

## TECHNICAL INFORMATION

### BEST-MK 2535

**BEST-MK 2535** is a one component, solvent free, high strength anaerobic curing adhesive based on Dimethacrylate ester. The viscosity is high.

**BEST-MK 2535** is recommended for locking and sealing of pipe- and screw joints and especially for pipe threads exposed to heat.

**BEST-MK 2535** combines high strength with excellent heat and 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 high viscosity provides a good adhesive dispersion on the surfaces to be bonded.

### PROPERTIES (liquid product)

Chemical Type	Methacrylate ester
Curing system	anaerobic
Colour	rot
Strength	heat resistant
Viscosity (Brookfield)	3.500 – 6.000 mPas/thix
Density (DIN EN 542)	1,1 x 10 <sup>3</sup> kg/m <sup>3</sup>
Thread sizes	up to R2”
Thread friction	0,17
Shelf life in unopened original container (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	5 - 15 min.
Functional strength	5 - 12 hrs.
Total curing time	24 hrs.

**STRENGTH VALUES (cured product)**

Compression/shear strength (DIN EN 15337)	at 24°C	24 N/mm <sup>2</sup>
	at 200°C	23 N/mm <sup>2</sup>
Break loose Moment (DIN EN 15865)		30 Nm
Breakaway Moment (DIN EN 15865)		40 Nm
Temperature range (Screw joints)		-60°C to +230°C

**ENVIRONMENTAL AND CHEMICAL RESISTANCE**

(DIN EN 53287 - test in accordance to DIN EN 15865)

in % of the initial strength after 1000h Chemical absorption

Water/Glycol at 87°C	100%
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 damage. May cause respiratory irritation. Toxic to aquatic life with long lasting effects. General knowledge for safe handling of chemicals is recommended. Please consult the 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. 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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