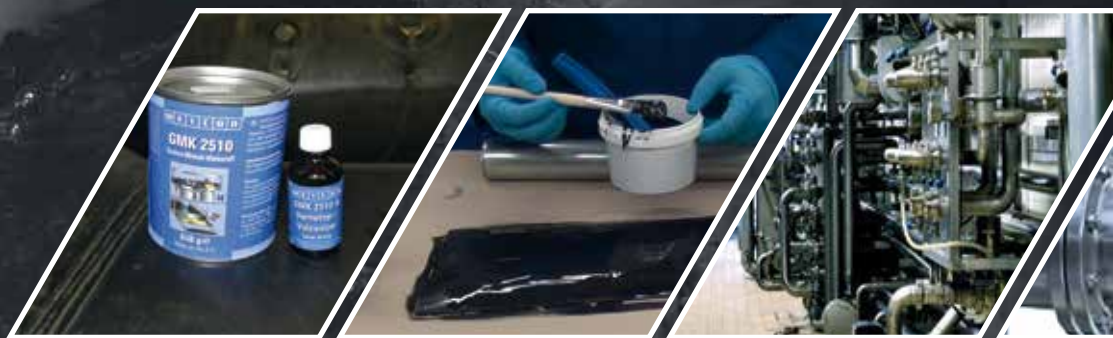


Rubber  
Metal Adhesive

# GMK 2510

New



# Rubber Metal Adhesive

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## GMK 2510

**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, to themselves and among each other. 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.

### Applications

- Bonding rubber to metal plates
- Bonding rubber profiles, door seals in motor vehicles, utilities, caravans and containers
- Joining rubber conveyor belts
- Fixing insulation material or sound absorbing foils/plates to construction parts
- Bonding rubber linings to containers, drums and cylinders

### Surface pre-treatment

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

### Mixing and processing

Before adding the activator, the adhesive and its additives must be stirred thoroughly and bubble-free. Then mix adhesive and activator for four minutes with the application spatula or mechanical mixers at low speed (max. 500 rpm) to obtain a homogeneous mixture. Only prepare the quantity which can be applied within the evaporation time.

Apply two to three thin layers 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.

690 g   
 16200690

### Technical Data

	GMK 2510
Basis:	Polychloroprene (CR)
Density:	0,85 g/cm <sup>3</sup>
Viscosity:	1.500 mPa.s
Mixing ratio:	100:7
Colour:	black
Consumption:	150 g/m <sup>2</sup>
Evaporation time:	5 - 15 minutes
Final strength:	approx. 24 hours
Temperature range:	From -40°C (-40°F) to +80°C (+176°F), briefly (1 hour) up to 130°C (+265°F)
Processing temperature:	+15°C to +35°C (+59 to 95°F); the adhesive gels under +5°C (+41°F), however is ready to use again by carefully heating it to room temperature!
Storage stability:	12 months in unopened container
Storage:	at room temperature (+15°C/+59°F to +25°C/+77°F), dry, in densely closed packaging

### Average tensile shear strength

	GMK 2510
Galvanised steel / EPDM:	0,60 N/mm <sup>2</sup> (60,0 N/cm <sup>2</sup> *) 87 psi
Galvanised steel / galvanised steel:	3,00 N/mm <sup>2</sup> (300,0 N/cm <sup>2</sup> *) 435 psi
Galvanised steel / SBR:	0,50 N/mm <sup>2</sup> (50,0 N/cm <sup>2</sup> *) 72 psi
Galvanised steel / NBR:	0,49 N/mm <sup>2</sup> (49,0 N/cm <sup>2</sup> *) 71 psi

\* Tensile shear test in accordance with DIN 53281-83



Bonding a base rubber plate in an inflatable dinghy

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