



TECHNICAL INFORMATION

BEST-MK 1325

BEST-MK 1325 is a one-component, solvent-free, high strength and low viscous anaerobic curing adhesive based on di-methacrylate-ester.

BEST-MK 1325 is designed for permanent securing and sealing of threads. It is also recommended for bonding of coaxial parts, bearings and bushings.

BEST-MK 1325 combines high strength with excellent chemical resistance. The breakloose 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.

PROPERTIES (liquid product)

Chemical type	Di-methacrylate-ester
Curing system	Anaerobic
Appearance	Green
Strength class	High
Viscosity (Brookfield)	500 mPas
Density (DIN 51757)	1,1 x 10 ³ kg/m ³
Thread size	up to M20
Max. gap filling	0,05 – 0,15 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)	36 Nm
Breakawaymoment (DIN 54454)	43 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	90 %
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	90%

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

HEALTH AND SAFETY STANDARDS

This product is not classified as dangerous according to regulation (EC) 1272/2008. 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.

Revision: 130524
Revision Date: 24.05.2013