

**URGENT**

**TB 1-1520-240-20-164**

**DEPARTMENT OF THE ARMY TECHNICAL BULLETIN**

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**CH-47 SERIES AIRCRAFT, M24 DOOR MOUNTED  
ARMAMENT SUBSYSTEM**

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Headquarters, Department of the Army, Washington, D. C.  
01 February 2006

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**DISTRIBUTION STATEMENT A: Approved for public release; distribution is unlimited.**

**NOTE**

This message is effective until rescinded or superseded.

**NOTE**

This message is issued IAW AR 95-1 and has not been transmitted to units subordinate to addressees. Addressees will immediately retransmit this message to all subordinate units, activities or elements affected or concerned. MACOMS will immediately verify this transmission to the AM-COM SOF Compliance Officer (AMSAM-SF-A, safeadm@redstone.army.mil).

**NOTE**

MACOM commanders may authorize temporary exception from message requirements IAW AR 95-1, Ch 6. Exception may only occur when combat operations or matter of life or death in civil disasters or other emergencies are so urgent that they override the consequences of continued aircraft operation.

**NOTE**

Commanders unable to comply with the requirements of this message within the time frame specified will change the affected aircraft status symbol to a Red //X//.

**1. SUMMARY.**

a. Background. Newly manufactured M24 Helicopter Armament Door/Window Gun System Mounts for the CH-47 Chinook Helicopter have firing arc limit stops that allow the weapon to intercept the aircraft fuel tanks. These mounts require modification to prevent damage to the aircraft. Also, older M24 Gun Mounts may have defective limit stops as well.

b. Message Purpose.

- (1) Inspect M24 Door/Window System Gun Mounts to determine configuration.
- (2) Provide correction procedures for discrepant M24 Door/Window System Gun Mounts.
- (3) Clarify inspection requirements of the M24 Gun Mount limit stops.

**2. END ITEMS AFFECTED – ALL CH-47 SERIES AIRCRAFT.**

**3. ASSEMBLIES/COMPONENTS/PARTS AFFECTED.**

- a. Suspect/discrepant assemblies/components/parts:

NOMENCLATURE	PN	NSN
LEFT MOUNT ASSEMBLY	11699655	1005-01-507-3874
RIGHT MOUNT ASSEMBLY	11699658	1005-01-507-3875

- b. Additional assemblies/components/parts to be inspected:

NOMENCLATURE	PN	NSN
M24 DOOR/WINDOW MOUNTED HELICOPTER ARMAMENT SUBSYSTEM	11691606	1005-00-763-1404

**NOTE**

When complying with the requirements of this message, complete forms and records entries IAW DA PAM 738-751. ULLS-A units will use appropriate "E" forms.

**4. INITIAL TAMMS (THE ARMY MAINTENANCE SYSTEM) COMPLIANCE REQUIREMENTS.**

- a. Upon receipt of this message, make the following entry on the DA Form 2408-13-1. Enter a Red Horizontal Dash //--// status symbol with the following statement: "Comply with requirements of CH-47-06-SOF-01 prior to next armed flight but NLT 27 Jan 06."

**NOTE**

The TAMMS Compliance Reporting Form is available at "www.redstone.army.mil/sof/tamms.xls" (use lower case letters only) or may be obtained from the units servicing LAR. Alternate forms may be approved by the AMCOM SOF Compliance Officer.

**NOTE**

The TAMMS Compliance Report only confirms the unit has made the initial logbook entry for assigned aircraft. TAMMS Compliance Reports will include aircraft serial numbers (in numerical order), date of entry on DA Form 2408-13-1, unit address, local POC name and phone number.

- b. TAMMS Compliance Report. Submit TAMMS Compliance Report via priority e-mail to "safeadm@redstone.army.mil" NLT 24 Jan 06 IAW AR 95-1. If e-mail is not available, the report may be faxed to: SOF Compliance Officer at DSN 897-2111 or (256) 313-2111.

**5. TASK/INSPECTION COMPLIANCE REPORTING REQUIREMENTS.**

**NOTE**

The Task/Inspection Reporting Form is available at "www.redstone.army.mil/sof/log.xls" (use lower case letters only) or may be obtained from the units servicing LAR. This report will cite the message number, date of inspection, aircraft serial number, aircraft hours, component serial number, component hours, and results of the inspection.

- a. Aircraft. Submit Task/Inspection Compliance Report for this message to LOG POC NLT 30 Jan 06.

b. Retail Stock (Installation level and below). Submit Task/Inspection Compliance Report for this message to LOG POC NLT 30 Jan 06.

c. Wholesale Stock (Including Depot Stock, Depot Maintenance and Single Stock Fund). Provide local POC, address and phone number. Report compliance with this message IAW para 8 to LOG POC NLT 30 Jan 06.

**6. SPECIAL PROVISIONS TO MESSAGE REQUIREMENTS (AIRCRAFT).**

a. Aircraft in AVIM or Depot Level Maintenance. Commanders, Facility Managers and contractors will not issue aircraft until they are in compliance with this message.

b. Aircraft at contractor facility. DD 250 aircraft will be in compliance with this message prior to departure.

c. Aircraft in Transit. Comply with message requirements prior to first armed flight after arrival but NLT 10 days of arrival.

**7. TECHNICAL PROCEDURES/INSTRUCTIONS.**

**NOTE**

This message includes a required addendum. If the addendum is not included with this message, it may be downloaded at (use lower case letters only): “<https://ams14.redstone.army.mil/safety/sof/pic/c47s0601.pdf>” Adobe Reader or Adobe Acrobat, Version 6 or higher, is required to view the addendum. Adobe Reader may be downloaded free of charge from “[www.adobe.com](http://www.adobe.com)”.

a. Determine if M24 Door/Window Mounted Helicopter Armament Subsystem, PN 11691606, NSN 1005-00-763-1404, is installed and/or on-hand. The M24 Subsystem includes both left (window) and right (door) side M24 Gun Mount Assemblies.

**NOTE**

M24 Mount Assemblies that are on-hand but not currently installed will also be inspected IAW this message. Installation of the M24 Mount Assembly is required in order to comply with this message.

(1) If the M24 Door/Window Mounted Helicopter Armament Subsystem is installed and/or on-hand, proceed to para 7.b.

(2) If the M24 Door/Window Mounted Helicopter Armament Subsystem is not on-hand, proceed to para 7.f.

b. Conduct visual inspection of the Left Mount Assembly (PN 11699655) and the Right Mount Assembly (PN 11699658) to determine if the modified stops have been installed IAW TM 9-1005-262-13, Appendix E, Change 2. If modified, an “S” should be annotated on the Gun Mount data plate. This modification added a 1/4 inch rod that is welded or brazed next to the machined stop (see addendum).

(1) If the 1/4 inch rods are present, conduct visual inspection for wear or damage and the brazing for cracking or debonding. Proceed to para 7.d.

(2) If the 1/4 inch rods are not present, complete modification IAW para 7.c.

c. Modification of M24 Gun Mounts. If the 1/4 inch rods (stops) are not present, complete modification as follows (see addendum).

(1) Use 1/4 inch (6.35 mm) thick drill rod (steel, round, cold rolled or cold drawn, 1010-1020).

(2) Position rod upright abutting machined stop in mount.

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(3) Grind bottom end of drill rod to clear fillet in the bottom of the mount when positioned as show in the addendum.

(4) Braze drill rod upright in position shown in the addendum. Utilize the appropriate AWS Brazing Specification, e. g., AWS C3.4 for Torch Brazing or AWS C3.6 for Furnance Brazing. Braze on both sides.

(5) Cut off the top of the drill rod flush with top cam surface of the mount.

(6) Grind and/or file top of cut drill rod to a smooth finish. Break all sharp edges.

(7) Repeat steps 7.c.1 thru 7.c.6 for forward and aft stops on each mount.

(8) Etch or stamp an "S" on the Gun Mount data plate to show the modification is complete. Proceed to para 7.d.

d. Verification of stop limits. For each M24 Gun Mount, insert a dowel, (or other suitable rod at least 3 feet in length) into the barrel of the gun and move the gun in azimuth to its limits. Use the dowel/rod and the machine gun sights to verify a 6 inch clearance between the bullet trajectory and all aircraft surfaces. Remove the dowel/rod.

(1) If the minimum 6 inch clearance is not achieved, do not use the gun in this configuration. Make appropriate entry on DA Form 2408-13-1. Recheck the stop limits as directed above to achieve the required 6 inch clearance.

(2) If the minimum 6 inch clearance is achieved, proceed to para 7.e.

e. M24 Subsystem Preventative Maintenance Checks/Services (PMCS). Complete PMCS requirements IAW TM 9-1005-262-13 dated 29 December 1986, (with Change 2 dated 15 September 2005), Chapter 2. Special emphasis must be applied during the "Before Operation" checks on Page 2-2, item No's 2 and 3. Inspect the M24 Gun Mount, with particular attention to the stops, the stops brazing, and the Gun Mount Cam.

f. Clear the initial entry from para 4.a and note compliance on DA Form 2408-15.

**8. PROCEDURES/INSTRUCTIONS FOR ASSEMBLIES/COMPONENTS/PARTS IN WORK OR IN STOCK (AT ALL LEVELS INCLUDING WAR RESERVES).** Annotate the serviceability tag with "CH-47-06-SOF-01, M24 Door Mounted Armament Subsystem, Not Complied With". Do not remove original condition tags.

a. Items in Retail Stock. Commanders and Facility Managers that maintain retail stock at installation level and below will complete the following procedures.

(1) Suspend issue of affected items until in compliance with message requirements.

(2) Comply with inspection and correction procedures as required to return items to serviceable stock.

(3) Submit a Task/Inspection Report to LOG POC IAW para 5.

b. Items in Single Stock Fund and in work (Overhaul/Repair Facility).

(1) Depot, Unit and other Maintenance Activity Commanders will ensure items listed in para 3 are not issued until they are in compliance with this message.

(2) Submit Task/Inspection Compliance Report to Wholesale POC IAW para 5.

c. Items in Wholesale Stock. Wholesale stock was inspected during coordination of this message.

**9. SPECIAL TOOLS AND FIXTURES REQUIRED. N/A.**

**10. SUPPLY/PARTS (REQUISITION/DISPOSITION). N/A.**

- a. Parts required: N/A.
- b. Bulk and consumable materials:

NOMENCLATURE	NSN
SILVER BRAZING ALLOY	3439-00-853-9276
BRAZING FLUX	3439-00-914-8390
DRILL ROD	9505-00-228-6209 (or equivalent)

- c. Requisitioning instructions. Requisition bulk and consumable materials using normal supply procedures.
- d. Disposition of discrepant parts/components. N/A.
- e. Disposition of hazardous material. IAW Environmental Protection Agency directives as implemented by your servicing Environmental Coordinator (AR 200-1).

**11. MAINTENANCE APPLICATION.**

- a. Category of Maintenance. AVUM or AVIM.
- b. Estimated time required.
  - (1) Time to complete inspection. Total of 0.2 man-hours using 1 person.
  - (2) Time for repair/replacement. Total of 2.0 man-hours using 1 person.

**12. PUBLICATION REQUIREMENTS.**

- a. References.
  - (1) AR 95-1.
  - (2) AR 200-1.
  - (3) DA PAM 738-751.
  - (4) TM 9-1005-262-13, w/Change 2.
  - (5) TM 9-1005-262-23P.
  - (6) TM 1-1520-240-23.
- b. Publication changes. N/A.

**13. POINTS OF CONTACT.**

- a. Technical POCs are:
  - (1) Primary. Mr. Michael B. Moore, AMSRD-AMR-AE-C, DSN 897-3617 or (256) 313-3617. Fax is DSN 897-4726 or (256) 313-4726. E-mail is "michael.moore@peoavn.us.army.mil".

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(2) Alternate. Mr. James R. Hamilton, AMSRD-AMR-AE-C, DSN 897-3380 or (256) 313-3380. Fax is DSN 897-4726 or (256) 313-4726. E-mail is "james.hamilton@peoavn.redstone.army.mil".

**b. Logistical POCs are:**

(1) Primary. Mr. James T. Appleton, SFAE-AV-CH, DSN 897-0729 or (256) 313-0729. Fax is DSN 897-4726 or (256) 313-4726. E-mail is "james.appleton@peoavn.redstone.army.mil".

(2) Alternate. Mr. Bill Olson, SFAE-AV-CH, DSN 897-0721 or (256) 313-0721. Fax is DSN 897-4726 or (256) 313-4726. E-mail is "william.olson@peoavn.redstone.army.mil".

**c. Forms and records POCs are:**

(1) Primary. Ms. Ann Waldeck, AMSAM-MMC-MA-NM, DSN 746-5564 or (256) 876-5564. Fax is DSN 746-4904 or (256) 876-4904. E-mail is "ann.waldeck@redstone.army.mil".

(2) Alternate. Ms. Sibyl Johnson, AMSAM-MMC-MA-NM, DSN 788-6696 or (256) 842-6696. Fax is DSN 746-4904 or (256) 876-4904. E-mail is "sibyl.johnson@redstone.army.mil".

**d. Safety POCs are:**

(1) Primary. Mr. Randall Rushing (SAIC), AMSAM-SF-A, DSN 897-2092 or (256) 313-2092. Fax is DSN 897-2111 or (256) 313-2111. E-mail is "randall.rushing@us.army.mil".

(2) Alternate. Mr. Russell Peusch, AMSAM-SF-A, DSN 788-8632 or (256) 842-8632. Fax is DSN 897-2111 or (256) 313-2111. E-mail is "russell.peusch@redstone.army.mil".

**e. Foreign military sales POC.** Mr. Ronnie W. Sammons, AMSAM-SA-AS-UT, DSN 897-0875 or (256) 313-0875. Fax is DSN 897-0411 or (256) 313-0411. E-mail is "ronnie.sammons@redstone.army.mil".

**f. After hours.** Contact the AMCOM Operations Center (AOC) DSN 897-2066/7 or (256) 313-2066/7.

**NOTE**

A listing of published Safety Messages can be viewed at "<https://ams14.redstone.army.mil/safety/sof/index.html>". This is a secured website which requires an Army Knowledge Online (AKO) ("www.us.army.mil") ID and password.

**14. REPORTING OF ERRORS AND RECOMMENDING IMPROVEMENTS.**

You can help improve this publication. If you find any mistakes or if you know of a way to improve the procedures, please let us know. Mail your letter or DA Form 2028 (Recommended Changes to Publications and Blank Forms) directly to: Commander, U.S. Army Aviation and Missile Command, ATTN: AMSAM-MMC-MA-NP, Redstone Arsenal, AL 35898-5000. You may also submit your recommended changes by E-Mail directly to [2028@redstone.army.mil](mailto:2028@redstone.army.mil) or by fax (256) 842-6546/DSN 788-6546. A reply will be furnished directly to you. Instruction for sending an electronic 2028 may be found at the back of this publication.

By Order of the Secretary of the Army:

Official:



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## ***These are the instructions for sending an electronic 2028***

The following format must be used if submitting an electronic 2028. The subject line must be exactly the same and all fields must be included; however, only the following fields are mandatory: 1, 3, 4, 5, 6, 7, 8, 9, 10, 13, 15, 16, 17, and 27.

From: "Whomever" [whomever@avma27.army.mil](mailto:whomever@avma27.army.mil)  
To: [2028@redstone.army.mil](mailto:2028@redstone.army.mil)  
Subject DA Form 2028

1. **From:** Joe Smith
2. **Unit:** home
3. **Address:** 4300 Park
4. **City:** Hometown
5. **St:** MO
6. **Zip:** 77777
7. **Date Sent:** 19-OCT-93
8. **Pub no:** 55-2840-229-23
9. **Pub Title:** TM
10. **Publication Date:** 04-JUL-85
11. **Change Number:** 7
12. **Submitter Rank:** MSG
13. **Submitter FName:** Joe
14. **Submitter MName:** T
15. **Submitter LName:** Smith
16. **Submitter Phone:** 123-123-1234
17. **Problem:** 1
18. **Page:** 2
19. **Paragraph:** 3
20. **Line:** 4
21. **NSN:** 5
22. **Reference:** 6
23. **Figure:** 7
24. **Table:** 8
25. **Item:** 9
26. **Total:** 123
27. **Text:**

This is the text for the problem below line 27.

