



Aircraft Industries



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

SERVICE BULLETIN

SB No. **L-410/057b**

Aeroplane Type: **L-410**

Revision No. **IR**

Date of Issue: **Oct 18, 2023**

The technical content of this document is approved under the authority of the DOA ref. EASA.21J.119.

Classification: Recommended

Subject: Installation of protective washers to prevent airframe parts corrosion.

Supersedure: N/A

1. PLANNING INFORMATION

A. APPLICABILITY

L-410 UVP – Turbolet, L 410 FG, L 410 UVP-LW.

B. CONCURRENT REQUIREMENTS

None.

C. REASON

Electrochemical corrosion of airframe parts due to salt, moisture and temperature.

D. COMPLIANCE TIME

As per operator's requirement.

E. MANPOWER

Supposed Man-hours: 26 M-hours

F. MATERIAL

Will be delivered by the aeroplane manufacturer Aircraft Industries, a.s., 686 04 Kunovice, Czech Republic based on 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

B522 112N Washers under grounding

2. Maintenance Manual L 410 UVP or L 410 UVP-LW, chap.:

20.12.00	20.20.00	24.30.04	24.40.00	53.50.00	57.51.00
57.54.00					

L. AFFECTED DOCUMENTS

AFM not affected
MS not affected
MM not affected
WM not affected

2. IMPLEMENTATION INFORMATION

A. PREPARATORY WORK

- Disconnect the external power supply plug according to the MM, chap. 24.40.00.B.
- Remove accumulators from the airplane according to the MM, chap. 24.30.04.A.
- Remove the wing tips and ABC tabs according to the MM, chap. 57.54.00, page 401.
- Remove the aileron trim tab according to the MM, chap. 57.51.00, page 404.
- Remove the LH rear side cover of wing-to-fuselage fillets according to the MM, chap. 053.50.00.
- Remove the front cover pos. 1 of the tail unit-to-fuselage fillets according to the MM, chap. 53.50.00, Fig. 2, page 4 and 403.
- Open the doors of front baggage compartment.
- Open the front emergency door.
- Open the entrance and cargo doors.

B. CHECK OR INSPECTION

None.

C. DISASSEMBLY

NOTE

Clean the corroded surface (if corroded) to metallic lustre with smooth transitions after removing each of the grounding below. Treat the cleaned surface with Bonderite M-CR 600 Aero accord. to the MM, chap. 20.12.00. Or you can use Bonderite M-CR 1200S Aero, but only one layer of coating to keep good conductivity. Use material pos. 1 of point 3.B. of this bulletin.

- Remove grounding from the B030 611N rib of the fin and fuselage sheet metal, Dwg No. B522 112N sheet 2, Section A2-A2 and View S2.
- Remove grounding from the B025 002N hinge of the ABC tab and rib 31, sheet 2, Section C2-C2 and View P2.
- Remove grounding from the front baggage compartment doors and fuselage skin, sheet 2, Section D2-D2.
- Remove grounding from the rudder hinges on the ribs 2 and 5, sheet 2, Section G2-G2.
- Remove grounding from the front emergency door and door frame, sheet 2, Section E2-E2.
- Remove grounding from the entrance and cargo doors and door frame, sheet 2, Section F2-F2.
- Remove grounding from the hinge of aileron trim tab and aileron trim tab, sheet 2, View Y2 and Z2.
- Remove grounding from the fuselage skin at the frame 14 (under the LH rear side cover of wing-to-fuselage fillets) and wing rear spar web at the LH rib 3, sheet 2, Section H2-H2 and View R2.
- Remove groundings from the B013 173LP main LG doors, sheet 3, View X3 and Y3.
- Remove groundings from the wing flaps and slats hinges on the ribs 4, 10, 15, 20, sheet 3.

D. ASSEMBLY

NOTE

Keep conductive connection of individual groundings according to the Dwg No. B522 112N.

- Insert new washers pos. 1 between grounding strap lugs and the B030 611N rib and fuselage sheet metal and install back the grounding according to the B522 112N sheet 2, Section A2-A2 and View S2. Use original connecting material and material pos. 1 of point 3.A. of this bulletin.
- Insert new washers pos. 2 between grounding strap lugs and the B025 002N hinge and rib 31 and install back the grounding according to the sheet 2, Section C2-C2 and View P2. Use original connecting material and material pos. 2 of point 3.A. of this bulletin.
- Insert new washers pos. 1 between grounding strap lugs and the door and fuselage skin and install back the grounding according to the sheet 2, Section D2-D2. Use original connecting material and material pos. 1 of point 3.A. of this bulletin.
- Insert new washers pos. 2 between grounding strap lugs and the rudder hinges and install back the groundings according to the sheet 2, Section G2-G2. Use original connecting material and material pos. 2 of point 3.A. of this bulletin.
- Insert new washers pos. 1 between grounding strap lugs and the door and door frame and install back the grounding according to the sheet 2, Section E2-E2. Use original connecting material and material pos. 1 of point 3.A. of this bulletin.
- Insert new washers pos. 1 between grounding strap lugs and the entrance and cargo doors and door frame and install back the groundings according to the sheet 2, Section F2-F2. Use original connecting material and material pos. 1 of point 3.A. of this bulletin.
- Insert new washers pos. 3 between grounding strap lugs and the hinge and aileron trim tab and install back the grounding according to the sheet 2, View Y2 and Z2. Use original connecting material and material pos. 3 of point 3.A. of this bulletin.
- Insert new washers pos. 4 between grounding strap lugs and the fuselage skin and wing rear spar web and install back the grounding according to the sheet 2, Section H2-H2 and View R2. Use original connecting material and material pos. 4 of point 3.A. of this bulletin.
- Insert new washers pos. 1, 2 between grounding strap lugs and the B013 173LP main LG doors and install back the grounding according to the View X3, Y3. Use original connecting material and material pos. 1, 2 of point 3.A. of this bulletin.
- Insert new washers pos. 2 between grounding strap lugs and hinges and install back the groundings according to the sheet 3. Use original connecting material and material pos. 2 of point 3.A. of this bulletin.

E. TESTS

1. Ground Tests

None.

2. Flight Tests

None.

F. COMPLETION WORK

- Coat all the above mentioned groundings with primer and top coat RAL 3020 according to the MM, chap. 20.20.00.
- Install the ABC tabs according to the MM, chap. 57.54.00, page 402 and wing tips. Use original connecting material and new split pins pos. 5, 6 of point 3.A. of this bulletin.
- Install the aileron trim tab according to the MM, chap. 57.51.00, page 405. Use original connecting material and new split pin pos. 7 of point 3.A. of this bulletin.
- Install the LH rear side cover of wing-to-fuselage fillets according to the MM, chap. 053.50.00.
- Install the front cover pos. 1 of the tail unit-to-fuselage fillets according to the MM, chap. 53.50.00.
- Close the doors of front baggage compartment.
- Close the front emergency door.
- Close the entrance and cargo doors.
- Install the aeroplane accumulators according to the MM, chap. 024.30.04.A.



3. BILL OF MATERIAL

A. MATERIAL DELIVERED BY THE AEROPLANE MANUFACTURER

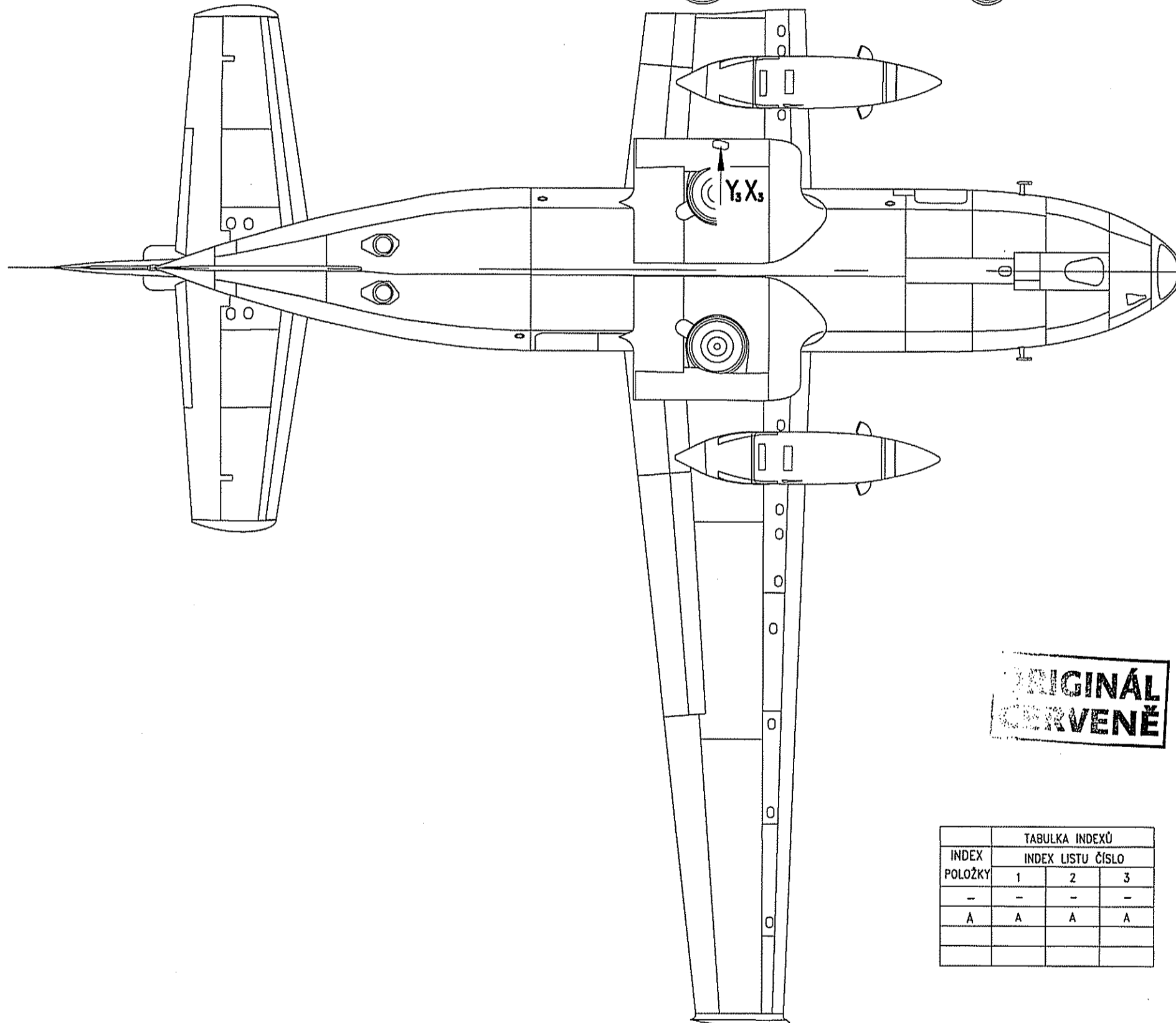
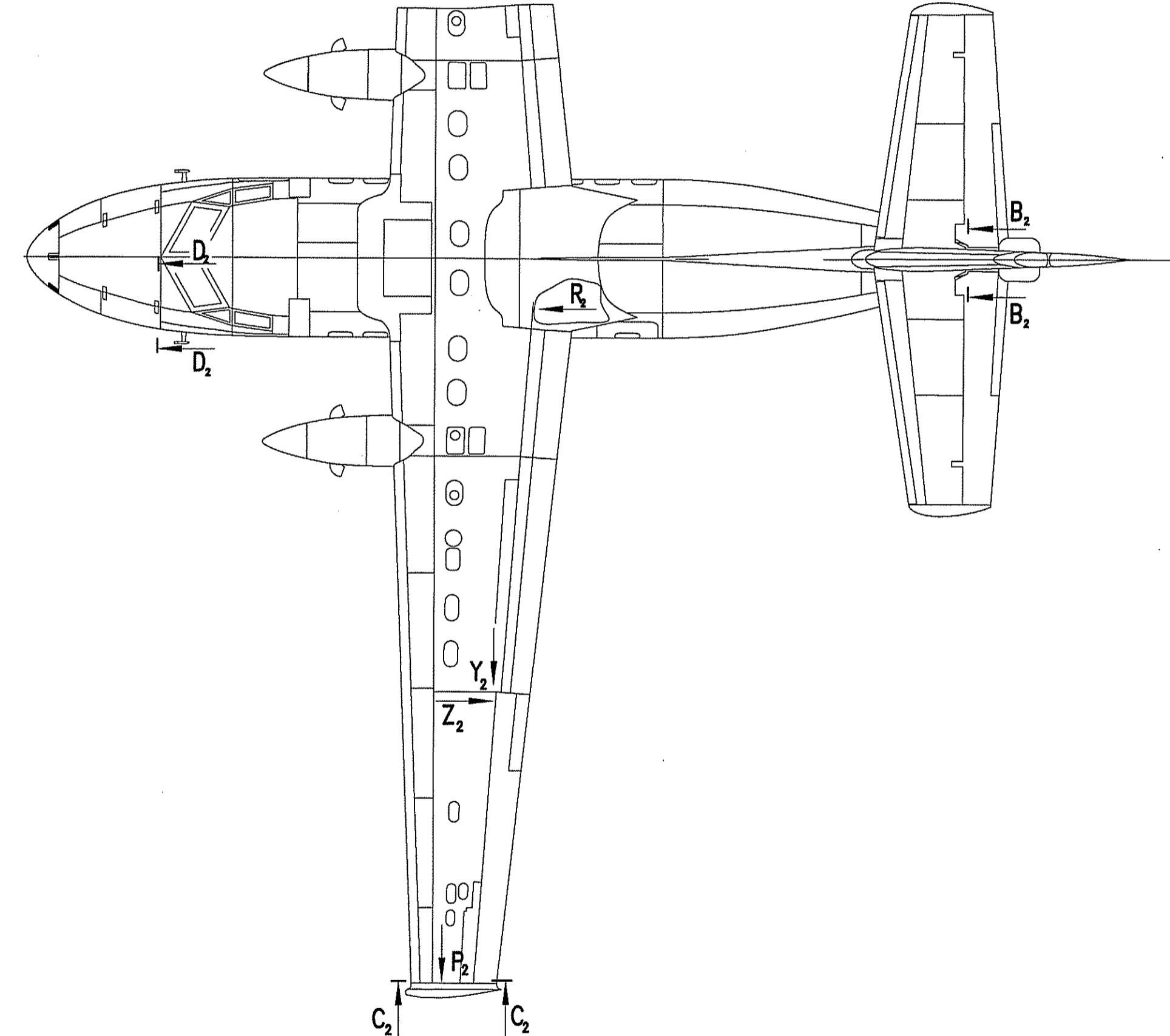
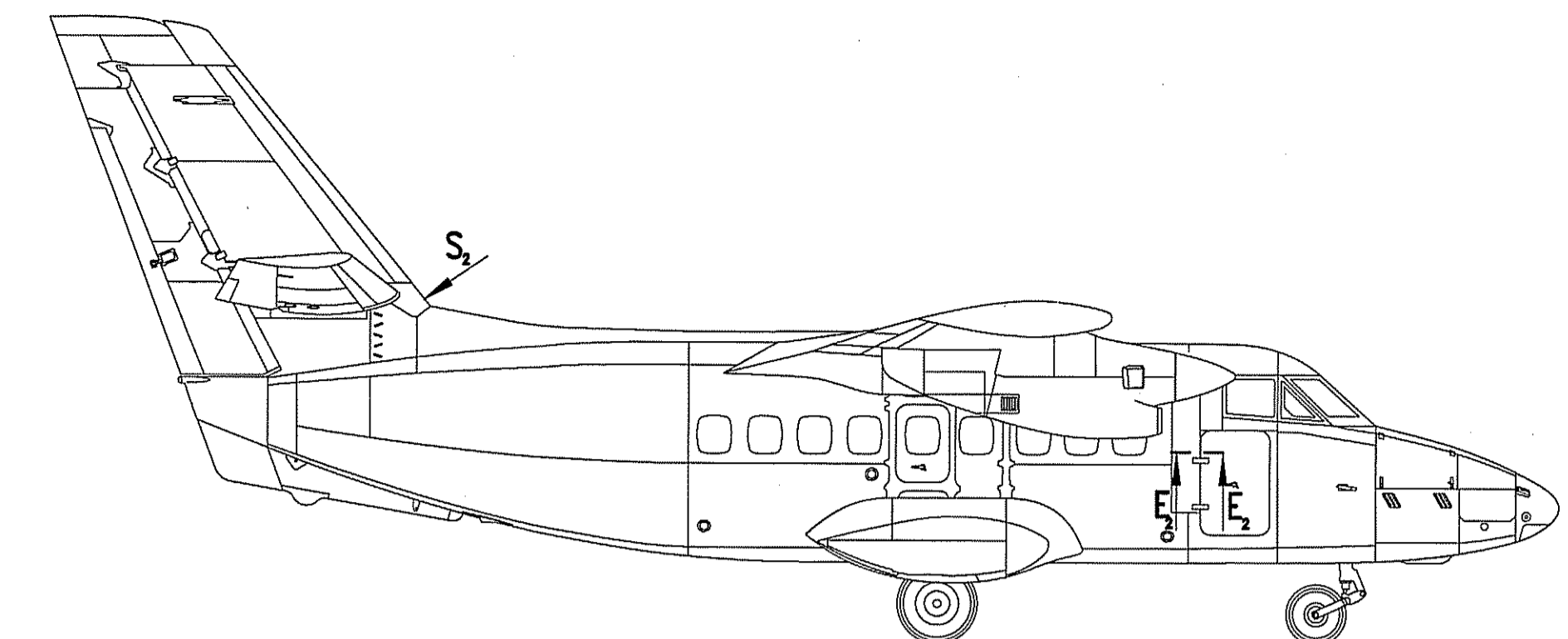
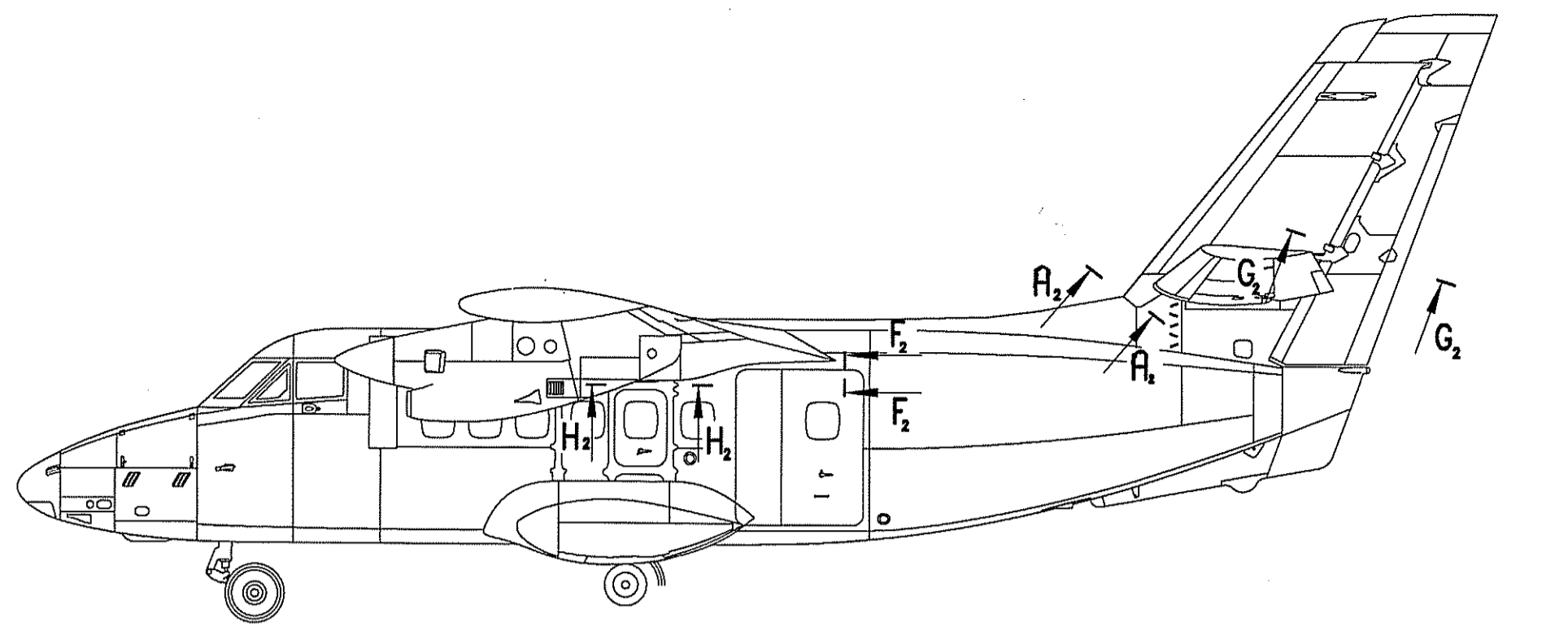
Pos.	Nomenclature	Name	Pcs/Arpln
1	B525098N	5.35 Washer	20
2	B524628N	4.3 Washer	50
3	B525099N	3.2 Washer	6
4	B518756N	8.2 Washer	6
5	31049012	1x12 Split pin, DIN 94	4
6	36106434	1.6x14 Split pin, DIN 94	6
7	36106436	1.6x16 Split pin, DIN 94	2

B. MATERIAL SUBJECT TO SPECIAL CONDITIONS DURING TRANSPORT

Pos.	Nomenclature	Name	Qty/Arpln
1	82055550	Bonderite M-CR 1200S Aero	50 g

4. RECORD IN THE AEROPLANE LOGBOOK

Record implementation of this L-410/057b Service Bulletin.



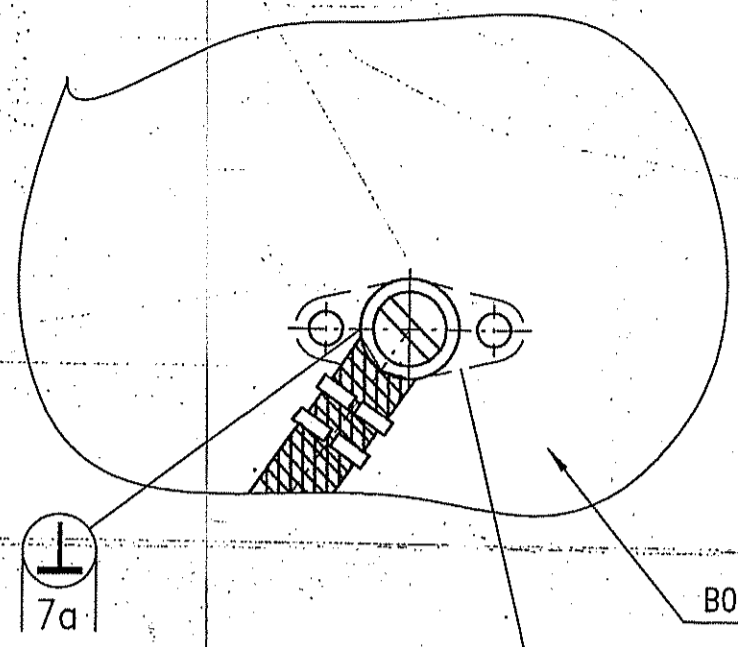
**ORIGINAL
ČERVENĚ**

TABULKA INDEXŮ			
INDEX POLOŽKY	1	2	3
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A	A	A	A

⊥
Vodíve propojeno
podle ONL 6661
5a,6a,7a,26a

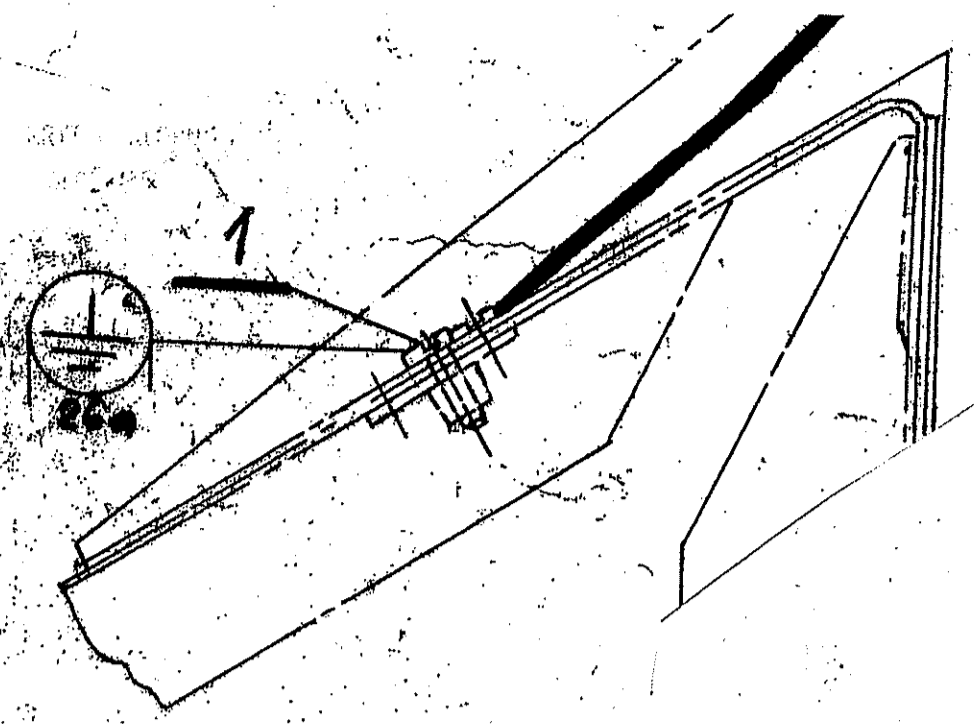
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Kontroloval: 29.8.23	Nedoma	Měřítka: -	Číslo výkresu: B522 112N						
Stavka: -	-	Čistá hmot: -	Index: A						
Únava: -	-	Kategorie: -	List: 1						
Norm. ref.: 195-7123	Krmíček	Sácha							
Schválil: -	-	-							

A-A₂
 ŽEBRO B030 601N
 PODLOŽKU POZICE 1 VLOŽIT MEZI OKO UKOSTŘENÍ A DÍLEC B030 611N

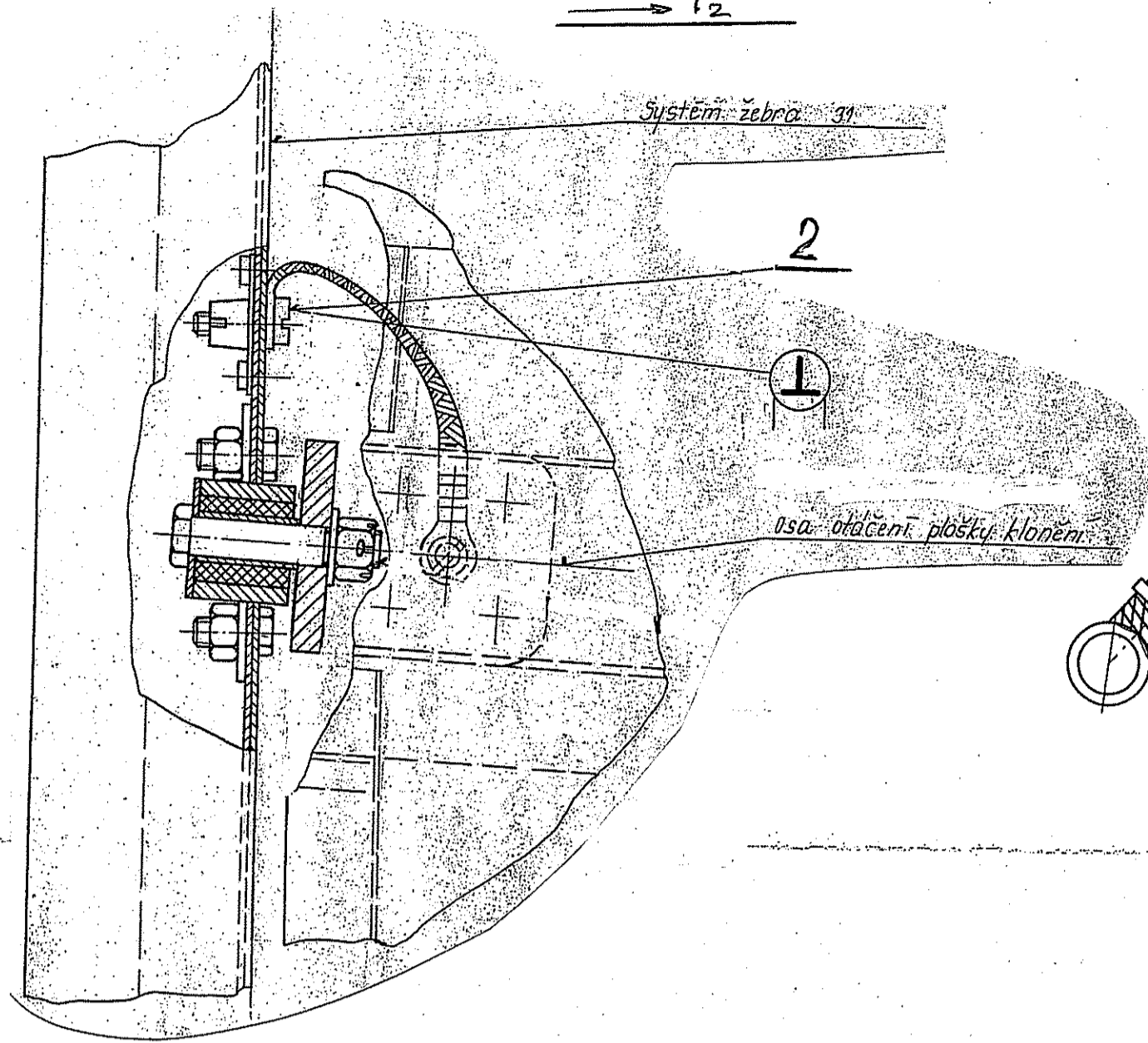


7a
 B030 611N
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 B525 098N

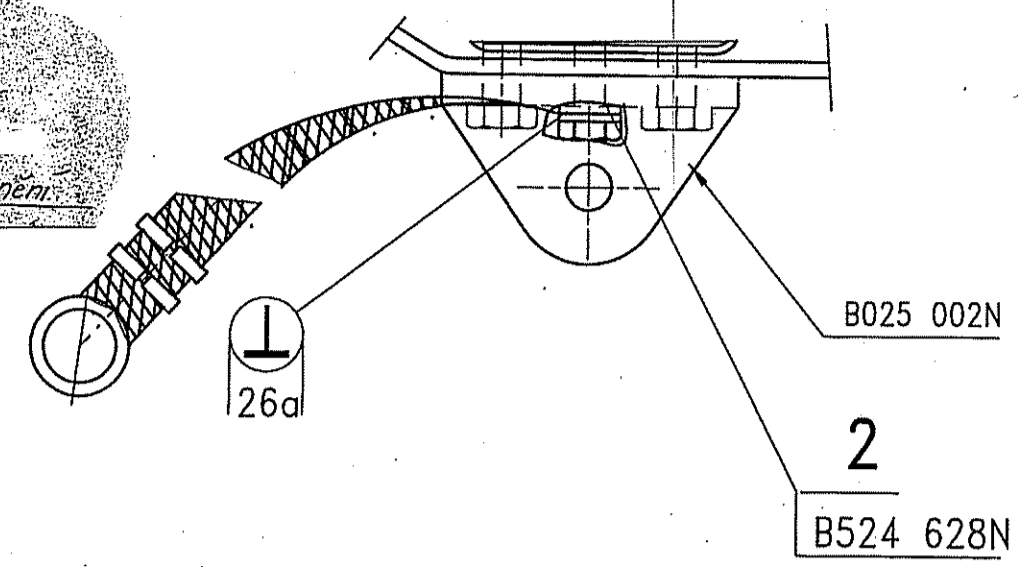
S₂



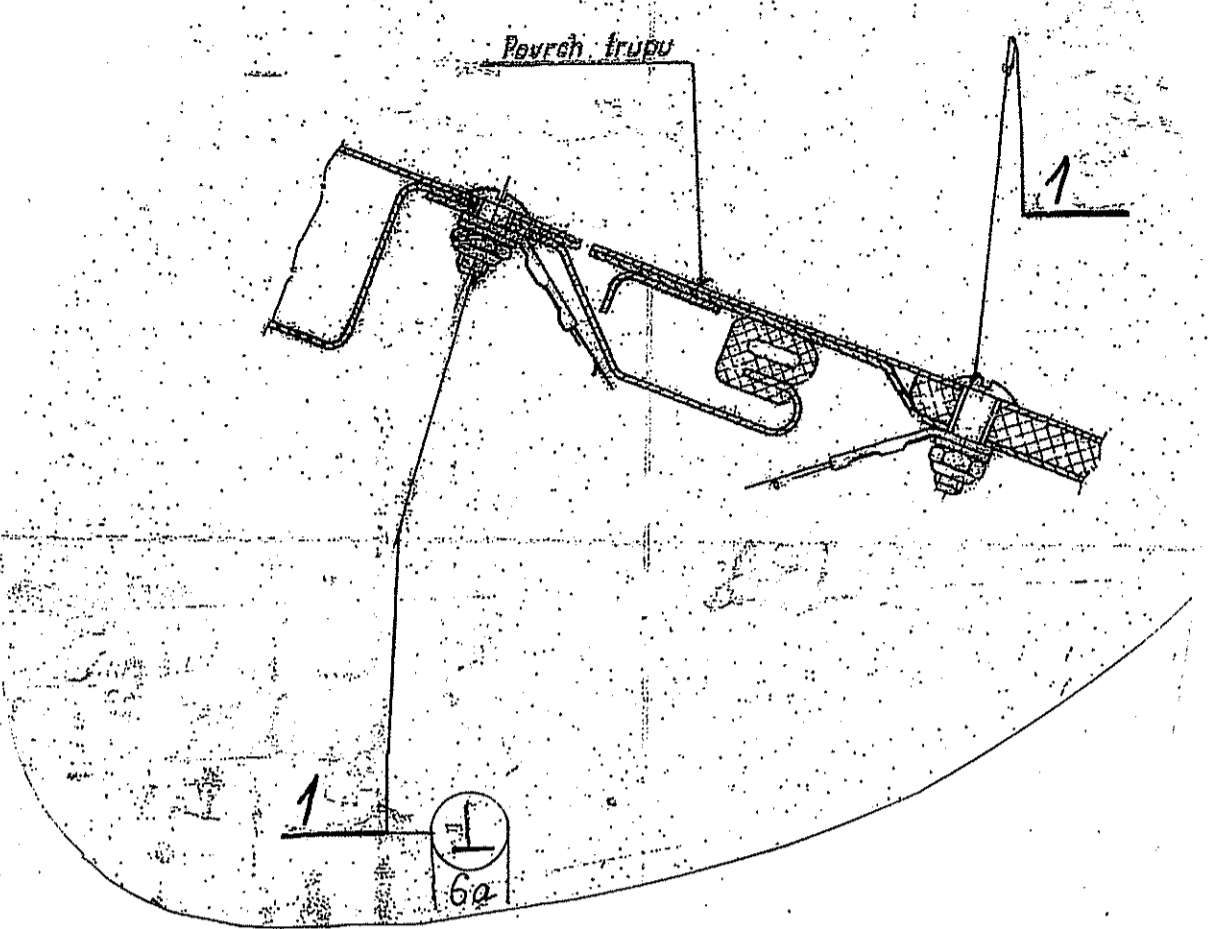
P₂



C-C₂
 PLOŠKA KLONĚNÍ B025 100LP
 PODLOŽKU POZICE 2 VLOŽIT MEZI OKO UKOSTŘENÍ A DÍLEC B025 002N

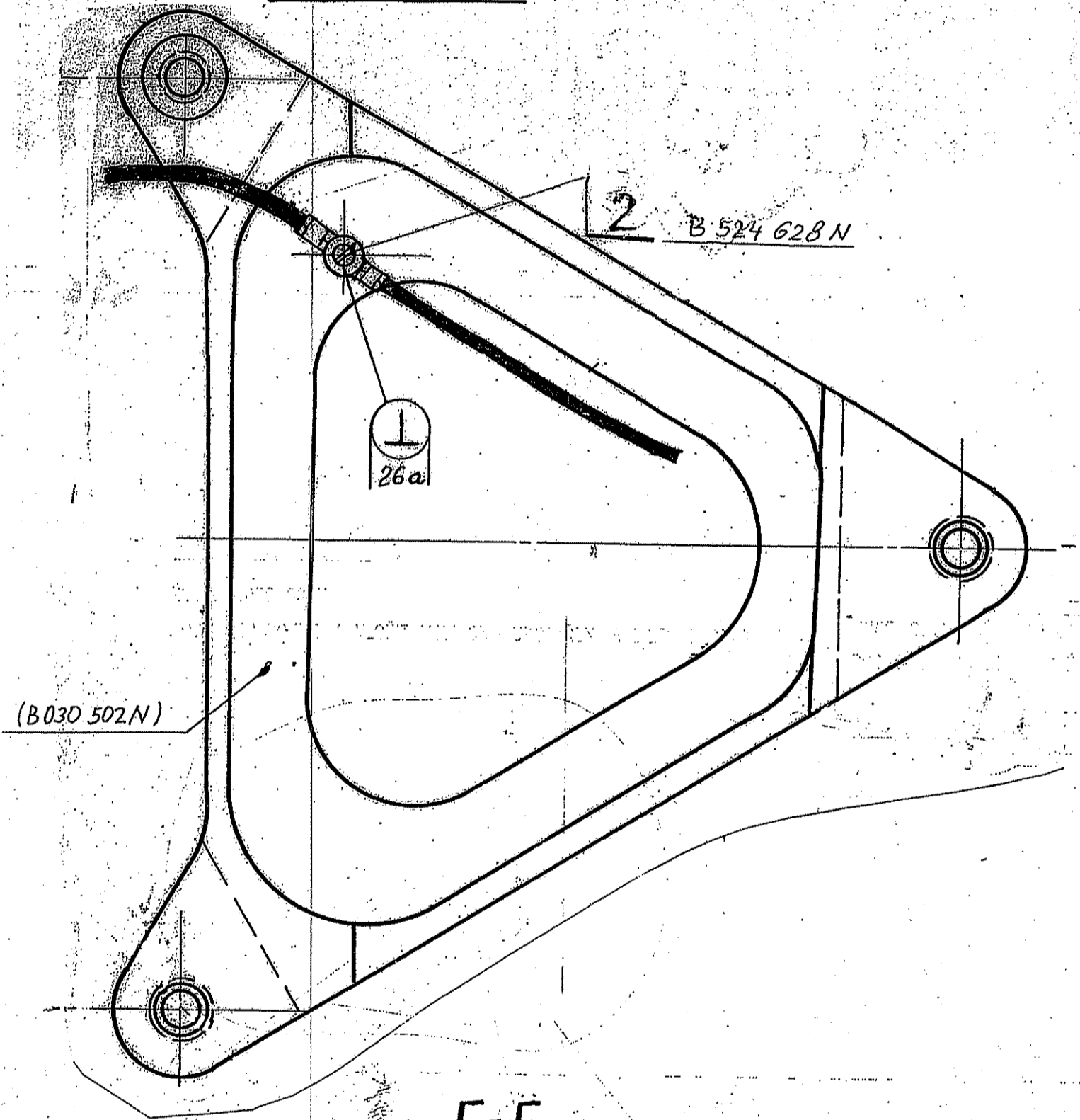


D-D

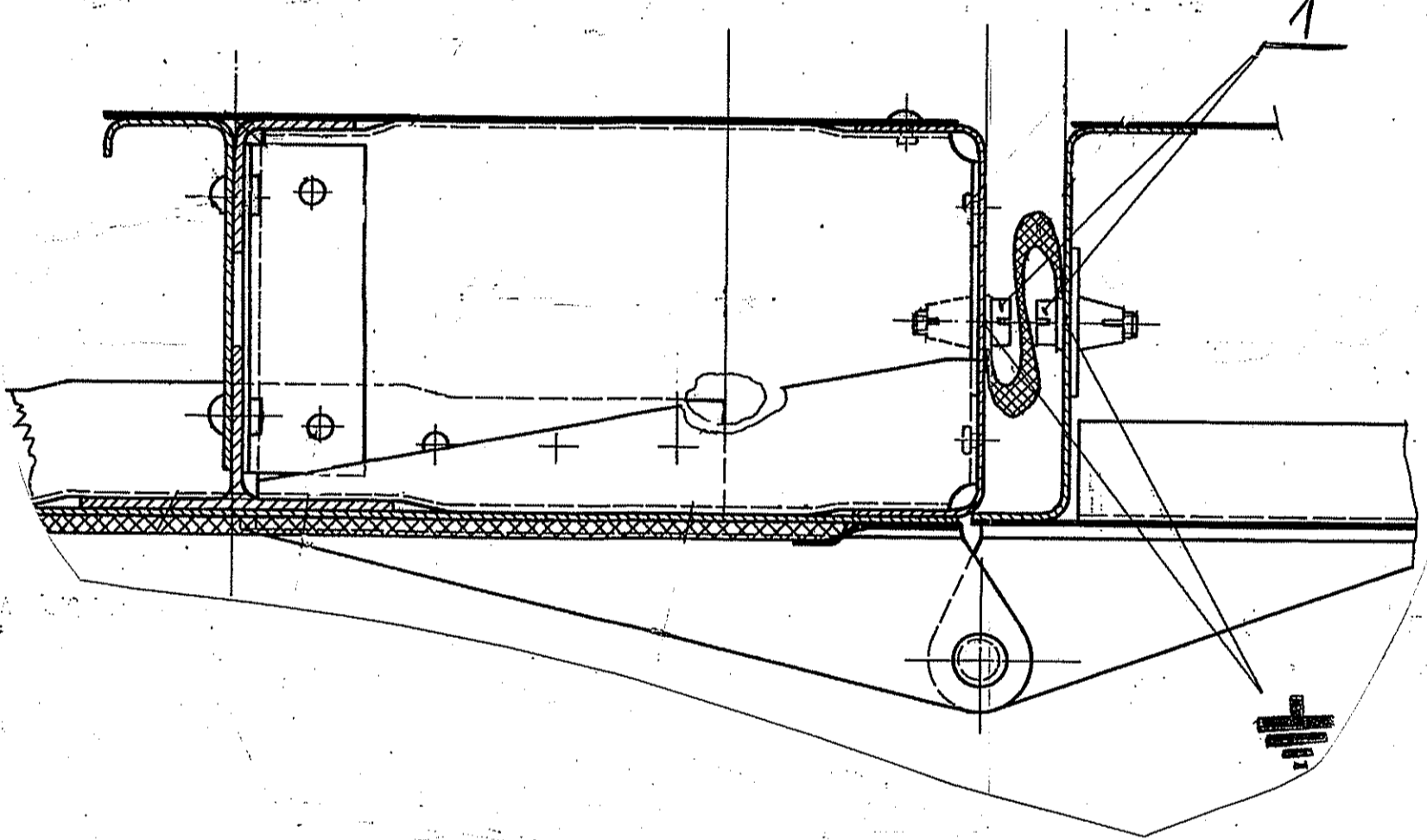
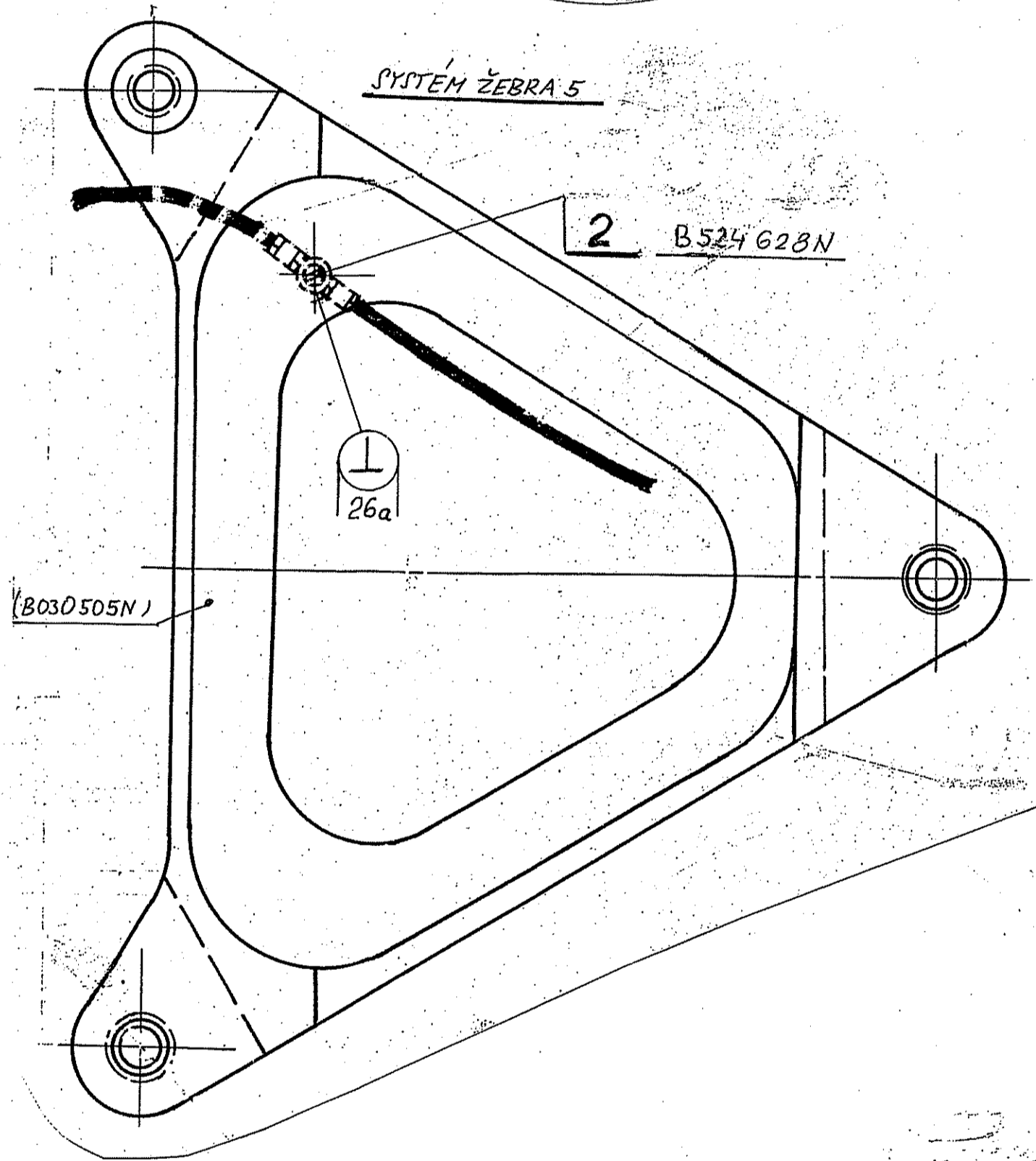


G₂-G₂

SYSTEM ŽEBRA 2

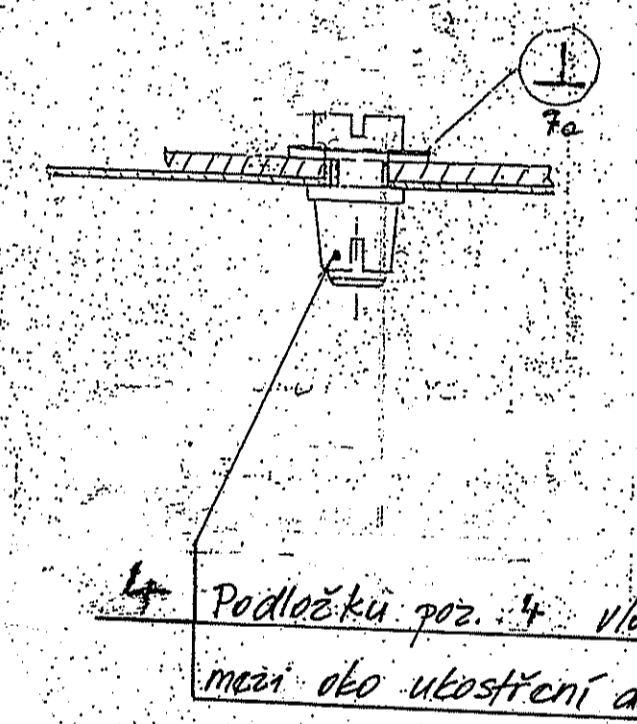


SYSTEM ŽEBRA 5



H₂-H₂

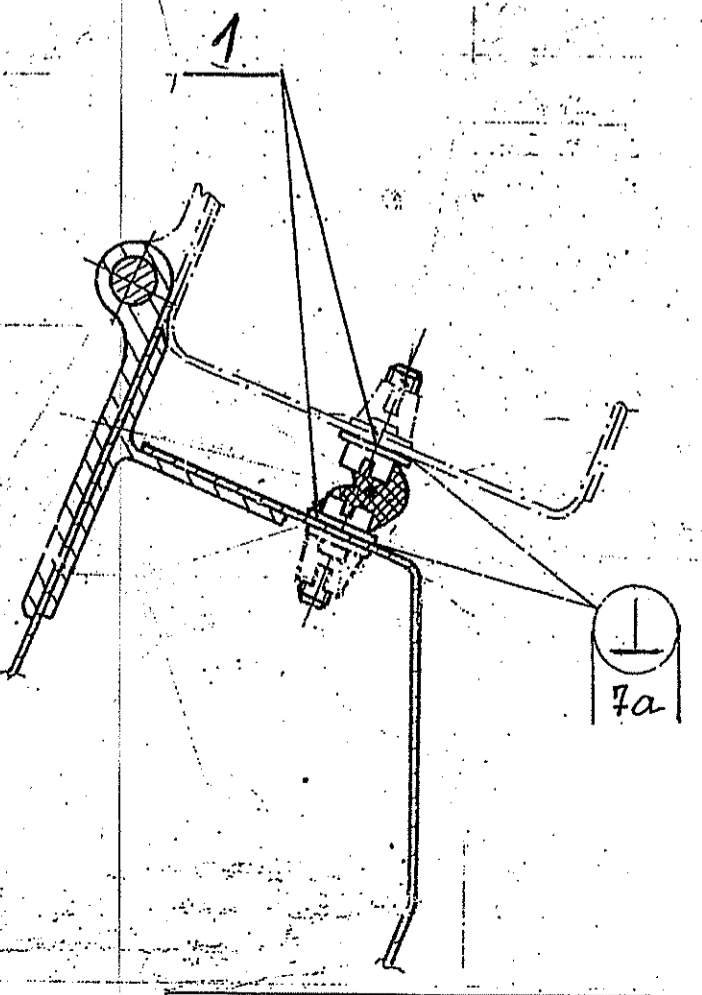
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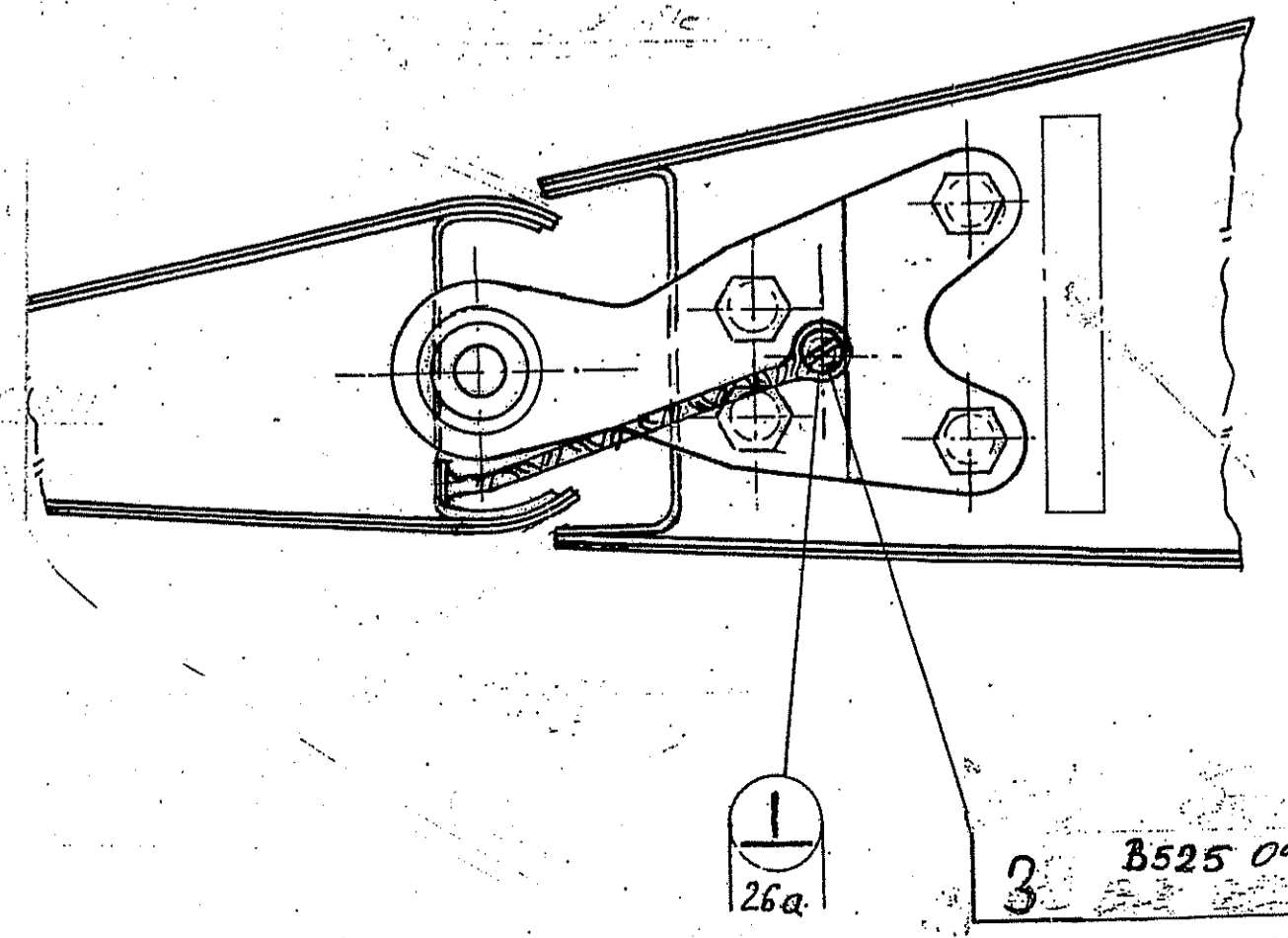
R₂

F₂-F₂
 M 1:1

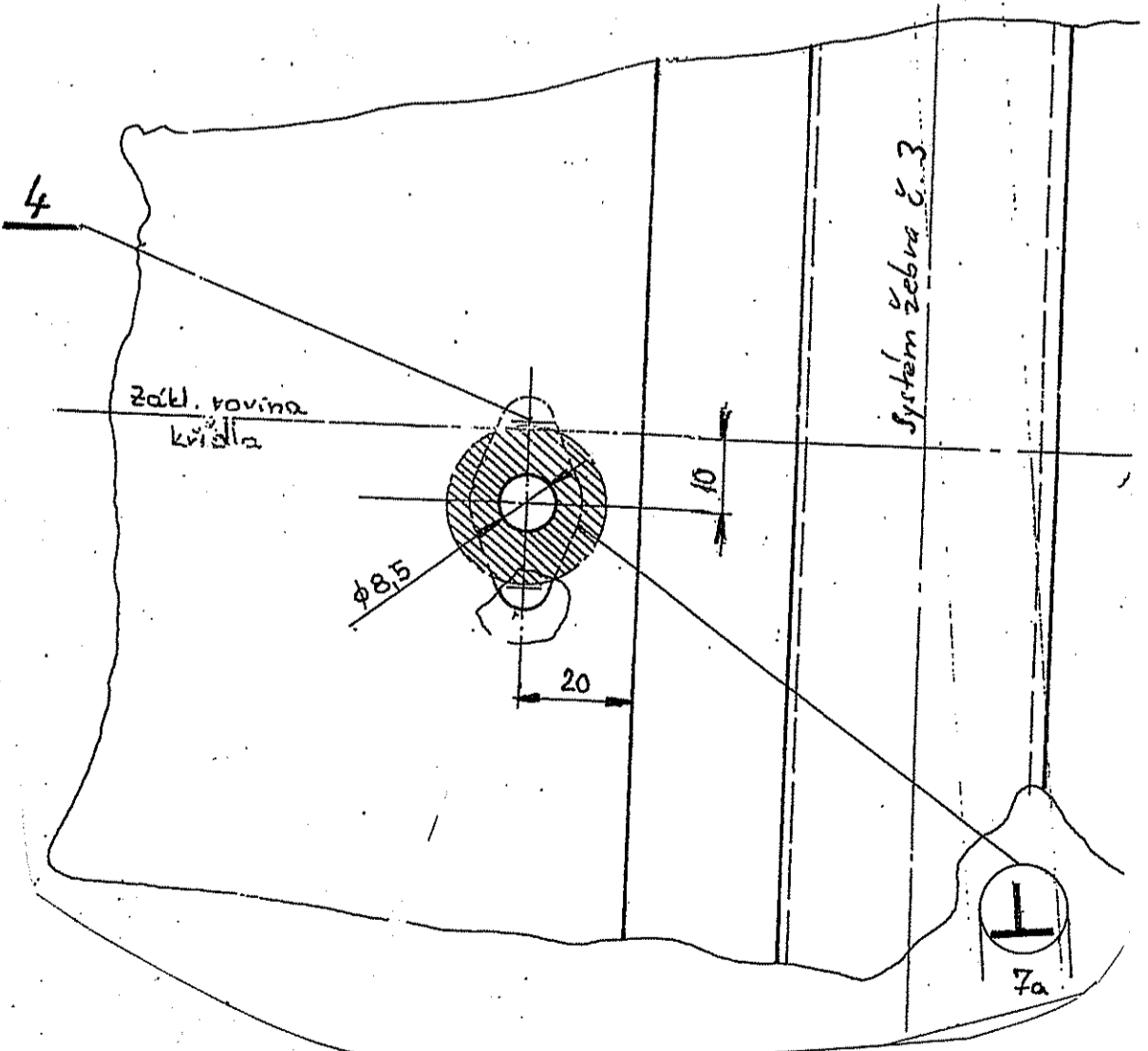
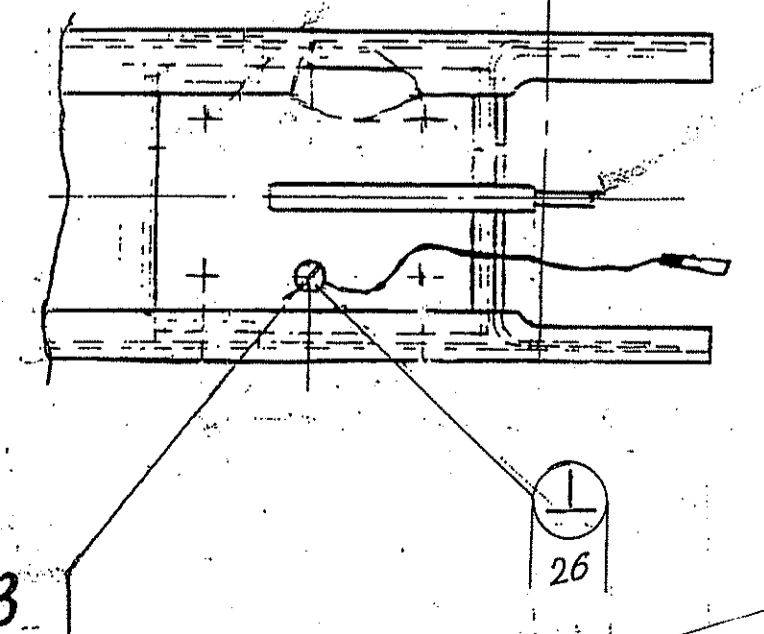


Vodivé propojeno podle ONL 6661.7a

Y₂
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 položen



Z₂
 Z B025 820N



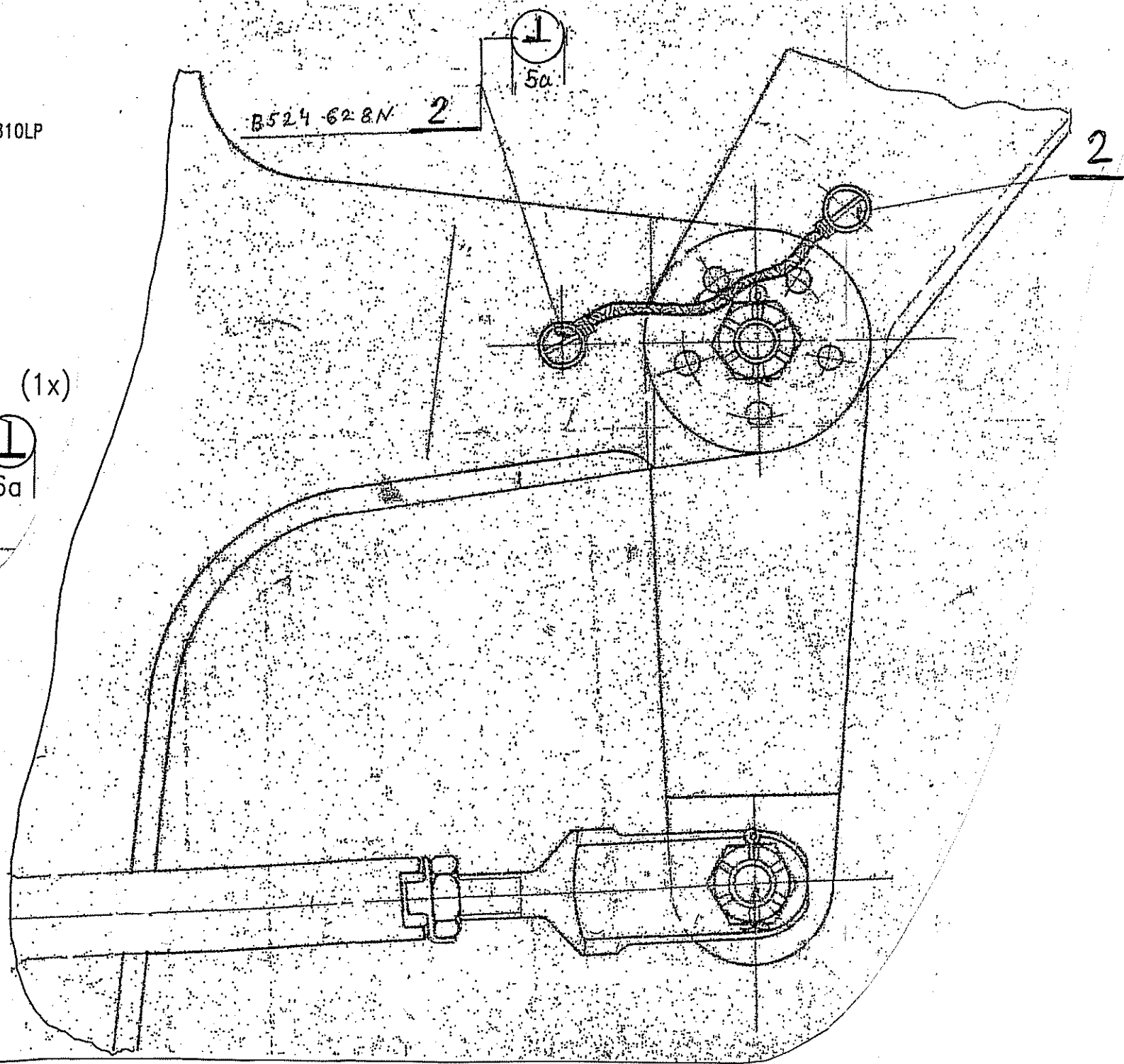
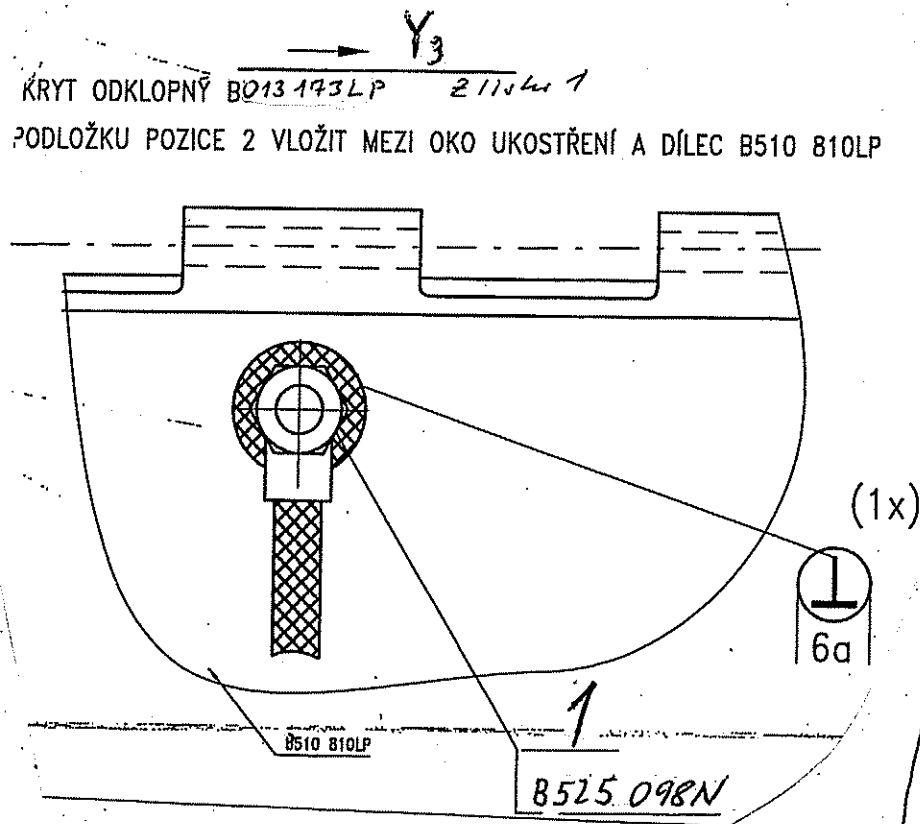
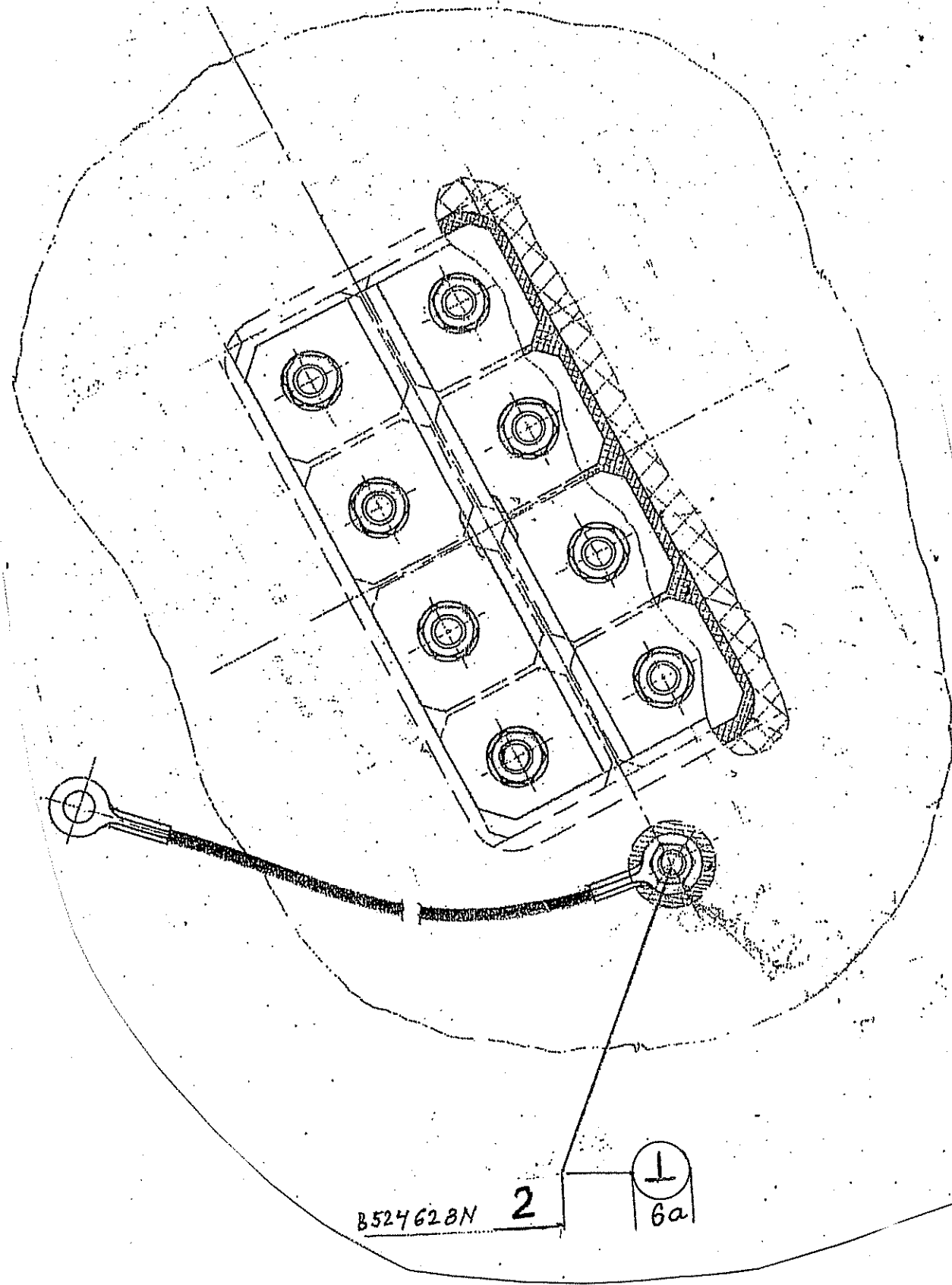
ORIGINAL ČERVENĚ

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Kontroloval:	Oharek:	Nedop:	Číslo krmol: -	Číslo výkresu: B522 112N	
Stavka: -	Ohava: -	Krmfóek:	Kategorie: S	Index: A	
Norm. ref.:	Sého:	Schválil: -	Kategorie: S	List: 2	

PLATÍ PRO PŘEMOSTĚNÍ NA ZÁVĚSECH NA TRUPU A ŽEBRECH 10, 15, 20.

Pohled X₃

1:1:1 z listu 1



**ORIGINAL
ČERVENĚ**

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Úprava:	-	-			A	
Norm. ref.:	29.8.2023	Krmíček	Kategorie:		List: 3	
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