

## TECHNICAL INFORMATION

## BEST-MK 4422

**BEST-MK 4422** is a one-component, solvent free, super strength, oil tolerant and low viscous anaerobically curing adhesive based on di-methacrylate-ester.

**BEST-MK 4422** is especially recommended for fastening of coaxial components, e. g. bearings, bushings and shaft-hub-connections. Due to its high viscosity it even bridges uneven areas. Other fields of application are the securing and sealing of threaded connections as well as – in combination with our activator BEST-Aktiv A the planar bonding of rubber with metals, metals with glass or ceramics and metals/metals.

**EST-MK 4422** combines extremely high strength with very good temperature and chemical resistance. Compressive shear tests show very good values under temperature as well as on oily adherends. Even on not thoroughly cleaned surfaces BEST-MK 4422 reaches very high strength. The strength values achieved in threaded connections might cause damage to screw or thread during disassembly. The low viscosity allows a good distribution and capillary action on the adherends.

PROPERTIES (liquid product)

Chemical type	Di-methacrylate-ester
Curing system	Anaerobic
Appearance	green
Strength class	Super strength
Viscosity (Brookfield)	200 mPas
Density (DIN 51757)	1,1 x 10 <sup>3</sup> kg/m <sup>3</sup>
Thread size	Up to M12
Max. gap	0,05 – 0,15 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	1 to 7 minutes
Functional strength	1 – 2 hours
Final strength	8 hours



**STRENGTH VALUES (cured product)**

Compression shear strength (DIN 54452)	
@ RT	37 N/mm <sup>2</sup>
@ 200°C	26 N/mm <sup>2</sup>
Breakloosemoment (DIN 54454)	50 Nm
Breakawaymoment (DIN 54454)	60 NM

**TEMPERATURE RANGE**

Threaded connections	-60°C – +175°C
Coaxial Components	-60°C – +220°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	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 more information on resistance against other chemicals please contact BEST-Klebstoffe.

**HEALTH AND SAFETY STANDARDS**

Warning! Causes skin irritation. Causes serious eye irritation. May cause an allergic skin reaction. May cause respiratory irritation. 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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