



# SERVICE LETTER L 115-Rev.1 – Enclosure No. 1

## REPAIR OF AIRCRAFT serial number 0665

All operations are to be conducted in conformance to:

- \* Maintenance Manual for the Z242L, Part II, Doc. No. 003.031.1 ev. Doc. No. 003.032.1
  - Directive 6.003 Riveting
  - Directive 6.102 Repairs in rear fuselage
  - Directive 6.201 Repairs of the wings
- \* Service Bulletin Z242L/67a

### Tools required:

Manual drill, riveter, set of riveting heads, 3.1 drill bit, 2.7 drill bit, 3.4 drill bit, temporary rivets, screwdriver, 7mm ring spanner, milling cutter, torque moment wrench

### Material required:

Stirrup mount, 1 pc	Z142.1313D	Z14213130000D00
Stirrup mount, 1 pc	Z142.1314D	Z14213140000D00
Bulkhead L patch, 1 pc	999-015-01	999015010000000
Shell patch, 1 pc –	999-016-01	999016010000000
DuK 3x6 rivet, 30 pcs	ČSN 02 2302.5	311870230060
DuV 3x5P rivet, 29 pcs	ČSN 02 2304.0	311869430050
DuV 3x6P rivet, 2 pcs	ČSN 02 2304.0	311869430060
DuV 3x7P rivet, 30 pcs	ČSN 02 2304.0	311869430070
DuK 2.6x6 rivet, 30 pcs	ČSN 02 2302.5	311870226060
DuV 2,6x5P rivet, 29 pcs	ČSN 02 2304.0	311869426050
DuV 2,6x6P rivet, 2 pcs	ČSN 02 2304.0	311869426060
DuV 2,6x7P rivet, 30 pcs	ČSN 02 2304.0	311869426070
M3x16 bolt, 4 pcs	ČSN 02 1131.24	311112074072

## ZLIN AIRCRAFT

Letiště 1887  
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M3 bolt, 11 pcs	100 ND	902704100003
M3 bolt, 11 pcs	ONL 3248	902424800003
Washer 3, 29 pcs	ČSN 02 1726.14	311131034003
M3x16 bolt, 7 pcs	DIN 963	311000000475
M6x20 bolt, 4 pcs	DIN 933	309589330620
M6x16 bolt, 2 pcs	DIN 933	311000000340
M6 bolt, 6 pcs	DIN 985	309590985060
Washer, 6 pcs	ČSN 31 3282.11	903128211006
Buttons, 10 pcs	ONL 3451.1	321861010000
Punched belts (3 m), 2 pcs	PND 5-100-95	283559003000
0.6 mm surface metal sheet, 1 pc		
Glue, 1 pc	Loctite 243	247876243100
Containers with primer (primer 820R - 246235040820) and coating paint (RAL 3020 red - 246342003020, RAL 5010 blue - 246342005010, RAL 9003 white - 246342009003)		
Binding wire		
Brush paper		

### Disassembly

#### As per Drawing L242.8529

- Remove covers, item 26, from terminal brackets, item 17.
- Disconnect terminal brackets, item 17, from the battery.
- Remove the seal from the nuts, item 9. Loosen nuts, item 9.
- Remove holder, item 8.
- Remove battery, item 12, from the aircraft.

#### As per Drawing L242.1500E

- Loosen nuts, item 93, to disassemble covers, items 13, 14.
- Disassemble carefully to prevent damage to the coating.

#### As per Drawing L242.1300A

- Loosen (6) bolts, item 31, and remove stirrups, items 3, 4.
- Remove leather screen, item 9, at the consoles.
- Clean glue residues from the bulkhead and removed portion of screen



### As per Drawing L242.1310A

Measure and drill out (2) DuV 2.6x6P rivets and (1) DuZ rivet across the outer metal sheet. Remove the rivet heads from the space between the metal sheets.

Drill out (7) DuV 2.6x5P rivets.

### As per Drawing 999-015-00

Drill out (7) DuZ 2.6x7 rivets across the outer metal sheet. Remove the rivet heads from the space between the metal sheets.

Drill out (10) DuV 2.6x5 rivets in the crack area.

Cables running across the repair area must be released from the airframe and positioned to prevent damage. Mark the location of the belts.

**Mill and cut away the damaged sections of the bulkhead.** Remove all swarf from milling and cutting.

## Installation

### As per Drawing 999-015-00

Follow the drawing, position and secure the patch, item 1.

Copy and drill 3.1mm holes to bulkhead and patch.

Expand rivet holes in the shell to a diameter of 3.1 mm.

Rivet the patch to the bulkhead (15) DuK 3x6P rivets (311870230060)

Recess the hole to accommodate countersunk bolt head

Replace DuZ 2.6x7 rivets (311869526070) with 7xM3x16 bolts (311000000475), (14) washers 3 (311131034003) and (7) M3 nuts (902704100003).

Copy and drill holes in consoles, bulkhead and fuselage skin.

Expand rivet holes in the bulkhead to a diameter of 3.1 mm.

Expand bolt holes in the jacket to a diameter of 3.4 mm.

Clean and remove swarf from the expanded holes.

Replace (14) DuV 2.6x5P rivets (311869426050) with DuV 3x5P rivets (311869430050) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869426060) with DuV 3x6P rivets (311869430060) - for both consoles

Use temporary rivets to attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the bulkhead. Gradually replace the temporary rivets with permanent and fit them.

Replace (2) DuV 2.6x6P rivets (311869426060) with M3x16 bolts (311112074072) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869526060) with M3x16 bolts (311112074072) - for both consoles



Attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the outer jacket with (4) M3x16 bolts (311112074072), (8) washer 3 (311131034003) a (4) M3 nut (902704100003).

As per Drawing 999-016-00

Drill 3mm diameter holes on the ends of the crack in the outer jacket.

Patch the crack with 0.6mm sheet metal. Copy and drill (5) holes 3.1mm diameter.

Use (15) DuV 3x5P rivets (311869430050) to attach the sheet metal to the shell surface

**DRILL OUT RIVETS CAREFULLY SO THAT THE ORIGINAL HOLES DO NOT EXPAND AND RIVETS OF ORIGINAL SIZE CAN BE USED.**

**IF THE HOLES SHOW COMPRESSION OR OTHER DAMAGE, EXPAND THE SIZE AND USE RIVETS OF LARGER DIAMETER**

Attach cables to the frame with punched belts (283559003000) and buttons (321861010000), as marked before removal.

As per Drawing L242.1300A

Mount stirrups, items 3 and 4, as per the drawing; use M6x20 bolts, item 31, and M6x16, item 32, M6 nuts, item 39, and washers 6, item 43. For assembly use new bolts, nuts and washers!

Degrease and glue the leather screen, item 9, in the area of replaced mounts.

Close the zippers in the screen

Repair surface protection of the aircraft

As per Drawing L242.1500E

Use bolts, item 93, to mount bushings, items 13 and 14.

Assemble carefully to prevent damage to the coating.

As per Drawing L242.8529

Install battery, item 12, to the aircraft.

Use nuts, item 9, to install the mount, item 8.

Secure the nuts, item 9, with binding wire

Attach leads to the battery terminals – tighten the nuts and apply rubber covers, item 26.

Tighten nuts at the required torque of 7.9 Nm.

**Seal all threaded connections with Loctite 243 glue.**



## SERVICE LETTER L 115-Rev.1 - Enclosure No. 2

### REPAIR OF AIRCRAFT serial number 0666

All operations are to be conducted in conformance to:

- \* Maintenance Manual for the Z242L, Part II, Doc. No. 003.031.1 ev. Doc. No. 003.032.1
  - Directive 6.003 Riveting
  - Directive 6.102 Repairs in rear fuselage
  - Directive 6.201 Repairs of the wings
- \* Service Bulletin Z242L/67a

**Tools required:**

Manual drill, riveter, set of riveting heads, 3.1 drill bit, 2.7 drill bit, 3.4 drill bit, temporary rivets, screwdriver, 7mm ring spanner, torque moment wrench

**Material required:**

DuV 3x5P rivet, 14 pcs	ČSN 02 2304.0	311869430050
DuV 3x6P rivet, 2 pcs	ČSN 02 2304.0	311869430060
Stirrup mount, 1 pc	Z142.1313D	Z14213130000D00
Stirrup mount, 1 pc	Z142.1314D	Z14213140000D00
M3x16 bolt, 4 pcs	ČSN 02 1131.24	311112074072
M3 bolt, 4 pcs	100 ND	902704100003
M3 bolt, 11 pcs	ONL 3248	902424800003
Washer 3, 8 pcs	ČSN 02 1726.14	311131034003
Buttons, 10 pcs	ONL 3451.1	321861010000
M6x20 bolt, 4 pcs	DIN 933	309589330620
M6x16 bolt, 2 pcs	DIN 933	311000000340
M6 bolt, 6 pcs	DIN 985	309590985060
Washer, 6 pcs	ČSN 31 3282.11	903128211006
Punched belts (3 m), 2 pcs	PND 5-100-95	283559003000
Glue, 1 pc	Loctite 243	247876243100



Containers with primer (primer 820R - 246235040820) and coating paint (RAL 3020 red - 246342003020, RAL 5010 blue - 246342005010, RAL 9003 white - 246342009003)

Binding wire

Brush paper

### **Disassembly**

As per Drawing L242.8529

Remove covers, item 26, from terminal brackets, item 17.

Disconnect terminal brackets, item 17, from the battery.

Remove the seal from the nuts, item 9. Loosen nuts, item 9.

Remove holder, item 8.

Remove battery, item 12, from the aircraft.

As per Drawing L242.1500E

Loosen nuts, item 93, to disassemble bushings, items 13, 14.

Disassemble carefully to prevent damage to the coating.

As per Drawing L242.1300A

Loosen (6) bolts, item 31, and remove stirrups, items 3, 4.

Remove leather screen, item 9, at the consoles.

Clean glue residues from the bulkhead and removed portion of screen

As per Drawing L242.1310A

Measure and drill out (2) DuV 2.6x6P rivets and (1) DuZ rivet across the outer metal sheet. Remove the rivet heads from the space between the metal sheets.

Drill out (7) DuV 2.6x5P rivets.

Cables running across the repair area must be released from the airframe and positioned to prevent damage. Mark the location of the belts.

### **Installation**

As per Drawing L242.1310A

Copy and drill holes in consoles, bulkhead and fuselage jacket.

Expand rivet holes in the bulkhead to a diameter of 3.1 mm.

Expand bolt holes in the jacket to a diameter of 3.4 mm.



Clean and remove swarf from the expanded holes.

Replace (14) DuV 2.6x5P rivets (311869426050) with DuV 3x5P rivets (311869430050) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869426060) with DuV 3x6P rivets (311869430060) - for both consoles

Use temporary rivets to attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the bulkhead. Gradually replace the temporary rivets with permanent and fit them.

Replace (2) DuV 2.6x6P rivets (311869426060) with M3x16 bolts (311112074072) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869526060) with M3x16 bolts (311112074072) - for both consoles

Attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the outer jacket with (4) M3x16 bolts (311112074072), (8) washer 3 (311131034003) a (4) M3 nut (902704100003).

### **Seal all threaded connections with Loctite 243 glue**

Attach cables to the frame with punched belts (283559003000) and buttons (321861010000), as marked before removal

#### As per Drawing L242.1300A

Mount stirrups, items 3 and 4, as per the drawing; use M6x20 bolts, item 31, and M6x16, item 32, M6 nuts, item 39, and washers 6, item 43. For assembly use new bolts, nuts and washers!

Degrease and glue the leather screen, item 9, in the area of replaced mounts.

Close the zippers in the screen

Repair surface protection of the aircraft

#### As per Drawing L242.1500E

Use bolts, item 93, to mount bushings, items 13 and 14.

Assemble carefully to prevent damage to the coating.

#### As per Drawing L242.8529

Install battery, item 12, to the aircraft.

Use nuts, item 9, to install the mount, item 8.

Secure the nuts, item 9, with binding wire

Attach leads to the battery terminals – tighten the nuts and apply rubber covers, item 26.

Tighten nuts at the required torque of 7.9 Nm.



## SERVICE LETTER L 115-Rev.1 - Enclosure No. 3

### REPAIR OF AIRCRAFT serial number 0667

All operations are to be conducted in conformance to:

- \* Maintenance Manual for the Z242L, Part II, Doc. No. 003.031.1 ev. Doc. No. 003.032.1
  - Directive 6.003 Riveting
  - Directive 6.102 Repairs in rear fuselage
  - Directive 6.201 Repairs of the wings
- \* Service Bulletin Z242L/67a

**Tools required:**

Manual drill, riveter, set of riveting heads, 3.1 drill bit, 2.7 drill bit, 3.4 drill bit, temporary rivets, screwdriver, 7mm ring spanner, torque moment wrench

**Material required:**

DuV 3x5P rivet, 14 pcs	ČSN 02 2304.0	311869430050
DuV 3x6P rivet, 2 pcs	ČSN 02 2304.0	311869430060
Stirrup mount, 1 pc	Z142.1313D	Z14213130000D00
Stirrup mount, 1 pc	Z142.1314D	Z14213140000D00
M3x16 bolt, 4 pcs	ČSN 02 1131.24	311112074072
M3 bolt, 4 pcs	100 ND	902704100003
M3 bolt, 11 pcs	ONL 3248	902424800003
Washer 3, 8 pcs	ČSN 02 1726.14	311131034003
Buttons, 10 pcs	ONL 3451.1	321861010000
M6x20 bolt, 4 pcs	DIN 933	309589330620
M6x16 bolt, 2 pcs	DIN 933	311000000340
M6 bolt, 6 pcs	DIN 985	309590985060
Washer, 6 pcs	ČSN 31 3282.11	903128211006
Punched belts (3 m), 2 pcs	PND 5-100-95	283559003000
Glue, 1 pc	Loctite 243	247876243100



Containers with primer (primer 820R - 246235040820) and coating paint (RAL 3020 red - 246342003020, RAL 5010 blue - 246342005010, RAL 9003 white - 246342009003)

Binding wire

Brush paper

### **Disassembly**

As per Drawing L242.8529

Remove covers, item 26, from terminal brackets, item 17.

Disconnect terminal brackets, item 17, from the battery.

Remove the seal from the nuts, item 9. Loosen nuts, item 9.

Remove holder, item 8.

Remove battery, item 12, from the aircraft.

As per Drawing L242.1500E

Loosen nuts, item 93, to disassemble bushings, items 13, 14.

Disassemble carefully to prevent damage to the coating.

As per Drawing L242.1300A

Loosen (6) bolts, item 31, and remove stirrups, items 3, 4.

Remove leather screen, item 9, at the consoles.

Clean glue residues from the bulkhead and removed portion of screen

As per Drawing L242.1310A

Measure and drill out (2) DuV 2.6x6P rivets and (1) DuZ rivet across the outer metal sheet. Remove the rivet heads from the space between the metal sheets.

Drill out (7) DuV 2.6x5P rivets.

Cables running across the repair area must be released from the airframe and positioned to prevent damage. Mark the location of the belts.

### **Installation**

As per Drawing L242.1310A

Copy and drill holes in consoles, bulkhead and fuselage jacket.

Expand rivet holes in the bulkhead to a diameter of 3.1 mm.

Expand bolt holes in the jacket to a diameter of 3.4 mm.



Clean and remove swarf from the expanded holes.

Replace (14) DuV 2.6x5P rivets (311869426050) with DuV 3x5P rivets (311869430050) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869426060) with DuV 3x6P rivets (311869430060) - for both consoles

Use temporary rivets to attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the bulkhead. Gradually replace the temporary rivets with permanent and fit them.

Replace (2) DuV 2.6x6P rivets (311869426060) with M3x16 bolts (311112074072) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869526060) with M3x16 bolts (311112074072) - for both consoles

Attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the outer jacket with (4) M3x16 bolts (311112074072), (8) washer 3 (311131034003) a (4) M3 nut (902704100003).

### **Seal all threaded connections with Loctite 243 glue**

Attach cables to the frame with punched belts (283559003000) and buttons (321861010000), as marked before removal

#### As per Drawing L242.1300A

Mount stirrups, items 3 and 4, as per the drawing; use M6x20 bolts, item 31, and M6x16, item 32, M6 nuts, item 39, and washers 6, item 43. For assembly use new bolts, nuts and washers!

Degrease and glue the leather screen, item 9, in the area of replaced mounts.

Close the zippers in the screen

Repair surface protection of the aircraft

#### As per Drawing L242.1500E

Use bolts, item 93, to mount bushings, items 13 and 14.

Assemble carefully to prevent damage to the coating.

#### As per Drawing L242.8529

Install battery, item 12, to the aircraft.

Use nuts, item 9, to install the mount, item 8.

Secure the nuts, item 9, with binding wire

Attach leads to the battery terminals – tighten the nuts and apply rubber covers, item 26.

Tighten nuts at the required torque of 7.9 Nm.



## SERVICE LETTER L 115-Rev.1 - Enclosure No. 4

### REPAIR OF AIRCRAFT serial number 0704

All operations are to be conducted in conformance to:

- \* Maintenance Manual for the Z242L, Part II, Doc. No. 003.031.1 ev. Doc. No. 003.032.1
  - Directive 6.003 Riveting
  - Directive 6.102 Repairs in rear fuselage
  - Directive 6.201 Repairs of the wings
- \* Service Bulletin Z242L/67a

**Tools required:**

Manual drill, riveter, set of riveting heads, 3.1 drill bit, 2.7 drill bit, 3.4 drill bit, temporary rivets, screwdriver, 7mm ring spanner, torque moment wrench

**Material required:**

DuV 3x5P rivet, 14 pcs	ČSN 02 2304.0	311869430050
DuV 3x6P rivet, 2 pcs	ČSN 02 2304.0	311869430060
Stirrup mount, 1 pc	Z142.1313D	Z14213130000D00
Stirrup mount, 1 pc	Z142.1314D	Z14213140000D00
M3x16 bolt, 4 pcs	ČSN 02 1131.24	311112074072
M3 bolt, 4 pcs	100 ND	902704100003
M3 bolt, 11 pcs	ONL 3248	902424800003
Washer 3, 8 pcs	ČSN 02 1726.14	311131034003
Buttons, 10 pcs	ONL 3451.1	321861010000
M6x20 bolt, 4 pcs	DIN 933	309589330620
M6x16 bolt, 2 pcs	DIN 933	311000000340
M6 bolt, 6 pcs	DIN 985	309590985060
Washer, 6 pcs	ČSN 31 3282.11	903128211006
Punched belts (3 m), 2 pcs	PND 5-100-95	283559003000
Glue, 1 pc	Loctite 243	247876243100



Containers with primer (primer 820R - 246235040820) and coating paint (RAL 3020 red - 246342003020, RAL 5010 blue - 246342005010, RAL 9003 white - 246342009003)

Binding wire

Brush paper

### **Disassembly**

As per Drawing L242.8529

Remove covers, item 26, from terminal brackets, item 17.

Disconnect terminal brackets, item 17, from the battery.

Remove the seal from the nuts, item 9. Loosen nuts, item 9.

Remove holder, item 8.

Remove battery, item 12, from the aircraft.

As per Drawing L242.1500E

Loosen nuts, item 93, to disassemble bushings, items 13, 14.

Disassemble carefully to prevent damage to the coating.

As per Drawing L242.1300A

Loosen (6) bolts, item 31, and remove stirrups, items 3, 4.

Remove leather screen, item 9, at the consoles.

Clean glue residues from the bulkhead and removed portion of screen

As per Drawing L242.1310A

Measure and drill out (2) DuV 2.6x6P rivets and (1) DuZ rivet across the outer metal sheet. Remove the rivet heads from the space between the metal sheets.

Drill out (7) DuV 2.6x5P rivets.

Cables running across the repair area must be released from the airframe and positioned to prevent damage. Mark the location of the belts.

### **Installation**

As per Drawing L242.1310A

Copy and drill holes in consoles, bulkhead and fuselage jacket.

Expand rivet holes in the bulkhead to a diameter of 3.1 mm.

Expand bolt holes in the jacket to a diameter of 3.4 mm.



Clean and remove swarf from the expanded holes.

Replace (14) DuV 2.6x5P rivets (311869426050) with DuV 3x5P rivets (311869430050) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869426060) with DuV 3x6P rivets (311869430060) - for both consoles

Use temporary rivets to attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the bulkhead. Gradually replace the temporary rivets with permanent and fit them.

Replace (2) DuV 2.6x6P rivets (311869426060) with M3x16 bolts (311112074072) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869526060) with M3x16 bolts (311112074072) - for both consoles

Attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the outer jacket with (4) M3x16 bolts (311112074072), (8) washer 3 (311131034003) a (4) M3 nut (902704100003).

### **Seal all threaded connections with Loctite 243 glue**

Attach cables to the frame with punched belts (283559003000) and buttons (321861010000), as marked before removal

#### As per Drawing L242.1300A

Mount stirrups, items 3 and 4, as per the drawing; use M6x20 bolts, item 31, and M6x16, item 32, M6 nuts, item 39, and washers 6, item 43. For assembly use new bolts, nuts and washers!

Degrease and glue the leather screen, item 9, in the area of replaced mounts.

Close the zippers in the screen

Repair surface protection of the aircraft

#### As per Drawing L242.1500E

Use bolts, item 93, to mount bushings, items 13 and 14.

Assemble carefully to prevent damage to the coating.

#### As per Drawing L242.8529

Install battery, item 12, to the aircraft.

Use nuts, item 9, to install the mount, item 8.

Secure the nuts, item 9, with binding wire

Attach leads to the battery terminals – tighten the nuts and apply rubber covers, item 26.

Tighten nuts at the required torque of 7.9 Nm.



## SERVICE LETTER L 115-Rev.1 - Enclosure No. 5

### REPAIR OF AIRCRAFT serial number 0705

All operations are to be conducted in conformance to:

- \* Maintenance Manual for the Z242L, Part II, Doc. No. 003.031.1 ev. Doc. No. 003.032.1
  - Directive 6.003 Riveting
  - Directive 6.102 Repairs in rear fuselage
  - Directive 6.201 Repairs of the wings
- \* Service Bulletin Z242L/67a

**Tools required:**

Manual drill, riveter, set of riveting heads, 3.1 drill bit, 2.7 drill bit, 3.4 drill bit, temporary rivets, screwdriver, 7mm ring spanner, torque moment wrench

**Material required:**

DuV 3x5P rivet, 14 pcs	ČSN 02 2304.0	311869430050
DuV 3x6P rivet, 2 pcs	ČSN 02 2304.0	311869430060
Stirrup mount, 1 pc	Z142.1313D	Z14213130000D00
Stirrup mount, 1 pc	Z142.1314D	Z14213140000D00
M3x16 bolt, 4 pcs	ČSN 02 1131.24	311112074072
M3 bolt, 4 pcs	100 ND	902704100003
M3 bolt, 11 pcs	ONL 3248	902424800003
Washer 3, 8 pcs	ČSN 02 1726.14	311131034003
Buttons, 10 pcs	ONL 3451.1	321861010000
M6x20 bolt, 4 pcs	DIN 933	309589330620
M6x16 bolt, 2 pcs	DIN 933	311000000340
M6 bolt, 6 pcs	DIN 985	309590985060
Washer, 6 pcs	ČSN 31 3282.11	903128211006
Punched belts (3 m), 2 pcs	PND 5-100-95	283559003000
Glue, 1 pc	Loctite 243	247876243100



Containers with primer (primer 820R - 246235040820) and coating paint (RAL 3020 red - 246342003020, RAL 5010 blue - 246342005010, RAL 9003 white - 246342009003)

Binding wire

Brush paper

### **Disassembly**

As per Drawing L242.8529

Remove covers, item 26, from terminal brackets, item 17.

Disconnect terminal brackets, item 17, from the battery.

Remove the seal from the nuts, item 9. Loosen nuts, item 9.

Remove holder, item 8.

Remove battery, item 12, from the aircraft.

As per Drawing L242.1500E

Loosen nuts, item 93, to disassemble bushings, items 13, 14.

Disassemble carefully to prevent damage to the coating.

As per Drawing L242.1300A

Loosen (6) bolts, item 31, and remove stirrups, items 3, 4.

Remove leather screen, item 9, at the consoles.

Clean glue residues from the bulkhead and removed portion of screen

As per Drawing L242.1310A

Measure and drill out (2) DuV 2.6x6P rivets and (1) DuZ rivet across the outer metal sheet. Remove the rivet heads from the space between the metal sheets.

Drill out (7) DuV 2.6x5P rivets.

Cables running across the repair area must be released from the airframe and positioned to prevent damage. Mark the location of the belts.

### **Installation**

As per Drawing L242.1310A

Copy and drill holes in consoles, bulkhead and fuselage jacket.

Expand rivet holes in the bulkhead to a diameter of 3.1 mm.

Expand bolt holes in the jacket to a diameter of 3.4 mm.



Clean and remove swarf from the expanded holes.

Replace (14) DuV 2.6x5P rivets (311869426050) with DuV 3x5P rivets (311869430050) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869426060) with DuV 3x6P rivets (311869430060) - for both consoles

Use temporary rivets to attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the bulkhead. Gradually replace the temporary rivets with permanent and fit them.

Replace (2) DuV 2.6x6P rivets (311869426060) with M3x16 bolts (311112074072) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869526060) with M3x16 bolts (311112074072) - for both consoles

Attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the outer jacket with (4) M3x16 bolts (311112074072), (8) washer 3 (311131034003) a (4) M3 nut (902704100003).

### **Seal all threaded connections with Loctite 243 glue**

Attach cables to the frame with punched belts (283559003000) and buttons (321861010000), as marked before removal

#### As per Drawing L242.1300A

Mount stirrups, items 3 and 4, as per the drawing; use M6x20 bolts, item 31, and M6x16, item 32, M6 nuts, item 39, and washers 6, item 43. For assembly use new bolts, nuts and washers!

Degrease and glue the leather screen, item 9, in the area of replaced mounts.

Close the zippers in the screen

Repair surface protection of the aircraft

#### As per Drawing L242.1500E

Use bolts, item 93, to mount bushings, items 13 and 14.

Assemble carefully to prevent damage to the coating.

#### As per Drawing L242.8529

Install battery, item 12, to the aircraft.

Use nuts, item 9, to install the mount, item 8.

Secure the nuts, item 9, with binding wire

Attach leads to the battery terminals – tighten the nuts and apply rubber covers, item 26.

Tighten nuts at the required torque of 7.9 Nm.



## SERVICE LETTER L 115-Rev.1 - Enclosure No. 6

### REPAIR OF AIRCRAFT serial number 0706

All operations are to be conducted in conformance to:

- \* Maintenance Manual for the Z242L, Part II, Doc. No. 003.031.1 ev. Doc. No. 003.032.1
  - Directive 6.003 Riveting
  - Directive 6.102 Repairs in rear fuselage
  - Directive 6.201 Repairs of the wings
- \* Service Bulletin Z242L/67a

**Tools required:**

Manual drill, riveter, set of riveting heads, 3.1 drill bit, 2.7 drill bit, 3.4 drill bit, temporary rivets, screwdriver, 7mm ring spanner, torque moment wrench

**Material required:**

DuV 3x5P rivet, 14 pcs	ČSN 02 2304.0	311869430050
DuV 3x6P rivet, 2 pcs	ČSN 02 2304.0	311869430060
Stirrup mount, 1 pc	Z142.1313D	Z14213130000D00
Stirrup mount, 1 pc	Z142.1314D	Z14213140000D00
M3x16 bolt, 4 pcs	ČSN 02 1131.24	311112074072
M3 bolt, 4 pcs	100 ND	902704100003
M3 bolt, 11 pcs	ONL 3248	902424800003
Washer 3, 8 pcs	ČSN 02 1726.14	311131034003
Buttons, 10 pcs	ONL 3451.1	321861010000
M6x20 bolt, 4 pcs	DIN 933	309589330620
M6x16 bolt, 2 pcs	DIN 933	311000000340
M6 bolt, 6 pcs	DIN 985	309590985060
Washer, 6 pcs	ČSN 31 3282.11	903128211006
Punched belts (3 m), 2 pcs	PND 5-100-95	283559003000
Glue, 1 pc	Loctite 243	247876243100



Containers with primer (primer 820R - 246235040820) and coating paint (RAL 3020 red - 246342003020, RAL 5010 blue - 246342005010, RAL 9003 white - 246342009003)

Binding wire

Brush paper

### **Disassembly**

As per Drawing L242.8529

Remove covers, item 26, from terminal brackets, item 17.

Disconnect terminal brackets, item 17, from the battery.

Remove the seal from the nuts, item 9. Loosen nuts, item 9.

Remove holder, item 8.

Remove battery, item 12, from the aircraft.

As per Drawing L242.1500E

Loosen nuts, item 93, to disassemble bushings, items 13, 14.

Disassemble carefully to prevent damage to the coating.

As per Drawing L242.1300A

Loosen (6) bolts, item 31, and remove stirrups, items 3, 4.

Remove leather screen, item 9, at the consoles.

Clean glue residues from the bulkhead and removed portion of screen

As per Drawing L242.1310A

Measure and drill out (2) DuV 2.6x6P rivets and (1) DuZ rivet across the outer metal sheet. Remove the rivet heads from the space between the metal sheets.

Drill out (7) DuV 2.6x5P rivets.

Cables running across the repair area must be released from the airframe and positioned to prevent damage. Mark the location of the belts.

### **Installation**

As per Drawing L242.1310A

Copy and drill holes in consoles, bulkhead and fuselage jacket.

Expand rivet holes in the bulkhead to a diameter of 3.1 mm.

Expand bolt holes in the jacket to a diameter of 3.4 mm.



Clean and remove swarf from the expanded holes.

Replace (14) DuV 2.6x5P rivets (311869426050) with DuV 3x5P rivets (311869430050) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869426060) with DuV 3x6P rivets (311869430060) - for both consoles

Use temporary rivets to attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the bulkhead. Gradually replace the temporary rivets with permanent and fit them.

Replace (2) DuV 2.6x6P rivets (311869426060) with M3x16 bolts (311112074072) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869526060) with M3x16 bolts (311112074072) - for both consoles

Attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the outer jacket with (4) M3x16 bolts (311112074072), (8) washer 3 (311131034003) a (4) M3 nut (902704100003).

### **Seal all threaded connections with Loctite 243 glue**

Attach cables to the frame with punched belts (283559003000) and buttons (321861010000), as marked before removal

#### As per Drawing L242.1300A

Mount stirrups, items 3 and 4, as per the drawing; use M6x20 bolts, item 31, and M6x16, item 32, M6 nuts, item 39, and washers 6, item 43. For assembly use new bolts, nuts and washers!

Degrease and glue the leather screen, item 9, in the area of replaced mounts.

Close the zippers in the screen

Repair surface protection of the aircraft

#### As per Drawing L242.1500E

Use bolts, item 93, to mount bushings, items 13 and 14.

Assemble carefully to prevent damage to the coating.

#### As per Drawing L242.8529

Install battery, item 12, to the aircraft.

Use nuts, item 9, to install the mount, item 8.

Secure the nuts, item 9, with binding wire

Attach leads to the battery terminals – tighten the nuts and apply rubber covers, item 26.

Tighten nuts at the required torque of 7.9 Nm.



## SERVICE LETTER L 115-Rev.1 - Enclosure No. 7

### REPAIR OF AIRCRAFT serial number 0707

All operations are to be conducted in conformance to:

- \* Maintenance Manual for the Z242L, Part II, Doc. No. 003.031.1 ev. Doc. No. 003.032.1
  - Directive 6.003 Riveting
  - Directive 6.102 Repairs in rear fuselage
  - Directive 6.201 Repairs of the wings
- \* Service Bulletin Z242L/67a

**Tools required:**

Manual drill, riveter, set of riveting heads, 3.1 drill bit, 2.7 drill bit, 3.4 drill bit, temporary rivets, screwdriver, 7mm ring spanner, torque moment wrench

**Material required:**

DuV 3x5P rivet, 14 pcs	ČSN 02 2304.0	311869430050
DuV 3x6P rivet, 2 pcs	ČSN 02 2304.0	311869430060
Stirrup mount, 1 pc	Z142.1313D	Z14213130000D00
Stirrup mount, 1 pc	Z142.1314D	Z14213140000D00
M3x16 bolt, 4 pcs	ČSN 02 1131.24	311112074072
M3 bolt, 4 pcs	100 ND	902704100003
M3 bolt, 11 pcs	ONL 3248	902424800003
Washer 3, 8 pcs	ČSN 02 1726.14	311131034003
Buttons, 10 pcs	ONL 3451.1	321861010000
M6x20 bolt, 4 pcs	DIN 933	309589330620
M6x16 bolt, 2 pcs	DIN 933	311000000340
M6 bolt, 6 pcs	DIN 985	309590985060
Washer, 6 pcs	ČSN 31 3282.11	903128211006
Punched belts (3 m), 2 pcs	PND 5-100-95	283559003000
Glue, 1 pc	Loctite 243	247876243100



Containers with primer (primer 820R - 246235040820) and coating paint (RAL 3020 red - 246342003020, RAL 5010 blue - 246342005010, RAL 9003 white - 246342009003)

Binding wire

Brush paper

### **Disassembly**

As per Drawing L242.8529

Remove covers, item 26, from terminal brackets, item 17.

Disconnect terminal brackets, item 17, from the battery.

Remove the seal from the nuts, item 9. Loosen nuts, item 9.

Remove holder, item 8.

Remove battery, item 12, from the aircraft.

As per Drawing L242.1500E

Loosen nuts, item 93, to disassemble bushings, items 13, 14.

Disassemble carefully to prevent damage to the coating.

As per Drawing L242.1300A

Loosen (6) bolts, item 31, and remove stirrups, items 3, 4.

Remove leather screen, item 9, at the consoles.

Clean glue residues from the bulkhead and removed portion of screen

As per Drawing L242.1310A

Measure and drill out (2) DuV 2.6x6P rivets and (1) DuZ rivet across the outer metal sheet. Remove the rivet heads from the space between the metal sheets.

Drill out (7) DuV 2.6x5P rivets.

Cables running across the repair area must be released from the airframe and positioned to prevent damage. Mark the location of the belts.

### **Installation**

As per Drawing L242.1310A

Copy and drill holes in consoles, bulkhead and fuselage jacket.

Expand rivet holes in the bulkhead to a diameter of 3.1 mm.

Expand bolt holes in the jacket to a diameter of 3.4 mm.



Clean and remove swarf from the expanded holes.

Replace (14) DuV 2.6x5P rivets (311869426050) with DuV 3x5P rivets (311869430050) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869426060) with DuV 3x6P rivets (311869430060) - for both consoles

Use temporary rivets to attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the bulkhead. Gradually replace the temporary rivets with permanent and fit them.

Replace (2) DuV 2.6x6P rivets (311869426060) with M3x16 bolts (311112074072) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869526060) with M3x16 bolts (311112074072) - for both consoles

Attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the outer jacket with (4) M3x16 bolts (311112074072), (8) washer 3 (311131034003) a (4) M3 nut (902704100003).

### **Seal all threaded connections with Loctite 243 glue**

Attach cables to the frame with punched belts (283559003000) and buttons (321861010000), as marked before removal

#### As per Drawing L242.1300A

Mount stirrups, items 3 and 4, as per the drawing; use M6x20 bolts, item 31, and M6x16, item 32, M6 nuts, item 39, and washers 6, item 43. For assembly use new bolts, nuts and washers!

Degrease and glue the leather screen, item 9, in the area of replaced mounts.

Close the zippers in the screen

Repair surface protection of the aircraft

#### As per Drawing L242.1500E

Use bolts, item 93, to mount bushings, items 13 and 14.

Assemble carefully to prevent damage to the coating.

#### As per Drawing L242.8529

Install battery, item 12, to the aircraft.

Use nuts, item 9, to install the mount, item 8.

Secure the nuts, item 9, with binding wire

Attach leads to the battery terminals – tighten the nuts and apply rubber covers, item 26.

Tighten nuts at the required torque of 7.9 Nm.



## SERVICE LETTER L 115-Rev.1 - Enclosure No. 8

### REPAIR OF AIRCRAFT serial number 0708

All operations are to be conducted in conformance to:

- \* Maintenance Manual for the Z242L, Part II, Doc. No. 003.031.1 ev. Doc. No. 003.032.1
  - Directive 6.003 Riveting
  - Directive 6.102 Repairs in rear fuselage
  - Directive 6.201 Repairs of the wings
- \* Service Bulletin Z242L/67a

**Tools required:**

Manual drill, riveter, set of riveting heads, 3.1 drill bit, 2.7 drill bit, 3.4 drill bit, temporary rivets, screwdriver, 7mm ring spanner, torque moment wrench

**Material required:**

DuV 3x5P rivet, 14 pcs	ČSN 02 2304.0	311869430050
DuV 3x6P rivet, 2 pcs	ČSN 02 2304.0	311869430060
Stirrup mount, 1 pc	Z142.1313D	Z14213130000D00
Stirrup mount, 1 pc	Z142.1314D	Z14213140000D00
M3x16 bolt, 4 pcs	ČSN 02 1131.24	311112074072
M3 bolt, 4 pcs	100 ND	902704100003
M3 bolt, 11 pcs	ONL 3248	902424800003
Washer 3, 8 pcs	ČSN 02 1726.14	311131034003
Buttons, 10 pcs	ONL 3451.1	321861010000
M6x20 bolt, 4 pcs	DIN 933	309589330620
M6x16 bolt, 2 pcs	DIN 933	311000000340
M6 bolt, 6 pcs	DIN 985	309590985060
Washer, 6 pcs	ČSN 31 3282.11	903128211006
Punched belts (3 m), 2 pcs	PND 5-100-95	283559003000
Glue, 1 pc	Loctite 243	247876243100

## ZLIN AIRCRAFT

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Containers with primer (primer 820R - 246235040820) and coating paint (RAL 3020 red - 246342003020, RAL 5010 blue - 246342005010, RAL 9003 white - 246342009003)

Binding wire

Brush paper

### Disassembly

As per Drawing L242.8529

Remove covers, item 26, from terminal brackets, item 17.

Disconnect terminal brackets, item 17, from the battery.

Remove the seal from the nuts, item 9. Loosen nuts, item 9.

Remove holder, item 8.

Remove battery, item 12, from the aircraft.

As per Drawing L242.1500E

Loosen nuts, item 93, to disassemble bushings, items 13, 14.

Disassemble carefully to prevent damage to the coating.

As per Drawing L242.1300A

Loosen (6) bolts, item 31, and remove stirrups, items 3, 4.

Remove leather screen, item 9, at the consoles.

Clean glue residues from the bulkhead and removed portion of screen

As per Drawing L242.1310A

Measure and drill out (2) DuV 2.6x6P rivets and (1) DuZ rivet across the outer metal sheet. Remove the rivet heads from the space between the metal sheets.

Drill out (7) DuV 2.6x5P rivets.

Cables running across the repair area must be released from the airframe and positioned to prevent damage. Mark the location of the belts.

### Installation

As per Drawing L242.1310A

Copy and drill holes in consoles, bulkhead and fuselage jacket.

Expand rivet holes in the bulkhead to a diameter of 3.1 mm.

Expand bolt holes in the jacket to a diameter of 3.4 mm.



Clean and remove swarf from the expanded holes.

Replace (14) DuV 2.6x5P rivets (311869426050) with DuV 3x5P rivets (311869430050) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869426060) with DuV 3x6P rivets (311869430060) - for both consoles

Use temporary rivets to attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the bulkhead. Gradually replace the temporary rivets with permanent and fit them.

Replace (2) DuV 2.6x6P rivets (311869426060) with M3x16 bolts (311112074072) - for both consoles

Replace (2) DuV 2.6x6P rivets (311869526060) with M3x16 bolts (311112074072) - for both consoles

Attach stirrup mounts, item 3 (Z14213130000D00) and item 4 (Z14213140000D00), to the outer jacket with (4) M3x16 bolts (311112074072), (8) washer 3 (311131034003) a (4) M3 nut (902704100003).

### **Seal all threaded connections with Loctite 243 glue**

Attach cables to the frame with punched belts (283559003000) and buttons (321861010000), as marked before removal

#### As per Drawing L242.1300A

Mount stirrups, items 3 and 4, as per the drawing; use M6x20 bolts, item 31, and M6x16, item 32, M6 nuts, item 39, and washers 6, item 43. For assembly use new bolts, nuts and washers!

Degrease and glue the leather screen, item 9, in the area of replaced mounts.

Close the zippers in the screen

Repair surface protection of the aircraft

#### As per Drawing L242.1500E

Use bolts, item 93, to mount bushings, items 13 and 14.

Assemble carefully to prevent damage to the coating.

#### As per Drawing L242.8529

Install battery, item 12, to the aircraft.

Use nuts, item 9, to install the mount, item 8.

Secure the nuts, item 9, with binding wire

Attach leads to the battery terminals – tighten the nuts and apply rubber covers, item 26.

Tighten nuts at the required torque of 7.9 Nm.