

## TECHNICAL INFORMATION

### BEST-MK 1523

**BEST-MK 1523** is a one component, solvent free, high strength anaerobic curing adhesive based on Dimethacrylate ester. The viscosity is medium.

**BEST-MK 1523** is especially recommended for bonding of coaxial parts, bearings and bushings with high temperature resistance requirements. Disassembly is extremely difficult. Also recommended for permanent locking and sealing of threaded fasteners.

**BEST-MK 1523** combines high strength with excellent heat and chemical resistance. The “break loose” 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 adhesive distribution on the bonding surfaces.

### PROPERTY (liquid product)

Chemical Type	Dimethacrylate ester
Curing system	anaerobic
Colour	green
Strength	heat resistant
Viscosity (Brookfield 25°C) Sp. 3/30 RPM	200-450 mPas
Density (DIN EN 542)	1,1 x 10 <sup>3</sup> kg/m <sup>3</sup>
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 in unopened container at 8°C to 21°C)	24 months
<u>Shelf life in unopened original BULK</u> (Storage in unopened container at 8 to 16°C)	3 months

### Curing time @23°C

Fixture time	5 - 15 min.
Functional strength	2 - 4 hrs.
Total curing time	12 hrs.

**STRENGTH VALUES (cured product)**

Compression/shear strength (DIN EN 15337)	at RT	24 N/mm <sup>2</sup>
	at 200°C	23 N/mm <sup>2</sup>
Break loose Moment (DIN EN 15865)		38 Nm
Breakaway Moment (DIN EN 15865)		50 Nm
Temperature range		
at bolted connection		-60 to +220°C
at assembly parts		-60 to +220°C

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

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	100%
Brake fluid at 23°C	100%
1,1,1 Trichlorethane at 23°C	100%
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**

Hazard Statements: Causes skin irritation. May cause an allergic skin reaction. Causes serious eye damage. May cause respiratory irritation. Toxic to aquatic life with long lasting effects. 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 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.

Revision: 180418

Revision date: 18.04.2018