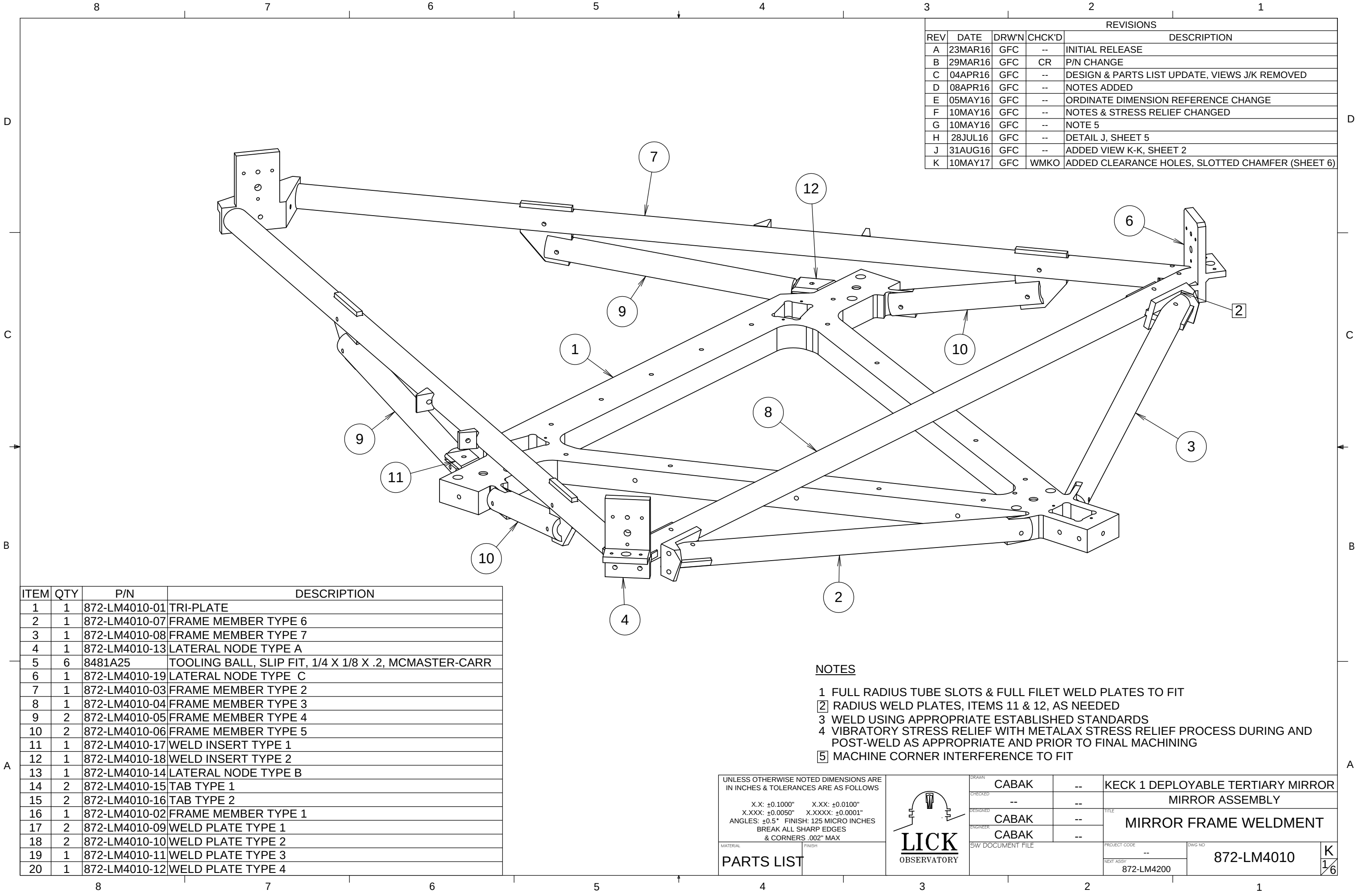




REVISIONS				
REV	DATE	DRW'N	CHCK'D	DESCRIPTION
A	23MAR16	GFC	--	INITIAL RELEASE
B	29MAR16	GFC	CR	P/N CHANGE
C	04APR16	GFC	--	DESIGN & PARTS LIST UPDATE, VIEWS J/K REMOVED
D	08APR16	GFC	--	NOTES ADDED
E	05MAY16	GFC	--	ORDINATE DIMENSION REFERENCE CHANGE
F	10MAY16	GFC	--	NOTES & STRESS RELIEF CHANGED
G	10MAY16	GFC	--	NOTE 5
H	28JUL16	GFC	--	DETAIL J, SHEET 5
J	31AUG16	GFC	--	ADDED VIEW K-K, SHEET 2
K	10MAY17	GFC	WMKO	ADDED CLEARANCE HOLES, SLOTTED CHAMFER (SHEET 6)

ITEM	QTY	P/N	DESCRIPTION
1	1	872-LM4010-01	TRI-PLATE
2	1	872-LM4010-07	FRAME MEMBER TYPE 6
3	1	872-LM4010-08	FRAME MEMBER TYPE 7
4	1	872-LM4010-13	LATERAL NODE TYPE A
5	6	8481A25	TOOLING BALL, SLIP FIT, 1/4 X 1/8 X .2, MCMASTER-CARR
6	1	872-LM4010-19	LATERAL NODE TYPE C
7	1	872-LM4010-03	FRAME MEMBER TYPE 2
8	1	872-LM4010-04	FRAME MEMBER TYPE 3
9	2	872-LM4010-05	FRAME MEMBER TYPE 4
10	2	872-LM4010-06	FRAME MEMBER TYPE 5
11	1	872-LM4010-17	WELD INSERT TYPE 1
12	1	872-LM4010-18	WELD INSERT TYPE 2
13	1	872-LM4010-14	LATERAL NODE TYPE B
14	2	872-LM4010-15	TAB TYPE 1
15	2	872-LM4010-16	TAB TYPE 2
16	1	872-LM4010-02	FRAME MEMBER TYPE 1
17	2	872-LM4010-09	WELD PLATE TYPE 1
18	2	872-LM4010-10	WELD PLATE TYPE 2
19	1	872-LM4010-11	WELD PLATE TYPE 3
20	1	872-LM4010-12	WELD PLATE TYPE 4

NOTES

- 1 FULL RADIUS TUBE SLOTS & FULL FILET WELD PLATES TO FIT
2 RADIUS WELD PLATES, ITEMS 11 & 12, AS NEEDED
3 WELD USING APPROPRIATE ESTABLISHED STANDARDS
4 VIBRATORY STRESS RELIEF WITH METALAX STRESS RELIEF PROCESS DURING AND POST-WELD AS APPROPRIATE AND PRIOR TO FINAL MACHINING
5 MACHINE CORNER INTERFERENCE TO FIT

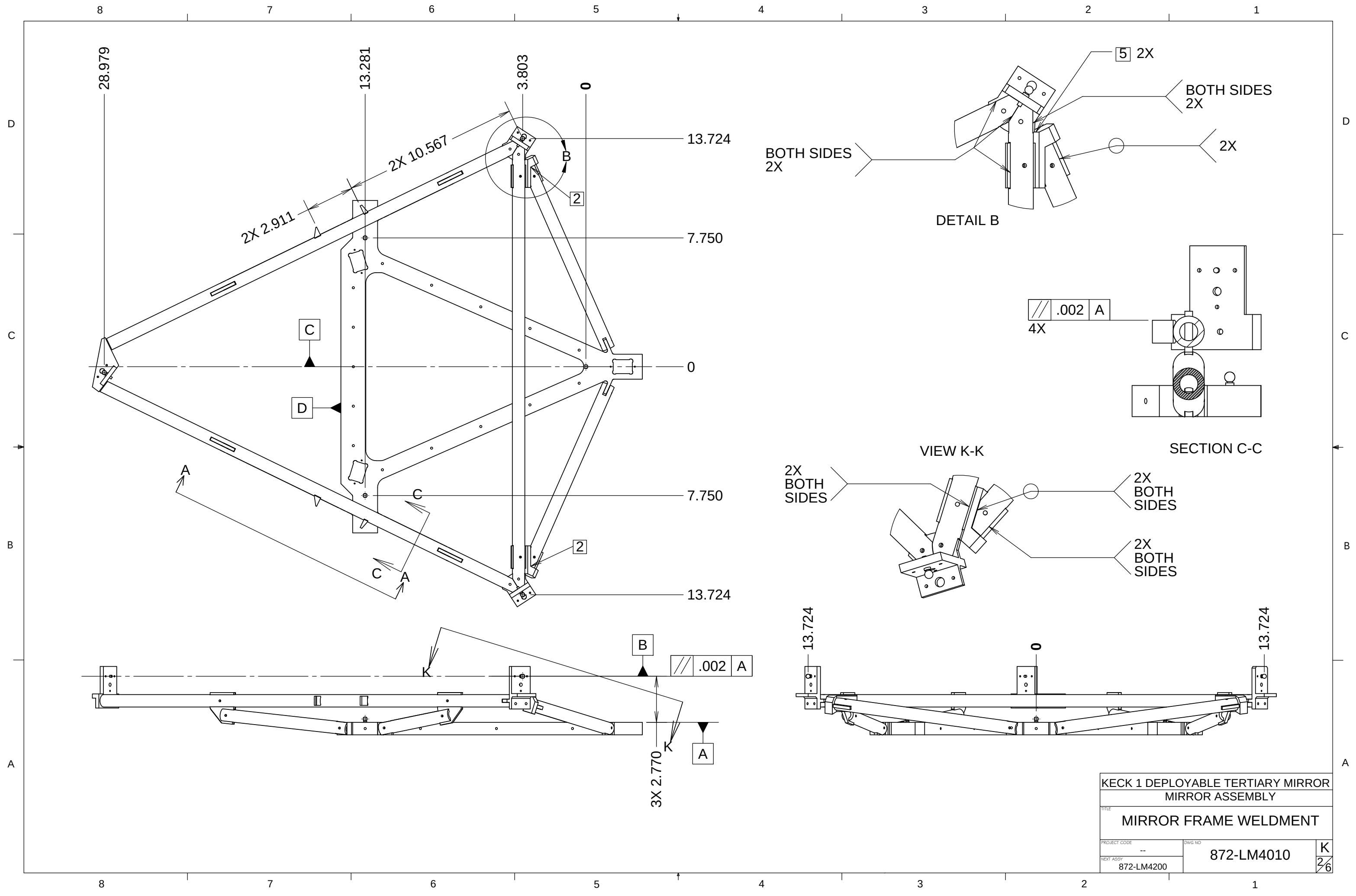
UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES & TOLERANCES ARE AS FOLLOWS

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

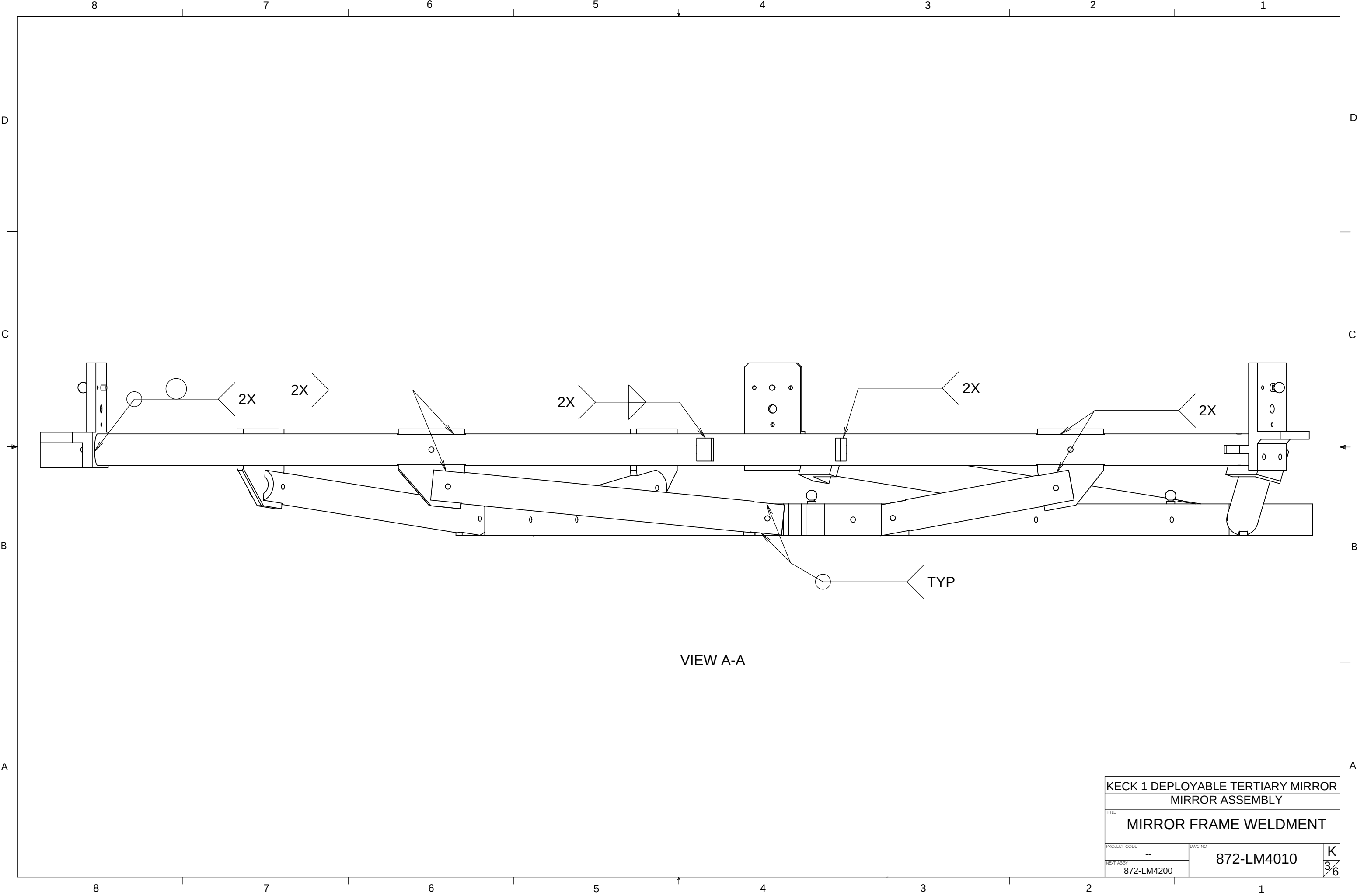
PARTS LIST



DRAWN	CABAK	--	KECK 1 DEPLOYABLE TERTIARY MIRROR	
CHECKED	--	--	MIRROR ASSEMBLY	
DESIGNED	CABAK	--	MIRROR FRAME WELDMENT	
ENGINEER	CABAK	--		
SW DOCUMENT FILE		PROJECT CODE	--	DWG NO
		NEXT ASSY	872-LM4200	872-LM4010
				K 1/6

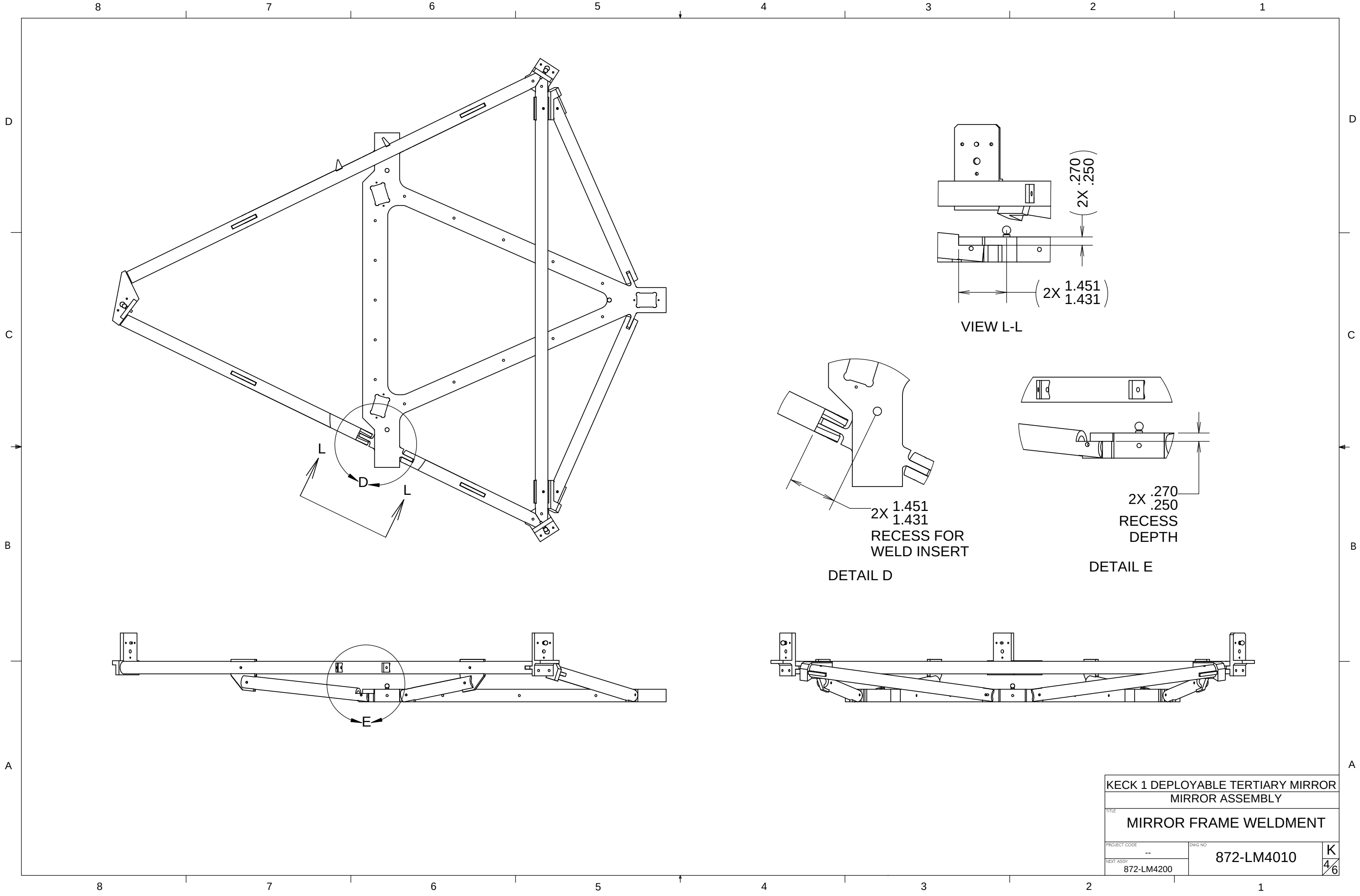


KECK 1 DEPLOYABLE TERTIARY MIRROR			
MIRROR ASSEMBLY			
TITLE			
MIRROR FRAME WELDMENT			
PROJECT CODE		DWG NO	
--		872-LM4010	
NEXT ASSY			
872-LM4200			
			K
			2/6



VIEW A-A

KECK 1 DEPLOYABLE TERTIARY MIRROR		
MIRROR ASSEMBLY		
TITLE		
MIRROR FRAME WELDMENT		
PROJECT CODE	--	DWG NO
NEXT ASSY	872-LM4200	872-LM4010
		K 3/6



KECK 1 DEPLOYABLE TERTIARY MIRROR		
MIRROR ASSEMBLY		
TITLE		
MIRROR FRAME WELDMENT		
PROJECT CODE	--	872-LM4010
NEXT ASSY	872-LM4200	
		K
		4/6

8

7

6

5

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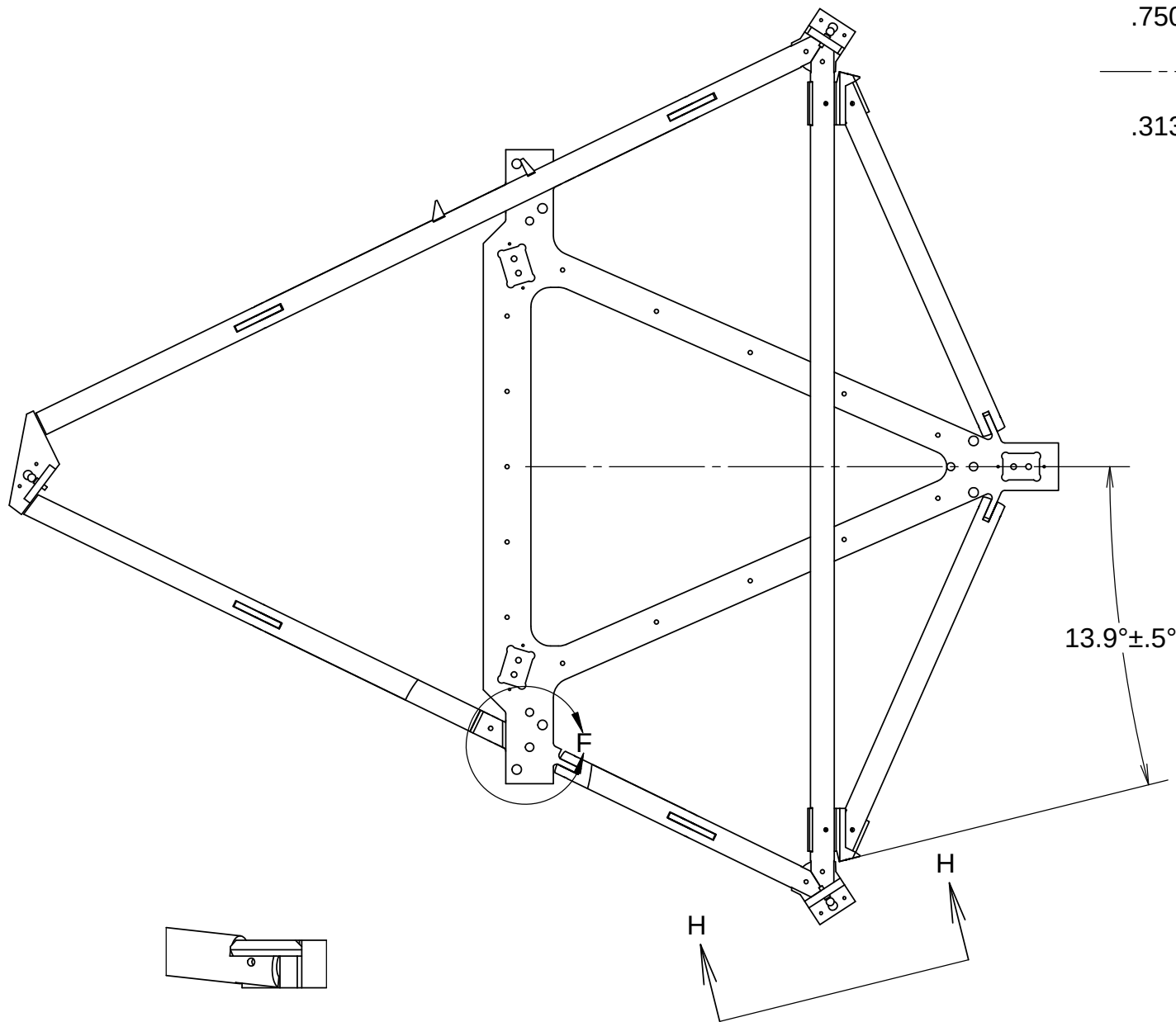
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D

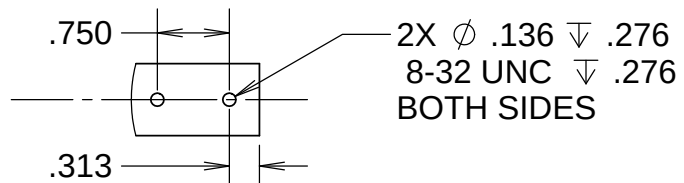
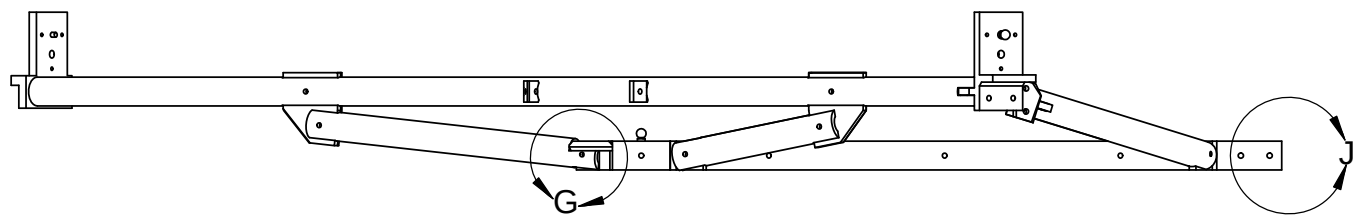
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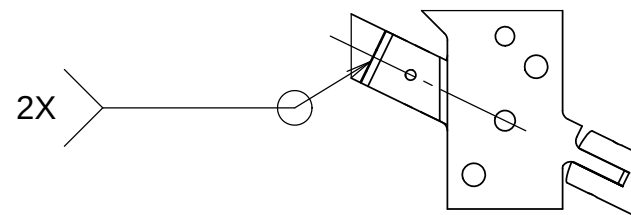
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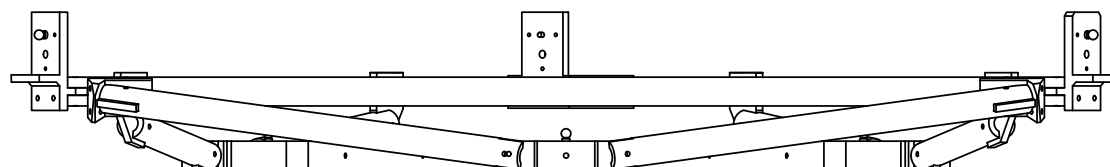
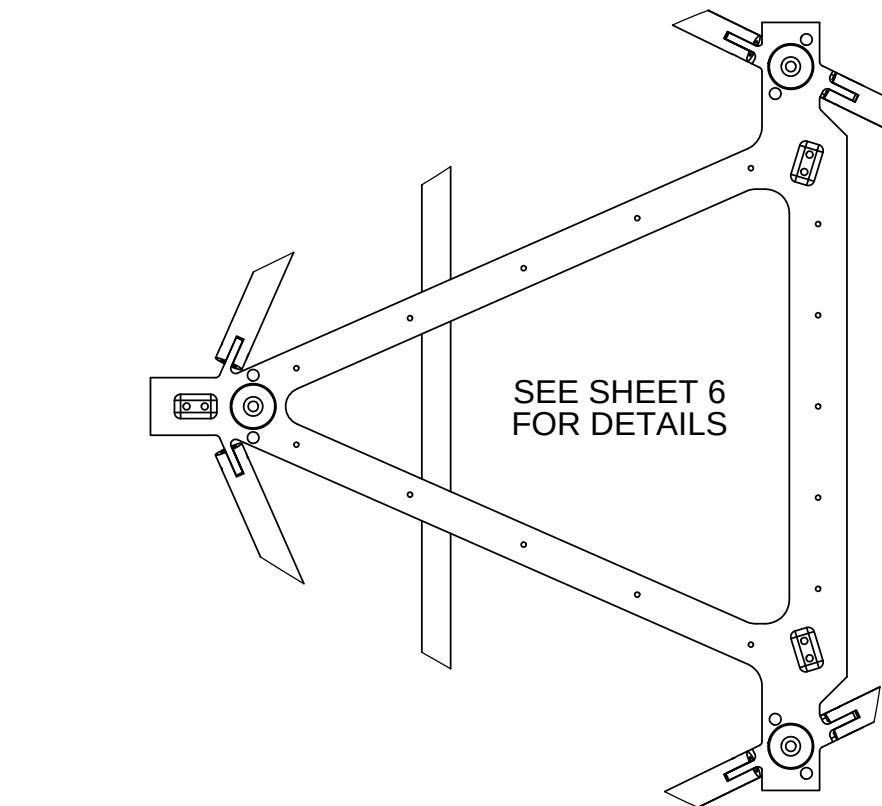
DETAIL G



DETAIL J



DETAIL F



D

C

B

A

KECK 1 DEPLOYABLE TERTIARY MIRROR MIRROR ASSEMBLY		
TITLE MIRROR FRAME WELDMENT		
PROJECT CODE --	DWG NO 872-LM4010	K 5/6
NEXT ASSY 872-LM4200		

