

TECHNICAL INFORMATION

BEST-MK 4425

BEST-MK MK 4425 is a one-component, solvent free, super strength and low viscous anaerobically curing adhesive based on di-methacrylate-ester.

BEST-MK MK 4425 is especially recommended for bonding of coaxial components, e. g. bearings, bushings and shaft-hub-connections. Another field of application is the securing and sealing of threaded connections.

BEST-MK MK 4425 combines extremely high strength with very good chemical and temperature resistance. In applications with threaded connections it reaches strength values, which might cause damage to screw or thread during disassembly. Its low viscosity allows a good distribution on the adherends.

PROPERTIES (liquid product)

Chemical type	Di-methacrylate-ester
Curing system	Anaerobic
Appearance	green
Strength class	Super strength
Viscosity (Brookfield)	400 - 800 mPas
Density (DIN EN 542)	1,1 x 10 ³ kg/m ³
Thread size	up to M20
Thread friction	0,17
Shelf life (Storage in unopened original container at 10°C up to 23°C)	24 months
Shelf life (Storage in unopened container at 8 up to 16°C)	3 months
<u>Curing time @23°C</u>	
Fixture time	1 to 7 minutes
Functional strength	1 – 2 hours
Final strength	6 hours

STRENGTH VALUES (cured product)

Compression shear strength (DIN EN 15337)	
@ RT	34 N/mm ²
@ 200°C	21 N/mm ²
Breakloosemoment (DIN EN 15865)	48 Nm
Breakawaymoment (DIN EN 15865)	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 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 more information on resistance against other chemicals please contact BEST-Klebstoffe.

HEALTH AND SAFETY STANDARDS

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