



## Cleaveland Aircraft Tool

2225 First St. Boone, IA 50036  
(515) 432-6794 (515) 432-7804 (FAX)  
mail@cleavelandtool.com  
www.cleavelandtool.com

# Static Port Installation Instructions

Thank you for choosing our static port fittings.

These fittings work very well when properly installed. The fittings are designed to be installed by drilling a 1/2" hole with a unibit into the .025" skin of the tailcone assembly. Deburr the inside of the skin sufficiently to allow the port mounting surface to sit flush on the inside skin surface. After this is done and deburred you should back drill the rivet attach holes with a #40 drill. The holes in the skin should be deburred and dimpled to accept an AN426-3 flush rivet. The static port mounting holes should be countersunk deep enough to accept the skin's dimple. If these countersinks are not deep enough the port will not sit flush on the inside of the skin and will not protrude the designed .010" into the airstream. Also it is important not to prime the port, or the inside of the skin in this area before the port is installed. The thickness of the primer will also cause the port to not function properly. Once installed the port will protrude from the surface slightly. When painting the airplane you should also paint the port. If you mask off the port, but paint the skin around it, the port will not protrude enough. Insert a toothpick tip or something similar to plug the hole prior to painting. After painting remove the plug while the paint is wet, then after the paint is dry you can use a deburring tool and a 1/16" drill bit to clean the hole up. Use a piece of 1/4" I.D. tubing to press on the back of the ports, then where ever you wish to transition to Van's 1/4" O.D. tubing simply slide Van's tubing inside the 1/4" I.D. tubing.



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