



SERVICE BULLETIN

SB No. **L-410/163b**

Revision No. **IR**

Aeroplane Type: **L-410**

Date of Issue: **Aug 20, 2026**

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

Classification: Recommended.

Subject: Check and possible replacement of the B535 406N clamps of autopilot rudder servo actuator cables.

Supersedure: N/A

1. PLANNING INFORMATION

A. APPLICABILITY

L-410 UVP – Turbolet, L 410 UVP-LW, L-410 UVP-E, L 410 UVP-E-LW, L 410 UVP-E9, L 410 UVP-E20, L-420 aeroplanes equipped with an autopilot.
L 410 NG aeroplanes up to S/N 5016 inclusive except S/N 5004, 5005, 5007.

B. CONCURRENT REQUIREMENTS

None.

C. REASON

Shift the B535 406N clamp due to a combination of several factors.

D. COMPLIANCE TIME

During next periodic maintenance Check 1 or earlier.

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 based on request.

G. NEW EQUIPMENT

None.

H. SPECIAL TOOLS

B971 051N (L410.9712) force-measuring set

I. EXPENSES

Material: To be covered by Aircraft Industries, a.s., 686 04 Kunovice, Czech Republic.
Work: To be covered by the operator.

J. WEIGHT AND BALANCE

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

K. REFERENCE DOCUMENTS

1. Drawings

B535 401N sheet 6 Installation of the KFC 275/325 autopilot
Y274 001N sheet 4 Installation of an autopilot (valid only for L 410 NG)

2. Maintenance Manual L 410 UVP; Doc. No. Do-L410-1131.0, sect.:

20.20.00	22.10.00	24.30.04	24.40.00	27.00.00	38.30.00
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3. Maintenance Manual L 410 UVP-E, E9, E20; Doc. No. Do-L410-1232.2, sect.:

020.20.00	022.10.00	024.30.04	024.40.00	027.00.00	038.30.00
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4. Maintenance Manual L-420; Doc. No. Do-L410-1233.2, sect.:

20-20-00	22-10-00	24-30-04	24-40-00	27-00-00	38-30-00
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5. Maintenance Manual L 410 NG, Doc. No. Do-L410NG-1230.2, sect.:

20-12-00	22-10-00	24-30-00	24-40-00	27-00-00
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6. Supplement No. xx of the Maintenance Manual, Doc. No. Do-L410NG-1230.2, sect.: xx = 16 (S/N 5008), 19 (S/N 5009), 22 (S/N 5012), 23 (S/N 5013)

25-20-00

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, sect. 024.40.00.B.
- Remove accumulators from the aeroplane according to the MM, sect. 024.30.04.A (24-30-00-A).
- Support the fuselage under the frame 24.
- Remove a cover or a toilet (if installed) at the 21st bulkhead according to the MM, sect. 038.30.00, page 401 or a galley (if installed) according to the Supplement No. xx of the MM, sect. 25-20-00.
- Locate the B596 331N service platform into the bay behind the 21st bulkhead.
- Set the pedal steering in the neutral position and block it.

B. CHECK OR INSPECTION

Valid for L-410 UVP – Turbolet, L 410 UVP-LW, L-410 UVP-E, L 410 UVP-E-LW, L 410 UVP-E9, L 410 UVP-E20, L-420 aeroplanes

- Check that the clamps pos. 20, Dwg No. B535 401N sheet 6, Detail VI6 on the rudder control cables have not shifted by means of the red marking.
 - If the clamps have not shifted, make a record in the Aeroplane Logbook according to the point 4. of this bulletin.
 - If any of the clamps has shifted, replace both original clamps by new ones together with fasteners according to the points 2.C., 2.D. of this bulletin.

NOTE

Replace both original clamps by new ones together with fasteners acc. to the points 2.C., 2.D. **on the aeroplane S/N 3503 without checking for shifting.**

Valid for L 410 NG aeroplanes

- Check that the clamps pos. 20, Dwg No. Y274 001N sheet 4, Section G-G on the rudder control cables have not shifted by means of the red marking.
 - If the clamps have not shifted, make a record in the Aeroplane Logbook according to the point 4. of this bulletin.
 - If any of the clamps has shifted, replace both original clamps by new ones together with fasteners according to the points 2.C., 2.D. of this bulletin.

C. DISASSEMBLY

Valid for L-410 UVP – Turbolet, L 410 UVP-LW, L-410 UVP-E, L 410 UVP-E-LW, L 410 UVP-E9, L 410 UVP-E20, L-420 aeroplanes

- Cut and remove locking wires and loosen the turnbuckles pos. 21, Dwg No. B535 401N sheet 6, Detail VI6.
- Unscrew the original nuts pos. 132, remove washers pos. 81, pull out screws pos. 47 and remove original clamps pos. 20.

Valid for L 410 NG aeroplanes

- Cut and remove locking wires pos. 105 and loosen the turnbuckles pos. 21, Dwg No. Y274 001N sheet 4, Detail V.
- Unscrew the original nuts pos. 138, remove washers pos. 81, pull out screws pos. 47 and remove original clamps pos. 20.

D. ASSEMBLY

Valid for L-410 UVP – Turbolet, L 410 UVP-LW, L-410 UVP-E, L 410 UVP-E-LW, L 410 UVP-E9, L 410 UVP-E20, L-420 aeroplanes

- Carefully degrease the rudder control cables with benzine at location of the clamps pos. 20, Dwg No. B535 401N sheet 6, Detail VI6.
- Install new clamps pos. 20 (appropriate groove radius must be set on approp. diameter of a cable) by means of new fasteners pos. 47, 81, 132 and torque the nuts to 5 - 6 Nm. A gap between halves of a clamp must be at least 0.8 mm. Secure the nuts with Loctite 243 according to the MM, sect. 020.20.00, page 845. Use material pos. 1 to 4 of point 3.A. of this bulletin and pos. 1 of point 3.B.
- Adjust the cable tension by means of the turnbuckles pos. 21 according to the MM, sect. 022.10.00, point 1.E.(15), page 408, table 401 (or point 1.E.(8), page 406, table 402 for L-420). **The thread of the cable end must be hidden in the turnbuckle by at least 8 mm!**
- Secure the turnbuckles pos. 21 and fix the bonding with locking wire. Use material pos. 5 of point 3.A. of this bulletin.

Valid for L 410 NG aeroplanes

- Carefully degrease the rudder control cables with benzine at location of the clamps pos. 20, Dwg No. Y274 001N sheet 4, Section G-G.
- Install new clamps pos. 20 (appropriate groove radius must be set on approp. diameter of a cable) by means of new fasteners pos. 47, 81, 138 and torque the nuts to 5 - 6 Nm. A gap between halves of a clamp must be at least 0.8 mm. Secure the nuts with Loctite 243 according to the MM, sect. 20-20-00, page 843. Use material pos. 1 to 4 of point 3.A. of this bulletin and pos. 1 of point 3.B.
- Adjust the cable tension by means of the turnbuckles pos. 21 according to the MM, sect. 22-10-00, point 1.E.(2), page 403, table 401. **The thread of the cable end must be hidden in the turnbuckle by at least 8 mm!**

- Secure the turnbuckles pos. 21 and fix the bonding with locking wire pos. 105, Detail V. Use material pos. 5 of point 3.A. of this bulletin.

E. TESTS

1. Ground Tests

- Unblock the pedal steering and verify free control movement.

Valid for L-410 UVP – Turbolet, L 410 UVP-LW, L-410 UVP-E, L 410 UVP-E-LW, L 410 UVP-E9, L 410 UVP-E20, L-420 aeroplanes

- Install the aeroplane accumulators according to the MM, sect. 024.30.04.A.
- Switch autopilot on according to the MM, sect. 022.10.00, page 301.
- Check YD activation and verify the rudder servo can be overpowered by means of the pedal steering.
- Switch YD button off and verify free movement of the pedal steering.

Valid for L 410 NG aeroplanes

- Install the aeroplane accumulators according to the MM, sect. 24-30-00-A.
- Perform YAW SERVO manually slip clutch override procedure according to the MM, sect. 22-10-00, page 301.
- Verify that the measured TORQUE value corresponds with value in the BP560 01N test record and fill in the form.

2. Flight Tests

None.

F. COMPLETION WORK

- Repair damaged paintings according to the MM, sect. 020.20.00 (20-12-00) and make marks with red paint for monitoring of the clamps shifting on the rudder control cables.
- Remove the B596 331N service platform from the bay behind the 21st bulkhead.
- Install the cover on the 21st bulkhead according to the MM, sect. 027.00.00, point 4.E.(19) or a toilet (if it is to be installed) at the 21st bulkhead according to the MM, sect. 038.30.00 or a galley (if it is to be installed) according to the Supplement No. xx of the MM, sect. 25-20-00.
- Remove a support of the fuselage (under the frame 24).

3. BILL OF MATERIAL

A. MATERIAL DELIVERED BY THE AEROPLANE MANUFACTURER

Pos.	Nomenclature	Name	Pcs/Arpln
1	B535406N	Clamp	4
2	30080522	M5x22 Screw, CSN 02 1101.44	6
3	31051745	M5 Nut, DIN 934	6
4	35655645	5.3 Washer, DIN 125-1A	6
5	19511908	Ø 0.8 mm Locking wire	1 m

B. MATERIAL SUBJECT TO SPECIAL CONDITIONS DURING TRANSPORT

Pos.	Nomenclature	Name	Qty/Arpln
1	82177508	Loctite 243	50 ml

4. RECORD IN THE AEROPLANE LOGBOOK

Record implementation of this L-410/163b Service Bulletin:

Check of the B535 406N clamps of autopilot rudder servo actuator cables has been performed in accordance with the SB L-410/163b.

Found status:

None of the B535 406N clamps have been shifted – the aeroplane is still conform with approved design.

or

One or both the B535 406N clamps have shifted – original clamps were replaced with modified B536 406N clamps.

Detail VI₆

z listu 2

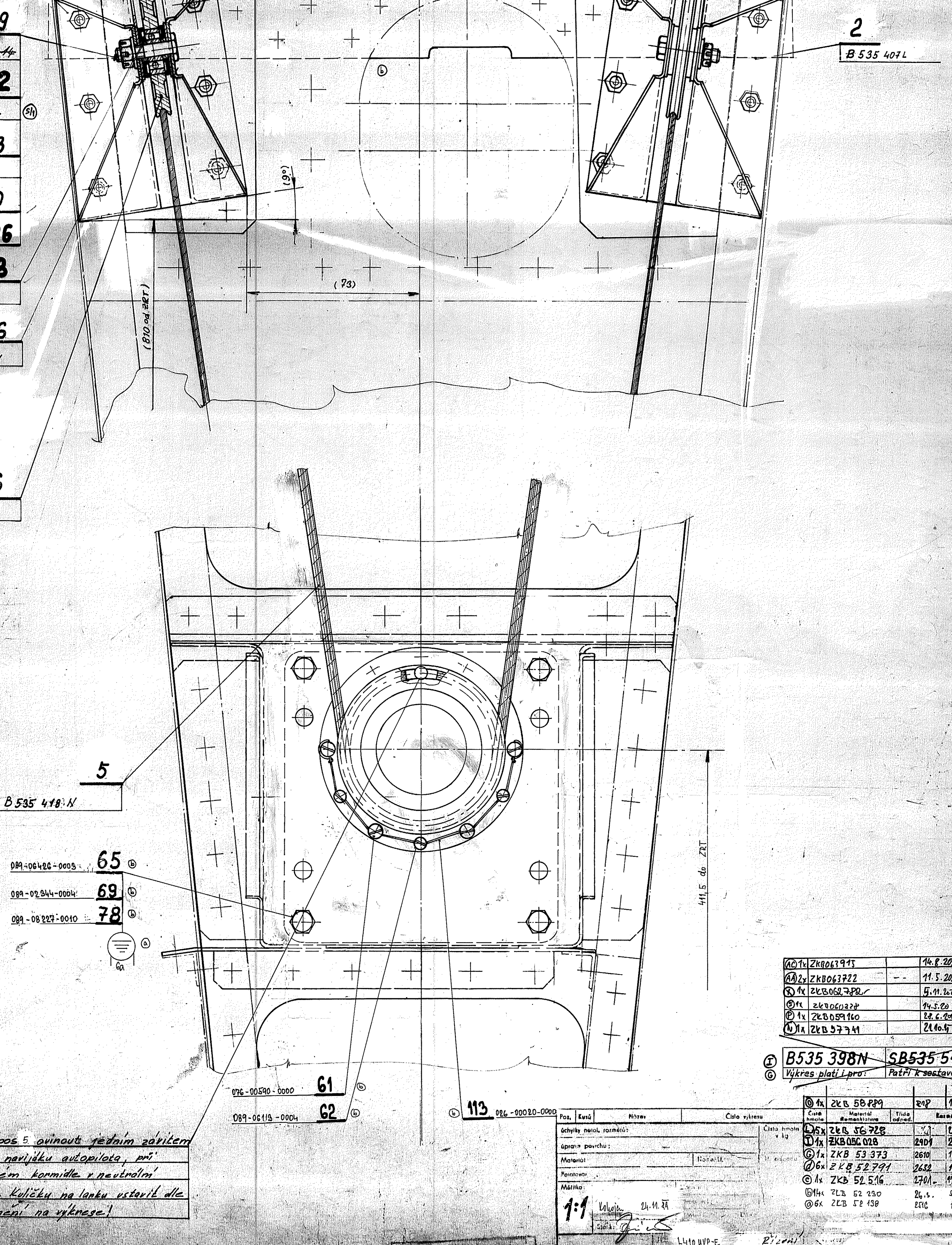
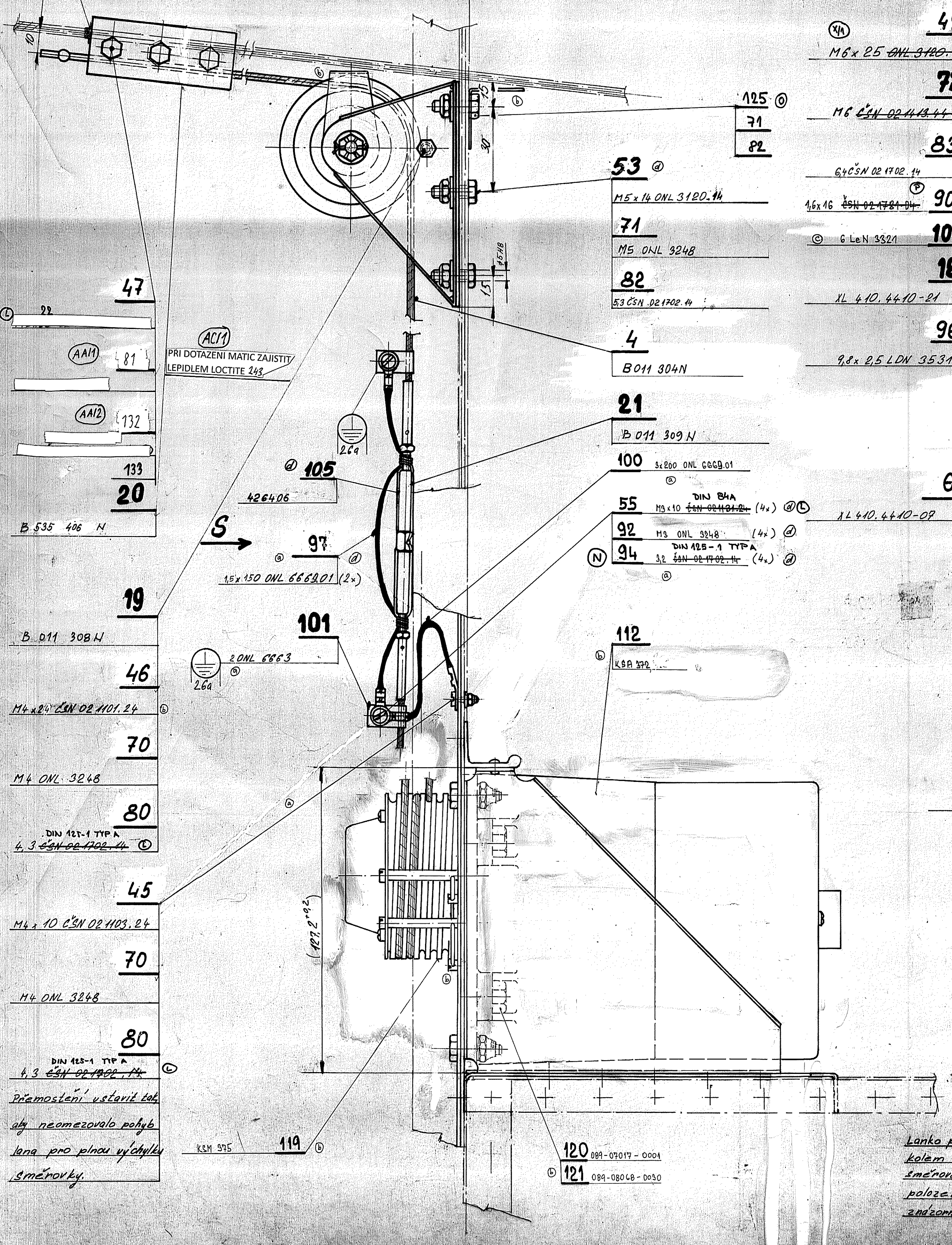
S. L.

24

syřt. přepážky

zařít barvou C 2001/B140
(pro kontrolu posunutí, vorty po lank)

Pohled S



- 47
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- 132
- 133
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- 4
- 21
- 100
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- 90
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- 96
- 6

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- 78
- 61
- 62

401x ZK063915	14.8.2024	72h
402x ZK063722	11.5.2024	24h
403x ZK063722	5.11.2024	Pr
404x ZK063722	14.5.20	Pr
405x ZK063722	28.6.2024	Pr
406x ZK063722	24.10.24	Pr

B535 398N SB535 540N b.v.
Vykres platí Lpro: Patřít k sestavě:

Číslo	Material	Stav	12.2.19	Pr
401x ZK063722	240	28.11.24	Pr	
402x ZK063722	2610	19.2.03	Pr	
403x ZK063722	2622	16.2.96	Pr	
404x ZK063722	2701	19.10.92	Pr	
405x ZK063722	28.5.	5.12.20	Pr	
406x ZK063722	28.6.	14.5.20	Pr	

Lanko pos 5 ovinout jedním závitem kolem navijky autopilota, při směřování kormidla v neutrolní poloze. Kuličku na lanku ustit dle značení na výkresu!

Zařadba autopilota B535 401N
KFC 275/325

