



TECHNICAL INFORMATION

BEST-MK 3247

BEST-MK 3247 is a one-component, solvent-free, medium strength, and high viscous anaerobically curing adhesive based on di-methacrylate-ester.

BEST-MK 3247 is the standard product for securing and sealing of pipe connections and the sealing of surfaces.

Due to its viscosity **BEST-MK 3247** is run resistant even when applied on vertical surfaces. Disassembly for repair is possible with regular tools without damaging the thread.

PROPERTIES (liquid product)

Chemical type	Di-methacrylate-ester
Curing system	Anaerobic
Appearance	blue
Strength class	medium
Viscosity (Brookfield)	70.000 mPas/pasty
Density (DIN 51757)	1,1 x 10 ³ kg/m ³
Thread size	up to R5"
Max. gap filling	0,1 – 0,3 mm
Thread friction	0,17
Shelf life <small>(Storage in unopened original container at 10°C up to 23°C)</small>	12 months
<u>Curing time @23°C</u>	
Fixture time	2 to 15 minutes
Functional strength	2 – 4 hours
Final strength	10 hours



STRENGTH VALUES (cured product)

Compression shear strength (DIN 54452)	17 N/mm ²
Breakloosemoment (DIN 54454)	17 Nm
Breakawaymoment (DIN 54454)	< M-LB
<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	100%
1,1,1 trichlorethane at 23°C	90%
Ethanol at 23°C	90%
Acetone at 23°C	95%

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.

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