

TECHNICAL INFORMATION

BEST-MK 1331

BEST-MK 1331 is a one component, solvent free, high strength anaerobic curing adhesive based on Dimethacrylate ester. The viscosity is medium.

BEST-MK 1331 is the standard product for permanent locking and sealing of threaded fasteners. Disassembly extremely difficult. Also recommended for bonding of coaxial parts, bearings and bushings and pipe sealing.

BEST-MK 1331 combines high strength with excellent chemical resistance. The “breakloose” moment with threaded fasteners is extremely high and could cause the fastener to break or damage the thread if removed. The medium viscosity provides a good fluid action which supports the adhesive distribution on the to be bonded surfaces.

PROPERTIES (liquid product)

Chemical Type	Dimethacrylate ester
Curing system	anaerobic
Colour	green
Strength	high
Viscosity (Brookfield)	1.000-2500 mPas / thix
Density (DIN EN 542)	1,1 x 10 ³ kg/m ³
Thread sizes up to	M12
Bonding gap	0,04 – 0,25 mm
Thread friction	0,16
<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 8 to 16°C)	ca. 3 months

Curing time @23°C

Fixture time	2 - 10 min.
Functional strength	2 - 3 hrs.
Total curing time	8 hrs.

STRENGTH VALUES (cured product)

Compression/shear strength (DIN 15337)	25 N/mm ²
Breakloose Moment (DIN 15865)	30 Nm
Breakaway Moment (DIN 15865)	35 Nm
Temperature range	-60°C bis +150°C

CHEMICAL AND ENVIRONMENTAL RESISTANCE
(DIN 53287 - test in accordance to DIN 15865)

in % of the initial strength after 1000h Chemical absorption

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

For resistance against other chemicals, please check the chemical resistance listing.

HEALTH AND SAFETY STANDARDS

This product is not classified as dangerous according to regulation (EC) 1272/2008. General knowledge for safe handling of chemicals are recommended. Please consult EU – Safety Data Sheet for further information.

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 its 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 document as necessary.

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