

## TECHNICAL INFORMATION

### BEST-MK 1326

**BEST-MK 1326** is a one component, solvent free, high strength anaerobic curing adhesive based on Dimethacrylate ester. The viscosity is low. For securing and sealing of passive and inactive surfaces without the use of an activator

**BEST-MK 1326** is the standard product for permanent locking and sealing of threaded fasteners. Disassembly extremely difficult. Also recommended for bonding of coaxial parts, bearings and bushings.

**BEST-MK 1326** combines high strength with excellent chemical resistance. The “breakloose” moment with threaded fasteners is extremely high and could cause the fastener to break or damage the thread if removed. The low viscosity provides a good capillary action which supports the adhesive distribution on the to be bonded surfaces.

#### Product characteristics

<b>Chemical Type</b>	<b>Dimethacrylate ester</b>
<b>Curing system</b>	<b>anaerobic</b>
<b>Colour</b>	<b>green</b>
<b>Strength</b>	<b>high</b>
<b>Viscosity (Brookfield)</b>	<b>500 mPas</b>
<b>Density (DIN 51757)</b>	<b>1,1 x 10<sup>3</sup> kg/m<sup>3</sup></b>
<b>Thread sizes up to</b>	<b>M20</b>
<b>Bonding gap</b>	<b>0,05 – 0,15 mm</b>
<b>Thread friction</b>	<b>0,17</b>
<b>Shelf life in unopened original container</b> (Storage at 8 to 21°C)	<b>2 years</b>
<b>Shelf life in unopened container BULK</b> (Storage at 8 to 16°C)	<b>3 months</b>

#### Curing time at 23°C

<b>Fixture time</b>	<b>2 - 10 min.</b>
<b>Functional strength</b>	<b>2 - 4 hrs.</b>
<b>Total curing time</b>	<b>8 hrs.</b>

**Strength of cured Material**

Compression/shear strength (DIN 54452)	25 N/mm <sup>2</sup>
Breakloose Moment (DIN 54454)	36 Nm
Breakaway Moment (DIN 54454)	43 Nm
Temperature range	-60°C bis +150°C

**Chemical/Solvent Resistance (DIN 53287 - test in accordance to DIN 54454) in % of the initial strength after 1000h Chemical absorption**

Motor Oil (MIL-L-46 152) at 125°C	100%
Unleaded Gasoline at 23°C	95%
Brake fluid at 23°C	95%
1,1,1 Trichlorethane at 23°C	95%
Ethanol at 23°C	100%
Acetone at 23°C	90%

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 damage. May cause respiratory irritation. General knowledge for safe handling of chemicals is recommended. Please consult EU – Safety Data Sheet for further information.

**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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