

## BA 4100 Series Product and Safety Information



### PRODUCT

**BA 4100 Series Composite Sealant Remover (CSR)** is a rotary cutter designed to remove sealant directly at the bond line. BA 4100 Series CSR is made from durable Torlon® material that can remove sealant in many applications at a lower product cost with greater efficiency and productivity. For aerospace application, BA 4100 Series CSR is safe to use on common protective coatings and structural materials.

### Installation

BA 4100 Series CSR can be used on rotary tools with 1/4"-28 UNF, 1/4" collet, and drill chuck interfaces. Screw in or attach/lock into rotary tool. A 1/4"-28 UNF to straight shank adapter may also be used with collet and drill chuck interfaces to attach the CSR.



*Attaching CSR to 1/4"-28 UNF interface*



*Attaching CSR to 1/4" collet interface*



*Attaching CSR to drill chuck interface*



*Attaching CSR with straight shank adapter*



## Rotational Speed

The BA 4100 Series CSR cuts sealant by rotating in the clockwise direction. Recommend to operate the CSR at 200-400 RPM for better controllability while avoiding heat buildup. Heat will accelerate wear on the CSR and may generate undesirable odor from the sealant.

The best way to determine the RPM is by calibrating the rotary tool of choice. However, it is possible to approximate the RPM by a visual method as follows to prolong the life of the CSR:

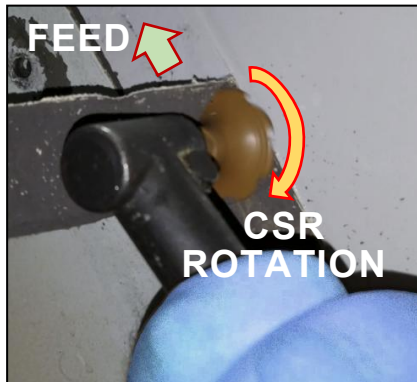


1. Place a marker on the CSR such as a white dot as shown.

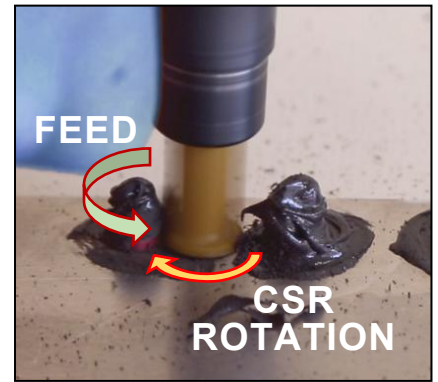
2. Attach the CSR to the rotary tool of choice. Rotate and adjust to visually achieve the approximate RPM. At 300 RPM, the marker is visually observable to complete each revolution and allowing the counting of 5 revolutions per second. At 400 RPM, the marker should start to blend/blur but the completion of each revolution is still observable. At 500 RPM and above, the marker would start to be a blurring trail making the completion of each revolution difficult to observe.

## Usage

For general application, use the BA 4110 to engage an edge of the sealant and feed the rotating action to cut at the bond line. To remove sealant around a fastener, use BA 4115 or BA 4120 to engage an edge of the sealant and feed the rotating action counter-clockwise around the fastener. Allow the CSR to rotate and cut the sealant while gradually feed without excessive force.



BA 4110 – General purpose use



BA 4115/4120 – Sealed fasteners

## SAFETY

Read all safety information before using this product.



- Wear eye and ear protection
- Wear face protection
- Wear hand protection – CSR contains sharp edges

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AS9100D + ISO9001:2015

- Avoid contact with flesh and/or clothing while the CSR is rotating
- Avoid direct impact against hard objects while the CSR is rotating
- Avoid excessive feeding force when cutting into the sealant material
- Avoid unnecessary damage – Test and familiarize with the CSR action on a similar surface before proceeding

## Made in the USA

Approval: Boeing BAC5000, MHIRJ, USAF