

Make it simple

Every component has a unique story.

It starts with the support of our technical team providing knowledge and expertise on materials, treatments and manufacturing processes. Production is fully monitored, managing a wide and differentiated range of cutting edge machinery. The entire manufacturing process is underpinned by a dedicated team that creates special tools and provides internal maintenance to prevent delays. Our quality control systems monitor precise manufacturing, even when thousandths are essential.

This is Gamba formula to respect commitments and make life simpler for our customers.



1935

Foundation year

110

Employees

11.000

Factory square meters

200

Machine tools

Predominantly high precision components

Gamba is specialized in manufacturing complex and high precision components for geometries, tolerances and difficult materials. Dimensions vary from 1 to 500 mm. Production lots are **spanning** from few dozens to thousands of units. They are required from different sectors such as hydraulic, tooling, textile machinery, premium automotive, electromechanics, food and medical machinery.

Multiple Materials

Gamba processes all main materials:

- Common and alloy steel, AVP
- Stainless steel, including duplex and super duplex
- Titanium
- Yellow and light alloys
- Plastic and composite materials
- Semi-finished materials as forged or molded parts

Turning

It's the main department, representing almost 50% of machinery.

- 4 CNC sliding headstock type bar lathes – size up to 25 mm
- 12 CNC fixed headstock bar lathes - size 45-65 mm
- 11 CNC fixed headstock for secondary operations - size up to 280 mm: (7 with gantry loader and 2 with hard turning equipment)
- 70 mechanical sliding headstock type bar lathes - size 1 to 25 mm

Milling

The milling department consists of 13 ISO 40 vertical machining centers with spindle speeds up to 20,000 rpm

- 4 5-axis
- 4 3-axis double pallet
- 5 3 or 4 axis single pallet

Grinding and honing

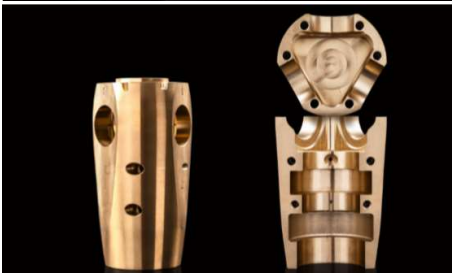
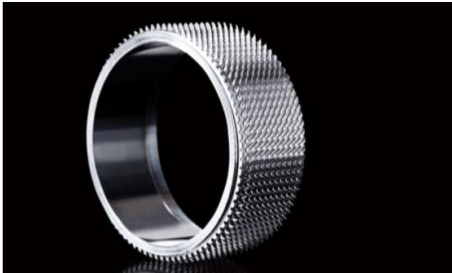
The grinding department has 17 machines of different types and is equipped with adequate instrumentation, including a motorized roundness measurement instrument, for the production of components with tolerances of even a few thousandths. The fleet includes:

- 4 external or external/internal CNC grinding machines
- 2 external hydraulic grinding machines with in-process electronic measuring head
- 2 manual external grinding machines for small size components
- 5 centerless (plunge and through feed)
- 2 hydraulic tangential grinding machines
- 1 CNC vertical honing machine
- 1 horizontal honing machine

Secondary manufactory processes

The secondary manufactory department consists of:

- 15 transfer machines with electro-pneumatic loading systems or robots
- 8 manual-loaded transfer machines
- 3 2-slides rolling machines
- 4 gear cutting machines up to module 1
- 1 laser marker
- 15 machines of various types
- 3 sandblasting machines
- 3 vibroblasting machines



Quality

A high trained and experienced team is essential when providing components that have geometric and dimensional tolerances of few thousandths of millimeters. A wide range of measurement equipment and monitoring process assist the department:

- Optical and contact measuring machines
- Roundness measurement machine
- About 500 manual tools
- About 1,000 threaded gauges
- About 3,000 gauges and dimes

The quality system has been certified since 1993 and updated to ISO 9001:2015 (Intertek No. 0614396-00).

Finishing and assembly

Experienced staff are in charge for deburring and any further need. In addition assembly and testing are provided internally.

Selected suppliers give support with thermal and galvanic treatments, with special attention when technical and aesthetic aspects are essential requirements.

Tooling, maintenance and automation

A team of 11 people, constantly trained with mechanical, electrical and electronic skills, support the engineering team by dealing with equipment, automation, maintenance and special tooling.

Reducing the dependence upon external suppliers, Gamba can maintain control over delivery times.

Technical advice

The long-standing experience supports customers to achieve their objectives of feasibility, accuracy, reliability and price. The department advises the most appropriate solutions including automation, dedicated equipment and special tools.

Gamba reproduces technical draws to guarantee anonymity during the production process.

Sales support

Gamba provides its customers with assistance at every stage with the immediate response from the sales team with written confirmation. Orders can be managed with pre-arranged delivery lots, scheduled up to one year, in order to reconcile cost effectiveness, flexibility and punctuality.

Sustainability

Gamba is a company surrounded by nature and has a conscious respect for it.

Only synthetic, biodegradable ester based coolants from vegetable products are used to protect employees health and environment.

Packing with strapped cardboard boxes allows complete recyclability.

An underground tank of more than 100 mc collects rainwater used in production processes.



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Department	Description	N.	Size	Supplier
CNC Lathes	CNC sliding headstock type	4	Ø 16-25	Citizen, Gildemeister
	CNC fixed headstock bar lathes	12	Ø 45-65	Biglia
	CNC fixed headstock for secondary operations	13	Ø 25-280	Doosan, Takamaz, Famar, Monforts
Mechanical lathes	Mechanical sliding headstock type bar lathes	70	Ø 1-25	Tornos, Peterman, Strohm
Vertical iso40 machining centers	3 or 4 axis	5	Max 1000	Kitamura, Doosan, Deckel Maho, Nikkei
	3 double pallet	4		
	5 axis	4	Max 630	Kitamura, Doosan, Nikkei
Grinding	CNC external / internal cylindrical grinding machines	4	Ø 130	Mar, Morara, Tacchella, Studer
	Centerless	5	Ø 80	Ghiringhelli
	Various	6	Ø 50	Morara, Lizzini
Honing	CNC vertical	1	Ø 12-120	Car
	Horizontal	1	Ø 4-25	Sunnen
Secondary operation machines	Transfer machines assisted by electro-pneumatic loading systems or by robots	25	Ø 25	Wirth & Gruffat
	Rolling machines	3	Max pitch 3	Magnaghi, Ort
	Gear hobbing machine up to Module 1	4	Max modulus 1	Gauthier
	Laser marker	1	Max 120	Keyence
Quality control	Roundness measuring machine	1		Taylor Hobson
	Contact 3d measuring machines	2		Hexagon
	Optical measuring machines	5		Hommel, Keyence, De Meet, ViciVision
	High precision linear heights	5		Mitutoyo
	Roughness tester	4		Zeiss-TSK, Mitutoyo, Mahr
	Digital measuring microscopes	6		Mitutoyo, Alpa, Jena
	Stereoscopic microscopes and other vision systems	9		Nikon, Vision
	Rockwell hardness tester	1		Alpa
Tooling and maintenance	Profile projectors	5		Baty, Galileo
	Lathes	10		Schaublin
	Milling machines	4		Elbo, Bridgeport, Schaublin
Washing and finishing	Tool machines	4		Ewag, Agathon
	Automatic metal washers	2		Ama universal
	Vibroblasting machines	3		Rollwash
	Sandblasting machines	3		Rollwash