



permanently elastic  
resistant to humidity

GMK 2410 is an adhesive based on poly-chloroprene (CR) for the high-strength, full-surface and flexible bonding of:

- rubber to rubber
- rubber to metal

WEICON GMK 2410 also bonds cellular rubber (e. g. neoprene), leather, felt, insulating material, textiles, wood, and many plastics.

GMK 2410 is not suitable for materials such as expanded polystyrene, polyethylene, polypropylene, fl exible PVC foam, and artificial PVC leather. The product can be used for many industrial applications.

### Technical data

Basis	Polychloroprene (CR)
Density	0,93 g/cm <sup>3</sup>
Viscosity	ca. 2.400 mPa.s
Colour	yellowish-brown
Consumption	250 - 350 g/m <sup>2</sup>
Evaporation time	5 - 10 min.
Contact adhesion time	10 min.
Final strength approx. after	ca. 24 h
Temperature resistance	-40 to +80, shortly up to +100 °C
Processing temperature	+15 bis +35 °C
Average tensile shear strength	
Galvanised steel / EPDM	0,16 N/mm <sup>2</sup>
Galvanised steel / galvanised steel	1,60 N/mm <sup>2</sup>
Galvanised steel / SBR	0,54 N/mm <sup>2</sup>
Galvanised steel / NBR	0,57 N/mm <sup>2</sup>

### Pretreatment of the surface

The parts to be bonded must be clean and dry and free of dust or grease (WEICON Surface Cleaner). Roughening the surfaces increases the bonding power efficiently.

### Processing

Stir the product well before use and then evenly apply a thin layer over the entire surface to be bonded with a paint brush or spatula (smooth or fine-toothed). Two or three thin layers may be required depending on the type of material and application. Depending on the layer

thickness, ambient temperature and air humidity, allow the coated surfaces to evaporate for 5 - 15 minutes.

With absorbent surfaces (e.g. felt), an additional adhesive layer should be applied after evaporating. As soon as the surfaces are dry but still feel a bit sticky (finger test), the parts must be joined under brief, strong pressure (e.g. with a roller or hammer). If the evaporation time is exceeded (over-drying), the adhesive must be applied again. Non-cured, exceeding adhesive can be removed with WEICON Surface Cleaner.

### Storage

At room temperature (+15°C to +25°C), dry, in densely closed packaging

Storage stability:

12 months in unopened container

### Note

Any product specifications and recommendations given herein must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do warrant the continuously high quality of our products being free from defects in accordance with and subject to our General Sales Conditions. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

### Health and Safety

When using WEICON products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets ([www.weicon.com](http://www.weicon.com)) must be observed.

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