

MIL-F-51110A(EA)
AMENDMENT 2
22 September 1986
SUPERSEDING
AMENDMENT 1
14 March 1986

MILITARY SPECIFICATION

FACEBLANK-LENS, C14R3

This amendment forms a part of MIL-F-51110A(EA), dated 16 November 1976, and is approved for use within the Chemical Research, Development and Engineering Center, Department of the Army and is available for use by all Departments and Agencies of the Department of Defense.

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2.1, Under "DRAWINGS", delete:

"- Tester, Leakage, Protective Mask, DOP, M14."
and substitute: "- Tester, Leakage, Protective Mask, M14."

3.3, Rewrite to read as follows:

"3.3 Faceblank-lens leakage. The overall leakage of the faceblank-lens, before aging and after aging in accordance with 4.4.4.3 for 48 +/- 1 hours instead of 24 hours, (excluding leakage at the faceblank periphery, hose stem, outlet valve stem, and microphone cable stem) shall not exceed 0.003 percent penetration when tested as specified in paragraph 4.4.4.1."

3.4, delete: "after weathering (4.4.4.4)" and substitute, "after weathering test in accordance with 4.4.4.4."

3.5, delete: "3.5 Weathering" in its entirety.

3.6, add new paragraph as follows:

"3.6 Faceblank-lens optical defects. Visual imperfections of the lens shall not exceed the minimum criteria specified by zone in 4.4.3.4. Optical defects are defined as imbedded particles, scratches, bubbles, or other imperfections which reduce visibility through the lens."

FSC 4240

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Change paragraph numbers:

3.6 Preproduction sample to 3.7 Preproduction sample.

3.7 Workmanship to 3.8 Workmanship.

Add new paragraph 3.9 as follows:

"3.9 Faceblank-lens bond separation. There shall be no evidence of incomplete bonding between faceblank and lens."

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4.3.2 Inspection procedure:

Delete: "Test 5 for weathering in accordance with 4.4.4.4 and examine them for compliance with 3.4 and 3.5", and replace with "Test 5 for weathering in accordance with 4.4.4.4 and examine them for compliance with 3.4."

Delete: "Test 5 after aging for 48 +/- 1 hours in accordance with 4.4.4.1 and then examine them for defects 103 and 105 of 4.4.3.3 (see 4.4.4.3).", and replace with "Test 5 before aging and after aging for 48 +/- 1 hours in accordance with 4.4.4.1 and then examine them for compliance with 3.3 and for defects 103 and 105 of 4.4.3.3 (see 4.4.4.3)."

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4.4.2.2 For destructive tests, delete: "(3.4 and 3.5)" and substitute "(3.4)".

4.4.3.3:

Delete under critical defect:

"1 Faceblank-lens leakage before aging 4.4.4.1"

and add in its place:

"None defined"

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	<u>Critical:</u>	<u>Defects</u>	<u>Acceptance Standards</u>
Add:	2	Lens optical defects	4.4.3.4
Change:	<u>Major:</u>		
From:	"105	Cement missing or inadequate"	
To:	"105	Faceblank-lens bond separation	4.4.4.6"
From:	"106	Excessive adhesive and/or activator on lens"	
To:	"106	Any adhesive and/or activator on the lens beyond 3/32 inch from the bonded area"	

4.4.3.4, add new paragraph as follows:

"4.4.3.4 Optical defects. The areas of vision of the plastic lens shall be examined by zones, as indicated in Figure 2, as follows:

Zone A may contain up to an aggregate total of two bubbles, imbedded particles or spots of 1/16 inch diameter or less provided that they are at least two inches apart. Zone A may not contain any scratches, abraded areas, creases or other surface imperfections which will interfere with vision.

Zone B may contain up to five bubbles or imbedded particles of 1/16 inch diameter or less provided that they are scattered in such a manner that they are at least one inch apart. Zone B may contain up to three scratches provided that they are not longer than 1/4 inch and not wider than .020 inch and they are at least one inch apart.

(Applicable to M24 Mask: Zone B may not contain creases and concave contoured areas with permanent set which distort vision).

Zones C and D shall not require examination."

PAGE 5

4.4.4.6, add new paragraph as follows:

"4.4.4.6 Bond separation. The faceblank-lens bond shall be examined by gently rolling the faceblank away from the lens and visually inspecting for separation between the lens and faceblank around the entire periphery of the lens on inside and outside surface."

Custodian:

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Preparing activity:

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Project No. 4240-A847

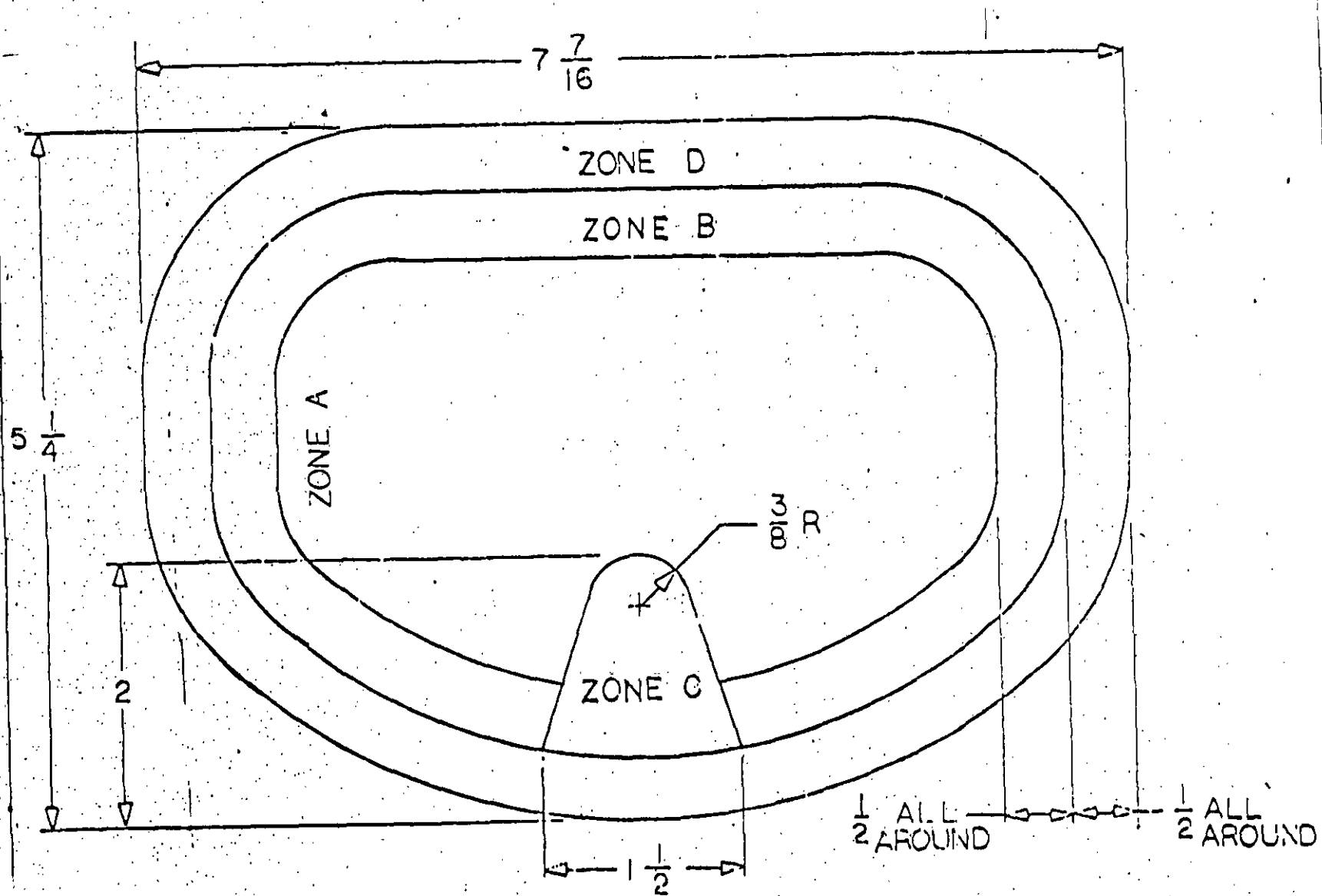


FIGURE 2

This sketch is Intended for In process acceptance and inspection purposes only