



TECHNICAL INFORMATION

BEST-MK 1312

BEST-MK 1312 is a one-component, solvent-free, high strength and capillary anaerobic curing adhesive based on di-methacrylate-ester.

BEST-MK 1312 is especially recommended for bonding of coaxial parts like bushings and bearings and for sealing of cast iron parts. It is also recommended for subsequent bonding and securing of thread connections and repairs of hairline cracks in metal casings.

BEST-MK 1312 combines high strength with excellent chemical resistance. The break loose moment is very high. Disassembly of thread connections might cause damage to thread or screw. The low viscosity provides a good capillary action supporting an even distribution of the product on the bonding surfaces. The adhesive is especially recommended for subsequent application. Due to its low viscosity the adhesive fills in gaps and very fine hairline cracks and cures in place.

PROPERTIES (liquid product)

Chemical type	Di-methacrylate-ester
Curing system	Anaerobic
Appearance	Green
Strength class	High
Viscosity (Brookfield)	12 mPas
Thread size	
application of adhesive before assembly of parts	up to M5
application adhesive after assembly of parts	all thread sizes
Density (DIN 51757)	1,1 x 10 ³ kg/m ³
Max. gap filling	0,01 – 0,05 mm
Thread friction	0,17
Shelf life (Storage in unopened original container at 10°C up to 23°C)	12 months
<u>Curing time @23°C</u>	
Fixture time	2 to 10 minutes
Functional strength	2 – 4 hours
Final strength	8 hours



STRENGTH VALUES (cured product)

Compression shear strength (DIN 54452)	25 N/mm ²
Breakloosemoment (DIN 54454)	35 Nm
Breakawaymoment (DIN 54454)	45 Nm
<u>TEMPERATURE RANGE</u>	-60°C – +150°C

CHEMICAL AND ENVIRONMENTAL RESISTANCE

(DIN 53287 – Test in accordance with DIN 54454)

in % of the initial strength after 1000h chemical absorption

Water/Glycol at 87°C	95 %
Motor oil (MIL-L-46 152) at 125°C	100%
Unleaded Gasoline at 23°C	95%
Brake fluid at 23°C	95%
1,1,1 trichlorethane at 23°C	95%
Ethanol at 23°C	100%
Acetone at 23°C	95%

For more information on resistance against other chemicals please contact BEST-Klebstoffe.

HEALTH AND SAFETY STANDARDS

This product has been classified as *Xi* irritant, irritates eyes and skin! General rules regarding handling of chemicals apply. For further information please see corresponding material safety data sheets.

General

The data and information above correspond to the current know-how of BEST-Klebstoffe GmbH & Co.KG. Our information and data have been developed from laboratory tests and extensive practical experience. It is the user's responsibility to perform receiving inspections and to determine suitability for the user's purpose of any production methods. We disclaim all warranties expressed or implied, that any product will have specific properties for a particular purpose. BEST-Klebstoffe GmbH & Co. KG reserves the right to change the contents of this document as necessary.

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