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Aircraft Industries, a.s. / Na Záhonech 1177 / Kunovice 686 04 / Czech Republic

# SERVICE BULLETIN

SB No. **L-410/006b**

Aeroplane Type: **L-410**

Revision No. **IR**

Date of Issue: **Jul 8, 2020**

The technical content of this document is approved under the authority of DOA No. EASA.21J.119

**Classification:** Recommended

**Subject:** Double-locking of bolts of the aileron, elevator and rudder trim tabs control.

**Supersedure:** N/A

## 1. PLANNING INFORMATION

### A. APPLICABILITY

L 410 UVP-E20 aeroplanes up to S/N 3312 inclusive except aeroplanes equipped with doubled control of trim tabs.

### B. CONCURRENT REQUIREMENTS

None.

### C. REASON

Improvement of reliability of trim tabs control system.

### D. COMPLIANCE TIME

As per operator's requirement.

### E. MANPOWER

Supposed Man-hours      8 M-hours

### F. MATERIAL

Will be delivered by the aeroplane manufacturer Aircraft Industries, a.s., 686 04 Kunovice, Czech Republic against an order.

### G. NEW EQUIPMENT

None.

## H. SPECIAL TOOLS

None.

## I. EXPENSES

To be covered by the operator.

## J. WEIGHT AND BALANCE

Influence of the installation on an empty aeroplane weight and moment is negligible.

## K. REFERENCE DOCUMENTS

### 1. Drawings

B535 360N sheet 1	Aileron trim tab control
B536 261N	Rudder trim tab control
B536 280N sheet 2, 3, 4	Elevator trim tab control

### 2. Maintenance Manual, Doc. No. Do-L410-1232.2, chap.:

020.20.00	027.12.00	027.12.01	027.22.00	027.22.01	027.32.00
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## L. AFFECTED DOCUMENTS

AFM	not affected
MS	not affected
MM	will be implemented from Revision No. 36
WM	not affected

## 2. IMPLEMENTATION INFORMATION

### A. PREPARATORY WORK

- Remove split pins from nuts mounting the UT 6D electro-mechanical strut and trim tab control lever according to the MM, chap. 027.12.01, page 401, points 1.E.(1) to (3).
- Open lids on the bottom LH and RH sides of the stabilizer between ribs 2 and 3 behind the rear spar.
- Remove split pins from nuts mounting the UT 6D electro-mechanical strut and trim tab control lever according to the MM, chap. 027.22.01, page 401, points 1.E.(1) to (3)(a).

### B. CHECK OR INSPECTION

None.

## C. DISASSEMBLY

### Aileron Trim Tab

- Unscrew the castle nut pos. 11, Dwg. No. B535 360N sheet 1 from the bolt pos. 7. Keep it for reassembly.
- Unscrew the castle nut pos. 12 and remove washer pos. 24 from the bolt pos. 9. Keep the nut for reassembly.
- Unscrew the castle nut pos. 12 and remove washer pos. 24 from the bolt pos. 8. Keep the nut for reassembly.
- Unscrew the castle nuts pos. 19 and remove washers pos. 20 from the bolts pos. 18. Keep the nuts for reassembly.

### Elevator Trim Tabs

- Remove the split pin pos. 78, unscrew castle nut pos. 60, Dwg. No. B536 280N sheet 4, View S4 and remove washer pos. 34 from the bolt pos. 44. Keep the nut for reassembly.
- Remove the split pin pos. 79, unscrew castle nut pos. 61, Dwg. No. B536 280N sheet 3, Detail III3 and remove washer pos. 69 from the bolt pos. 43. Keep the nut for reassembly.
- Remove the split pins pos. 78, unscrew castle nuts pos. 60, Dwg. No. B536 280N sheet 3, Detail III3 and remove washers pos. 34 from the bolts pos. 37. Keep the nuts for reassembly.
- Remove the split pin pos. 78, unscrew castle nut pos. 60, Dwg. No. B536 280N sheet 4, Detail VI4 and remove washer pos. 34 from the bolt pos. 37. Keep the nut for reassembly.

### Rudder Trim Tab (valid only for aeroplanes up to S/N 2903 inclusive)

- Unscrew the castle nut pos. 21, Dwg. No. B536 261N sheet 1 from the bolt pos. 13. Keep it for reassembly.
- Unscrew the castle nut pos. 21, Section A-A and remove washer pos. 28 from the bolt pos. 13. Keep the nut for reassembly.
- Unscrew the castle nut pos. 22, Section A-A and remove washer pos. 19 from the bolt pos. 12. Keep the nut for reassembly.
- Unscrew the castle nut pos. 20, Dwg. No. B536 261N sheet 1 and remove washer pos. 28 from the bolt pos. 5. Keep them for reassembly.
- Unscrew the castle nut pos. 20, Dwg. No. B536 261N sheet 2, View X2 and remove washer pos. 27 from the pin pos. 35. Keep the nut for reassembly.

## D. ASSEMBLY

### Aileron Trim Tab

- Install a circlip pos. 48 on the bolt pos. 7, Dwg. No. B535 360N sheet 1, washer pos. 52 and tighten the castle nut pos. 11. Lock the nut by new split pin pos. 15. Use material pos. 3, 8, 11 of point 3.A. of this bulletin.
- Put a washer pos. 50 on the bolt pos. 9, install a circlip pos. 46, washer pos. 50 and tighten the castle nut pos. 12. Lock the nut by new split pin pos. 16. Use material pos. 1, 4, 9 of point 3.A. of this bulletin.
- Put washers pos. 14, 50 on the bolt pos. 8, install a circlip pos. 46, washer pos. 50 and tighten the castle nut pos. 12. Lock the nut by new split pin pos. 16. Use material pos. 1, 4, 5, 9 of point 3.A. of this bulletin.
- Put a washer pos. 54 on the bolts pos. 18, install a circlip pos. 47, washer pos. 51 and tighten the castle nuts pos. 19. Lock the nuts by new split pin pos. 21. Use material pos. 2, 6, 7, 10 of point 3.A. of this bulletin.

### Elevator Trim Tabs

- Put a washer pos. 67 on the bolt pos. 44, Dwg. No. B536 280N sheet 4, View S4, install a circlip pos. 81, washer pos. 116 and tighten the castle nut pos. 60. Lock the nut by new split pin pos. 78. Use material pos. 21, 23, 24, 26 of point 3.A. of this bulletin.
- Install a circlip pos. 29 on the bolt pos. 43, Dwg. No. B536 280N sheet 3, Detail III3, washer pos. 115 and tighten the castle nut pos. 61. Lock the nut by new split pin pos. 79. Use material pos. 20, 22, 25 of point 3.A. of this bulletin.
- Install circlips pos. 81 on the bolts pos. 37, Dwg. No. B536 280N sheet 3, Detail III3, washers pos. 116 and tighten the castle nuts pos. 60. Lock the nuts by new split pin pos. 78. Use material pos. 21, 23, 26 of point 3.A. of this bulletin.
- Put a washer pos. 67 on the bolt pos. 37, Dwg. No. B536 280N sheet 4, Detail VI4, install a circlip pos. 81, washer pos. 116 and tighten the castle nut pos. 60. Lock the nut by new split pin pos. 78. Use material pos. 21, 23, 24, 26 of point 3.A. of this bulletin.

### Rudder Trim Tab (valid only for aeroplanes up to S/N 2903 inclusive)

- Install a circlip pos. 46 on the bolt pos. 13, Dwg. No. B536 261N sheet 1, washer pos. 50 and tighten the castle nut pos. 21. Lock the nut by new split pin pos. 32. Use material pos. 31, 34, 37 of point 3.A. of this bulletin.
- Install a circlip pos. 46 on the bolt pos. 13, Section A-A, washer pos. 50 and tighten the castle nut pos. 21. Lock the nut by new split pin pos. 32. Use material pos. 31, 34, 37 of point 3.A. of this bulletin.
- Put a washer pos. 14 on the bolt pos. 12, Section A-A, install a circlip pos. 48, washer pos. 14 and tighten the castle nut pos. 22. Lock the nut by new split pin pos. 33. Use material pos. 32, 35, 38 of point 3.A. of this bulletin.
- Install a circlip pos. 47 on the bolt pos. 5, Dwg. No. B536 261N sheet 1, washer pos. 28 and tighten the castle nut pos. 20. Lock the nut by new split pin pos. 31. Use material pos. 30, 36 of point 3.A. of this bulletin.

- Put a washer pos. 51 on the pin pos. 35, Dwg. No. B536 261N sheet 2, View X2, install a circlip pos. 47, washer pos. 51 and tighten the castle nut pos. 20. Lock the nut by new split pin pos. 31. Use material pos. 30, 33, 36 of point 3.A. of this bulletin.

## E. TESTS

### 1. Ground Tests

#### Check of individual joints

- A washer must be installed between castle nut and circlip and a circlip must not be deformed.
- There must be no axial play in a joint.
- A castle nut must be properly locked by a split pin.

#### Check of trim tabs operation

- Check operation of the aileron trim tab according to the MM, chap. 027.12.00, page 301.
- Check operation of the elevator trim tab according to the MM, chap. 027.32.00, page 301.
- Check operation of the rudder trim tab according to the MM, chap. 027.22.00, page 301 (valid only for aeroplanes up to S/N 2903 inclusive).

### 2. Flight Tests

None.

## F. COMPLETION WORK

- Repair damaged paintings with paint according to the MM, chap. 020.20.00.
- Install removed lids on the aileron, stabilizer and rudder.

### 3. BILL OF MATERIAL

#### A. MATERIAL DELIVERED BY THE AEROPLANE MANUFACTURER

Pos.	Nomenclature	Name	Pcs/Arpln
<b>Aileron Trim Tab</b>			
1	36157005	5 Circlip, LeN 3321	2
2	36157006	6 Circlip, LeN 3321	2
3	36157008	8 Circlip, LeN 3321	1
4	35615510	0.5x5 Washer, ONL 3271, (pos. 50)	4
5	35611511	1x5x11 Washer, 3402A, (pos. 14)	1
6	35615610	0.5x6x10 Washer, 3402A, (pos. 51)	2
7	35655654	6.4 Washer, DIN 125-1A, (pos. 54)	2
8	35615816	0.5x8x16 Washer, 3402A, (pos. 52)	1
9	31049012	1x12 Split pin, DIN 94	2
10	36106436	1.6x16 Split pin, DIN 94	2
11	36106458	2x18 Split pin, DIN 94	1
<b>Elevator Trim Tabs</b>			
20	36157005	5 Circlip, LeN 3321	2
21	36157006	6 Circlip, LeN 3321	8
22	35615510	0.5x5 Washer, ONL 3271, (pos. 115)	2
23	35615610	0.5x6x10 Washer, 3402A, (pos. 116)	8
24	35655654	6.4 Washer, DIN 125-1A, (pos. 67)	4
25	31049012	1x12 Split pin, DIN 94	2
26	36106434	1.6x14 Split pin, DIN 94	8
<b>Rudder Trim Tab (valid only for aeroplanes up to S/N 2903 inclusive)</b>			
30	36157005	5 Circlip, LeN 3321	2
31	36157006	6 Circlip, LeN 3321	2
32	36157008	8 Circlip, LeN 3321	1
33	35615510	0.5x5 Washer, ONL 3271, (pos. 51)	2
34	35615610	0.5x6x10 Washer, 3402A, (pos. 50)	2
35	35615816	0.5x8x16 Washer, 3402A, (pos. 14)	2
36	36101212	1.2x12 Split pin, CSN 02 1781.04	2
37	36101620	1.6x20 Split pin, CSN 02 1781.04	2
38	36100220	2x20 Split pin, CSN 02 1781.04	1

**4. RECORD IN THE AEROPLANE LOGBOOK**

Double-locking of bolts of the aileron, elevator and rudder trim tabs control has been accomplished in accordance with the L-410/006b Service Bulletin.

**Valid only for aeroplanes from S/N 2904**

Double-locking of bolts of the aileron and elevator trim tabs control has been accomplished in accordance with the L-410/006b Service Bulletin.

Date: .....

Accomplished by: .....

(name and signature of authorised staff)