

TECHNICAL INFORMATION

BEST-MK 3248



BEST-MK 3248 is a one component, solvent free, medium strength and high viscous anaerobic curing adhesive based on Dimethacrylate ester.

BEST-MK 3248 is the standard product for securing and sealing of pipe connections and the sealing of surfaces.

Due to its viscosity, **BEST-MK 3248** is run-resistant even when applied on vertical surfaces. Disassembly for repair is possible with normal tools without damaging the thread.

Directions for use:

For Assembly

1. For best results, clean all surfaces (external and internal) with **BEST-Clean 1000** and allow drying. 2. If the material is an inactive metal or the cure speed is too slow, spray with **BEST-Active A** and allow drying. 3. Apply a 360° bead of product to the leading threads of the male fitting, leaving the first thread free. Force the material into the threads to thoroughly fill the voids. For bigger threads and voids, adjust product quantity accordingly and apply a 360° bead of product also on the female threads. 4. Using compliant practices assemble and wrench tighten fittings in accordance with manufacturers' recommendations. 5. Properly tightened fittings will seal instantly to moderate pressures. For maximum pressure resistance and solvent resistance allow the product to cure a minimum of 24 hours.

For Disassembly

1. Remove with standard hand tools. 2. Where hand tools do not work because of excessive engagement length or large diameters (over 1"), apply localized heat to approximately 250 °C. Disassemble while hot.

For Cleanup

1. Cured product can be removed with a combination of soaking in a solvent and mechanical abrasion such as a wire brush.

Product characteristics

Chemical Type	Dimethacrylate ester
Curing system	anaerobic
Colour	orange
Strength	medium
Viscosity (Brookfield)	55.000 - 70.000 mPas/pasty
Density (DIN 51757)	1,1 x 103kg/m ³
Thread sizes	up to R5"
Bonding gap	0,1 – 0,3 mm



Thread friction	0,17
Shelf life (Storage in unopened container at 8 to 21°C)	24 months
Shelf life BULK (Storage in unopened container at 8 to 16°C)	3 months
<u>Curing time at 23°C</u>	
Fixture time	2 - 15 min.
Functional strength	2 - 4 hrs.
Total curing time	10 hrs.
<u>Strength of cured Material</u>	
Compression/shear strength (DIN 54452)	17 N/mm ²
Breakloose Moment (DIN 54454)	17 Nm
Breakaway Moment (DIN 54454)	<M-LB
Temperature range	-60°C up to +150°C

Health and safety standards

This product is not classified as dangerous according to regulation (EC) 1272/2008. General rules regarding handling of chemicals apply. For further information, please see corresponding MSDS.

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 the 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 as necessary.

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