

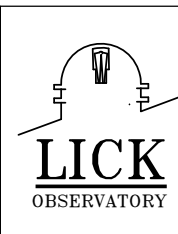
REVISIONS				
DRWN	DATE	CHK'D	REV	DESCRIPTION
CR	14JAN2016		A	INITIAL RELEASE
CR	31MAR16		B	ADDED MORE CUTOUTS AND 3 ADDITIONAL THICKER SHEET METAL POCKETS, RECESS FOR ENCODER TAPE
CR	DEC17		C	REMOVED MATERIAL FROM GALIL POCKET -SEE PAGE 10

Weldment Cut List		
ITEM NO.	QTY.	PARTNUMBER
1	24	KDM-2200-1
2	2	KDM2200-2
3	1	KDM2200-3
4	1	KDM2200-4
5	1	KDM2200-5
6	4	KDM2200-6

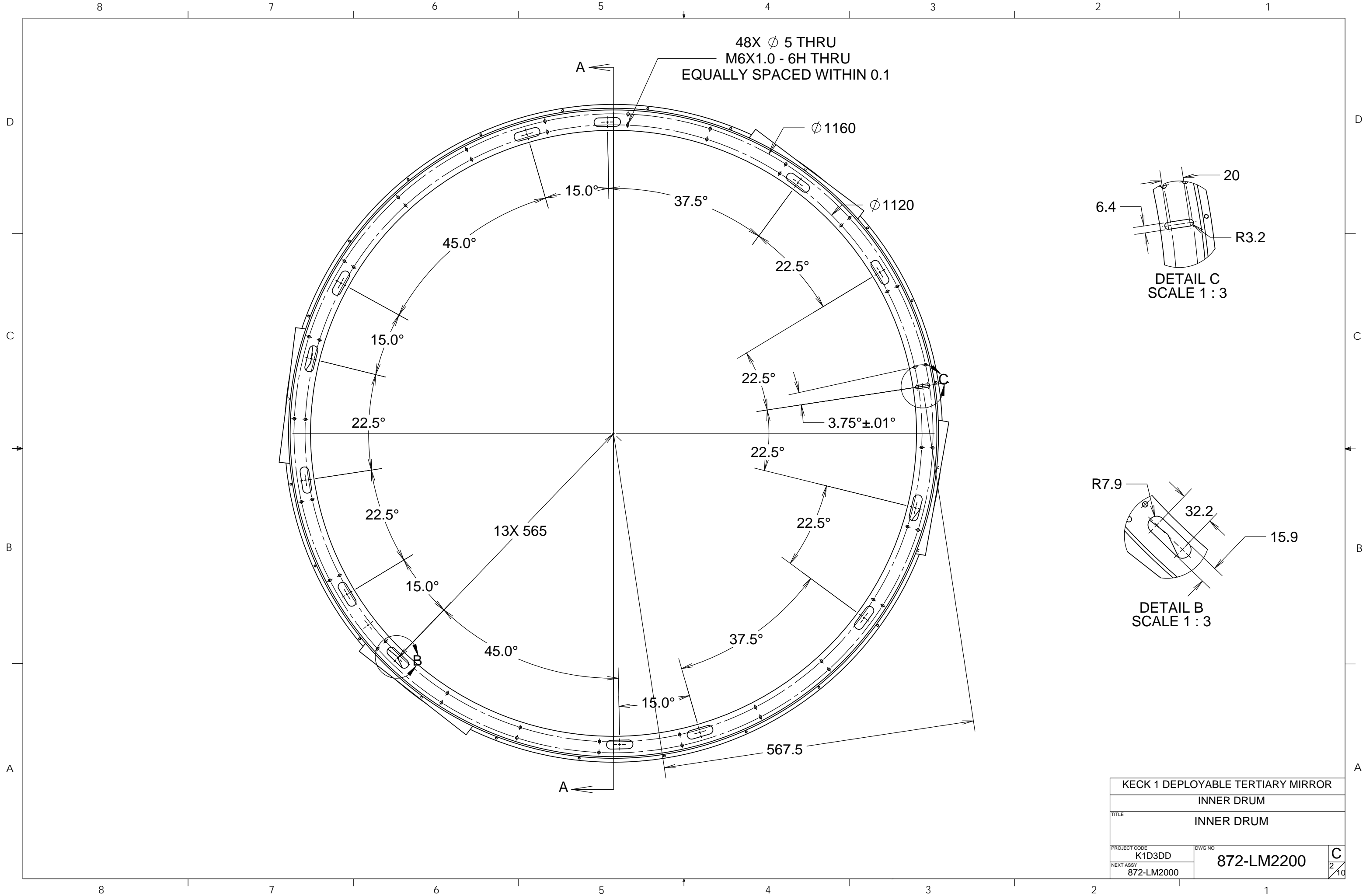
NOTES:

1. GEOMETRIC TOLERANCES AND DIMENSIONS PER ASME Y14.5-2009
2. ASTM A36 STEEL OR EQUIVALENT
3. STRESS RELIEVE AFTER WELDING AND BEFORE MACHINING
4. PAINT WITH Akzo Nobel 463-3-8 Flat Black Temperature Control Epoxy Manufactured by Akzo Nobel Aerospace Corporation.
5. ITEMS 3, 4, AND 5 CAN START THICKER THAN THE NOMINAL THICKNESS DIMENSIONS AND MACHINED AFTER WELDING TO TOLERANCES SPECIFIED IN THIS DRAWING, ITEM 4 CAN BE 1/4 INCH ROLLED PLATE (OR THICKER IF NEEDED)
6. 3-5 MM FILLET WELDS AT ALL INTERFACES
7. MASK/DO NOT PAINT ON SURFACES SHOWN ON LAST PAGE

UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES & TOLERANCES ARE AS FOLLOWS X.X: ±0.1000" X.XX: ±0.0100" X.XXX: ±0.0050" X.XXXX: ±0.0001" ANGLES: ±0.5° FINISH: 125 MICRO INCHES BREAK ALL SHARP EDGES & CORNERS .002" MAX	
MATERIAL SEE NOTE 2	FINISH --



DRAWN <b>C. RATLIFF</b>		<b>KECK 1 DEPLOYABLE TERTIARY MIRROR</b>	
CHECKED <b>J. WARD</b>	1-13-16	<b>INNER DRUM</b>	
DESIGNED <b>C. RATLIFF</b>	12/30/15	<b>INNER DRUM</b>	
ENGINEER <b>C. RATLIFF</b>		PROJECT CODE K1D3DD	DWG NO 872-LM2200
SW DOCUMENT FILE 872-LM2200.SLDASM	QUANTITY 1	REV C 1/10	



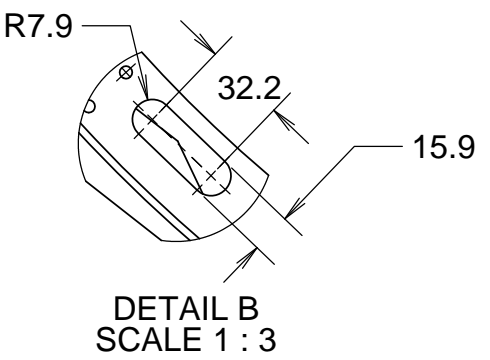
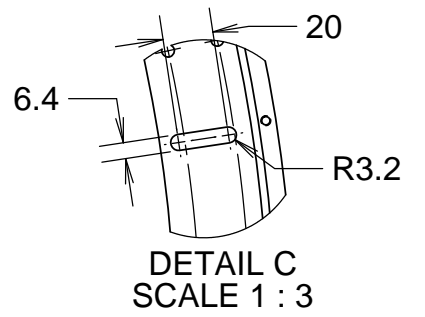
48X  $\phi$  5 THRU  
M6X1.0 - 6H THRU  
EQUALLY SPACED WITHIN 0.1

$\phi$  1160

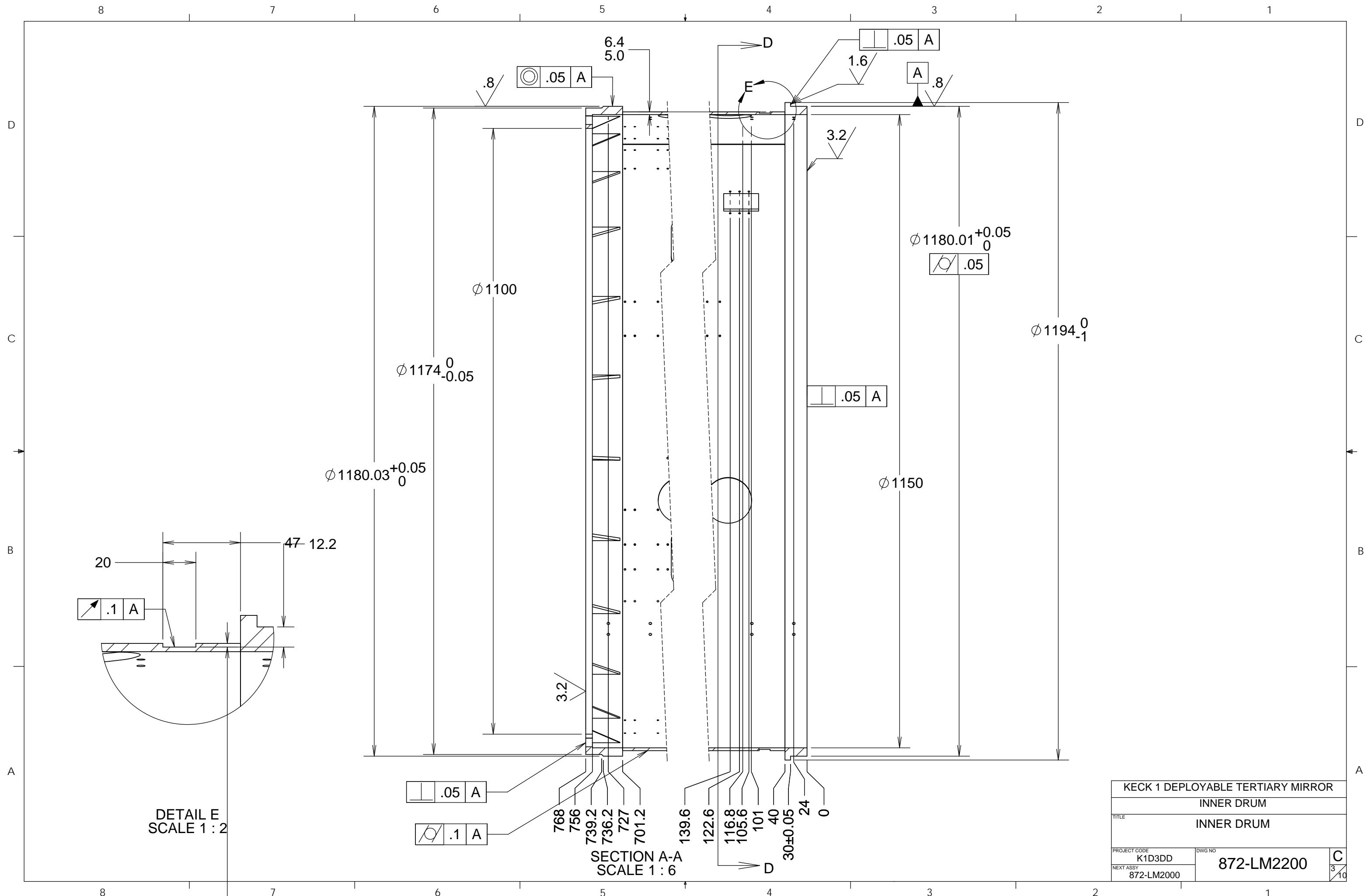
$\phi$  1120

13X 565

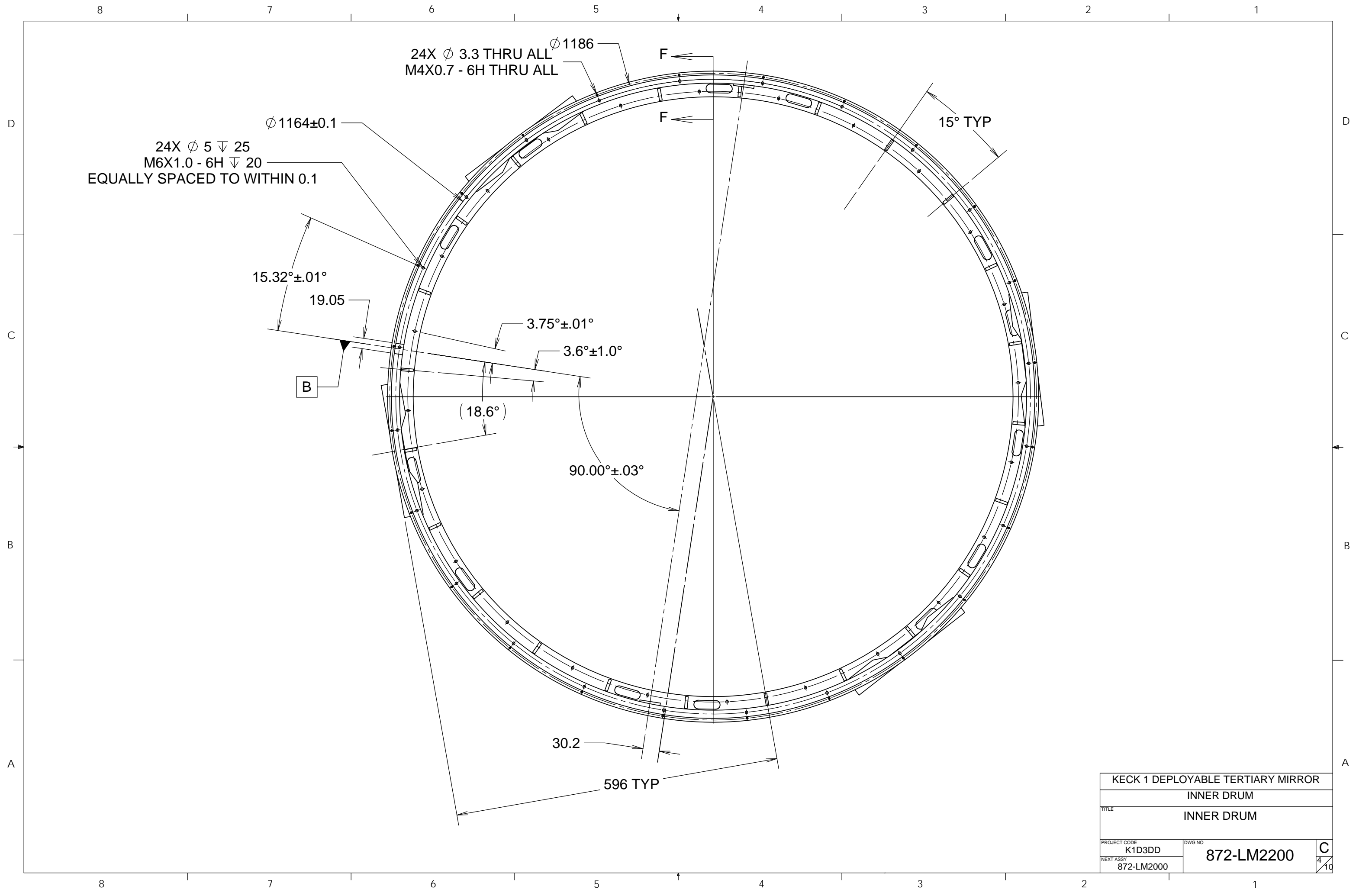
567.5



PROJECT CODE		DWG NO	
K1D3DD		872-LM2200	
NEXT ASSY		872-LM2000	
TITLE		C	
KECK 1 DEPLOYABLE TERTIARY MIRROR		2/10	
INNER DRUM			
INNER DRUM			



PROJECT CODE		DWG NO	
K1D3DD		872-LM2200	
NEXT ASSY		872-LM2000	
TITLE		C	
KECK 1 DEPLOYABLE TERTIARY MIRROR		3/10	
INNER DRUM			
INNER DRUM			



24X Ø 3.3 THRU ALL  
M4X0.7 - 6H THRU ALL

24X Ø 5 ∇ 25  
M6X1.0 - 6H ∇ 20  
EQUALLY SPACED TO WITHIN 0.1

Ø 1164±0.1

Ø 1186

15° TYP

15.32°±0.01°

19.05

3.75°±0.01°

3.6°±1.0°

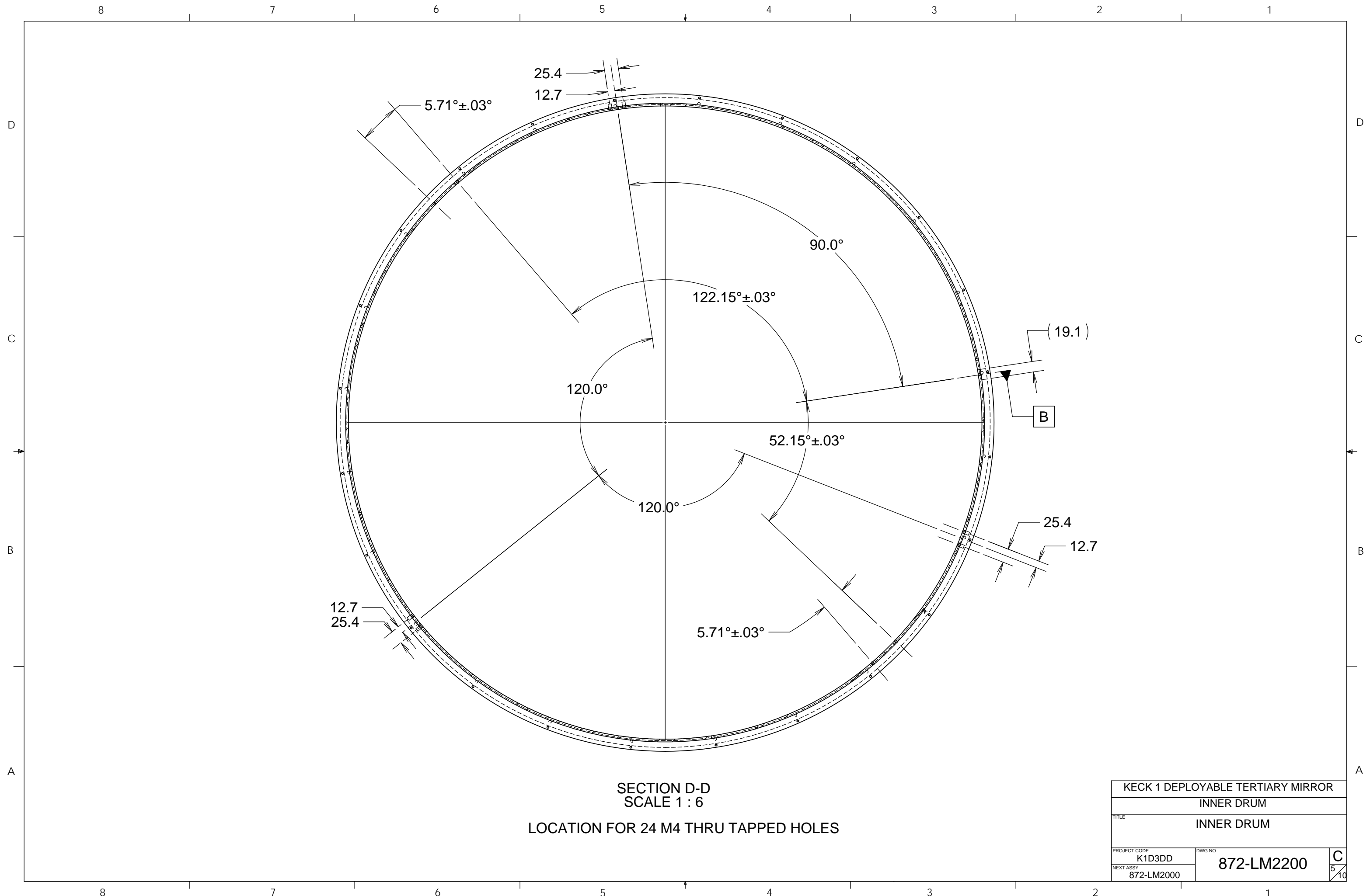
(18.6°)

90.00°±0.03°

30.2

596 TYP

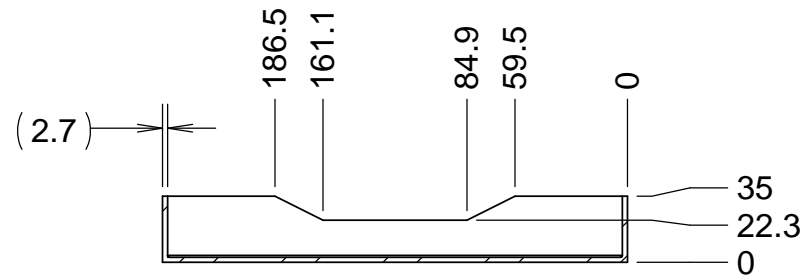
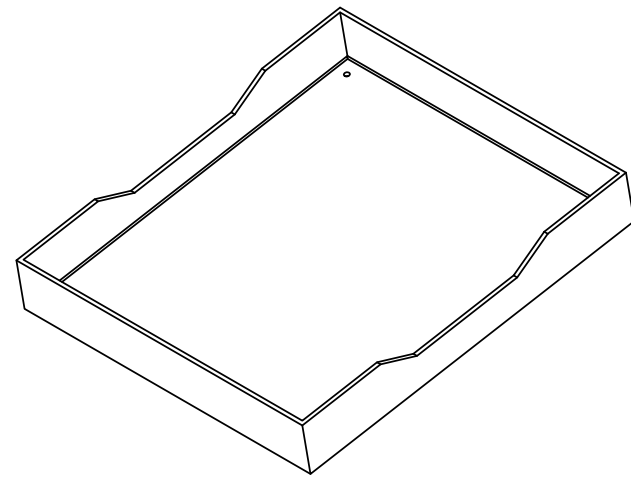
PROJECT CODE		DWG NO	
K1D3DD		872-LM2200	
NEXT ASSY		872-LM2000	
TITLE		C	
KECK 1 DEPLOYABLE TERTIARY MIRROR		4	
INNER DRUM		10	
INNER DRUM			



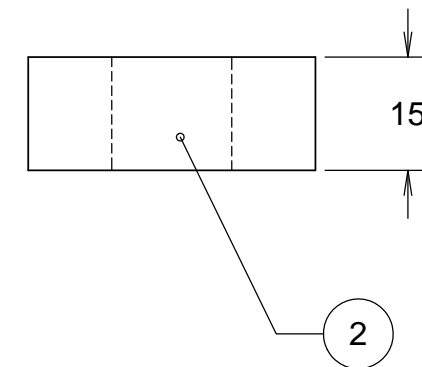
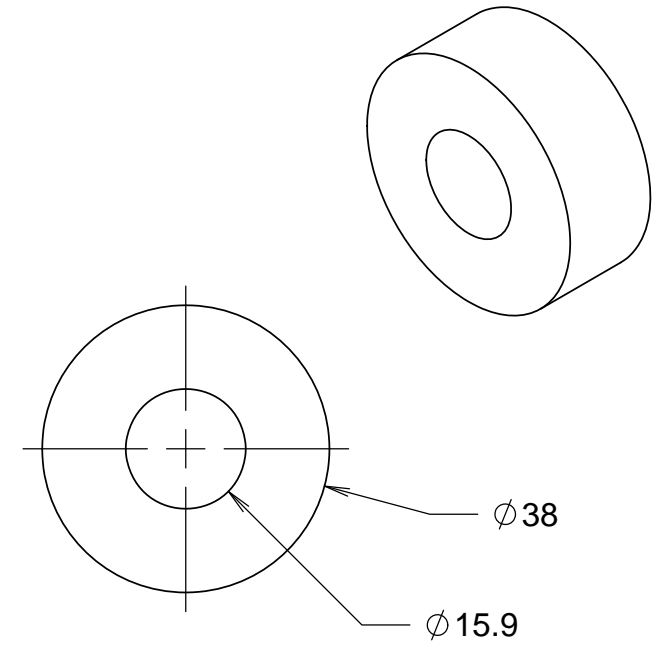
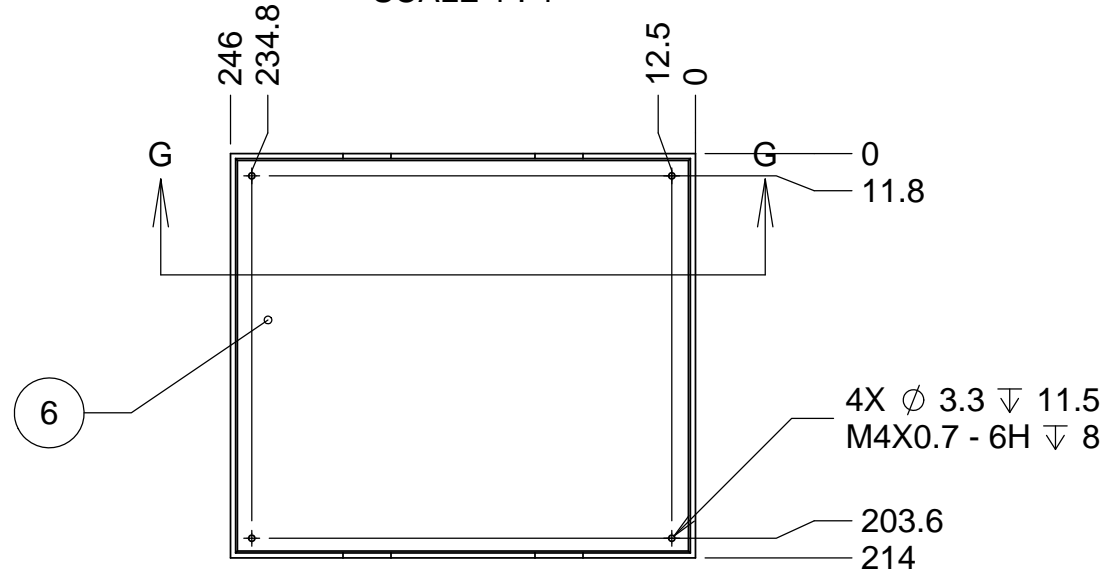
SECTION D-D  
 SCALE 1 : 6  
 LOCATION FOR 24 M4 THRU TAPPED HOLES

PROJECT CODE		K1D3DD		DWG NO		872-LM2200	
NEXT ASSY		872-LM2000		TITLE		INNER DRUM	
						C	
						5/10	



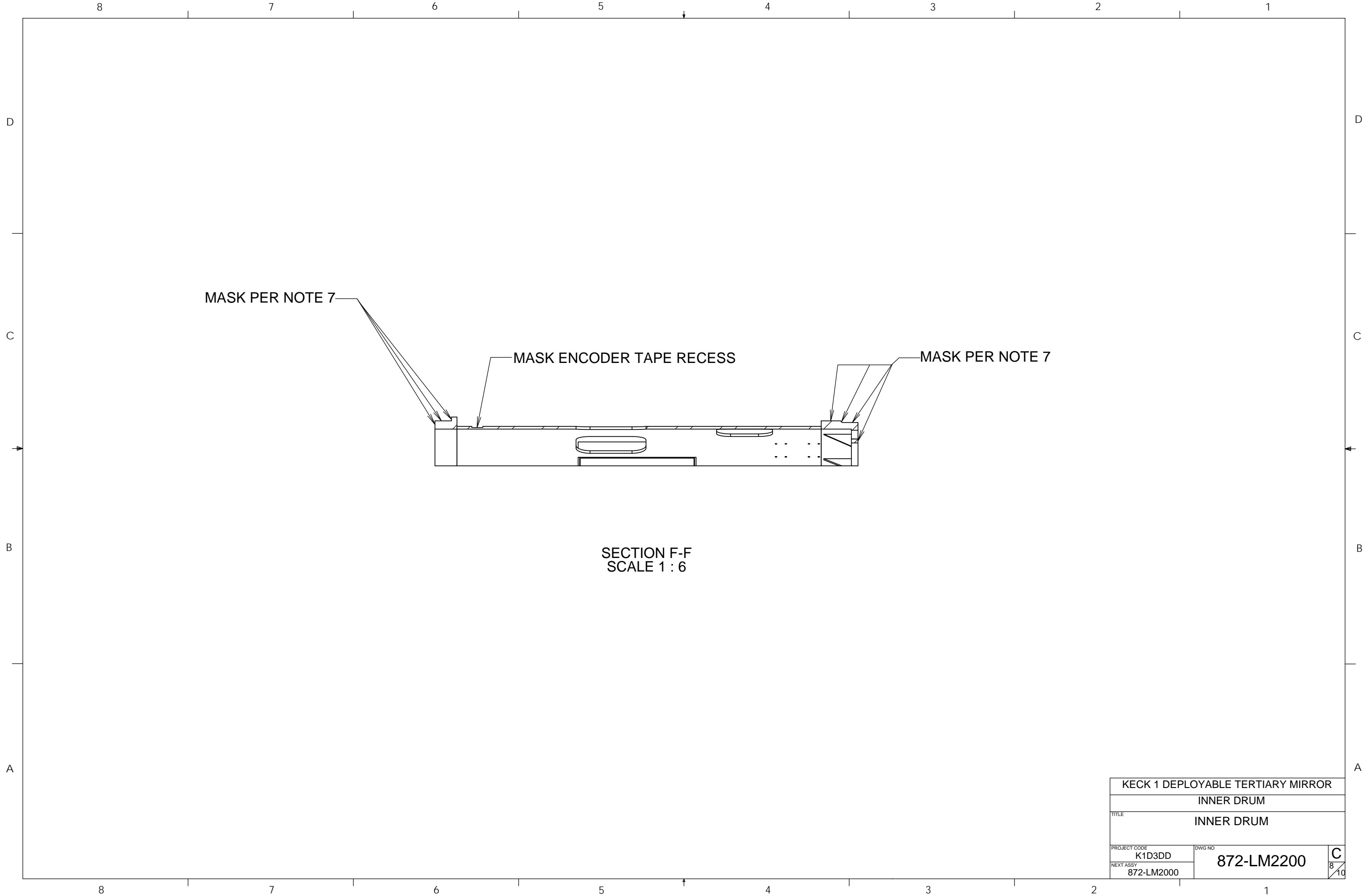


SECTION G-G  
SCALE 1 : 4



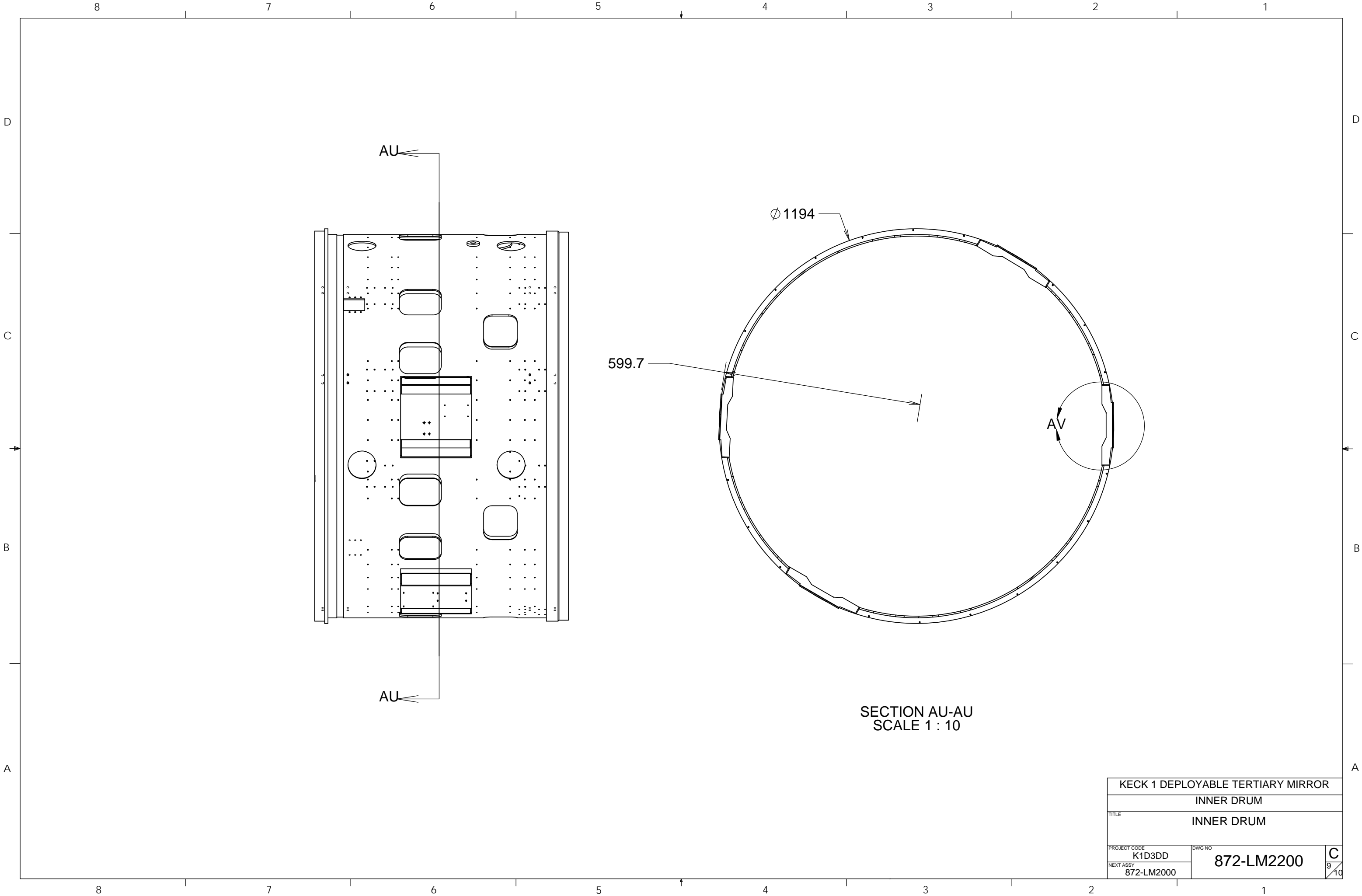
USE 2.7MM THICK (12 GAUGE) SHEET METAL FOR ITEM 6, WELD SEAMS,  
ALL FACES FLAT TO LESS THAN 1 MM, INSIDE BEND RADII 1.5 MM MAX

PROJECT CODE		DWG NO	
K1D3DD		872-LM2200	
NEXT ASSY		C	
872-LM2000		7/10	



PROJECT CODE		K1D3DD		DWG NO		872-LM2200		C 8/10
NEXT ASSY		872-LM2000		872-LM2200				
KECK 1 DEPLOYABLE TERTIARY MIRROR				INNER DRUM				
TITLE				INNER DRUM				





AU

Ø1194

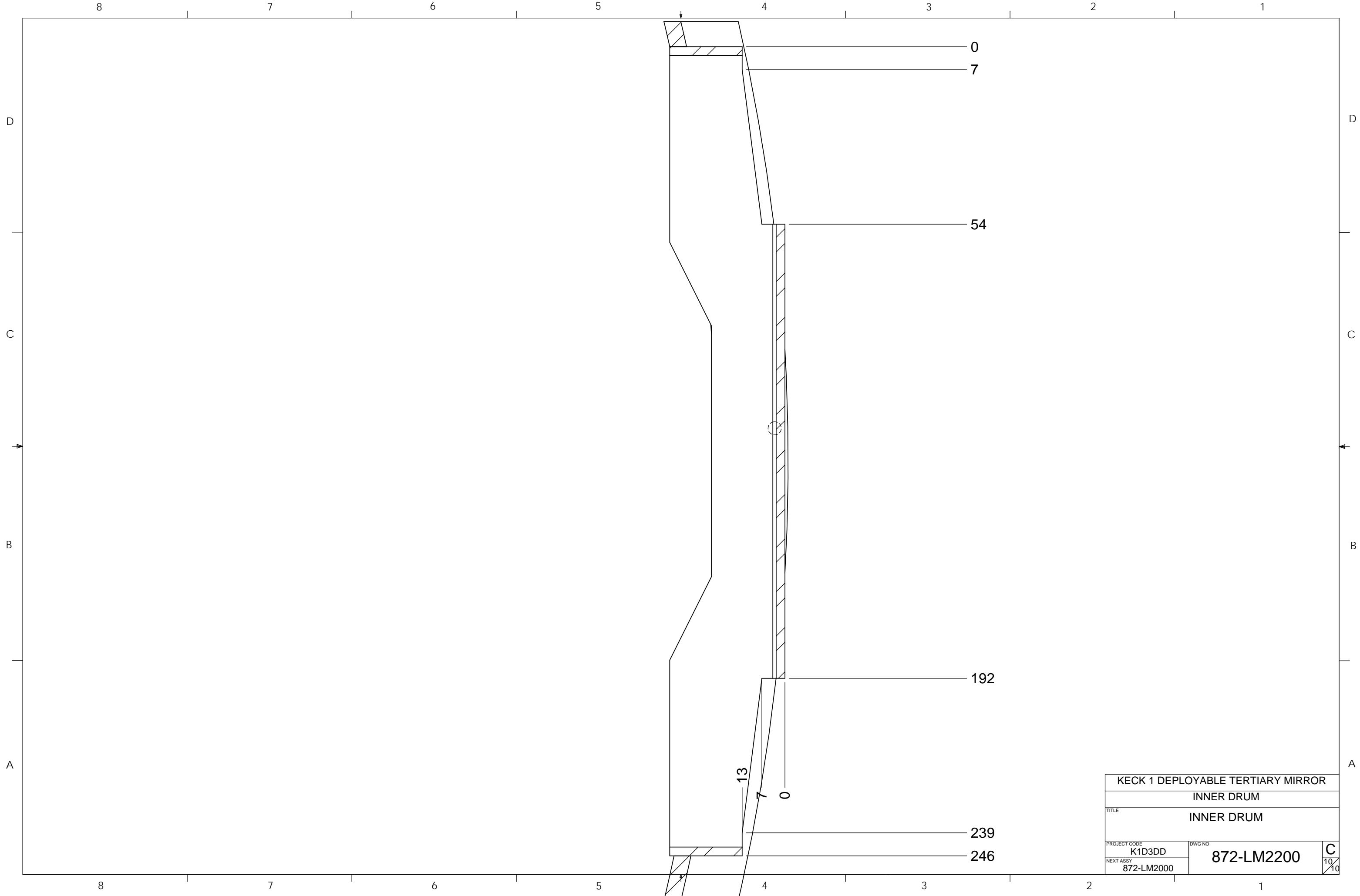
599.7

AV

AU

SECTION AU-AU  
SCALE 1:10

PROJECT CODE		K1D3DD		DWG NO		872-LM2200	
NEXT ASSY		872-LM2000		TITLE		INNER DRUM	
						C 9 10	



PROJECT CODE		K1D3DD		DWG NO		872-LM2200	
TITLE		INNER DRUM		872-LM2200		C	
NEXT ASSY		872-LM2000		872-LM2200		10/10	