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GMK 2510 High Strength Contact Adhesive is a two-part, industrial grade glue for high strength surface bonding. Developed by Weicon in Germany, this contact adhesive has been designed for applications that require extremely high strength bonds.

GMK 2510 can be used with many different material combinations. More information on these and the other features of this glue is included below...

Material Compatibility for Bonding.

GMK 2510 is designed for making high strength joins across larger surface areas. It is compatible with the following materials:

- Metal
- Rubber (except silicone).
- Insulation materials (e.g. epoxy glass, phenolic, fibreglass).
- Polyurethane materials with an adhesive coating.
- Wood.
- Stone.
- Many different types of plastic (see below for some exclusions).

Though it is compatible with many materials, it's not suited for everything. GMK 2510 is not suitable for joining polystyrene foam, polyethylene, polypropylene, PVC soft foam or PVC imitation leather.

Permanently Elastic Bonds.

Bonds made with GMK 2510 Contact Adhesive are permanently elastic. This ensures that the cured adhesive can withstand changes in bonding stress and some material movement as it is exposed to dynamic loads. The result is a high strength adhesive that lasts.

Applications for GMK 2510 Contact Adhesive.

GMK 2510 has been developed for jobs that require a high strength bond between two surfaces spread across a larger surface area. Some of the applications it is used for including:

- Joining and laminating of metal sheets and shim.
- Fixing rubber wear mats and liners to metal frames.
- Laminating insulation materials.
- Affixing a textile layer to a rubber or solid insulation base.
- Securing timber panels.
- Bonding flat stone panels to supporting panels.
- Many other specialised areas in the mining, agricultural, transport and mechanical engineering sectors.

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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.

Date Created: 28/8/2018

Date Modified: 28/8/2018

Document # SSD-TDS-SWP000280

Technical Details**Properties**

Basis	Polychloroprene (CR)
Colour	Black
Density	0.85 g/cm ³
Viscosity	1,500 MPa
Mixing Ratio (Adhesive to Activator)	100:7
Consumption	150 – 300 g/m ²
Processing Temperature	+15°C to +35°C
Evaporation Time	5-15 Minutes
Final Strength	24 Hours (Approx.)
Continuous Temperature Resistance	-40°C to +80°C
Short-Term Temperature Resistance (1 Hour Approx.)	+130°C
IMPA Codes	81 52 39 & 81 52 40

Average Tensile Shear Strength

Galvanised Steel to EPDM Rubber	0.60 N/mm ²
Galvanised Steel to Galvanised Steel	3.00 N/mm ²
Galvanised Steel to SBR Rubber	0.50 N/mm ²
Galvanised Steel to NBR Rubber	0.49 N/mm ²

General Instructions for Use.

One of the most important things to know about using GMK 2510 is that the adhesive must be applied to both materials being joined. With that in mind, general-use instructions are...

Surface Preparation before Bonding.

The parts/surfaces being bonded must be clear and dry. Ensure they are free of dust or grease.

When bonding very smooth surfaces, roughening them prior to bonding will improve adhesion considerably.

Mixing the Two Components that make up GMK 2510.

Mix the adhesive and activator together thoroughly. Ensure there are no bubbles left in the mixture. Mixing time should be about four minutes with either the plastic application spatula or a mechanical mixer set to low speed (500 RPM max.).

GMK 2510 has a mix ratio of 100:7 adhesive to activator. Ensure that you only mix together the quantity you are sure you will be able to use within the evaporation time of 5-15 minutes.

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Applying the Contact Adhesive.

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

GMK 2510 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 2510 Contact Adhesive is available from Swift Supplies Australia in two (standard) sizes:

- 324gm Kit (300gm Adhesive, 24gm Activator)
- 690gm Kit (650gm Adhesive, 40gm Activator)

Custom sizes also available upon request.

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