

[METRIC]

MIL-A-48611A  
 AMENDMENT 3  
 22 JULY 1992  
 SUPERSEDING  
 AMENDMENT 2  
 14 APRIL 1983

**MILITARY SPECIFICATION**  
**ADHESIVE SYSTEM, EPOXY-ELASTOMERIC, FOR**  
**GLASS TO METAL**

This amendment forms a part of Military Specification MIL-A-48611A, dated 30 August 1982, and is approved for use by all Departments and Agencies of the Department of Defense.

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- \* 4 4 1, line 3: Delete "0.16cm" and substitute "0.32 (min)"
- \* line 5. Delete "0.100cm" and substitute "0.30cm (min)".

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Add the following new paragraphs

6.7 Debonding procedure. Satisfactory debonding of glass to metal bonds, formed with epoxy based adhesives conforming to the requirements as contained herein, can be accomplished through the use of the solvent N-Methyl-2-Pyrrolidone. A quantity of solvent, sufficient to completely submerge the assembly to be debonded, should be brought to an elevated temperature in excess of 90°C but less than 150°C. (The higher the solvent temperature the faster will be the debonding effect) The volatility of the solvent at elevated temperatures will necessitate a hooded area such as in 6.5 above plus the use of condensing retort for the confining and condensing of gaseous solvent. A debonding effect should be obtained in one hour or less for a 2cm<sup>2</sup> assembly and in three hours or less for an 8cm<sup>2</sup> assembly depending on actual solvent temperature. The time of submersion may have to be extended to completely remove the primer coating (if applicable) Further debonding information, debonding process detail or solvent availability or use, is obtainable from the address indicated in 6.4.

6.8 Supersession. The adhesive system described in this specification should be used in place of that covered by MMM-A-131 for Military applications.

AMSC N/A

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**NOTE:** The margins of this amendment are marked with asterisks to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous issue.

**Custodian**

**Army - AR  
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**Preparing activity**

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**Review activities**

**Army - MD  
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**(Project 8040-0525)**