

4046 HE

Spreadable SMP



Technical data sheet

Version: V0 - 10-2025

1. Properties

- SMP | free of silicone, isocyanate and solvents
- RTV1 compound
- odourless
- virtually shrink-free cross-linking
- particularly resistant to UV rays, ageing and weathering
- adheres even to damp surfaces
- long working time
- EMICODE® EC 1^{PLUS} „very low emission“

2. Areas of application

- For sound-insulating, full-surface and elastic bonding.
- Specially developed for work with floor, wall and ceiling coverings as well as panels.
- Perfect adhesive properties even on wood, metal and coated substrates.

3. Technical data

CTM*	Standard	Feature	Unit	Value
		Base		SMP
		Curing mechanism		RTV 1
		Skin formation time at +23 °C 50% RH	mins	~ 30
		Full curing time at +23 °C 50% RH	mm/24 hrs	~ 2.20
	EN ISO 1183-1	Density	g/cm ³	~ 1.50
	DIN EN ISO 868	Shore A hardness		~ 43
	EN ISO 10563	Volume shrinkage	%	~ 2.50
		Initial tack		low
	DIN 53504-S2	Elongation at break	%	~ 480
	DIN 53504-S2	Tensile strength	N/mm ²	~ 2.15
	DIN 53504-S2	Modulus of elasticity 100 %	N/mm ²	~ 1.12
	DIN ISO 34-1	Tear resistance	N/mm	~ 15.30
		Temperature resistance (long term exposure)	°C	-40 to +110
		Processing temperature	°C	+5 to +35
f-1-0/g-1-0		Shear stress 51/s	Pa	~ 4140
f-1-0/g-1-0		Viscosity 51/s	Pa·s	~ 81
	DIN EN ISO 8394-1	Extrusion rate 310 ml cartridge	g/min	~ 75
		Electrical conductivity (volume resistance)	Ω·cm	> 1 x 10 ¹⁰
		Thermal conductivity	W/(m·K)	~ 0.39
		Colours		Old white
		Packaging		Barrel, hobbock, 400 & 600 ml film bag, 310 ml cartridge
		Shelf life		Barrel/hobbock: 6 months Film bag/cartridge: 9 months (when stored in a cool and dry place in the original container)

* Corporate Test Method | CTM copies available on request

4046 HE

4. Substrate preparation

The adhesive surfaces must be flat, stable, free of cracks, dust, oil and grease, and resistant to tension and pressure. On non-absorbent substrates, pre-cleaning with 828 Basic Cleaner is recommended. For sensitive surfaces, compatibility should be checked in advance to avoid surface damage. If necessary, carefully pre-treat the adhesive surfaces with a suitable primer. Sanding with fine abrasive fleece can further improve adhesion on smooth surfaces. Due to the many different coating systems, an adhesion test is recommended before application on painted surfaces.

Substrate*	Pre-treatment
ABS Metzoplast ABS 7 H	828 Basic Cleaner Primer 100
Aluminium	828 Basic Cleaner
Aluminium 6016	828 Basic Cleaner Primer 140
Aluminium AlCuMg1	828 Basic Cleaner
Aluminium AlMg1	828 Basic Cleaner
Anodised aluminium	828 Basic Cleaner
Concrete formwork smooth	free of dust
Concrete wet, polished	free of dust
GFK	828 Basic Cleaner
Glass	828 Basic Cleaner
Natural stone	828 Basic Cleaner
PC Makrolon Makroform 099	828 Basic Cleaner
PET	828 Basic Cleaner
PMMA Röhm sanitary grade	828 Basic Cleaner
Polyacrylic PMMA XT 20070 Röhm ^{*1}	828 Basic Cleaner Primer 140
Polystyrene PS Iroplast	828 Basic Cleaner Primer 100
PU cutting quality	828 Basic Cleaner Primer 100
PVC Kömadur ES	828 Basic Cleaner Primer 100
PVC soft	828 Basic Cleaner Primer 100
Steel DC04	828 Basic Cleaner
Steel hot-dip galvanised	828 Basic Cleaner
Stainless steel	828 Basic Cleaner
Tile	828 Basic Cleaner
Zinc	828 Basic Cleaner

* On substrates not listed in this table, the processor must always carry out preliminary tests to check the suitability of the product. This table is based on adhesion tests carried out on test specimens from Rocholl under laboratory conditions. In practice, adhesive properties depend on a variety of external influences (weather, contamination, etc.). Therefore, this table is for guidance only and does not constitute a binding statement. The tests carried out above refer only to adhesive properties and are not indicative of compatibility with the substrates mentioned.
*1: Different types of PLEXIGLAS® show certain differences in their chemical resistance. In some applications, the formation of stresses must be expected. These stresses, in combination with certain agents, can lead to 'stress cracking'. The duration of exposure, temperature and concentration of the acting substance have a fundamental influence on the possible 'stress cracks'. When using our products in combination with PLEXIGLAS®, the suitability must therefore be checked in advance.
*2: Compatibility with a wide variety of mirror coatings from different manufacturers is regularly tested in our laboratory. Due to the manufacturing processes of different manufacturers, which are not known to us in detail, and depending on the existing substrate and bonding variants, preliminary tests are recommended.

5. Processing

General information: 4046 HE can be processed at substrate and ambient temperatures between +5 °C and +35 °C. The ideal processing temperature is about +20 °C. The viscosity of the uncured material is temperature-dependent, meaning that viscosity increases at low temperatures and decreases at high temperatures. In addition, a variety of external influences, such as humidity, UV exposure, chemical influences, high temperatures, etc., must be taken into account. These and other factors can have a significant effect on the material properties of the product and its shelf life. The expiry date stated on the product must be strictly adhered to, as the product properties can no longer be guaranteed if this date is exceeded. Good ventilation must be ensured during processing and curing.

Processing: Before application, the processor must ensure that all materials that come into contact with the product do not cause any incompatibilities. The polymer must be processed within the specified skin formation time. 4046 HE is applied over the entire surface using a notched trowel. For small-format elements and/or flat substrates, the use of a fine toothed trowel is recommended. For large-format elements or uneven or rough substrates, a coarse toothed trowel should be used. The substrates to be bonded must be completely wetted. If a primer is used, its flash-off time must be observed. When working on large areas of vapour-proof substrates, one of the adhesive surfaces must be moistened with dew. The supply of moisture and higher temperatures accelerate the curing speed. In large-area applications, the formation of the vulcanised material and thus also the build-up of adhesive strength is delayed. Material consumption depends heavily on the existing substrate and the thickness of the material applied. In general, approximately 800 to 900 g per square metre can be expected. Uneven substrates increase consumption accordingly.

Removal: Uncured 4023 can be removed with 502 Surface Cleaner or 504 Universal Cleaning Wipes, while cured material can only be removed mechanically. If it comes into contact with the skin, it must be cleaned immediately.

4046 HE

6. Application restrictions

- Not suitable for bonding in permanently wet or underwater areas.
- Avoid contact with mirror films, coated glass units and substrates containing tar or bitumen.
- Compatibility with various coatings must be checked before application.
- Without pre-treatment, no adhesion to plastics with low-energy surfaces, such as PE, PP or PTFE.
- Not suitable for permanent sealing and bonding of copper and brass.

7. Safety notices

Sämtliche Sicherheitshinweise sind dem aktuellen Sicherheitsdatenblatt zu entnehmen, welches unter **www.ramsauer.eu** eingesehen werden kann.

8. Liability for defects

All information, in particular suggestions for the processing and use of our products, is based on our knowledge and previous experience. Depending on the specific circumstances, in particular with regard to the substrate, processing and environmental conditions, the results may differ from our specifications. Therefore, no guarantee can be given for the quality of the results achieved, which are influenced by the aforementioned circumstances. No legal claims of any kind can be asserted against Ramsauer GmbH & Co KG on the basis of this information or verbal advice, provided that we are not guilty of intent or gross negligence. Ramsauer GmbH & Co KG guarantees that its products will retain their technical properties as specified in the technical data sheets until their expiry date. Product users must observe the latest technical data sheet, which can be downloaded from our website at **www.ramsauer.eu**. Our current General Terms and Conditions apply. These are also available on our website. With the publication of a new version or revision of a technical data sheet, all previous versions of the respective product lose their validity.

