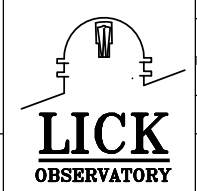


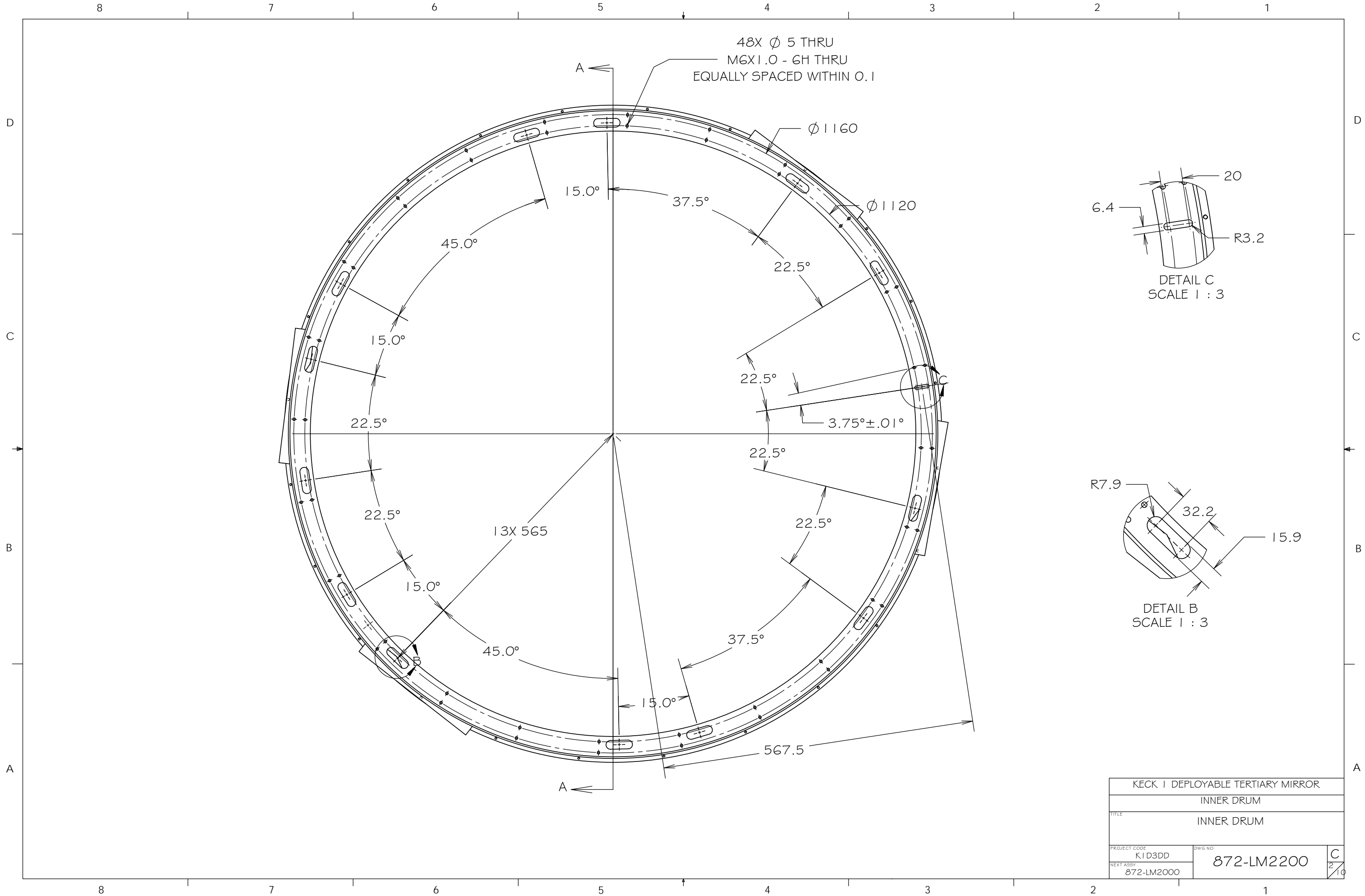
REVISIONS				
DRWN	DATE	CHK'D	REV	DESCRIPTION
CR	14JAN2016		A	INITIAL RELEASE
CR	31MAR16		B	ADDED MORE CUTOUTS AND 3 ADDITIONAL THICKER SHEET METAL POCKETS, RECESS FOR ENCODER TAPE
CR	DEC17		C	REMOVED MATERIAL FROM GALIL POCKET -SEE PAGE 10

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 MILLIMETERS * TOLERANCES ARE AS FOLLOWS: X: ±0.25mm X.X: ±0.10 mm X.XX: ±0.01 mm		DRAWN C. RATLIFF		PROJECT CODE K1D3DD		DWG NO 872-LM2200		REV C	
ANGLES: ±0.5° FINISH: 3 MICRONS (µm) BREAK ALL SHARP EDGES * CORNERS .25mm MAX		CHECKED J. WARD		DATE 1-13-16		TITLE INNER DRUM		REV 1	
MATERIAL SEE NOTE 2		DESIGNED C. RATLIFF		DATE 12/30/15		TITLE INNER DRUM		REV 1	
FINISH --		ENGINEER C. RATLIFF		QUANTITY 1		NEXT ASSY 872-LM2000		REV 1	
		SW DOCUMENT FILE 872-LM2200.SLDA5M						REV C	





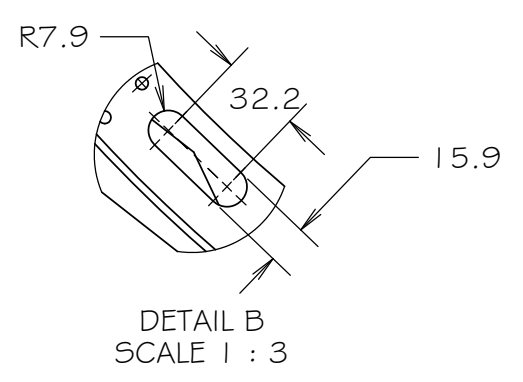
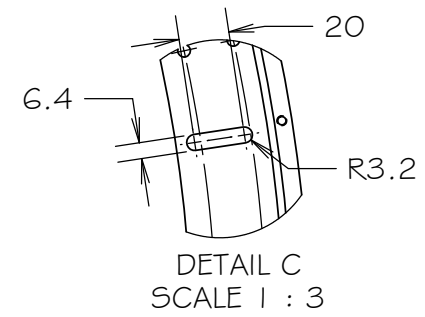
48X Ø 5 THRU
 MGX1.0 - GH THRU
 EQUALLY SPACED WITHIN 0.1

Ø1160

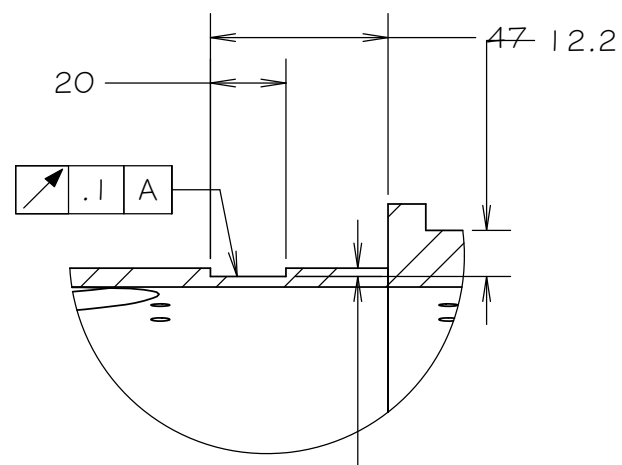
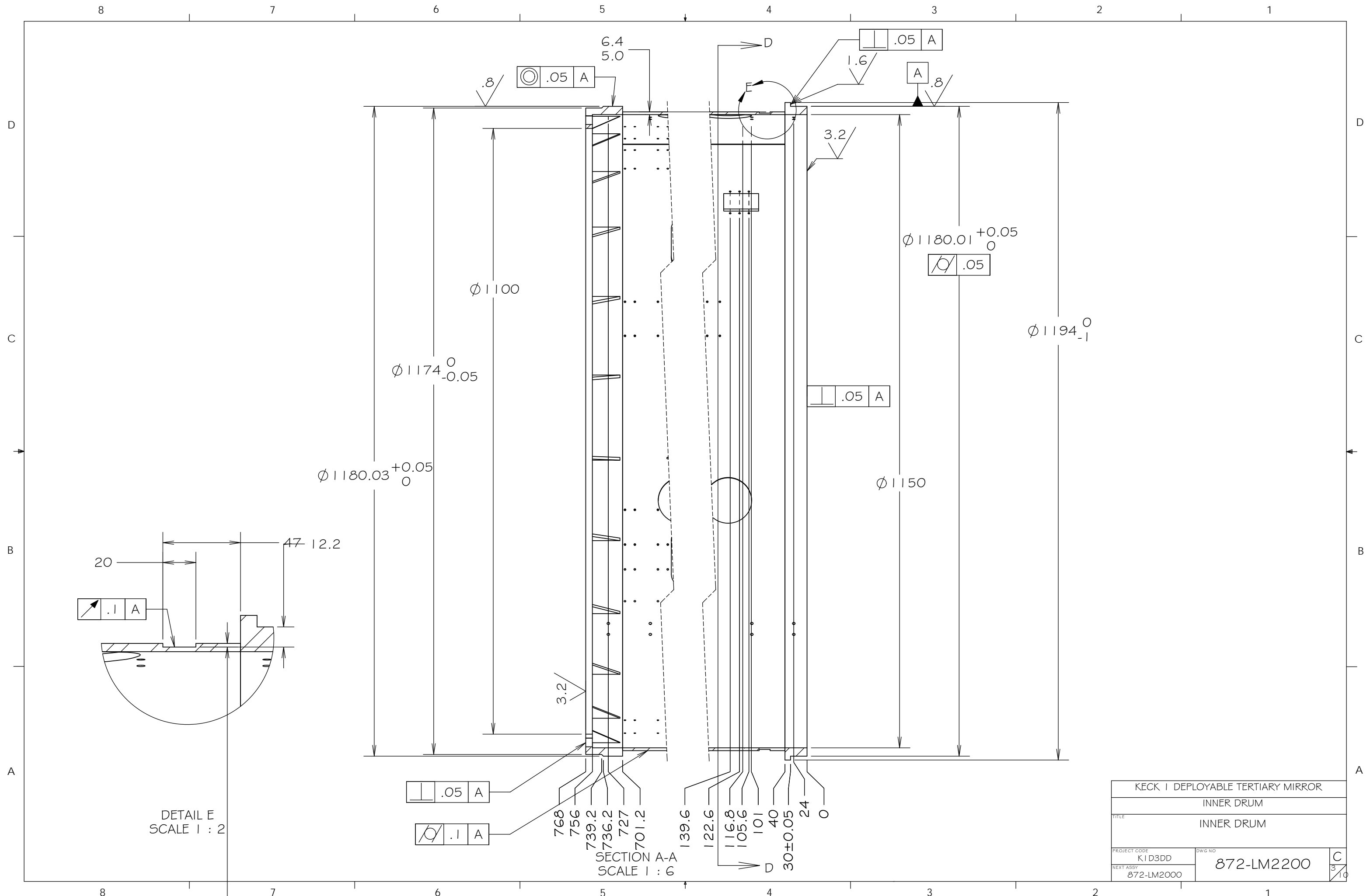
Ø1120

13X 565

567.5



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



DETAIL E
SCALE 1 : 2

SECTION A-A
SCALE 1 : 6

- \perp .05 A
- ϕ .1 A
- 768
- 756
- 739.2
- 736.2
- 727
- 701.2
- 139.6
- 122.6
- 116.8
- 105.6
- 101
- 40
- 30±0.05
- 24
- O

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

8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A

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

Ø1186

F

F

15° TYP

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

Ø1164±0.1

15.32±.01°

19.05

3.75±.01°

3.6±1.0°

B

(18.6°)

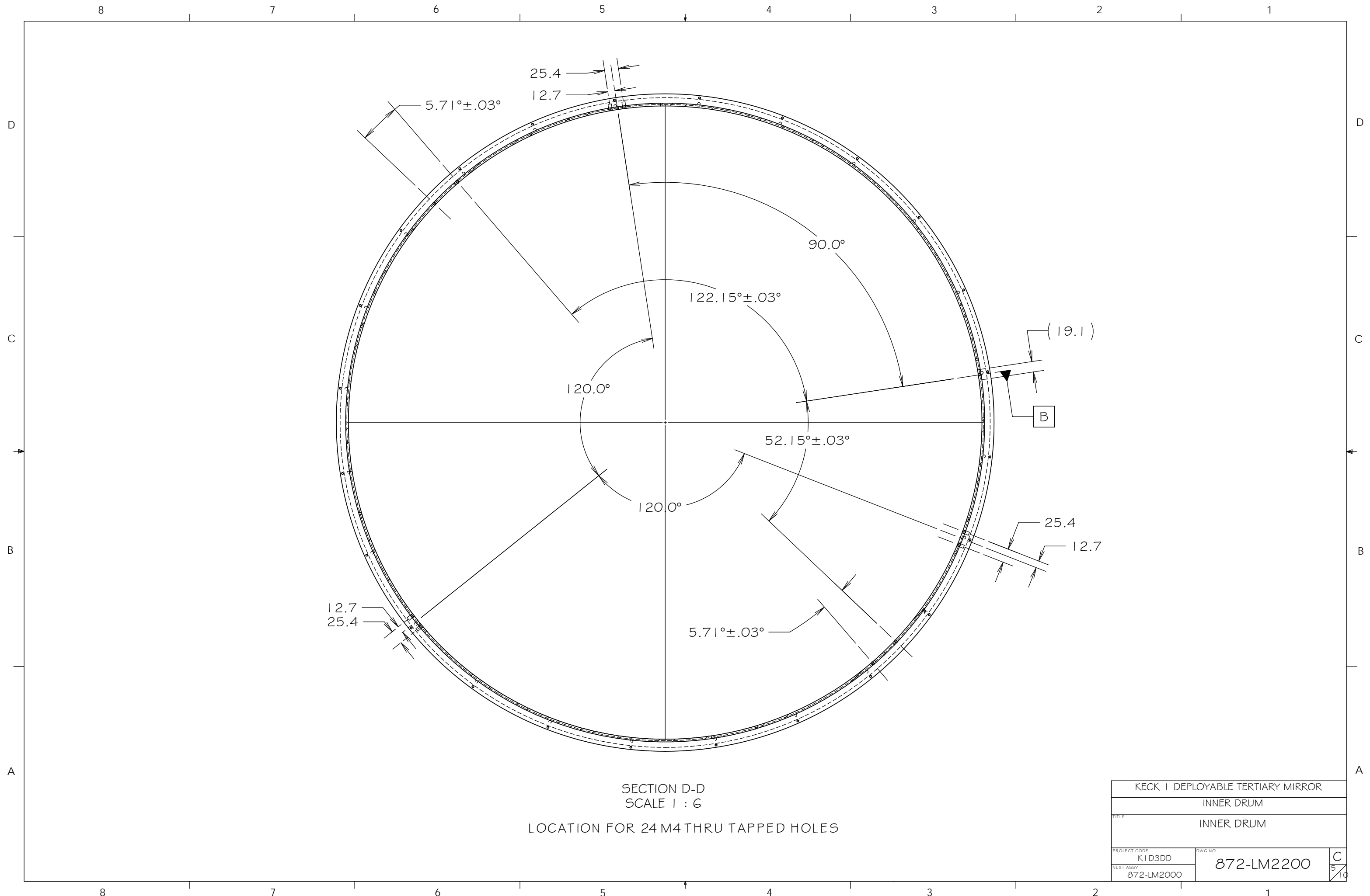
90.00±.03°

30.2

596 TYP

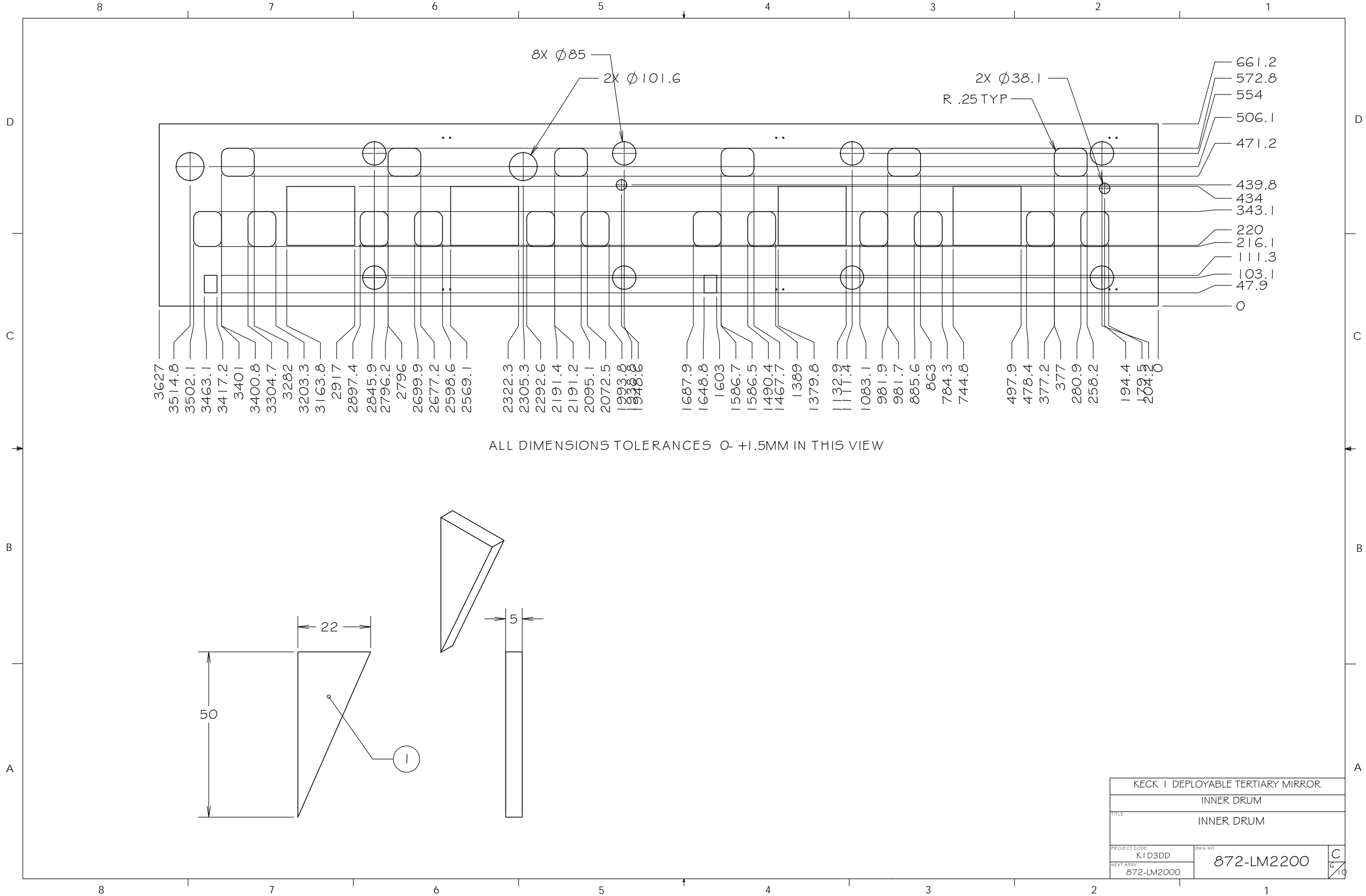
8 7 6 5 4 3 2 1

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



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

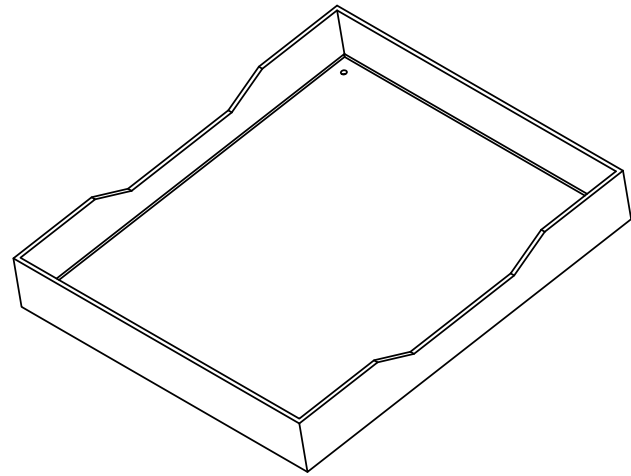
PROJECT CODE		DWG NO	
K1D3DD		872-LM2200	
NEXT ASSY		872-LM2000	
TITLE		C	
KECK I DEPLOYABLE TERTIARY MIRROR		5	
INNER DRUM		10	
INNER DRUM			



8 7 6 5 4 3 2 1

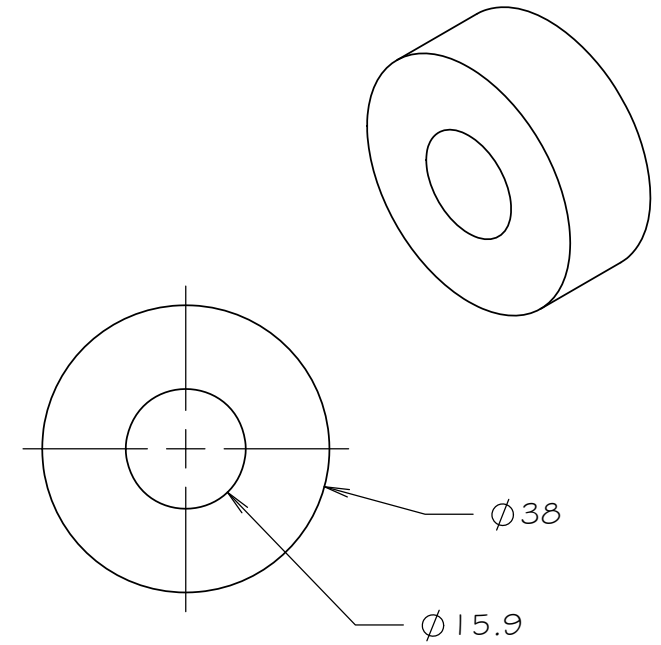
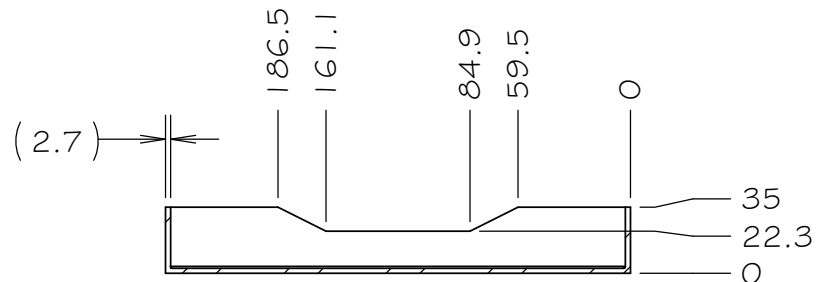
D

D



C

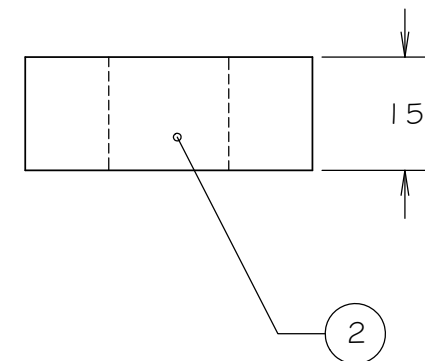
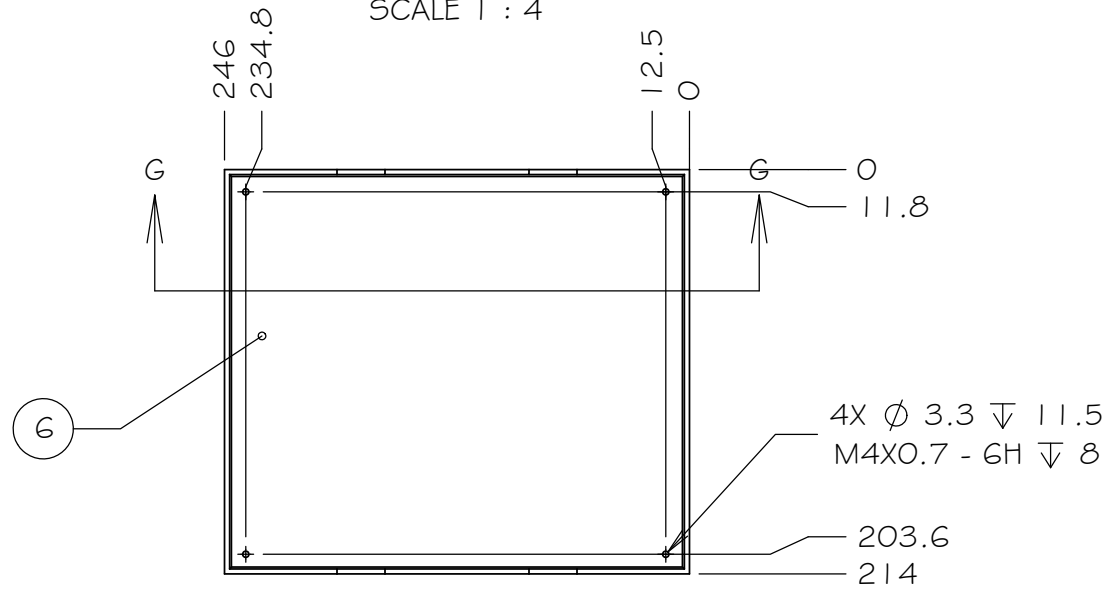
C



B

B

SECTION G-G
SCALE 1 : 4



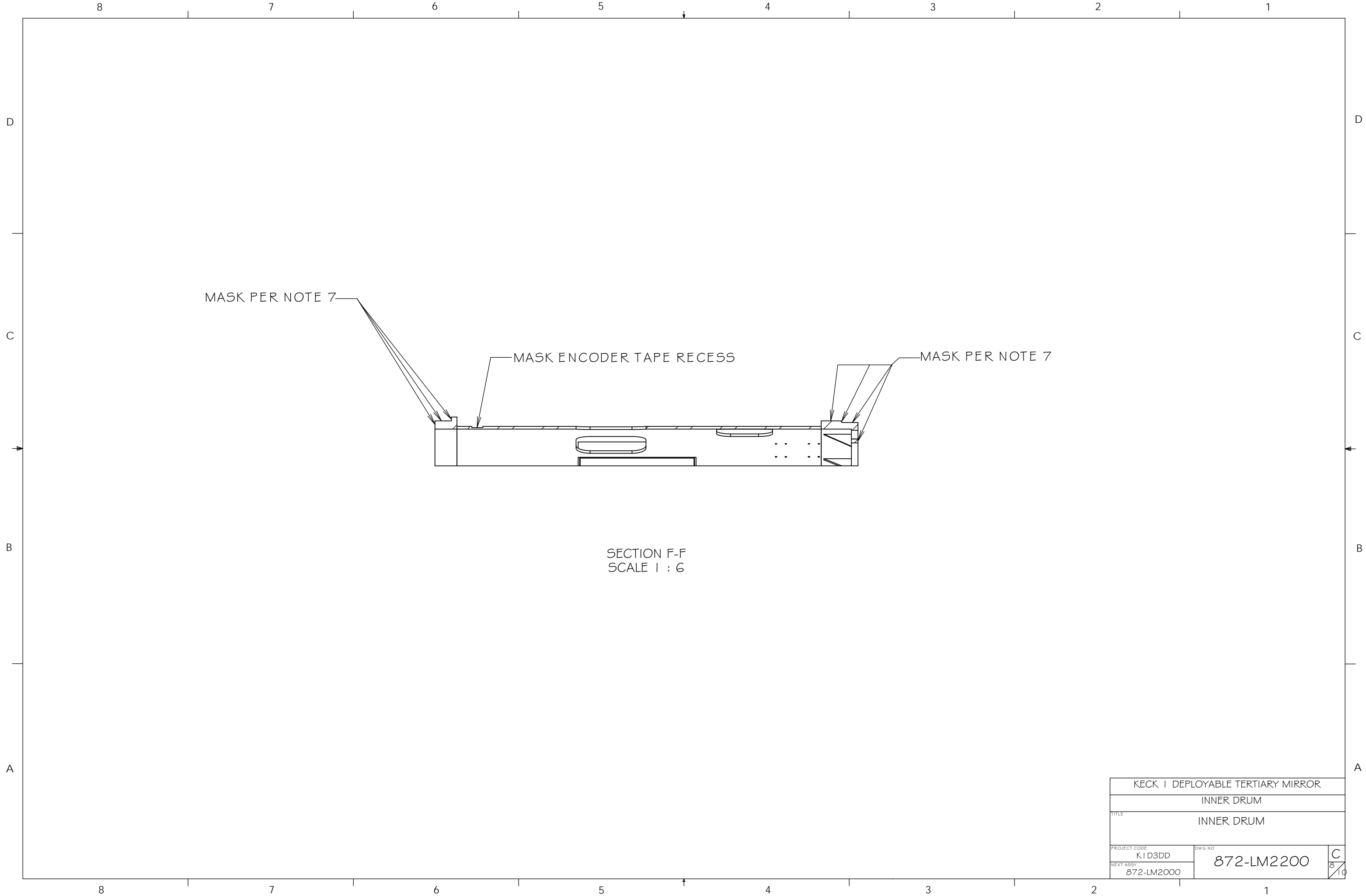
A

A

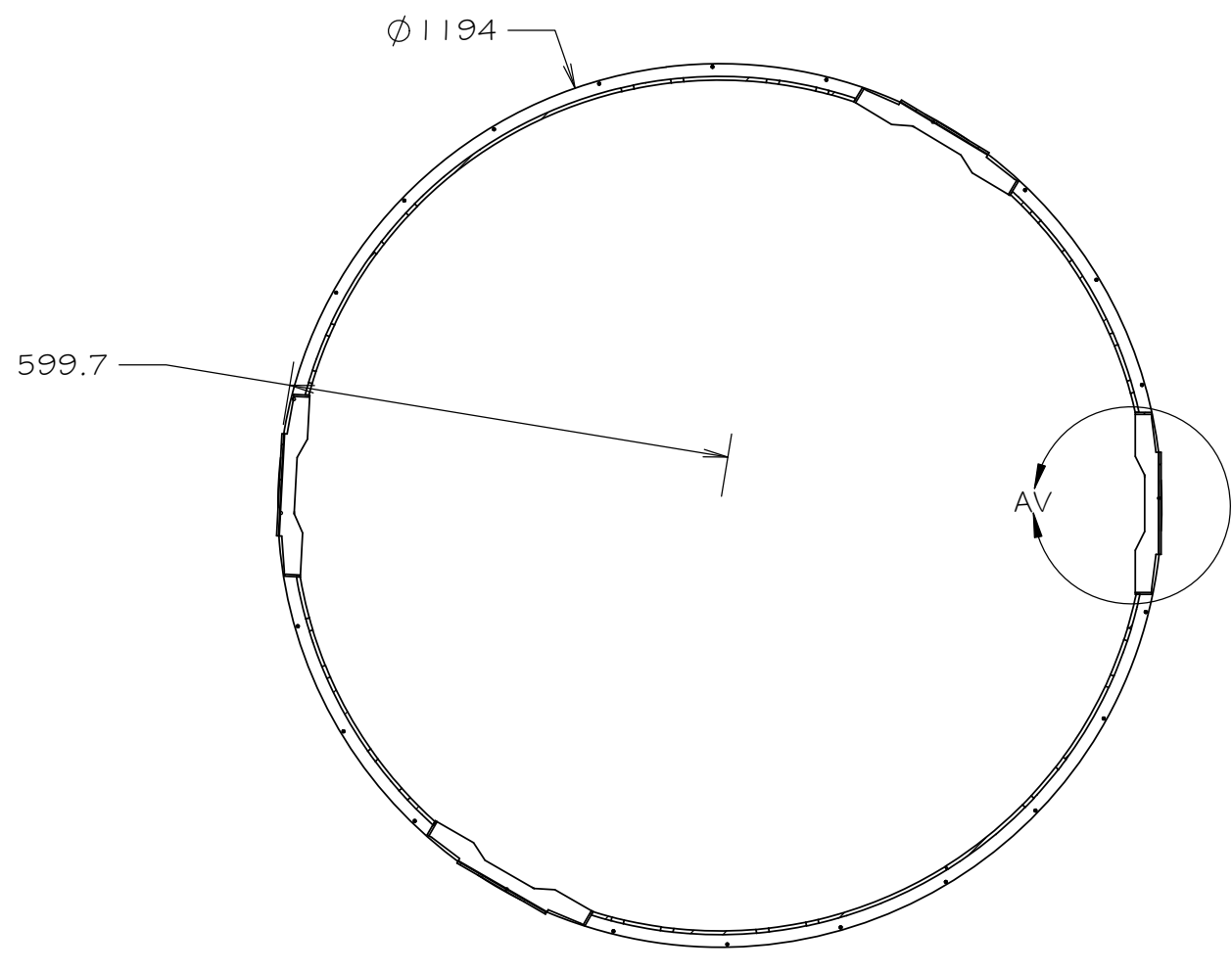
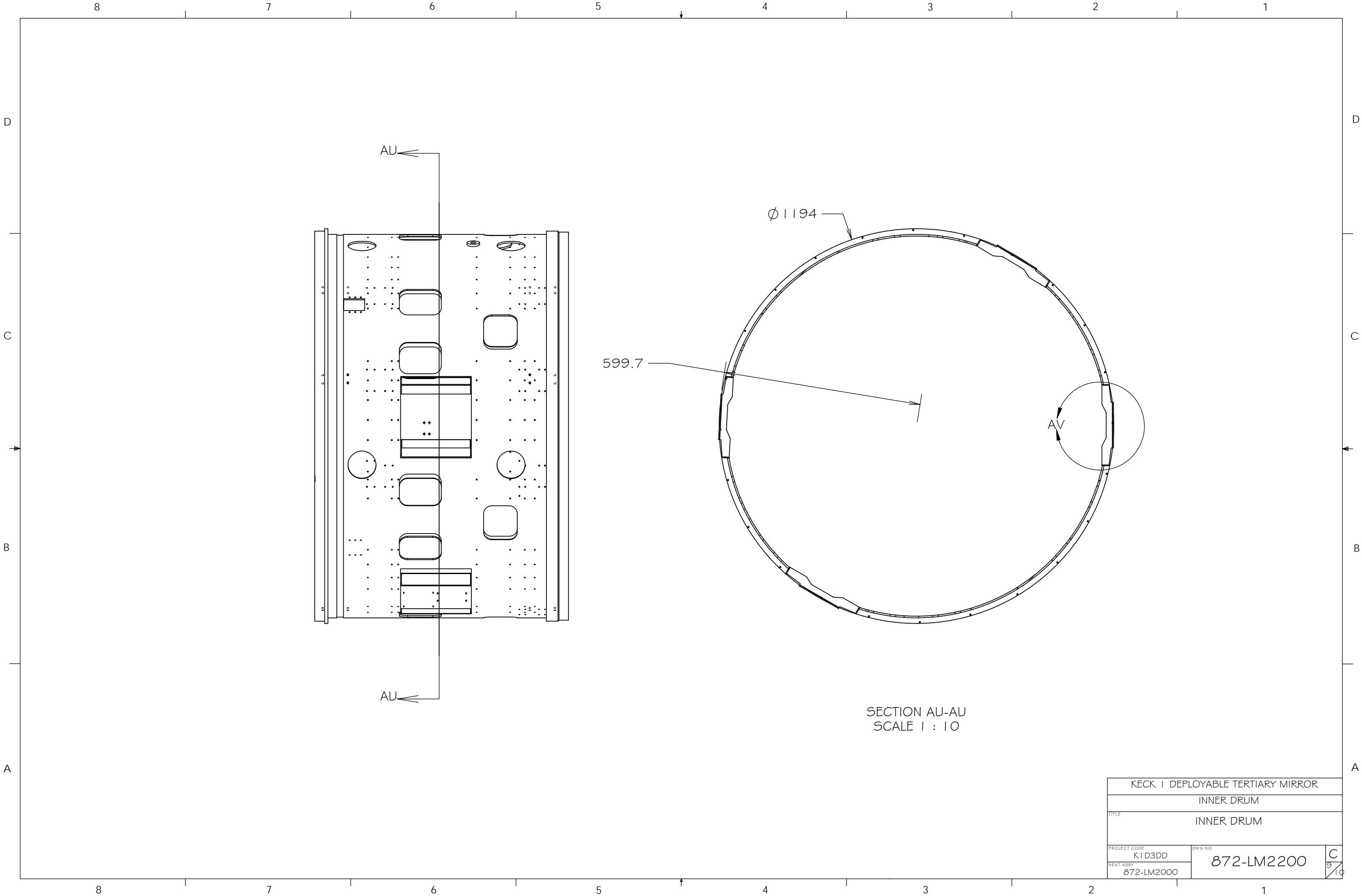
USE 2.7MM THICK (12 GAUGE) SHEET METAL FOR ITEM 6, WELD SEAMS,
ALL FACES FLAT TO LESS THAN 1 MM, INSIDE BEND RADII 1.5MM MAX

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

8 7 6 5 4 3 2 1



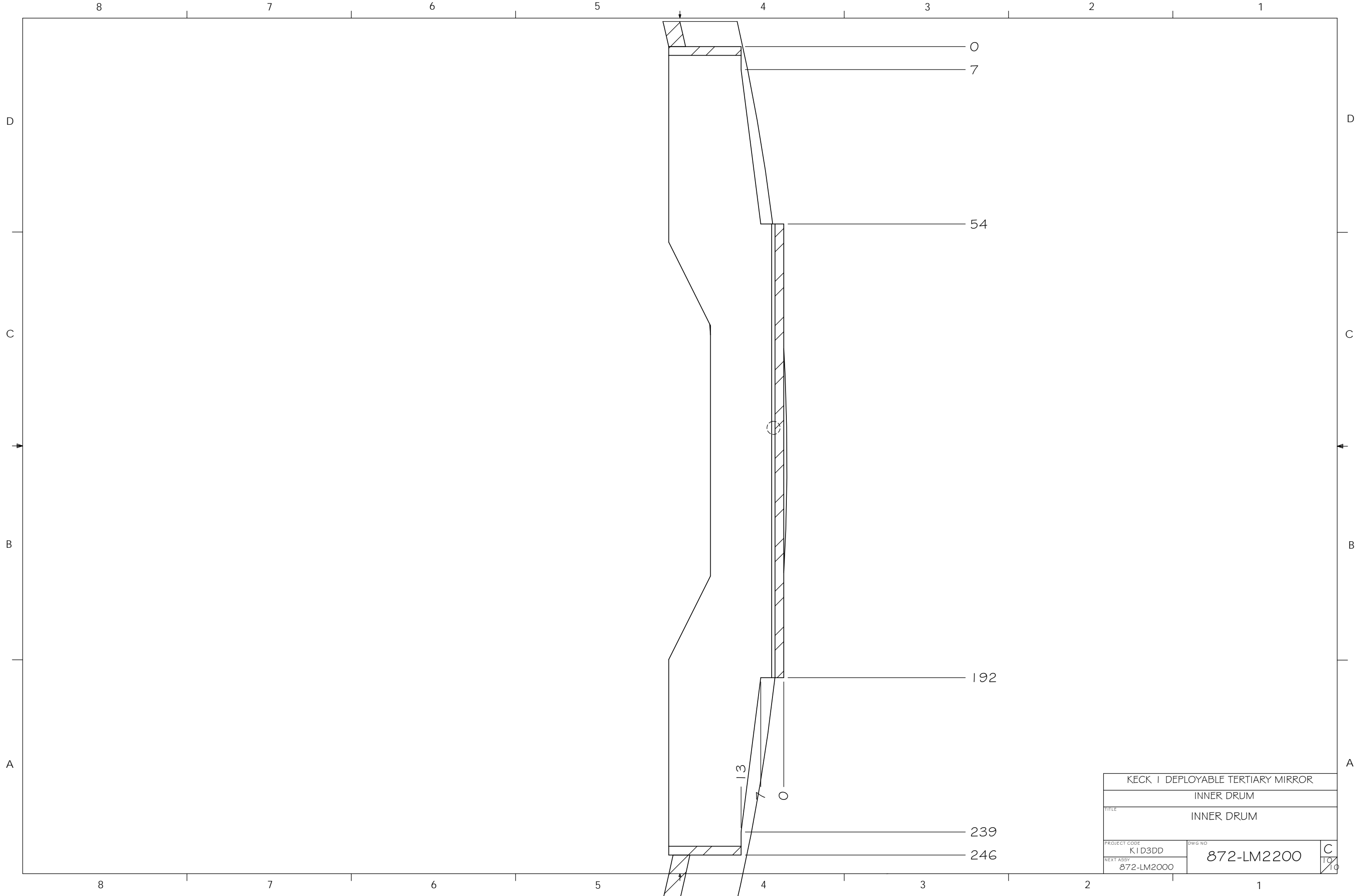
KECK I DEPLOYABLE TERTIARY MIRROR		
INNER DRUM		
TITLE INNER DRUM		
PROJECT CODE K1D3DD	DWG NO 872-LM2200	C 8 10
NEXT ASSY 872-LM2000		



SECTION AU-AU
SCALE 1 : 10

PROJECT CODE		DWG NO	
K1D3DD		872-LM2200	
NEXT ASSY		872-LM2000	
TITLE		INNER DRUM	
KECK I DEPLOYABLE TERTIARY MIRROR		INNER DRUM	

C
9
10



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