

TECHNICAL INFORMATION BEST-MK 3247

BEST-MK 3247 is a one component, solvent free, low strength anaerobic curing adhesive based on Dimethacrylate ester. The viscosity is medium.

BEST-MK 3247 is the standard product recommended for sealing of flanges and pipe threads. Also recommended for locking and sealing of threaded fasteners, which require normal disassembly with standard hand tools.

BEST-MK 3247 has a flow behavior, which provides for no running off even on vertical expanses. The connection can be loosened without damage of threads in case of repair.

PROPERTIES (liquid product)

Chemical Type	Dimethacrylate ester
Curing system	anaerobic
Colour	blue
Strength	medium
Viscosity (Brookfield)	600.000 - 1.200.00 mPas / paste-like
Density (DIN EN 542)	1,1 x 10 ³ kg/m ³
Thread sizes up to	R5"
Bonding gap	0,10 – 0,30 mm
Thread friction	0,17
<u>Shelf life in unopened original container</u> (Storage temperature at 8 to 21°C)	2 Years
<u>Shelf life in unopened original BULK</u> (Storage temperature at 8 to 16°C)	ca. 3 months

CURING TIME @ 23°C

Fixture time	2 - 15 min.
Functional strength	2 - 4 hrs.
Total curing time	10 hrs.



STRENGTH VALUES (cured product)

Compression/shear strength (DIN EN 15337)	17 N/mm ²
Breakloose Moment (DIN EN 15865)	17 Nm
Breakaway Moment (DIN EN 15865)	<M-LB
Temperature range	-60°C bis +150°C

ENVIRONMENTAL AND CHEMICAL 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	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 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 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. All information and data is based on 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 for changes necessary for technical improvements.

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