
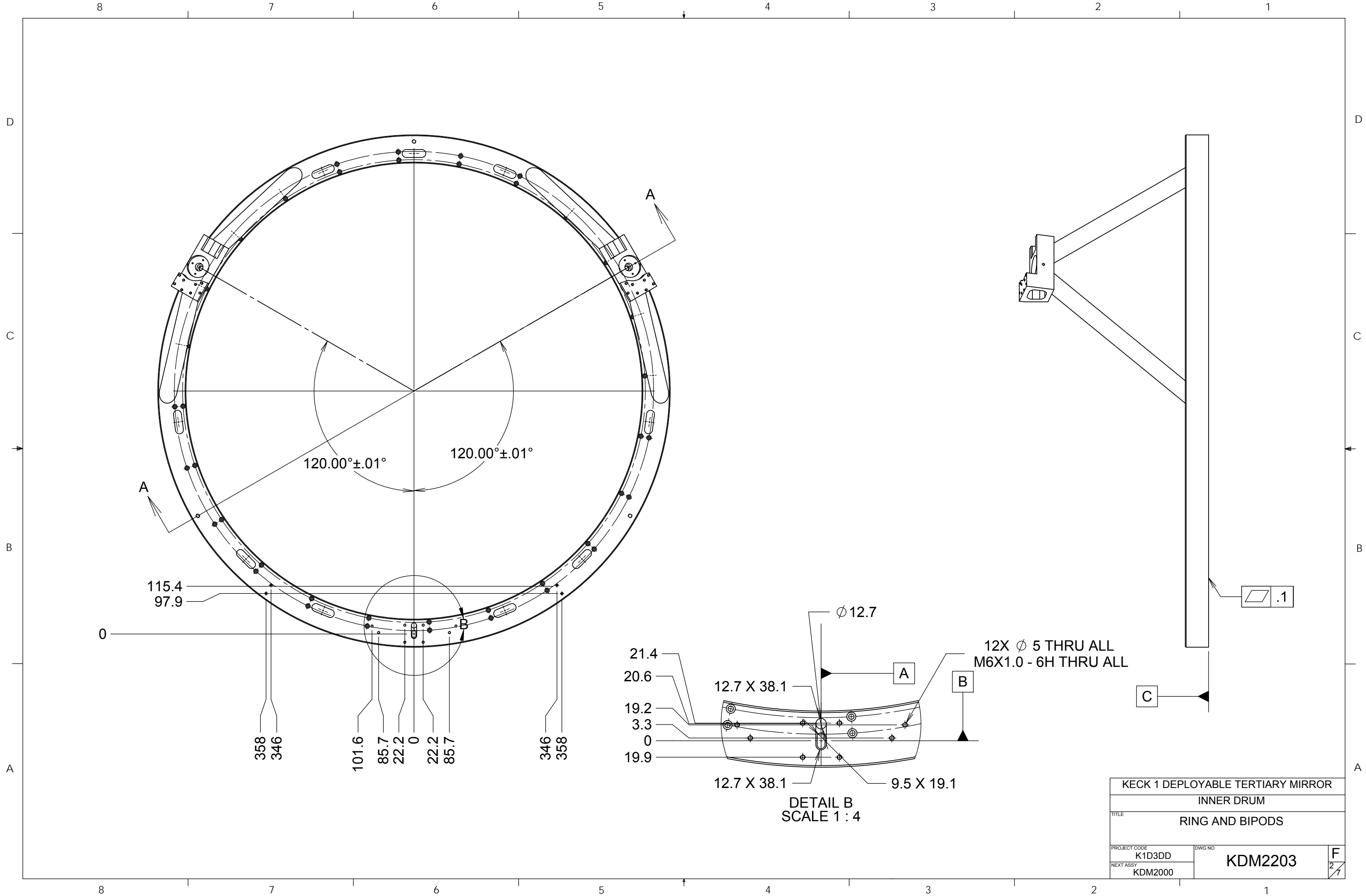


REVISIONS				
DRWN	DATE	CHK'D	REV	DESCRIPTION
CR	14FEB16		A	PRELIMINARY RELEASE
CR	29APR16		B	ADDED HOLES TO ITEMS 3 AND 4 ADDED TOLERNACES
CR	19MAY16		C	ADDED DIAMETERS FOR ITEMS 1 AND 2
CR	6JUN16		D	MODIFIED WELD NOTE, ADDED HOLE DIMS TO ITEMS 3 AND 4, ADDED HOIST RING TAPPED HOLES
CR	15JUL2016		E	ADDED PAINT SPEC AND SURFACES TO MASK
CR	10AUG16		F	ADDED MATERIAL AND MOVED HOLES IN ITEMS 3 AND 4. NOW 75MM WIDE

Weldment Cut List		
ITEM NO.	QTY.	DESCRIPTION
1	2	KDM2203-1
2	2	KDM2203-2
3	1	KDM2203-3
4	1	KDM2203-4
5	1	KDM2203-5

- NOTES:
1. GEOMETRIC TOLERANCES AND DIMENSIONS PER ASME Y14.5-2009
 2. ASTM A500 STEEL OR EQUIVALENT
 3. GEOMETRIC TOLERANCES APPLY AFTER WELDING
 4. 3-5MM FILLET WELD AT ALL INTERFACES, ALL AROUND
 5. PAINT WITH Akzo Nobel 463-3-8 Flat Black Temperature Control Epoxy Manufactured by Akzo Nobel Aerospace Corporation.
 6. 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 CHECKED NA	2-10-16 TITLE INNER DRUM	PROJECT CODE K1D3DD DWG NO KDM2203	REV F 1/7
ANGLES: ±0.5° FINISH: 3 MICRONS (µm) BREAK ALL SHARP EDGES & CORNERS .25mm MAX			DESIGNED C. RATLIFF ENGINEER C. RATLIFF	2/3/16 QUANTITY 1		
MATERIAL SEE NOTE 2	FINISH --		SW DOCUMENT FILE KDM2203.SLDPRT			



115.4
97.9
0

358 346
101.6 85.7 22.2 0 22.2 85.7
346 358

21.4
20.6
19.2
3.3
0
19.9

12.7 X 38.1

Ø 12.7

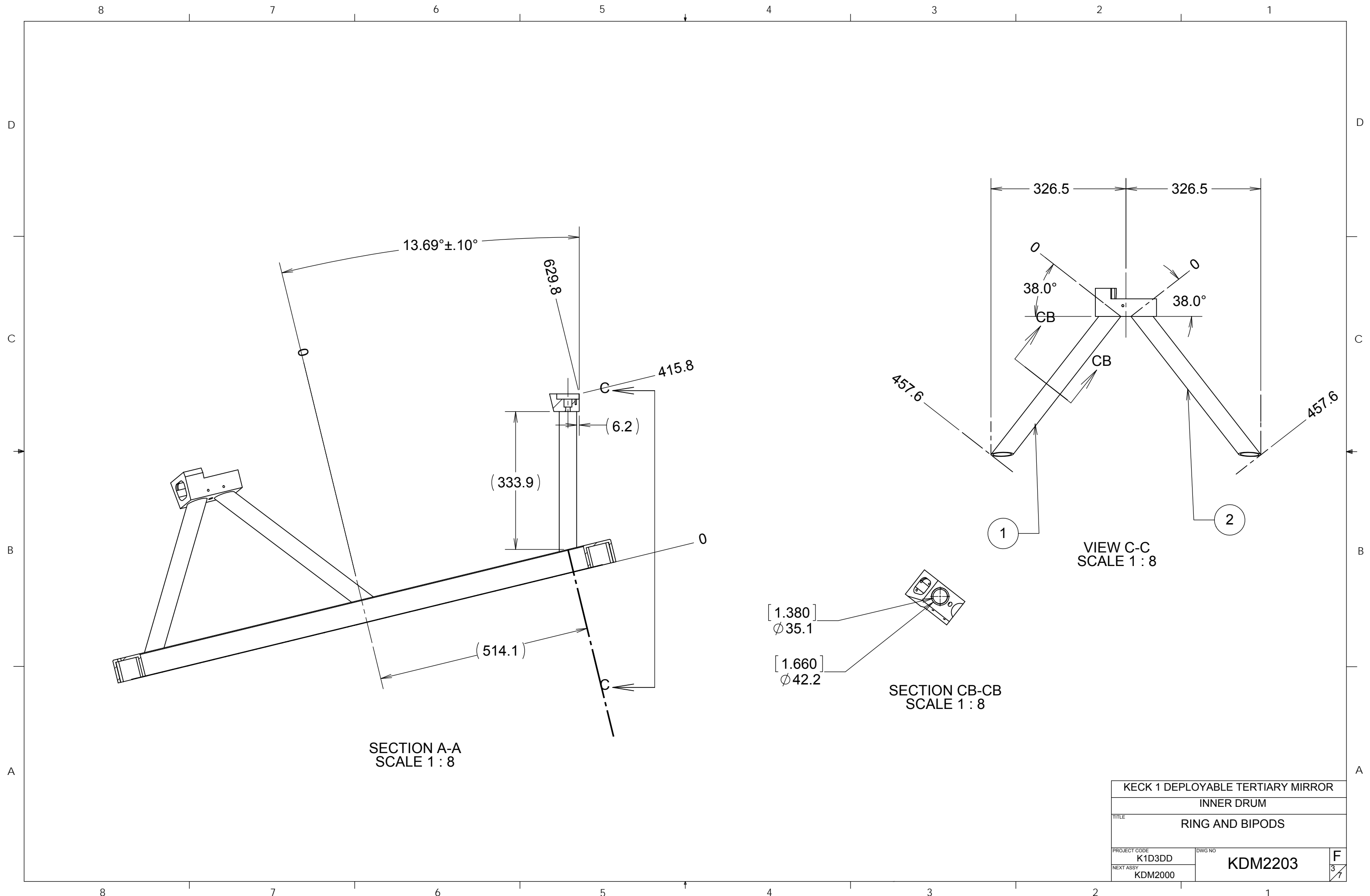
12.7 X 38.1

9.5 X 19.1

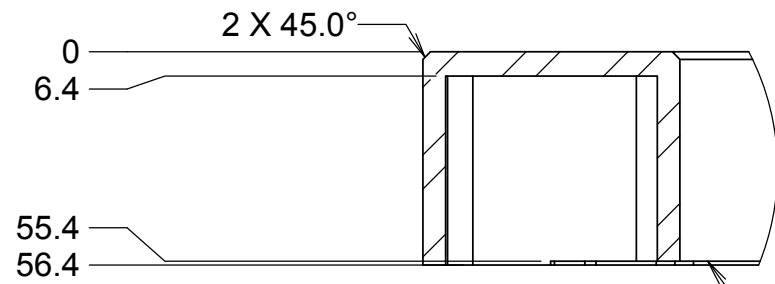
12X Ø 5 THRU ALL
M6X1.0 - 6H THRU ALL

DETAIL B
SCALE 1 : 4

KECK 1 DEPLOYABLE TERTIARY MIRROR	
INNER DRUM	
TITLE RING AND BIPODS	
PROJECT CODE K1D3DD	DWG NO KDM2203
NEXT ASSY KDM2000	F 2/7

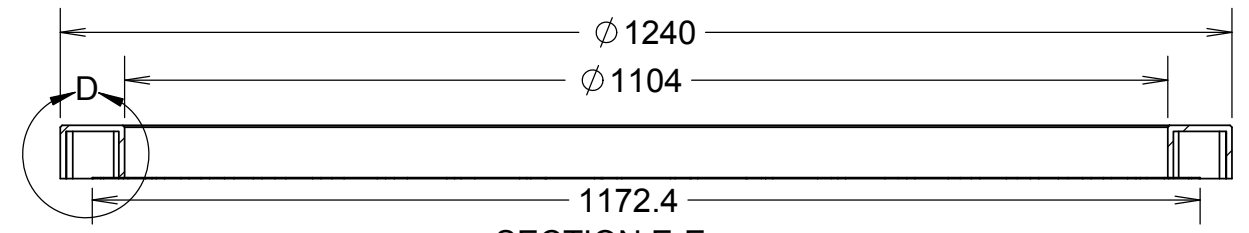


KECK 1 DEPLOYABLE TERTIARY MIRROR		
INNER DRUM		
TITLE RING AND BIPODS		
PROJECT CODE K1D3DD	DWG NO KDM2203	F 3/7
NEXT ASSY KDM2000		



DETAIL D
SCALE 1 : 2

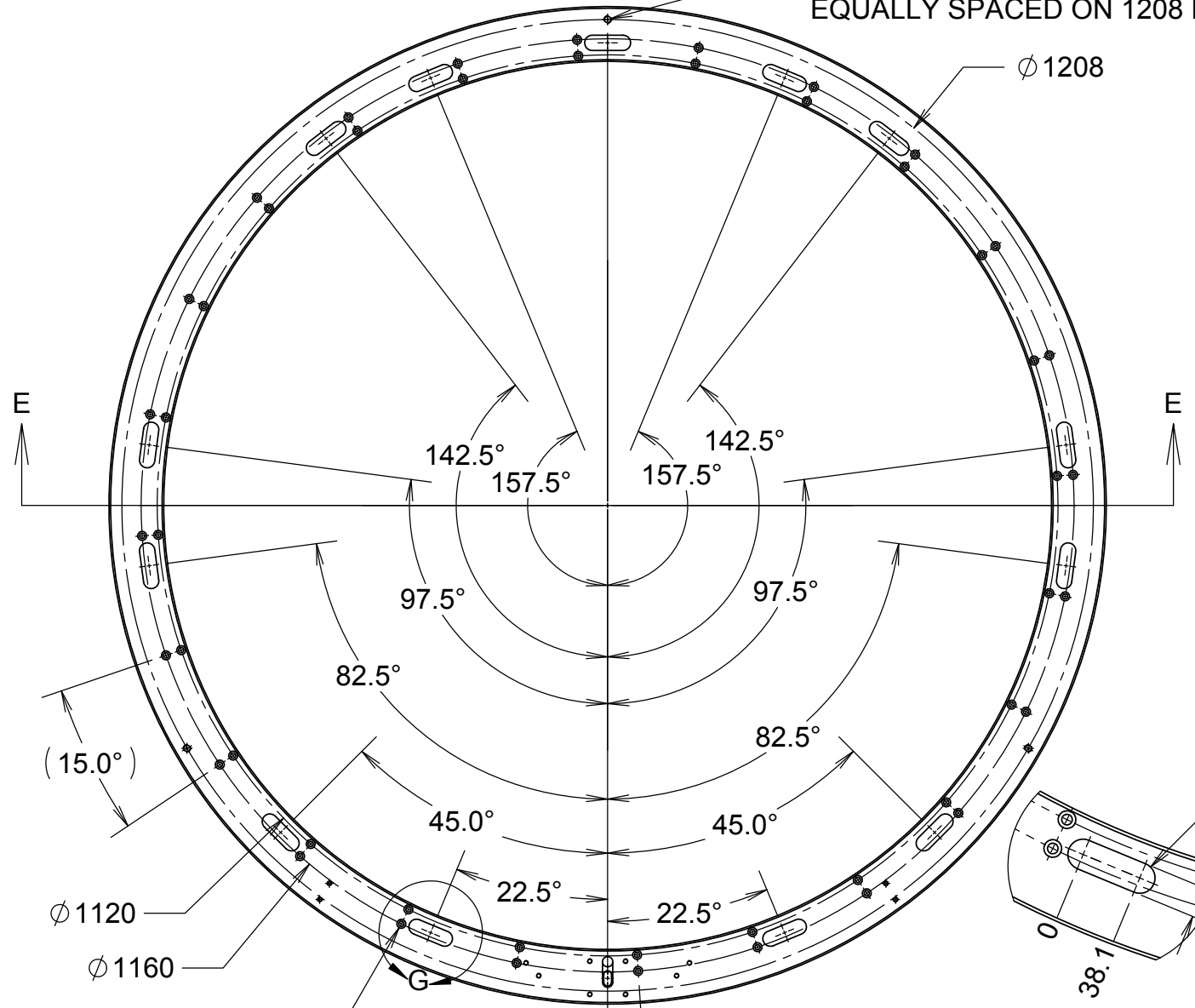
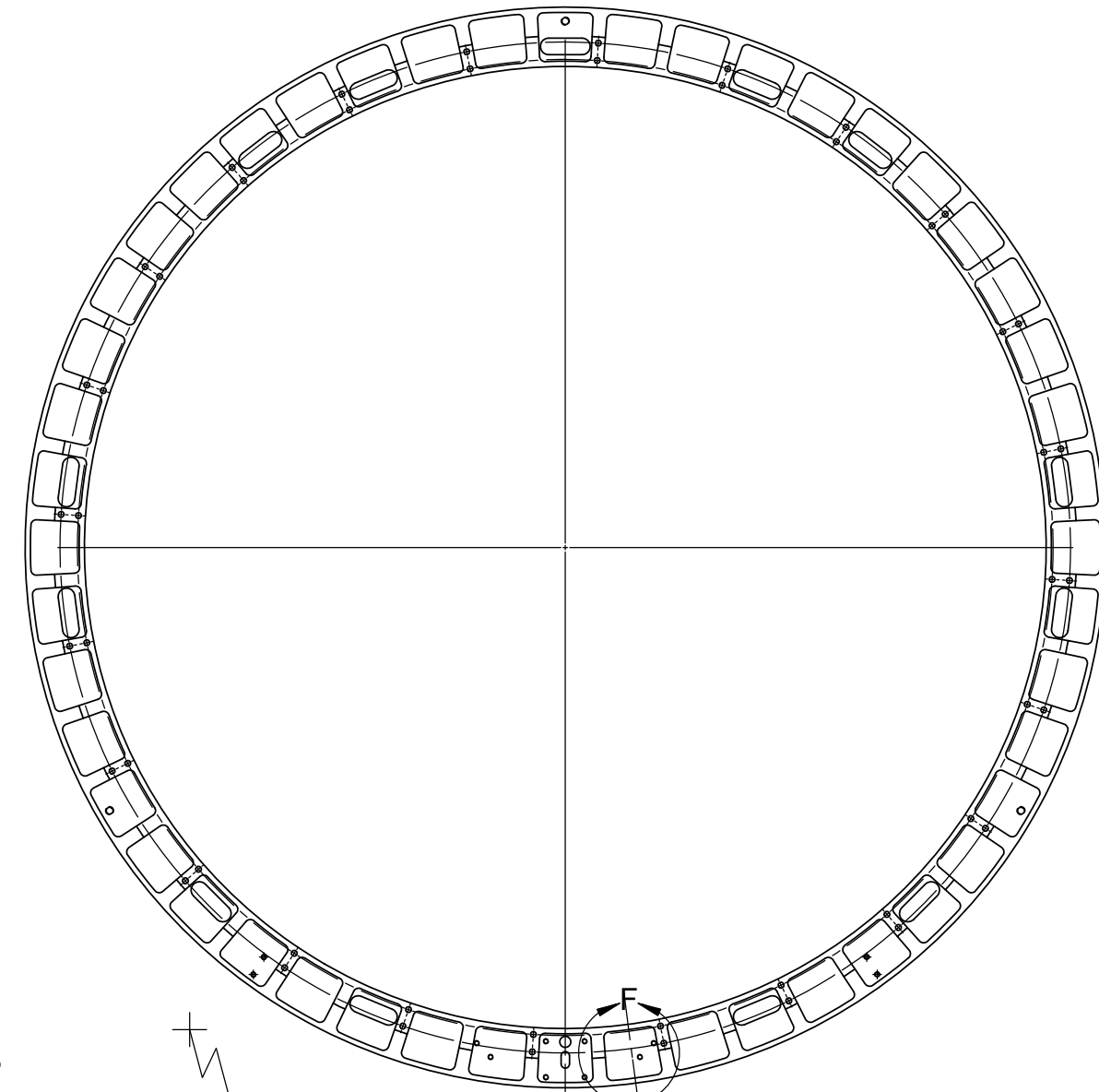
\parallel .05 C



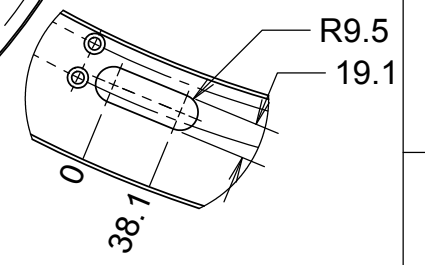
SECTION E-E
SCALE 1 : 8

3X ϕ 7.9 THRU ALL
3/8-16 UNC THRU ALL
EQUALLY SPACED ON 1208 B.C.

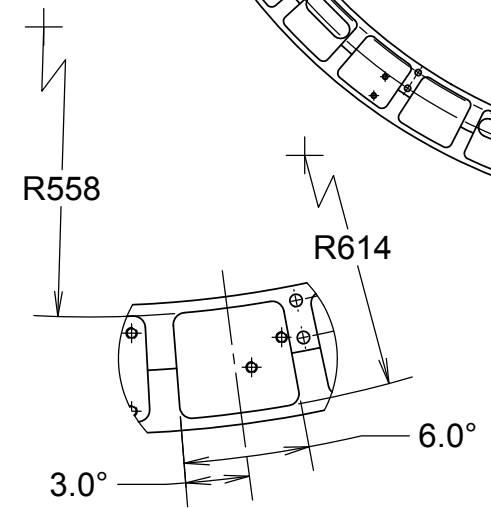
ϕ 1208



48X ϕ 6.6 THRU ALL
 \square ϕ 11 ∇ 6
EQUALLY SPACED WITHIN 0.25
ON BOLT CIRCLES SHOWN



DETAIL G
SCALE 1 : 4



DETAIL F
SCALE 1 : 4

KECK 1 DEPLOYABLE TERTIARY MIRROR	
INNER DRUM	
TITLE RING AND BIPODS	
PROJECT CODE K1D3DD	DWG NO KDM2203
NEXT ASSY KDM2000	F 4/7

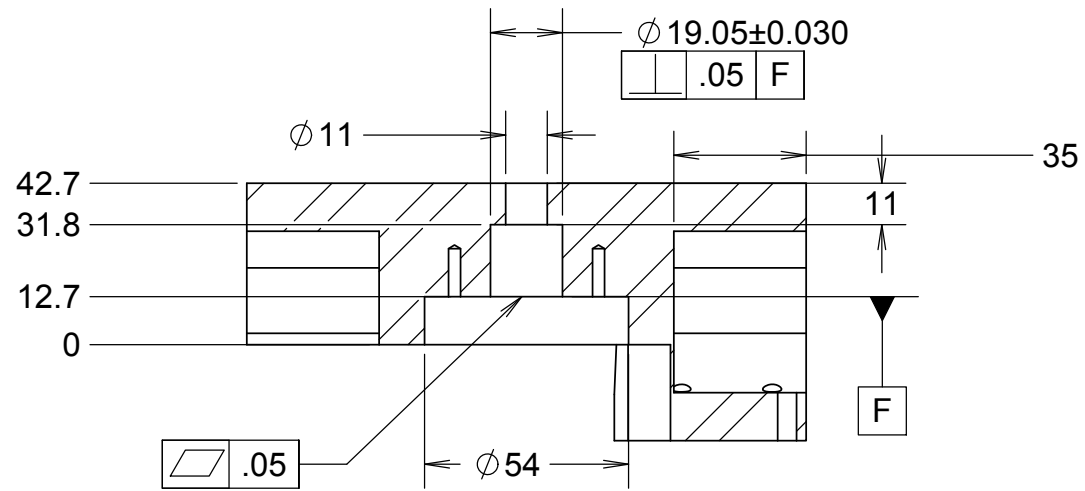
8 7 6 5 4 3 2 1

D
C
B
A

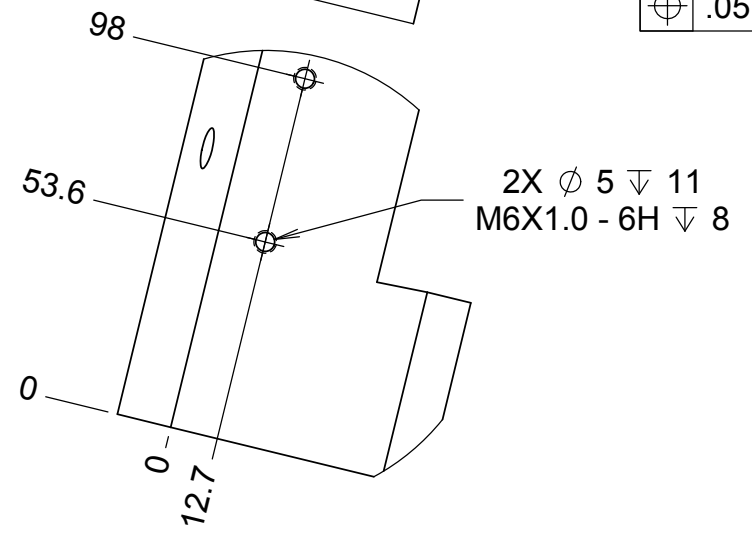
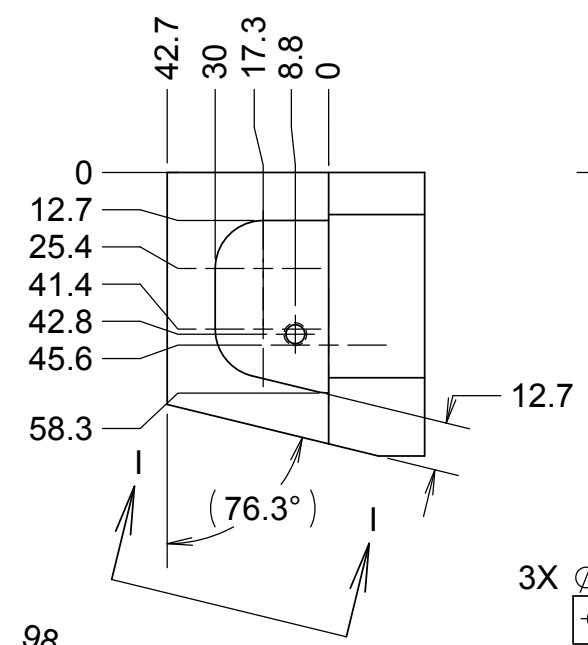
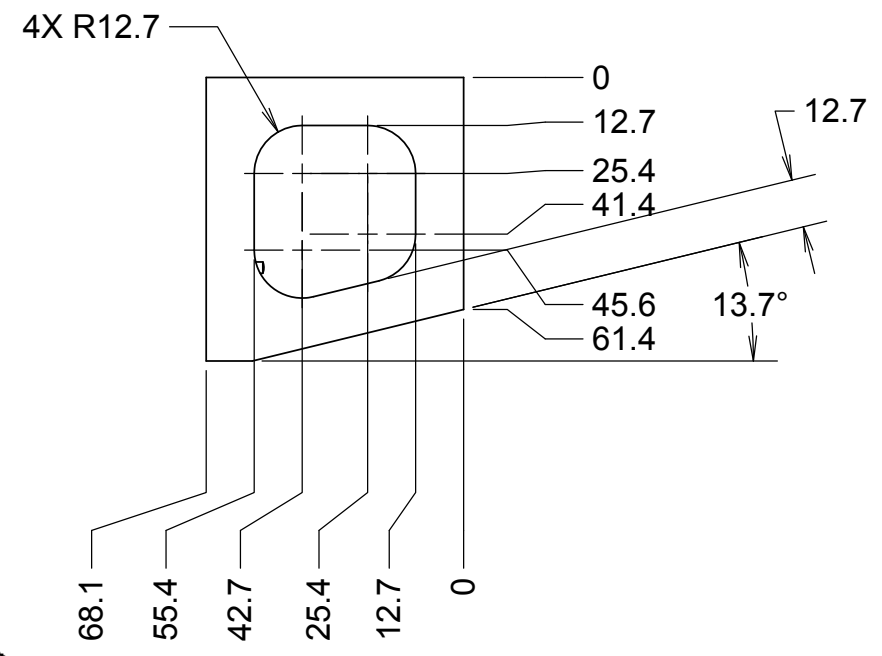
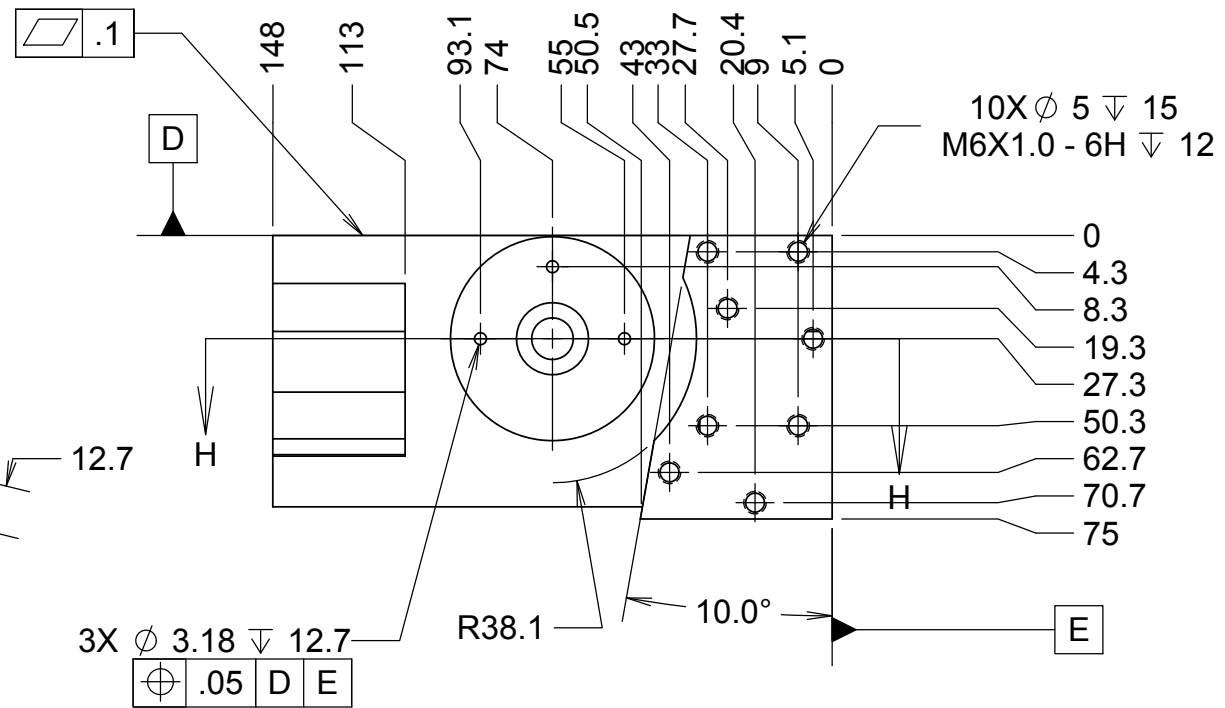
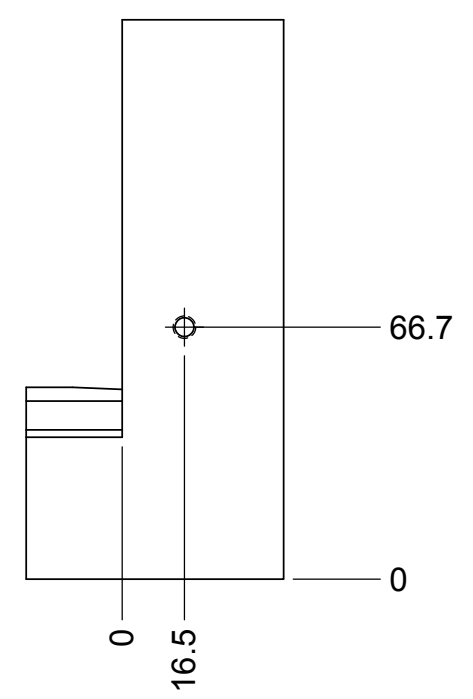
A

8 7 6 5 4 3 2 1

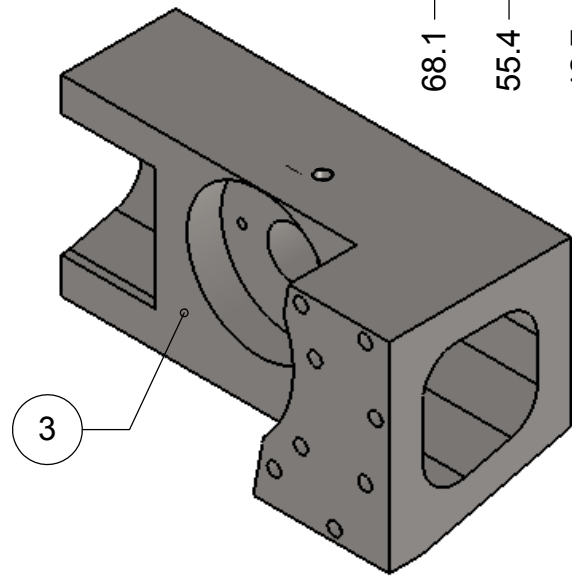
A



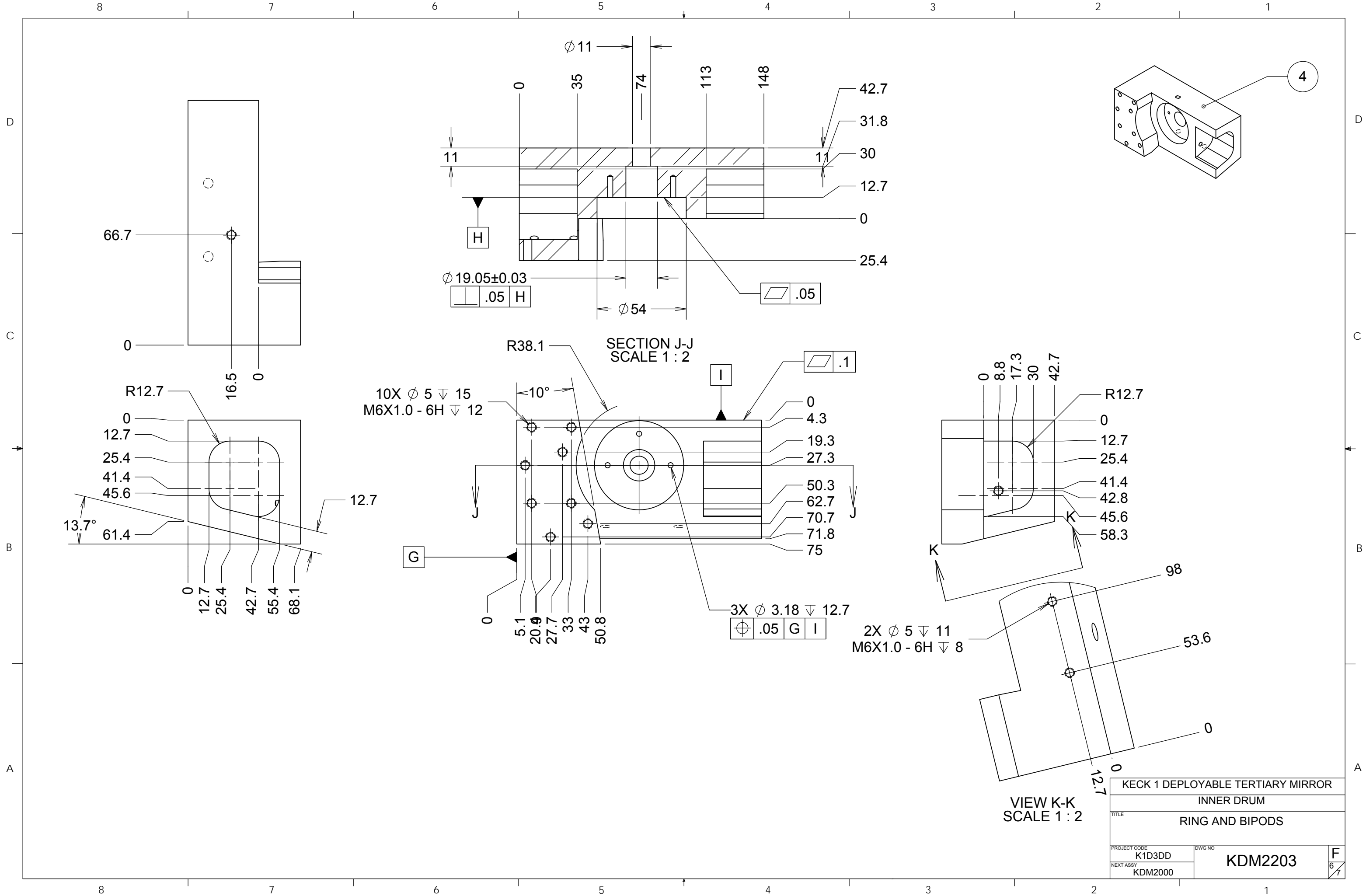
SECTION H-H
SCALE 1 : 2



VIEW I-I
SCALE 1 : 2



PROJECT CODE		DWG NO	
K1D3DD		KDM2203	
NEXT ASSY		F	
KDM2000		5/7	



PROJECT CODE		DWG NO
K1D3DD		KDM2203
NEXT ASSY		
KDM2000		
TITLE		F
KECK 1 DEPLOYABLE TERTIARY MIRROR INNER DRUM RING AND BIPODS		6/7

