



SERVICE BULLETIN

SB No. **L-410/152b**

Revision No. **IR**

Aeroplane Type: **L-410**

Date of Issue: **Jun 30, 2026**

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

Classification: Recommended.

Subject: Reinforcement of the elevator GSA 80 servo actuator installation of the GFC 700 Autopilot.

Supersedure: N/A

1. PLANNING INFORMATION

A. APPLICABILITY

L 410 NG aeroplanes up to S/N 5013 inclusive except S/N 5004, 5005, 5007.

B. CONCURRENT REQUIREMENTS

None.

C. REASON

Insufficient stiffness of the elevator GSA 80 servo actuator installation.

D. COMPLIANCE TIME

60 calendar days from receipt of the material 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

The empty weight is increased by 0.06 kg (0.12 lb).

The moment at empty weight is increased by 0.53 kg·m (0.46 lb·in/100).

The centre of gravity position at empty weight is shifted by 0.005 % MAC rearwards.

K. REFERENCE DOCUMENTS

1. Drawings

Y274 001N sheet 5, 6 Installation of an autopilot

2. Maintenance Manual L 410 NG, Doc. No. Do-L410NG-1230.2, sect.:

20-11-00 20-12-00 22-10-00 24-30-00 24-40-00 25-20-00
27-00-00

3. 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

4. Airframe Repair Manual L 410 NG, Doc. No. Do-L410NG-2020.2, sect.:

51-00-00

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. 24-40-00-B.
- Remove accumulators from the aeroplane according to the MM, sect. 24-30-00-A.
- Support the fuselage under the frame 24.
- Remove the rear laminated fuselage cover.
- Remove the cover from the bulkhead 21 according to the MM, sect. 27-00-00, point 4.E.(4) or a galley (if installed) according to the Supplement No. xx of the MM, sect. 25-20-00.
- Install the B596 331N service platform into the bay behind the bulkhead 21.

B. CHECK OR INSPECTION

None.

C. DISASSEMBLY

NOTE

Follow instructions stated in ARM, sect. 51-00-00, page 414 during drilling out rivets. Do not damage holes!

- Cut locking wire, remove bonding and disconnect the cables pos. 8, 16, Dwg No. Y274 001N sheet 5, Detail II5.
- Carefully drill out rivets and remove the cover pos. 48, Dwg No. Y274 001N sheet 6, Section L-L.
- Unscrew four screws pos. 65 and remove washers pos. 82 and GSA 80 servo actuator pos. 9, sheet 6, Detail III6, Section L-L. Keep the material for reassembly.
- Carefully tear off a fabric blind from the bulkhead 26 at location of reinforcement of the servo actuator installation, sheet 6, View P.
- Carefully drill out five rivets according to the sheet 6, View P.

D. ASSEMBLY

- Measure and set the stiffener pos. 137, Dwg No. Y274 001N sheet 6, according to the View P, Q, Detail III6. Use material pos. 2 of point 3.A. of this bulletin.
- Redrill holes for rivets to $\varnothing$ 3.6 mm (2x) and $\varnothing$ 3.1 mm (11x). Stitch with cleco clamps.
- Set the angle bar pos. 136 according to the View P, Q, Detail III6. Use material pos. 1 of point 3.A. of this bulletin.
- Redrill holes for rivets to $\varnothing$ 3.1 mm according to the View P, Q. Stitch with cleco clamps. In case of difficult access, mark position of the angle bar pos. 136 on the stiffener pos. 137 and redrill holes for rivets outside the fuselage.
- Deburr all holes, stitch pos. 136, 137 and rivet them according to the View P, Q. Use material pos. 3 to 6 of point 3.A. of this bulletin. In case of difficult access, pos. 136, 137 can be riveted together outside the fuselage.
- Clean the installation area from material scraps and dirties. Coat heads of rivets with primer according to the MM, sect. 20-12-00.
- Rivet back the cover pos. 48, Dwg No. Y274 001N sheet 6, Section L-L, Detail III6. Coat heads of rivets with primer according to the MM, sect. 20-12-00. Use material pos. 3 of point 3.A. of this bulletin.
- Install back the GSA 80 servo actuator pos. 9, sheet 6, Detail III6, Section L-L by means of original washers pos. 82 and screws pos. 65. Keep conductive connection according to the Dwg.
- Wrap the cables pos. 25, 87 by one turn around the capstan according to the sheet 6, Detail III6, Section L-L and connect them to the cables pos. 8, 16, sheet 5, Detail II5 by means of turnbuckles pos. 21. **The thread of the cable end must be hidden in the turn-buckle by at least 8 mm! The elevator must be in the neutral position!**
- Verify the bonding pos. 99, 100, sheet 5, Detail II5 are set up so that they do not limit the movement of the cables for full deflection.
- Adjust the cable tension by means of turnbuckles according to the MM, sect. 22-10-00, point 1.E.(2)(g), page 403. Fix the bonding by means of the original connecting material. Keep conductive connection! Secure the turnbuckles pos. 21 and fix the bonding with locking wire. Use material pos. 8 of point 3.A. of this bulletin.
- Stick a fabric blind over the hole in the bulkhead 26 with Chemopren Extrem adhesive or equivalent – see MM, sect. 20-11-00, page 15. Use material pos. 7 of point 3.A. of this bulletin.
- Coat the fabric blind with aircraft dope (three layers). Grind each layer with fine emery paper.

E. TESTS

1. Ground Tests

- Install the aeroplane accumulators according to the MM, sect. 24-30-00-A.
- Perform PITCH 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. 20-12-00.
- Remove the B596 331N service platform from the bay behind the bulkhead 21.
- Install the cover on the bulkhead 21 according to the MM, sect. 27-00-00, point 4.E.(19) or a galley (if it is to be installed) according to the Supplement No. xx of the MM, sect. 25-20-00.
- Install back the rear laminated fuselage cover.
- Remove a support of the fuselage (under the frame 24).
- Record the weight and moment changes in the “Weight and Balance Record” in Section VI of the Airplane Flight Manual and update the empty weight and moment.

3. BILL OF MATERIAL

A. MATERIAL DELIVERED BY THE AEROPLANE MANUFACTURER

Pos.	Nomenclature	Name	Pcs/Arpln
1	Y274019N	Angle bar	1
2	B535747N	Stiffener	1
3	35191736	DuK 3x6 Rivet, CSN 02 2302.5	20
4	35191737	DuK 3x7 Rivet, CSN 02 2302.5	7
5	35191738	DuK 3x8 Rivet, CSN 02 2302.5	5
6	35191795	DuK 3.5x10 Rivet, CSN 02 2302.5	4
7	81350150	150 Fabric blind	1
8	19511908	Ø 0.8 mm Locking wire	1 m

4. RECORD IN THE AEROPLANE LOGBOOK

Record implementation of this L-410/152b Service Bulletin.