

**Technical Data Sheet**[swiftsupplies.com.au](http://swiftsupplies.com.au)

GMK 2410 Rubber Metal Contact Adhesive is an industrial-grade adhesive designed specifically for bonding rubber to metal and rubber to rubber. This high strength adhesive is used to create permanent, strong bonds and is usually used for larger surface areas.

In addition to its excellent compatibility with rubber and metal, GMK 2410 also works very well with cellular rubber (like our Neoprene Sponge Sheet), felt, insulation material, textiles, wood and many different types of plastic.

GMK 2410 is not recommended for bonding artificial PVC leather, PVC foam, polyethylene or polypropylene.

It is a polychloroprene (CR) based rubber adhesive that is yellow-ish in colour. Bonds created with GMK 2410 are not affected by humidity and exhibit excellent, permanent elasticity. Once fully cured, this adhesive will withstand temperatures between -40°C and +80°C as well as short-term spikes up to 100°C.

Contact adhesion time (which begins once the surfaces are pressed together) is approximately 10 minutes with some variation due to temperature and humidity to be expected. Full cure will be achieved after about 24 hours. GMK 2410 is manufactured in Germany by Weicon.

**Applications**

- Bonding rubber pads and sheet to metal wall structures, posts and piping.
- Sticking rubberised sponge and foam to metal supports
- Laminating different thicknesses of rubber sheet and sponge
- Gluing down rubber sheet to metal trays and plates
- Laminating felt to form new thicknesses or bonding felt to metal
- Gluing rubber to wood

**Preparation of the Surface**

To achieve optimum adhesion, the surfaces being bonded should be cleaned and dried before the adhesive is applied (Surface Cleaner or Cleaner S may be ideal for this). Roughening smooth surfaces will also significantly increase bonding power.

**Application**

If using one of the cans of GMK 2410, it is important to stir the contents prior to use.

Apply the adhesive in a thin, even layer onto both surfaces using a brush or spatula (smooth or finely notched). Let it dry from 5-10 minutes (depending on layer thickness, ambient temperature and humidity). On absorbing surfaces such as felt a second layer of the adhesive should be applied after the first layer has dried. As soon as the surfaces of the adhesive are dry but still a little bit tacky the parts must be joined with a strong pressure for a short period.

Once the evaporation time has passed, the adhesive will no longer form a bond and will need to be applied again. Non-cured excess adhesive can be removed with Weicon Surface Cleaner.

**Important**

The values listed here and the information presented should not be treated as a substitute for specific technical advice. We cannot warrant the products performance or suitability for particular applications.

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**Technical Details****Properties**

|                                   |                      |
|-----------------------------------|----------------------|
| Basis                             | Polychloroprene (CR) |
| Colour                            | Yellowish - Brown    |
| Viscosity                         | 2,400 MPa (Approx.)  |
| Processing Temperature            | +15°C to +35°C       |
| Evaporation Time                  | 5-10 Minutes         |
| Contact Adhesion Time             | 10 Minutes           |
| Final Strength                    | 24 Hours (Approx.)   |
| Continuous Temperature Resistance | -40°C to +80°C       |
| Short-Term Temperature Resistance | +100°C               |

**Average Tensile Shear Strength**

|                                      |                        |
|--------------------------------------|------------------------|
| Galvanised Steel to EPDM Rubber      | 0.16 N/mm <sup>2</sup> |
| Galvanised Steel to Galvanised Steel | 1.60 N/mm <sup>2</sup> |
| Galvanised Steel to SBR Rubber       | 0.54 N/mm <sup>2</sup> |
| Galvanised Steel to NBR Rubber       | 0.57 N/mm <sup>2</sup> |

**Storage**

GMK 2410 Rubber Metal Contact Adhesive should always be stored in its original (unopened) packaging in a cool, dry and dark area. The shelf life is at least 12 months if stored at room temperature (+15°C to +25°C).

**Available Sizes**

GMK 2410 Rubber Metal Contact Adhesive is available from Swift Supplies Australia in a variety of sizes and forms. Standard sizes are;

- 185gm Tubes
- 350gm Brush-Top Cans
- 700gm Containers

Also available upon request:

- 300gm Cans
- 5kg Buckets
- 25kg Buckets

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