



strong
permanently elastic
temperature-resistant

GMK 2510 is a 2-component adhesive based on polychloroprene for full-surface and permanently elastic bonding of parts which are continuously exposed to dynamic loads.

The advantage compared to 1-component contact adhesives is the considerably better adhesion and the improved temperature resistance.

GMK 2510 bonds rubber, metal, textiles, leather, sponge rubber (neoprene), CSM (Hypalon), insulating materials, PU materials with an adhesive coating, wood and many plastics. After curing the bonding is moisture-proof. WEICON GMK 2510 is not suitable for materials such as polystyrene foam, polyethylene, polypropylene parts, PVC soft foam and PVC imitation leather.

Technical data

Basis	Polychloroprene (CR)
Density	0,85 g/cm ³
Viscosity	1500 mPa.s
Colour	black
Consumption	150 g/m ²
Evaporation time	5 - 15 min.
Final strength approx. after	approx. 24 h
Temperature resistance	-40 to +80, short term (approx. 1 h) to +130 °C
Processing temperature	+15 to +35 °C
Average tensile shear strength	
Galvanised steel / EPDM	0,60 N/mm ²
Galvanised steel / galvanised steel	3,00 N/mm ²
Galvanised steel / SBR	0,50 N/mm ²
Galvanised steel / NBR	0,49 N/mm ²

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 (only the adhesive).

Mix the adhesive and activator together thoroughly and bubble-free for

four minutes with the application spatula or mechanical mixers at low speed (max. 500 rpm) (mixing ratio approx. 100:7) to obtain a homogeneous mixture. Only prepare the quantity which can be applied within the evaporation time.

Apply evenly onto the complete surfaces (both sides) to be bonded using a brush or a spatula (smooth or fine-toothed).

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) must be observed.

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