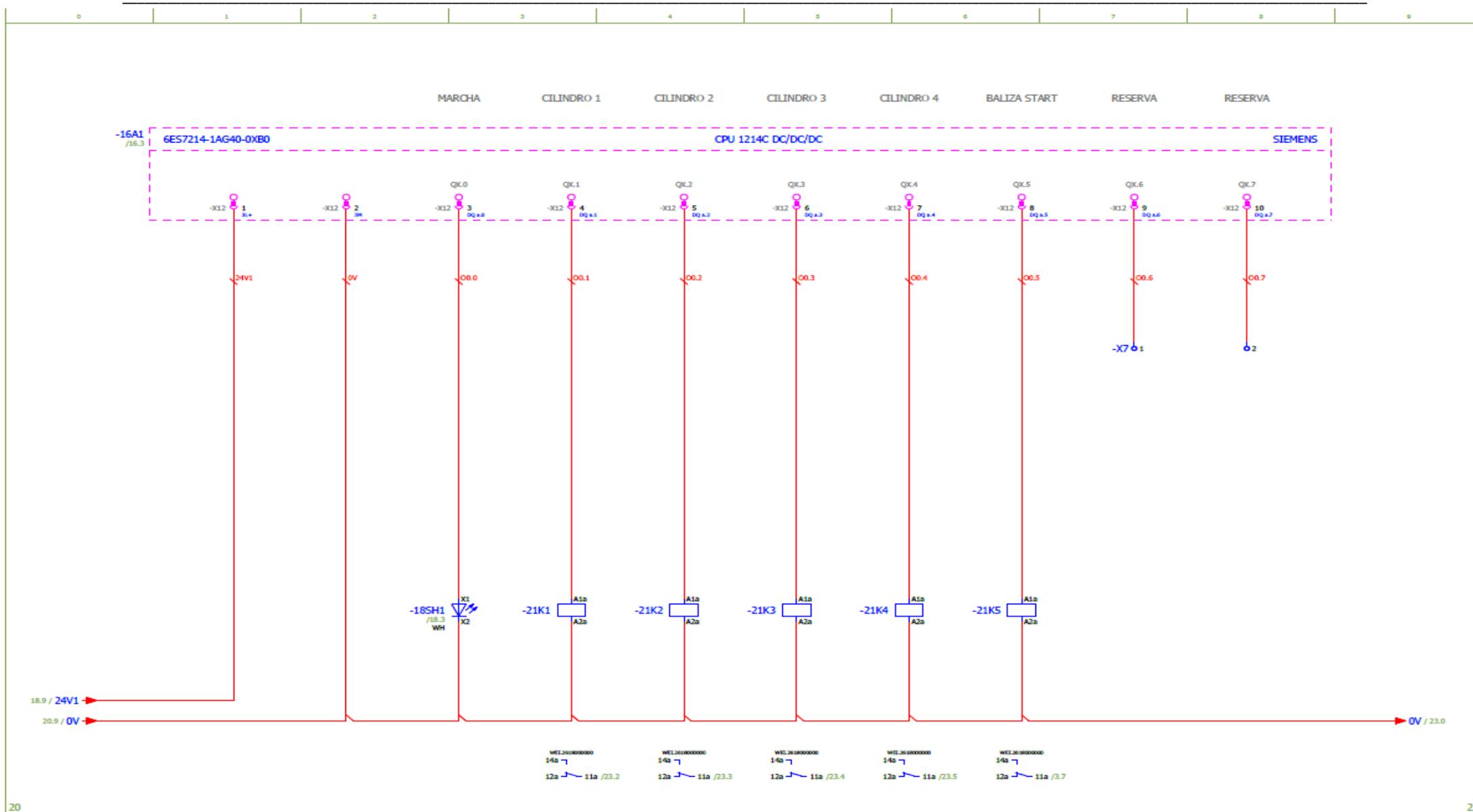
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 Automatic V-guide notcher  
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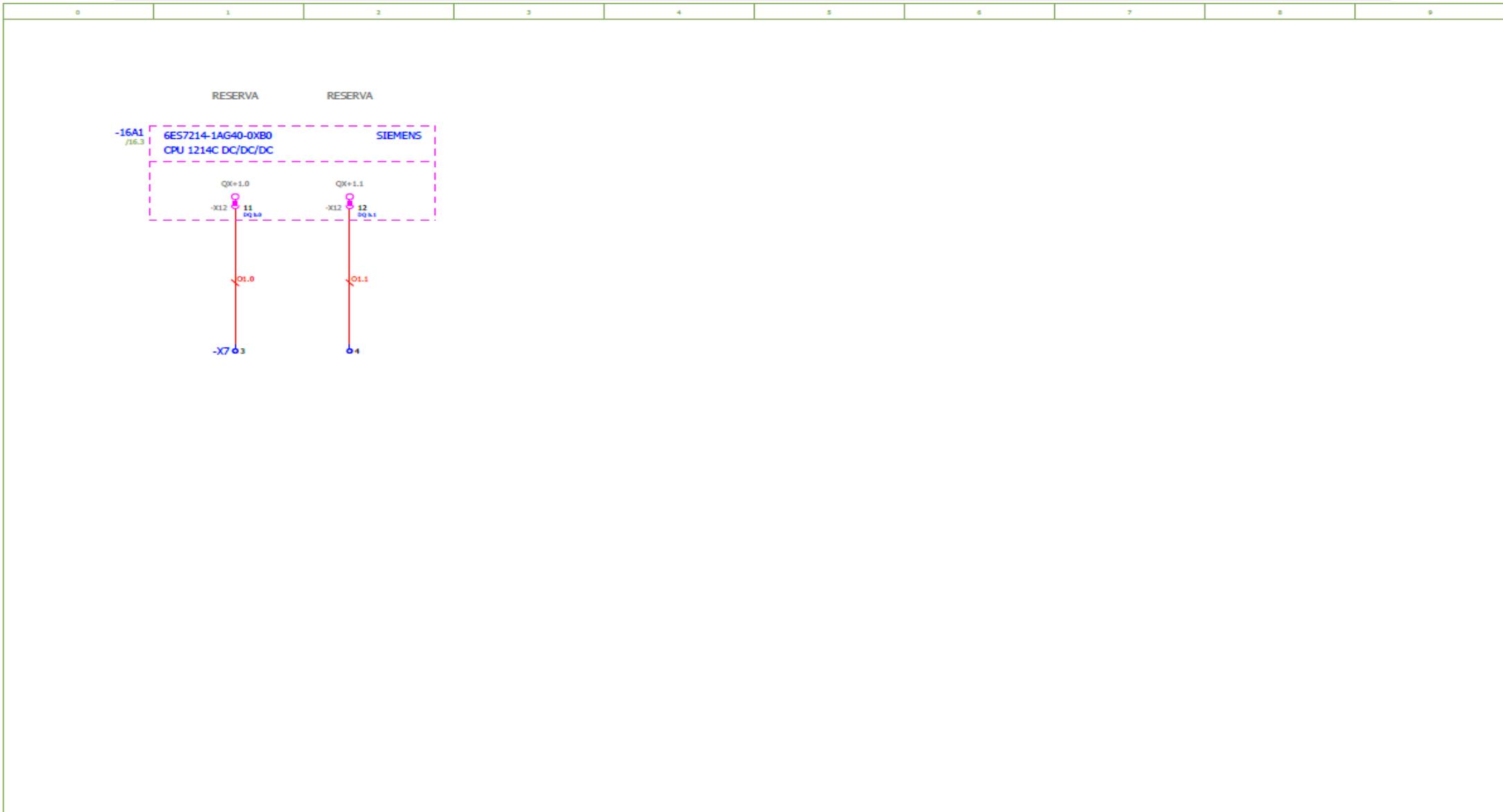


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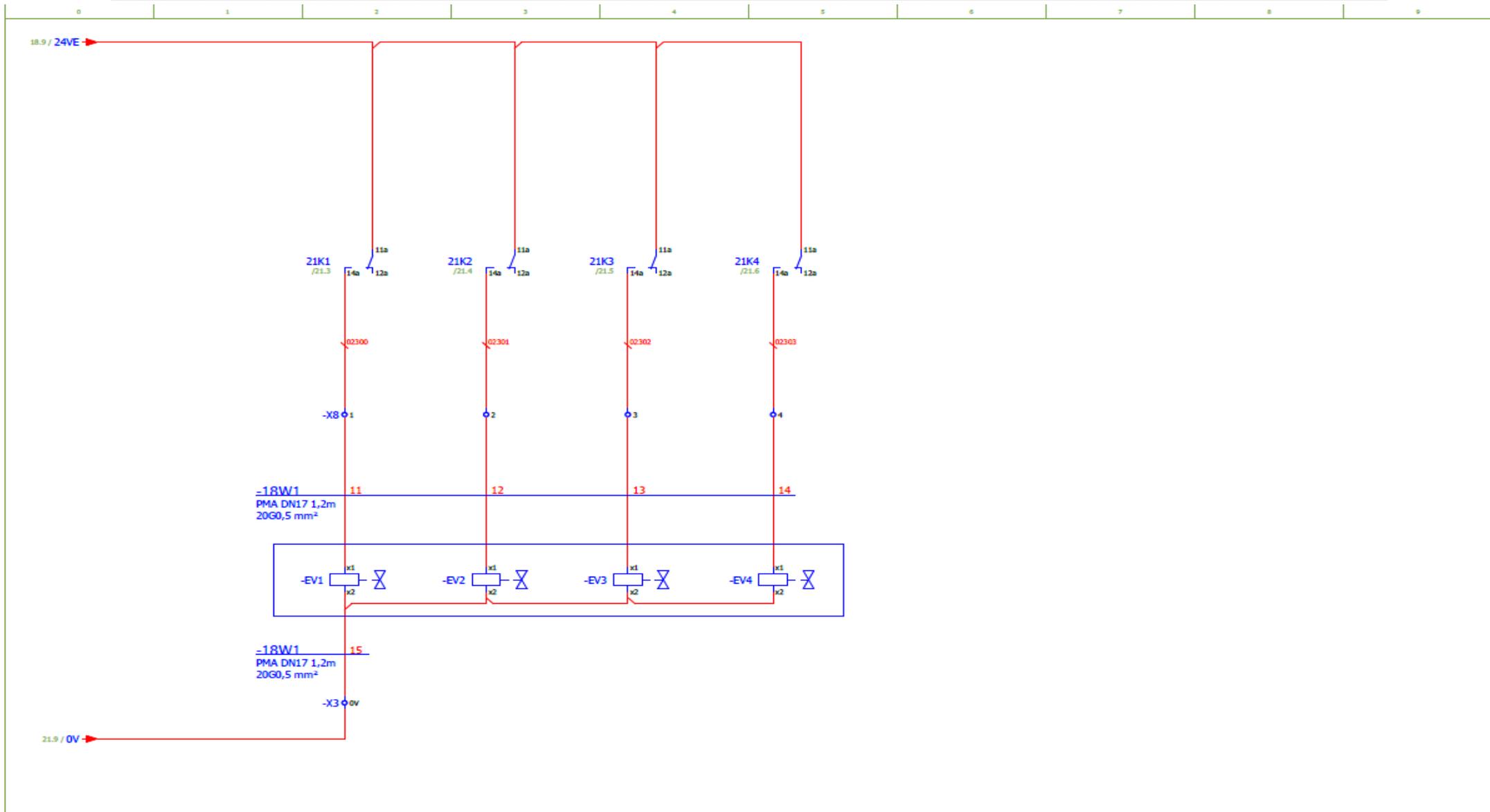
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## LAYOUT

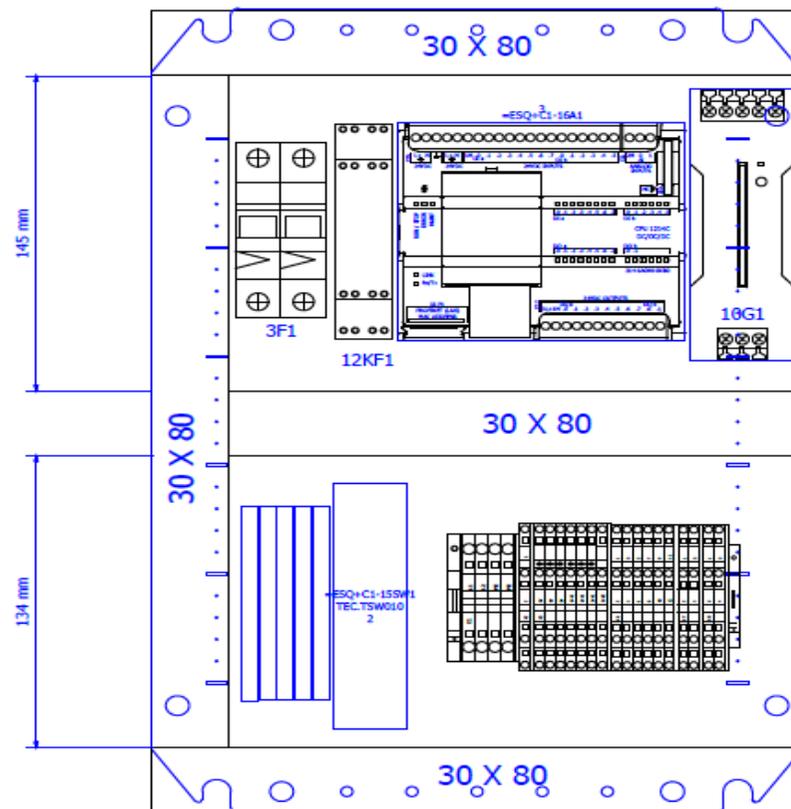
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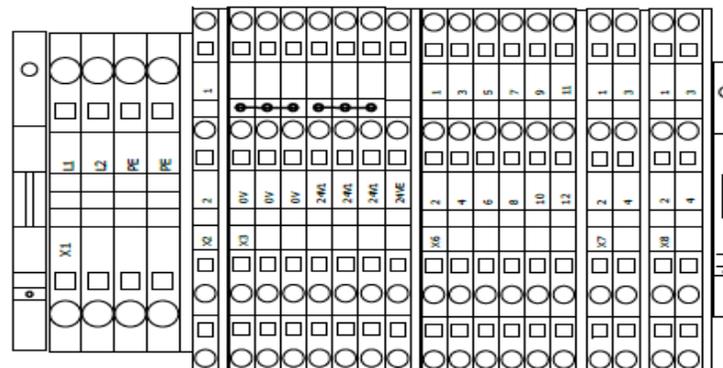
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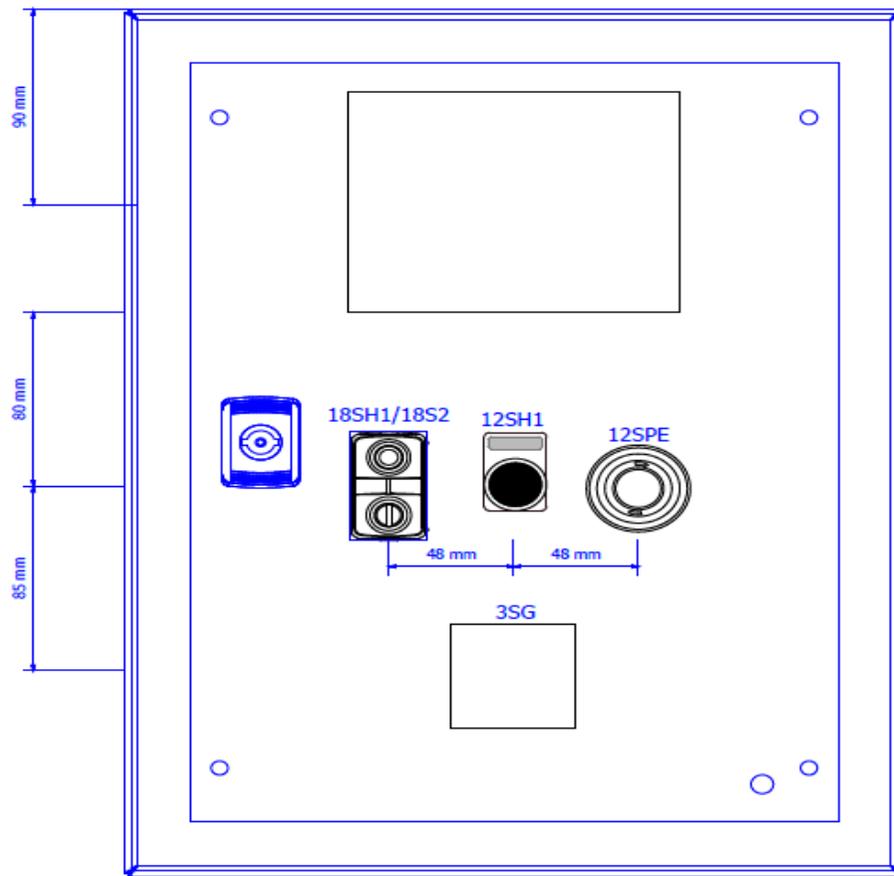
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	Maker		Approved by	J.S.P.				Page	72
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Model: VGN-22

ELDON 400x300x210  
 Ref: MAS0403021R5



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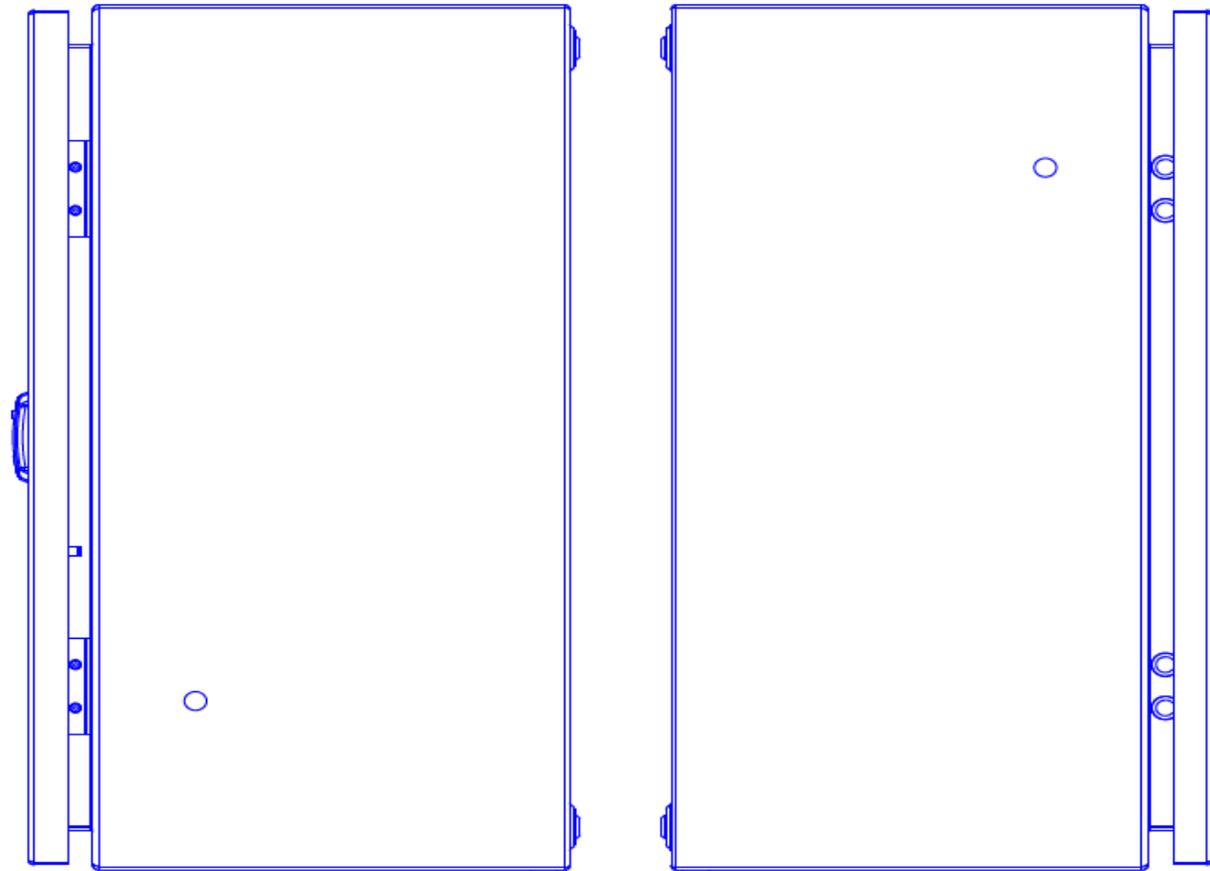


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Automatic V-guide notcher

Model: VGN-22

ELDON 400x300x210  
 Ref: MAS0403021R5



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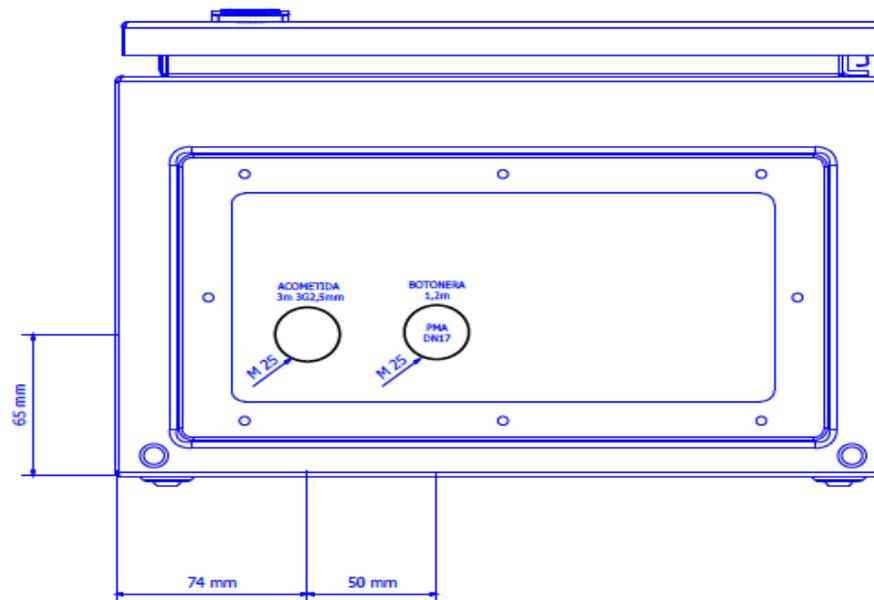


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Automatic V-guide notcher

Model: VGN-22

ELDON 400x300x210  
 Ref: MAS0403021R5



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