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**MANDATORY**

**SERVICE  
BULLETIN**

**MANDATORY SERVICE BULLETIN Z 242L/15a**

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- 1. MODELS AFFECTED:** All Z 242L aircraft up to S/No. 0676 incl.
- 2. SUBJECT:** Cracks on the exhaust muffler first chamber faces (Part/No. L 242.6671-01.00).
- 3. CORRECTION:**
  - 3.1. Check immediately the exhaust muffler faces for crack occurrence.
  - 3.2. Check regularly the exhaust muffler for cracks at the engine scheduled inspections after first 25 hours and then after every 50 hours of operation.
  - 3.3. In case of crack occurrence, optionally follow subsection 7.2. or 7.3. of this Bulletin.
- 4. TIME OF COMPLIANCE:**

Correction 3.1. - immediately after receipt of this Bulletin.

Correction 3.2. - at every scheduled inspection of the exhaust system in correspondence with the Z 242L Maintenance Manual - VOL.I, Chapter 5.
- 5. CORRECTION PERFORMED BY:** The user.
- 6. EXPENSES COVERED BY:**

Check, reassembly/assembly - the user.

Necessary material - for replacement:  
the exhaust muffler Part/No. L 242.6671-01.00, during the warranty period - the manufacturer; after the warranty expiration - the user.

- for repair:  
covers Part/No. L 242.6671-01.07 - the manufacturer.

7. PROCEDURE:

- 7.1. Check visually the first chamber of the exhaust muffler Part/No. L 242.6671-01.00 with the magnifier (4x magnifying)  
- See Fig. 1.

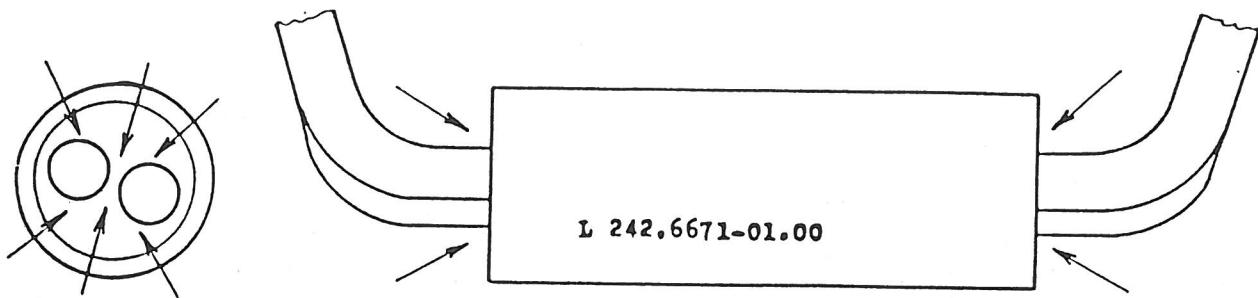


Fig. 1

→ checked area

- 7.2. After detecting any cracks, notify your Customers Service or the Manufacturer. A new or repaired muffler shall be sent you for replacement of the damaged one,  
or:
- 7.3. The user may repair the exhaust muffler himself if he complies with following conditions:
1. Use only the original parts delivered by the Manufacturer for repair.
  2. Follow a prescribed repair procedure.
  3. Observe the connecting dimensions of the exhaust muffler pipes/flanges.
  4. The repair must be accomplished by the properly authorised person (welder).

Repair procedure: 1. Weld cracks with TIG - welding device.

2. Check/reset the fitting of flanges to the engine outlets.  
Fit the covers (Item 2) on the muffler face - attach with clamps and tack-weld.  
Check/reset the fitting of flanges to the engine outlets.
3. Weld covers (Item 2) - with TIG-welding.  
Check/reset the fitting of flanges to the engine outlets.
4. Check visually welds and surrounding area for crack occurrence using the magnifier (4x magnifying).

Used welding method: Tungsten Inert Gas (TIG)

Filler wire: GI-420

(C-max.0.06, Mn - 1.8, Si - 0.4, Cr 19.0, Ni - 10.0, Nb - 1.0)

Consumption of the filler-wire: 0.023 kg approx.

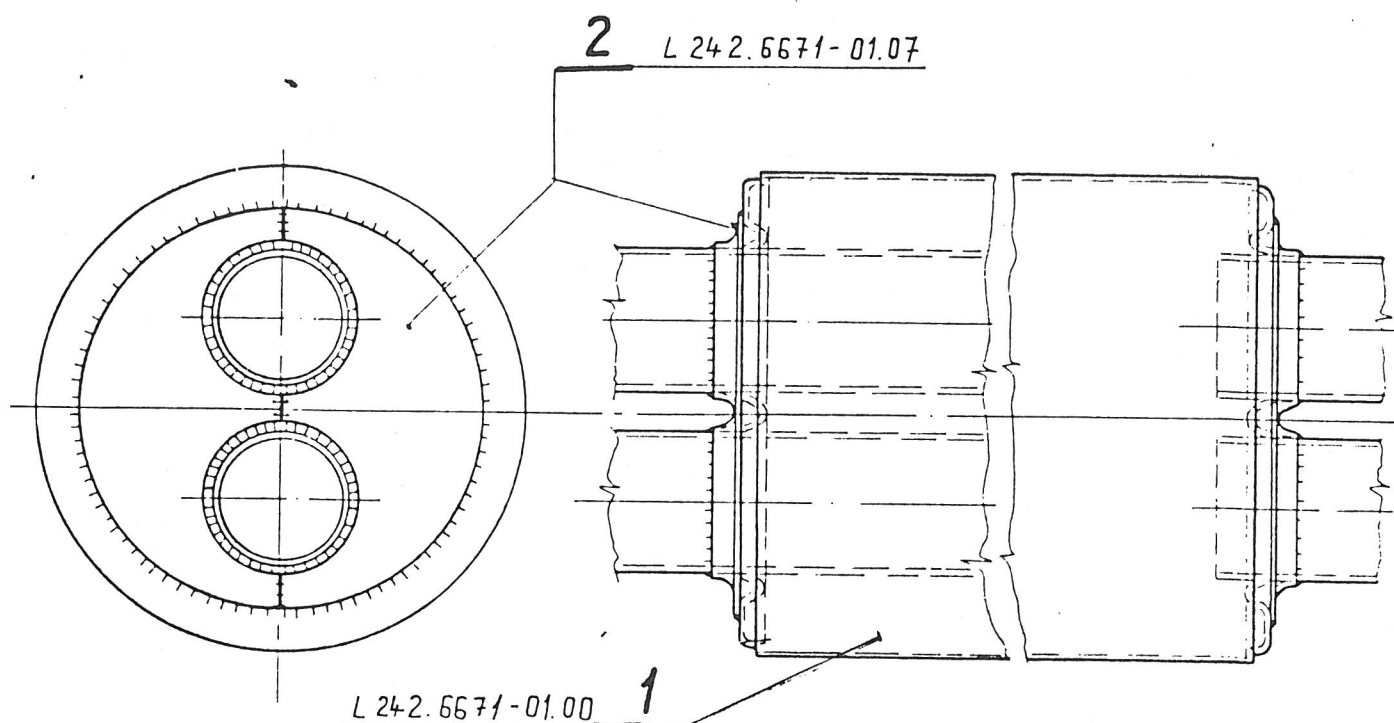

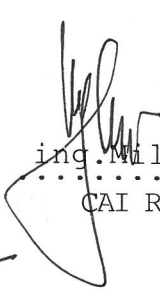


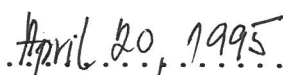
Fig. 2

- 8. NECESSARY MATERIAL:** Delivered by the manufacturer.  
For replacement - the exhaust muffler  
Part/No. L242.6671-01.00  
- 1 pc  
For repair - the cover Part/No.  
L242.6671-01.07 - 4 pcs

- 9. THIS BULLETIN IS EFFECTIVE FROM THE DATE OF APPROVAL BY THE CIVIL AVIATION INSPECTORATE.**

  
ing. Antonín Partika  
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Manufacturer's Representative

  
ing. Milan Vyhnálek  
.....  
CAI Representative

  
April 20, 1995  
.....  
Date of approval  
by the CAI

CONTACT ADDRESS:

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