

*Welcome to*

 **DAMBIS**  
JOINT STOCK COMPANY

*[www.dambis.com](http://www.dambis.com)*

## ***Basic facts about DAMBIS***

- JSC (joint stock company) Dambis was founded in 1992;
- Employees - in year 2014– 63;
- Turnover
  - in 2012 : 3.5 million EUR;
  - in 2013 : 4.1 million EUR;
- EN ISO 9001:2000 Quality Management System conformity certificate.
- EN ISO 14001:2004 Environmental Management System conformity certificate.
- Export to EU in year 2013 was 37% of turnover.

## *JSC DAMBIS main directions are:*

- **Metal working** - (CNC milling, turning, machining, cold stamping, workpiece cutting, welding, sheet material treatment – laser cutting, punching, bending).
- **Surface coating** – (shot-blast cleaning, vapour blasting, steel phosphatization, spray-powder coating).
- **Assembly works**

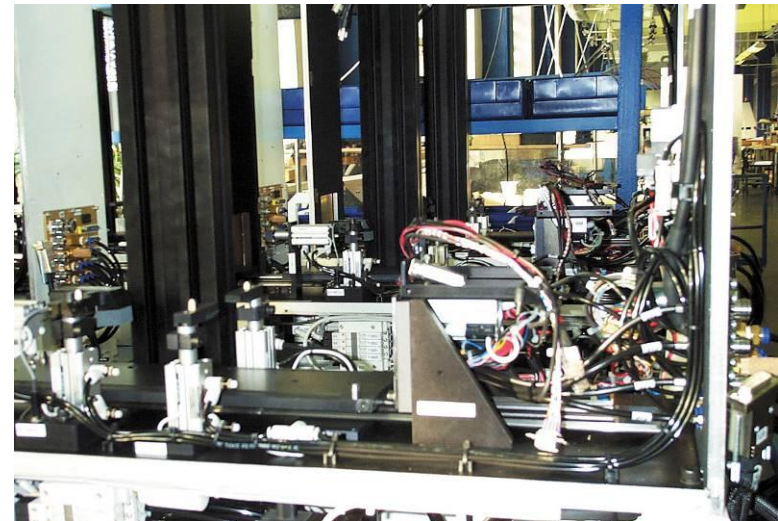
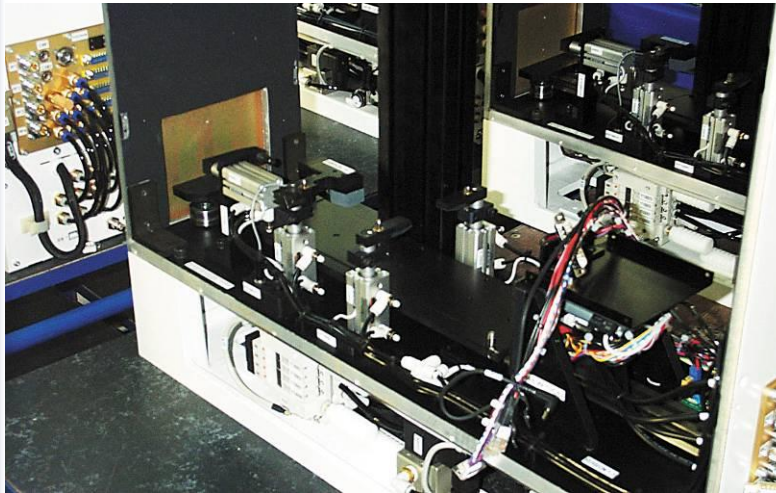
## *JSC DAMBIS main products are:*

**Electromechanical  
equipment;**

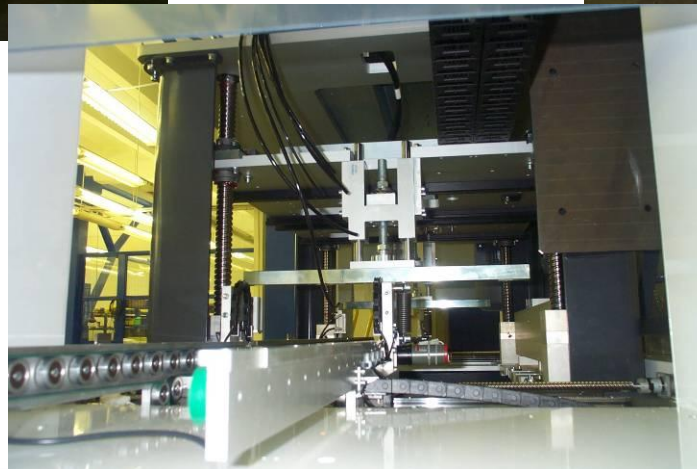
- **cabinets;**
- **boards;**
- **control boxes.**



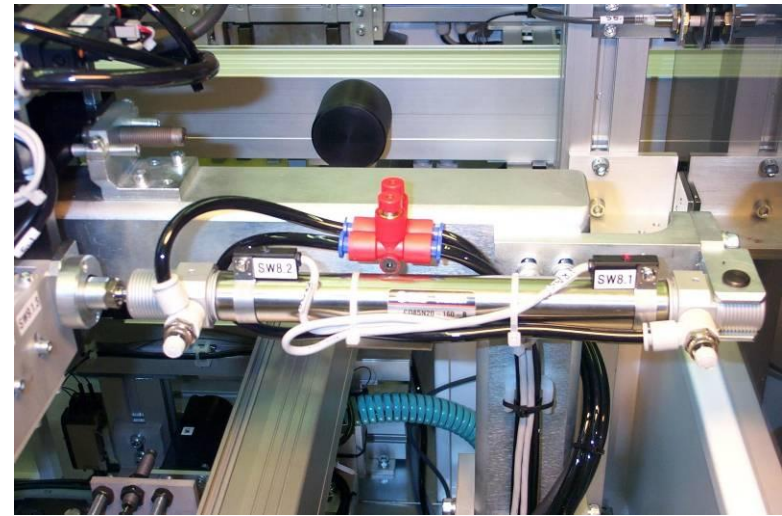
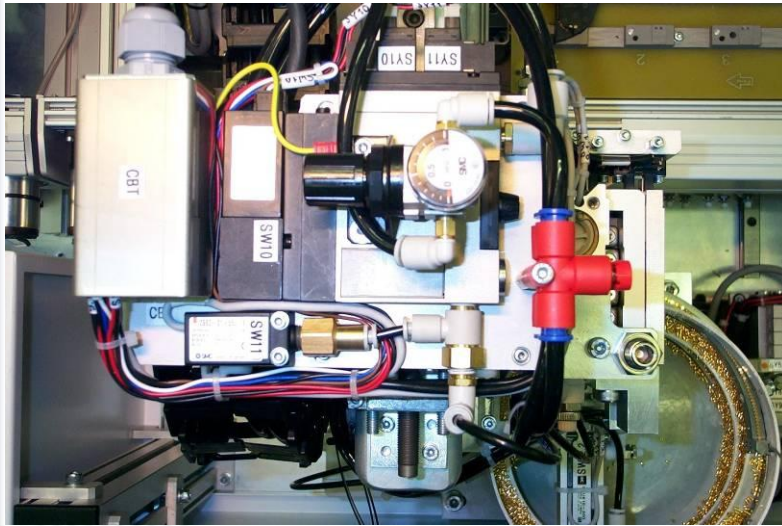
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## *JSC DAMBIS products are:*

**Foldable  
metal  
containers;**





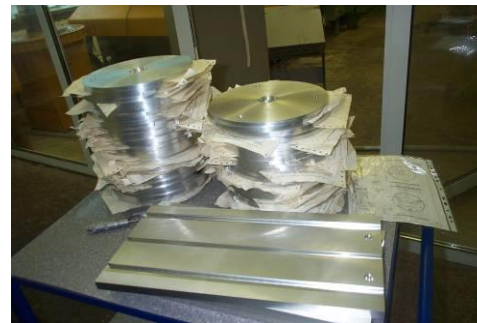
## *JSC DAMBIS products are:*

**Bent and welded  
metal structures;**



## *JSC DAMBIS products are:*

**Metal parts and  
articles, inclusive  
made on CNC  
machines;**



## *JSC DAMBIS machinery park:*

High investments were done to increase productivity and capacity, in year 2005 machine park JSC Dambis was completed with 15 new CNC machines and equipment including the ones in next slides.

- CNC Vertical Machining Centre with accessories;
- CNC Horizontal Machining Centre with accessories;
- CNC Two-spindle Turning-Milling Centre with accessories;
- CNC Hydraulic pressbrake with accessories;
- CNC Hydraulic coordinate punch press with accessories;
- CNC Laser cutting equipment with accessories;
- Lathe with accessories and Lathe with electronic control;
- CNC Hydraulic quilloine shear and accessories;
- CNC Semi-automatic tube bending equipment with accessories;

## *CNC coordinate meter equipment MITUTOYO CRYSTA-APEX C 9166*

Range of measurement: X = 905 mm, Y = 1605 mm, Z = 605 mm

Resolution = 0,0001 mm

Drive speed/CNC mode:

max.moving speed = 520 mm/s (3D)

max.measuring speed = 8 mm/s

Drive speed / Joystick mode:

moving speed = 0 – 80 mm/s

Measuring speed = 0 – 3 mm/s

Max.acceleration: 0.23G (3D)

Measurement table:

Material – granite stone

Size – 1060 x 2320 mm

Workpiece:

Max.height: 800 mm

Max.weight: 1500 kg

Width: 1670 mm

Depth: 2690 mm

Height: 2730 mm



## *CNC Laser cutting equipment TRUMPF TRUMATIC L3020*

Workspace – X = 3000 mm without repositioning  
Y = 1500 mm  
Z = 115 mm

Machine tolerances according VDI /DGQ 3441 - < + /- 0.1 mm/ m

Nominal laser power = 3200 W

Maximum plate of mild steel thickness = 20 mm

Maximum aluminium plate thickness = 8 mm



## *CNC Hydraulic coordinate punch press TRUMPF TRUMATIC 200R*

Press capacity = 20 t

Brush table

Sheet size without repositioning X = 2070 mm, Y = 1270 mm

Sheet size with one repositioning X = 4000 mm, Y = 1270 mm

Sheet thickness = 6.4 mm

Position accuracy < +/- 0.1 mm

Number of tools with

Multitools system = 90 pcs max

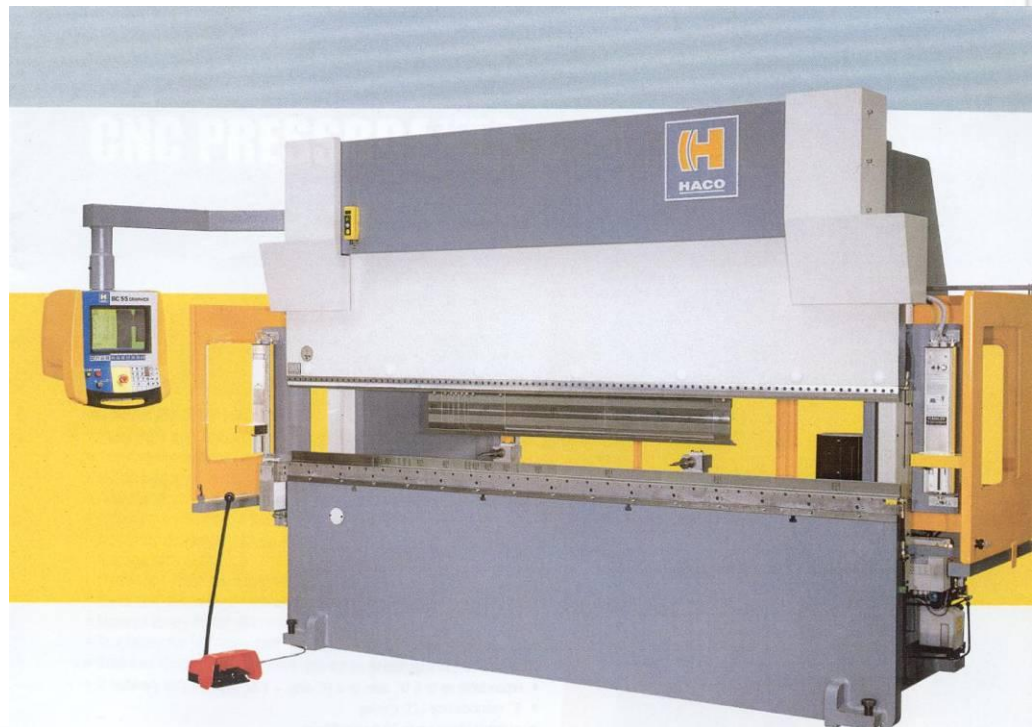
Incl. number of

rotating tool stations = 15 pcs



## *CNC Hydraulic pressbrake HACO EUROMASTER 30150*

Capacity = 150 t  
Frame distance = 2600 mm  
Working length = 3100 mm  
Stroke length - 200 mm  
X distance = 1000 mm  
Open height = 400 mm  
Hydraulic sheet  
following system  
Axes control = 6



## *CNC Hydraulic guillotine HACO TSX 30121 SAB*

Capacity mild steel - 0.5 - 12 mm  
Cutting length = 3050 mm  
Power backgauge stroke = 1000 mm  
Swing – away backgauge stroke  
Control: Enter the sheet thickness;  
Automatic cutting angle adjustment  
as a function of sheet thickness;  
Automatic hydraulic blade gap adjustment  
as a function of sheet thickness;  
Stroke control adjustment;  
Automatic position of the backgauge –  
position with electronic read – out;  
Automatic programmable  
retraction of backgauge;  
Back soft sheet support.





## *CNC Vertical Machining Centre HAAS VF-7/50-Taper*

Travels (mm) :X = 2134 ; Y = 813 ; Z = 762

Table size (mm) Length = 2134 ; Width = 711

Spindle: Taper size CT 50

Speed (rpm) = 7500

Spindle motor power (kW) - 22.4

Automatic tool changer:

Capacity - 30 + 1

Accuracy (mm) :

Positioning  $\leq \pm 0.00762$

Repeatability  $\leq \pm 0.00508$

4 – axis control



## *CNC Horizontal Machining Centre BRIDGEPORT HMC 700e*

Travels (mm) : X = 710 ; Y = 610 ; Z = 610  
Pallet changer ( 2 pallets ) size = 500 x 500 mm  
Spindle: Taper size BT 40  
    Speed (rpm) = 10000  
    Spindle motor power (kW) = 18  
Automatic tool changer (taper BT 40) :  
    Capacity - 60  
Accuracy (mm) :  
    Positioning  $\leq \pm 0.0075$   
    Repeatability  $\leq \pm 0.004$   
4 axis control



## *CNC Two-spindle Turning-Milling centre GOODWAY GS-280MS*

**Chuck size = 10"**

**Bar capacity (max) = 75 mm**

**Max turning diam. = 400 mm**

**Max turning length = 590 mm**

**Main spindle: Speed (rpm) = 40 - 4000**

**Main motor = 15 kW**

**Sub-spindle: Bar capacity = 30 mm**

**Speed (rpm) = 60 - 6000**

**Spindle driven motor = 7.5 kW**

**Rotating power turret head positions = 12**

**Accuracy (mm) : Positioning  $\leq \pm 0.005$**

**Repeatability  $\leq \pm 0.003$**

**Travels (mm) : X = 260 ; Z = 630**

**Automatic bar feeder: Bar length = 3300 mm;**

**Bar diameter min = 8mm, max = 75 mm**

- ▶ 30° slant-bed design provides smooth chip disposal and easier operator access.
- ▶ Stainless steel way covers and special steel wipers molded with industrial strength rubber are used for durability.
- ▶ Fully enclosed splashguards keep chips and coolant contained for a safe clean working environment.



- ▶ The auto lubrication system delivers metered amounts of lubrication to the slide ways, ball screws, and vital components. Distribution is automatically shut off during idling to prevent waste. (GS-280MS model shown with optional access)

\*1 Individual models may vary, please see "Specification" page or interference drawings for details.

\*2 Optional 10" Big-bore hydraulic cylinder & chuck provide  $\varnothing 78$  mm (3.07") bar capacity.

## *CNC PINACHO lathe MUSTANG 225x1500*

Swing over bed = 450 mm

Distance between centres = 1500 mm

Main spindle: Spindle bore = 65 mm

Speed variable (rpm) = 0 - 3000

Main motor = 7.5 kW

Automatic turret head positions = 8



## *DAMBIS offers in 2014*

- **Precise metal working:**
  - CNC turning;
  - CNC milling;
- **Sheet metal working, i.e:**
  - CNC laser cutting (table size 3000x1500mm);
  - CNC bending (table length 4000mm);
  - Punching;
- **Laser cut, punched, bent and welded steel structures and articles;**
- **Surface coating:**
  - Blasting
  - Wet and powder painting.

## *Cooperation partners*

**K.HARTWALL**



*Saves Your Energy*

**DIEFFENBACHER**



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