

# GUN-DRILLING

**Westcoast Cylinders Inc.** now offers a Gun-drilling service.

Gundrilling (also called Deep Hole Drilling) creates a deeper hole than conventional drilling. We offer 150 times the diameter and up.

Print and fax the following form for a direct quote on your gun-drilling needs.

**Quantity**

**Material**

CPO (Chromed Steel Bar (C1045 or equivalent))

IHCP (Induction Hardened Chrome Polished)

Stainless Steel. Grade =

Nitrotec

Other. Please provide details

Mat'l by Customer     Mat'l by Westcoast Cylinders Inc.

**Material diameter**  inches

**Length of material**  inches

**Depth of Blind hole**  inches    or     Through-Hole

**Diameter of Hole\***  inches

\*we offer 1/2" diameter standard; other sizes are available.

**Contact (name & co.)**

**Contact (ph/fax/email)**

Contact our Sales department for more information on our Gun-drilling service.



Telephone: **604.527.1120**  
Fax: **604.527.1170**  
Email: **sales@royalcylinders.com**  
Website: **www.royalcylinders.com**



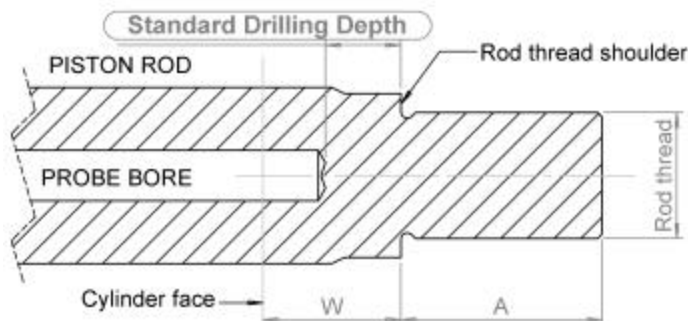
## NEW GUN-DRILLING CAPABILITY

**Westcoast Cylinders Inc.** is pleased to announce the acquisition of a gun-drilling machine. We can now offer in-house gun-drilling service – for details please contact our Inside Sales department.

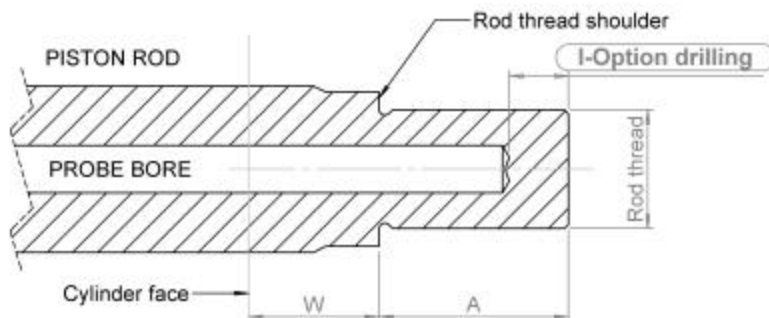
Gun-drilled piston rods, used in our Linear Positioner, Series T3H and T4H cylinders, provide several advantages - see below.



- **The piston rod is stronger** in the area of the rod thread undercut/rod shoulder because it is drilled to depth versus being hollow throughout (see illustration).
- Gun Drilling also **eliminates a potential leaking point** should the rod be damaged or fail in this area. Hollow rod also had a potential leak point at the rod plug – now eliminated. WCI can Gun Drill the rod to depth to suit your requirements.



- As a standard, all rods with male thread options are drilled deeper than the stroke of the cylinder. WCI does this so that **our cylinders may be able to accommodate probes that are a standard length.** For example, a cylinder with a 10 1/2" stroke may be able to fit a standard length probe with an electrical stroke of 12". Please reference version 5.5.5 of the Royal DXF generator software which will display what electrical stroke a cylinder can fit, as well as provide options to increase the electrical stroke, as explained below.
- **Electrical Stroke Extension, I-Option.** This option provides a deeper hole to suit longer probes. It matches the probe hole depth of cylinders that were produced prior to January 2006 (made with hollow shafting) and is the maximum drill depth that can be achieved without drilling right through the rod. With this option, the addition of a rod or a thread extension, or both, will further increase the length of probe that the cylinder can fit. This option is not available for Female Rod threads. *The I-option should also be selected for spare parts orders when the actual probe length is unknown.*



- **Rod Extension, W-Option.** A rod extension is the only way to increase the probe length with rods that are drilled per WCI's standard (I-Option not chosen). This is applicable to both male and female thread options.



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