

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.

BEST-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 adherents. 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 adherents.

Product characteristics

Chemical Type	Dimethacrylate ester
Curing system	anaerobic
Colour	green
Strength	super high
Viscosity (Brookfield 25 °C) Sp. 2/30 <rpm	500 mPas
Density (DIN EN 542)	1,1 x 10³kg/m³
Thread sizes up to	M12
Bonding gap	0,05 – 0,15 mm
Thread friction	0,17
Shelf life Storage in unopened container at 10 to 23°C)	2 Years
Shelf life Storage in unopened container at 8 to 16°C)	3 months

Curing time at 23°C

Fixture time	1 - 7 min.
Functional strength	1 - 2 hrs.
Total curing time	8 hrs.

**Strength of cured Material****Compression/shear strength (DIN EN 15337)****@23°C 37 N/mm²
@200°C 26 N/mm²****Breakloose Moment (DIN EN 15865)****50 Nm****Breakaway Moment (DIN EN 15865)****60 Nm****Temperature range****thread locking****-60°C up to +175°C****bonding of coaxial parts****-60°C up to +200°C****Chemical/Solvent 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.

Industrial health and safety standards

Hazard Statements: Causes skin irritation. May cause an allergic skin reaction. Causes serious eye irritation. May cause respiratory irritation.

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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