

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	Dimethacrylate ester
Curing system	anaerobic
Colour	blue
Strength	high strength
Viscosity (Brookfield) Sp. 2/30 RPM @25°C	500 - 800 mPas
Density (DIN EN 542)	1,1 x 10 ³ kg/m ³
Thread sizes	up to M20
Bonding gap	0,05 – 0,15 mm
Thread friction	0,17
<u>Shelf life in unopened original container</u> (Storage temperature 8 to 21°C)	24 months
<u>Shelf life in unopened original BULK</u> (Storage temperature at 8 to 16°C)	3 months

Curing time @23°C

Fixture time	2 - 10 min.
Functional strength	2 - 4 hrs.
Total curing time	8 hrs.

**STRENGTH VALUES (cured product)**

Compression/shear strength (DIN 15337)	25 N/mm ²
Breakloose Moment (DIN 158656)	36 Nm
Breakaway Moment (DIN 158656)	43 Nm
Temperature range	-60°C - +150°C

CHEMICAL AND ENVIRONMENTAL RESISTANCE**(DIN 53287 – Test in accordance with DIN 158656)**

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. They shall not release any customer from the duty to perform receiving inspections and to do test runs in view of any intended use, nor do they constitute a representation that any product will have specific properties or be suitable for any definite use. BEST-Klebstoffe GmbH & Co. KG reserves the right to change the contents of this as necessary.

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