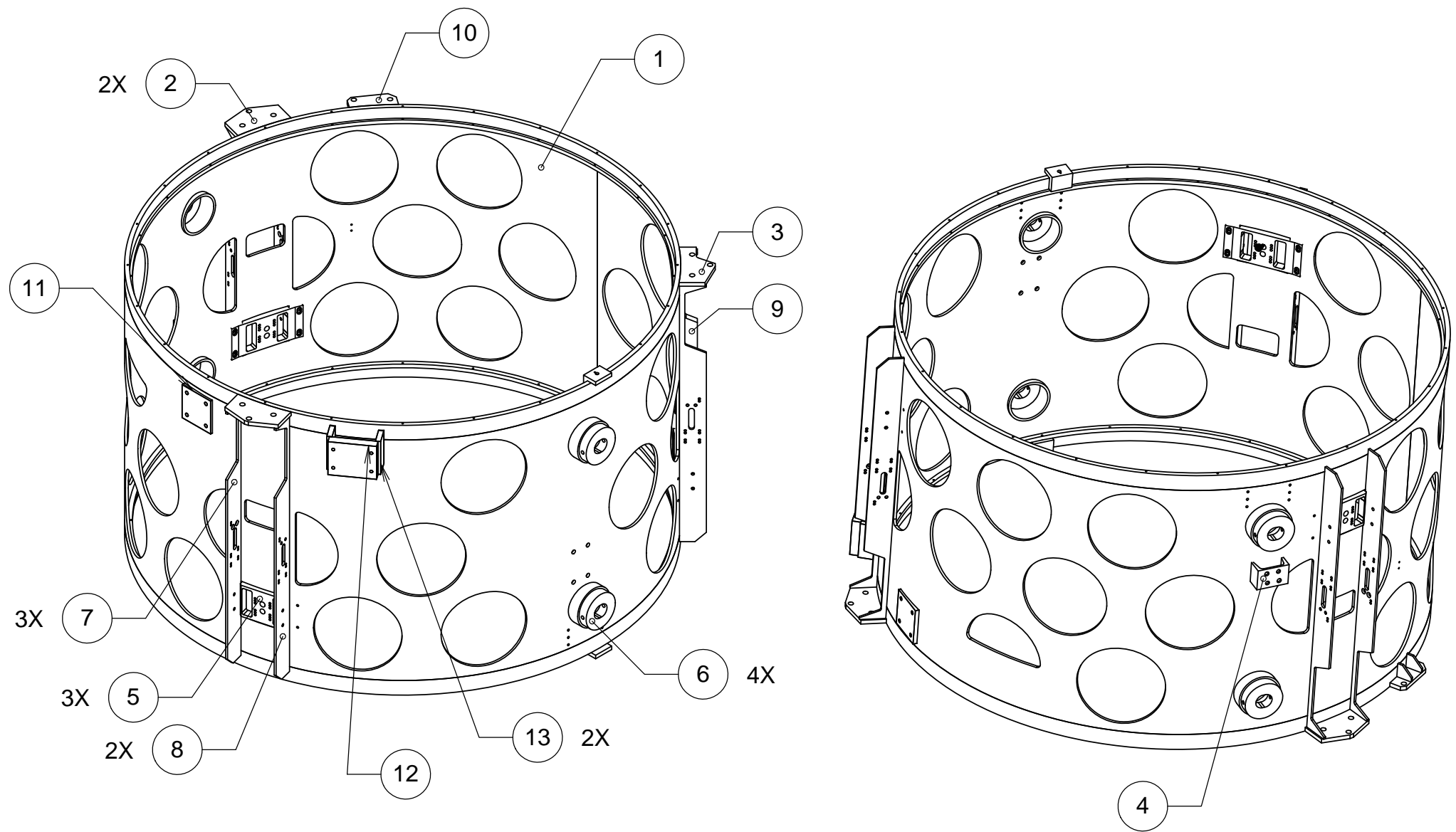


8 7 6 5 4 3 2 1

D
C
B
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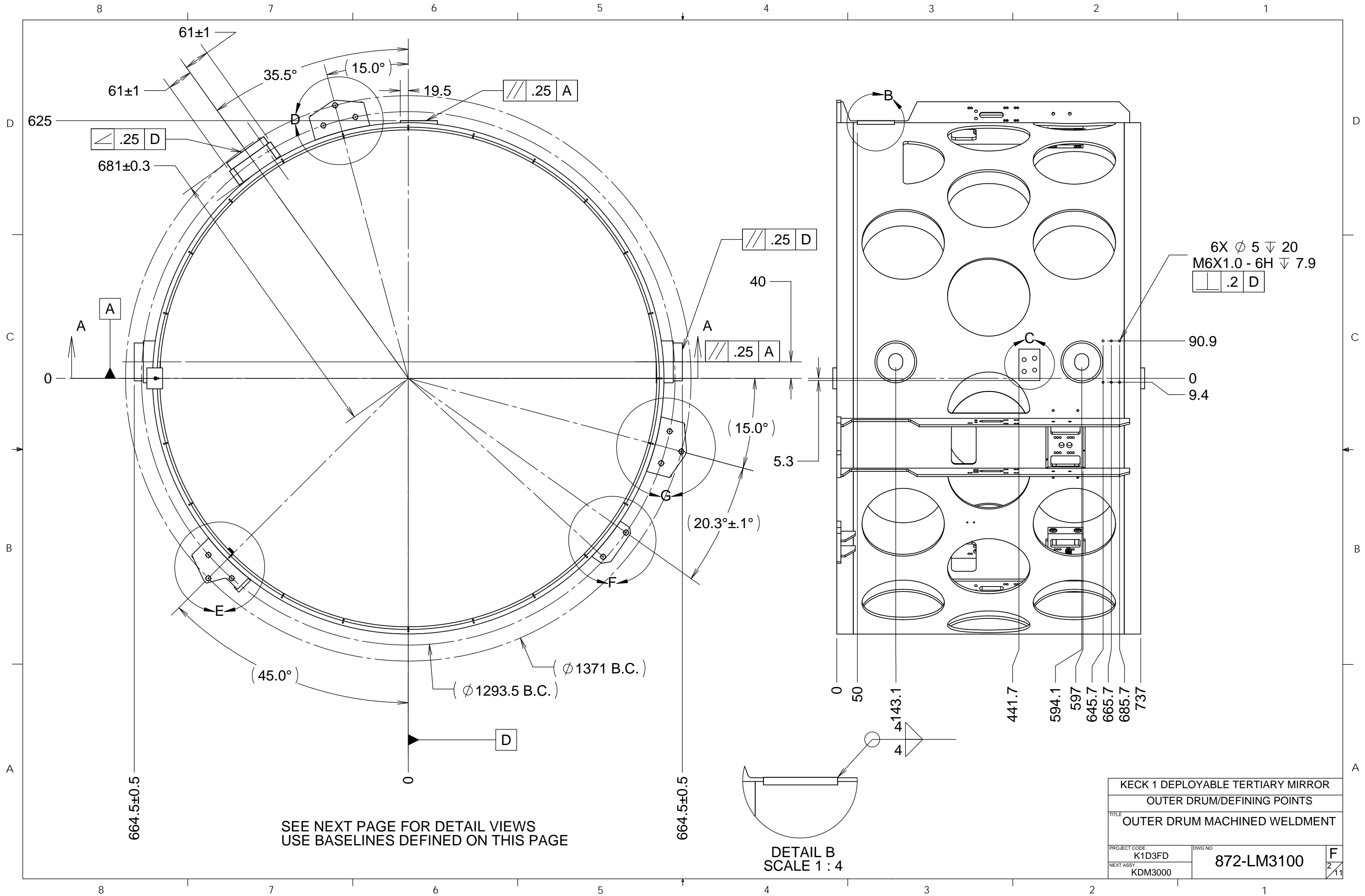
REVISIONS				
DRWN	DATE	CHK'D	REV	DESCRIPTION
CR	22APR15		A	PRELIMINARY RELEASE
CR	24APR15		B	FIXED NOTES, TITLE, VIEW CALLOUTS PER JC
CR	29MAY 15		C	MOVED DATUM A, RELAXED SOME TOLERANCES, REVISED ITEM 5
CR	5JUN15		D	DIMENSIONED AND TOLERANCED CERTAIN SURFACES AND HOLES IN POST WELDED STATE
CR	22MAR16		E	PAGE 5, D4, ADDED 48 HOLES FOR REMOVAL OF KAYDON BEARINGS
CR	12MAY17		F	ADDED HOLES FOR ALIGNMENT TOOLING

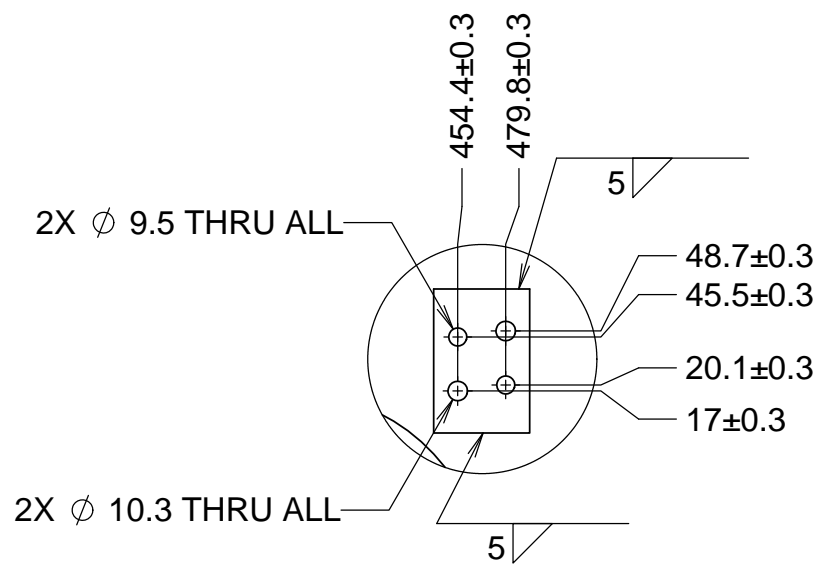
ITEM NO.	PartNo	DESCRIPTION	QTY.
1	KDM3100-1	ROLLED OUTER DRUM PLATE	1
2	KDM3100-2	COUNTER WEIGHT MOUNT	2
3	KDM3100-3	CUT COUNTERWEIGHT MOUNT	1
4	KDM3100-4	SEISMIC RESTRAINT	1
5	KDM3100-5	DEFINING POINT INTERFACE PLATE	3
6	KDM-3100-6	ROLLER SUPPORT	4
7	KDM3100-7	REINFORCING RIB C	3
8	KDM3100-8	REINFORCING RIB B	2
9	KDM3100-9	REINFORCING RIB A	1
10	KDM3100-10	INNER DRUM POSITION MOUNT	1
11	KDM3100-11	CHAIN DRIVE MOUNT	1
12	KDM3100-12	INNER DRUM SERVO MOUNT	1
13	KDM3100-13	INNER DRUM SERVO MOUNT PLATE B	2
15	872-LM2218	OUTER DRUM JIG	2
16	872-LM8215	JACKING SCREW, .535-40	1

- 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, EXCEPT ITEM 5, WELDING ITEM 5 WILL BE AFTER FIT TO TELESCOPE. ITEM 5 IS A SEPARATE PART THAT SHOULD BE FABRICATED AND FASTENED INTO PLACE WITH SCREWS AND MEET TOLERANCES SHOWN ON PAGE 3, IT WILL BE WELDED INTO PLACE AFTER FIT TO TELESCOPE
 4. PAINT WITH AMERCOAT 385 BLACK RESIN AND AMERCOAT 385 CURE MIX 50/50 BY VOLUME, FOR DETAILS REFER TO UCO LICK DOCUMENT D0938 PROVIDED BY UCO/LICK THREE STEP PROCESS. 1)WELD, ANNEAL AND PAINT, 2)FIT TO TELESCOPE (1-2 MONTHS DURATION), 3)WELD ITEM 5 AND MACHINE PRECISION SURFACES LAST
 5. ITEMS 2, 3, 5, 6, 10, AND 11 CAN START THICKER THAN THE NOMINAL THICKNESS DIMENSIONS AND MACHINED AFTER WELDING TO TOLERANCES SPECIFIED IN THIS DRAWING
 6. FLATNESS APPLIES TO 120MM WIDE AREA BETWEEN STIFFENING RIBS
 7. STIFFENING RIBS TO BE WELDED ALONG THEIR FULL LENGTH
 8. ITEMS 2, 3 AND 10 TO BE WELDED TO ITEMS 1, 7, 8 AND 9 WITH 3-5 MM FILLET WELDS AT ALL INTERFACES

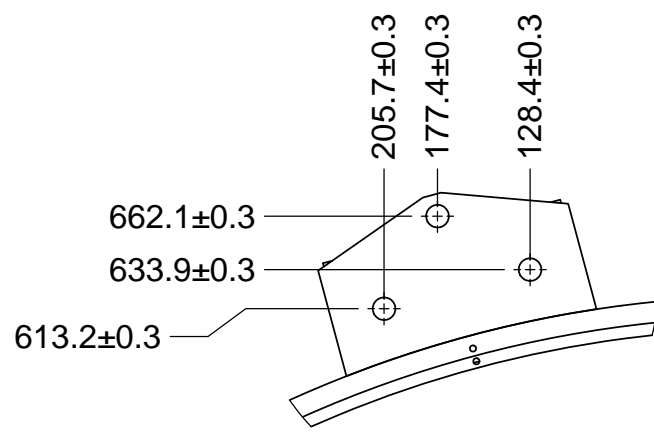
UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES & TOLERANCES ARE AS FOLLOWS X.X: ±0.1000" X.XX: ±0.0100" X.XXX: ±0.0050" X.XXXX: ±0.0001" ANGLES: ±0.5° FINISH: 125 MICRO INCHES BREAK ALL SHARP EDGES & CORNERS .002" MAX			DRAWN C. RATLIFF CHECKED JC, BR, JW, TW DESIGNED CR ENGINEER	KECK 1 DEPLOYABLE TERTIARY MIRROR OUTER DRUM/DEFINING POINTS TITLE OUTER DRUM MACHINED WELDMENT	
MATERIAL SEE NOTE 2	FINISH --		SW DOCUMENT FILE OUTER DRUM MACHINED WELDMENT	QUANTITY 1	PROJECT CODE K1D3FD NEXT ASSY KDM3000

8 7 6 5 4 3 2 1

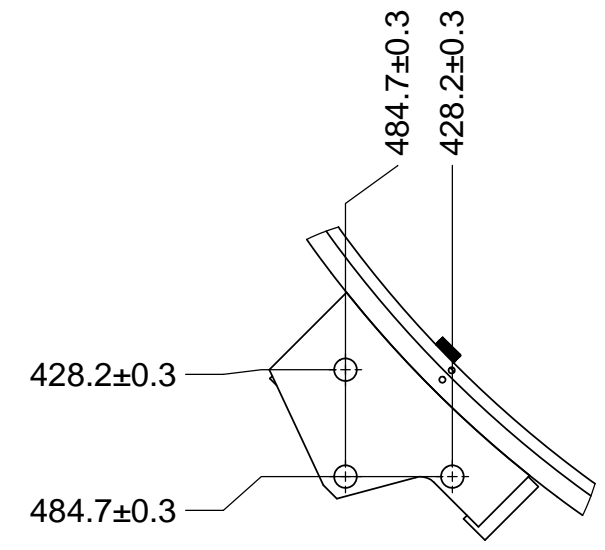




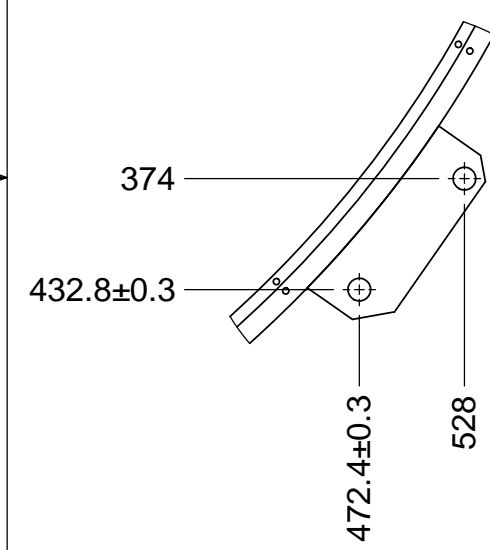
DETAIL C
SCALE 1 : 4



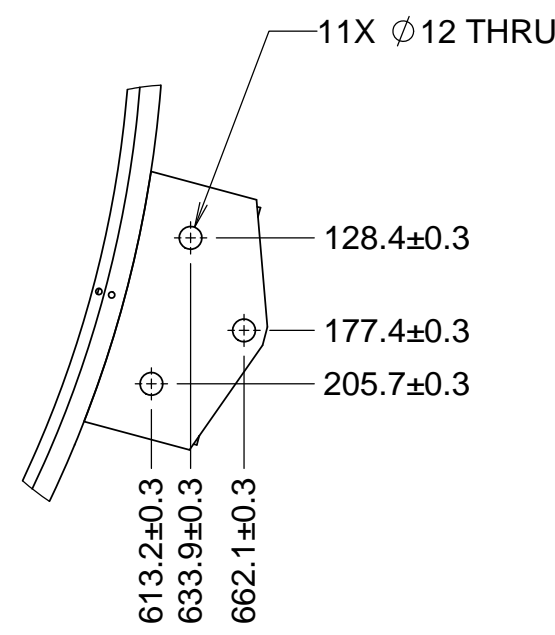
DETAIL D
SCALE 1 : 4



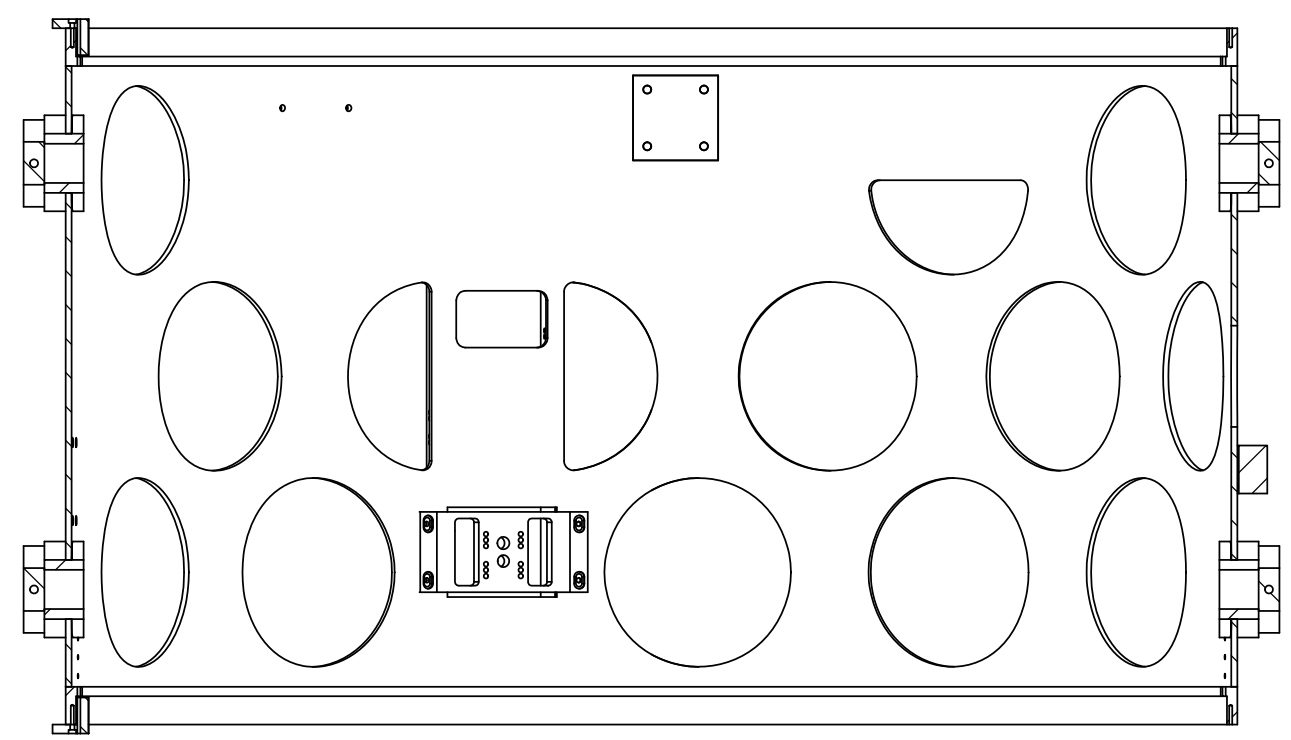
DETAIL E
SCALE 1 : 4



DETAIL F
SCALE 1 : 4



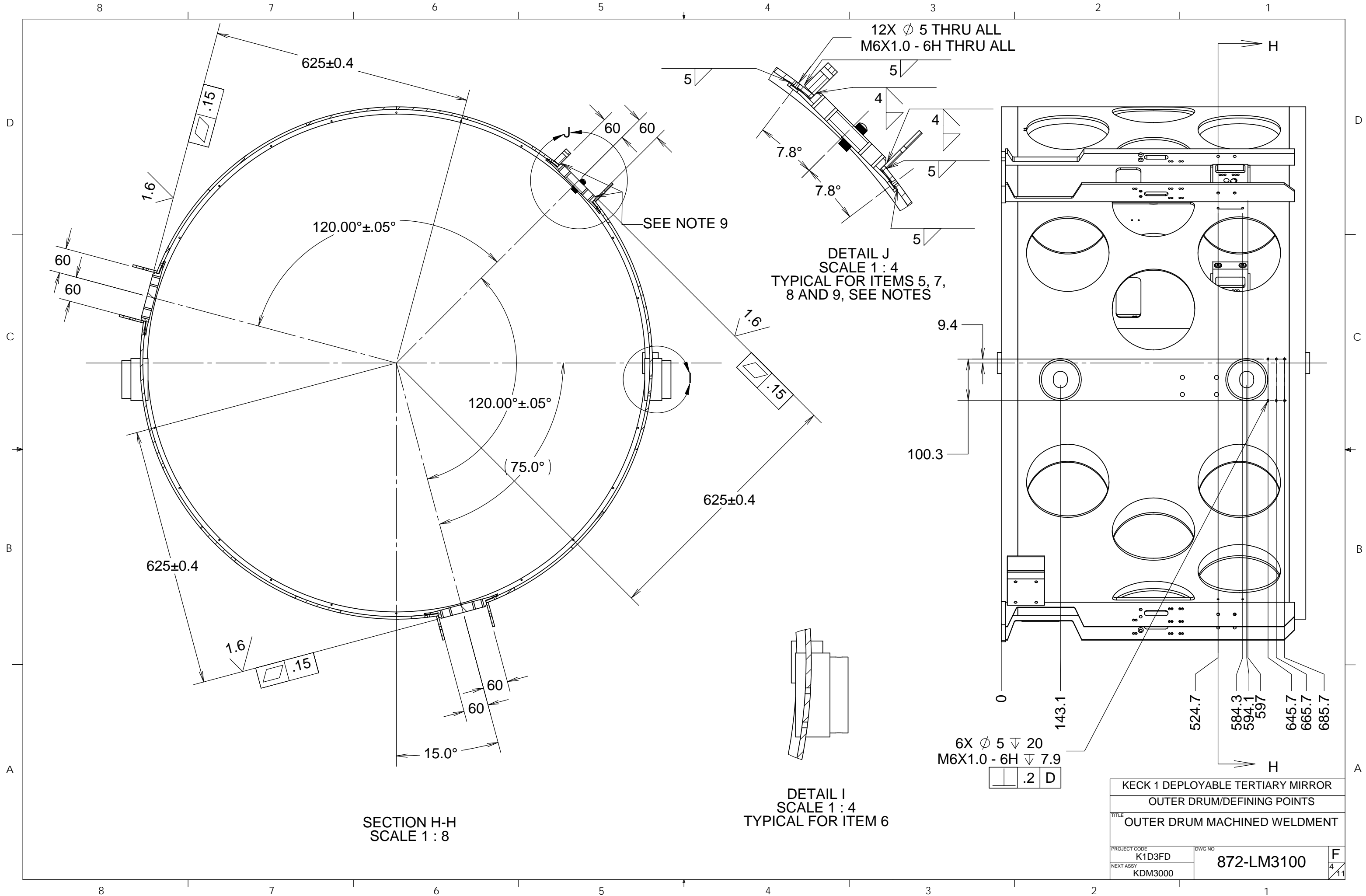
DETAIL G
SCALE 1 : 4



SECTION A-A
SCALE 1 : 8

KECK 1 DEPLOYABLE TERTIARY MIRROR
OUTER DRUM/DEFINING POINTS
TITLE
OUTER DRUM MACHINED WELDMENT

PROJECT CODE K1D3FD	DWG NO 872-LM3100	F 3 11
NEXT ASSY KDM3000		



12X Ø 5 THRU ALL
M6X1.0 - 6H THRU ALL

DETAIL J
SCALE 1 : 4
TYPICAL FOR ITEMS 5, 7,
8 AND 9, SEE NOTES

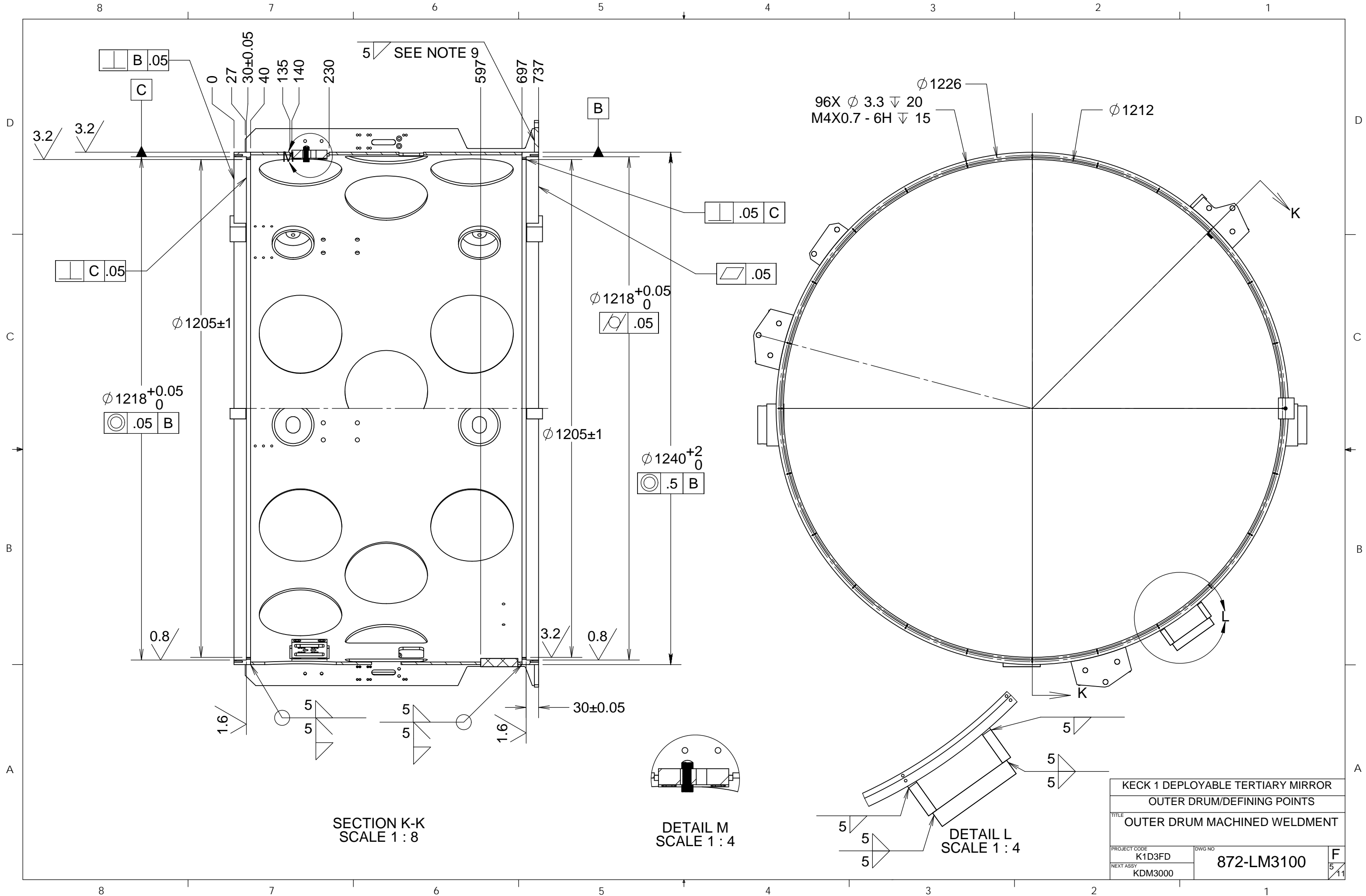
DETAIL I
SCALE 1 : 4
TYPICAL FOR ITEM 6

SECTION H-H
SCALE 1 : 8

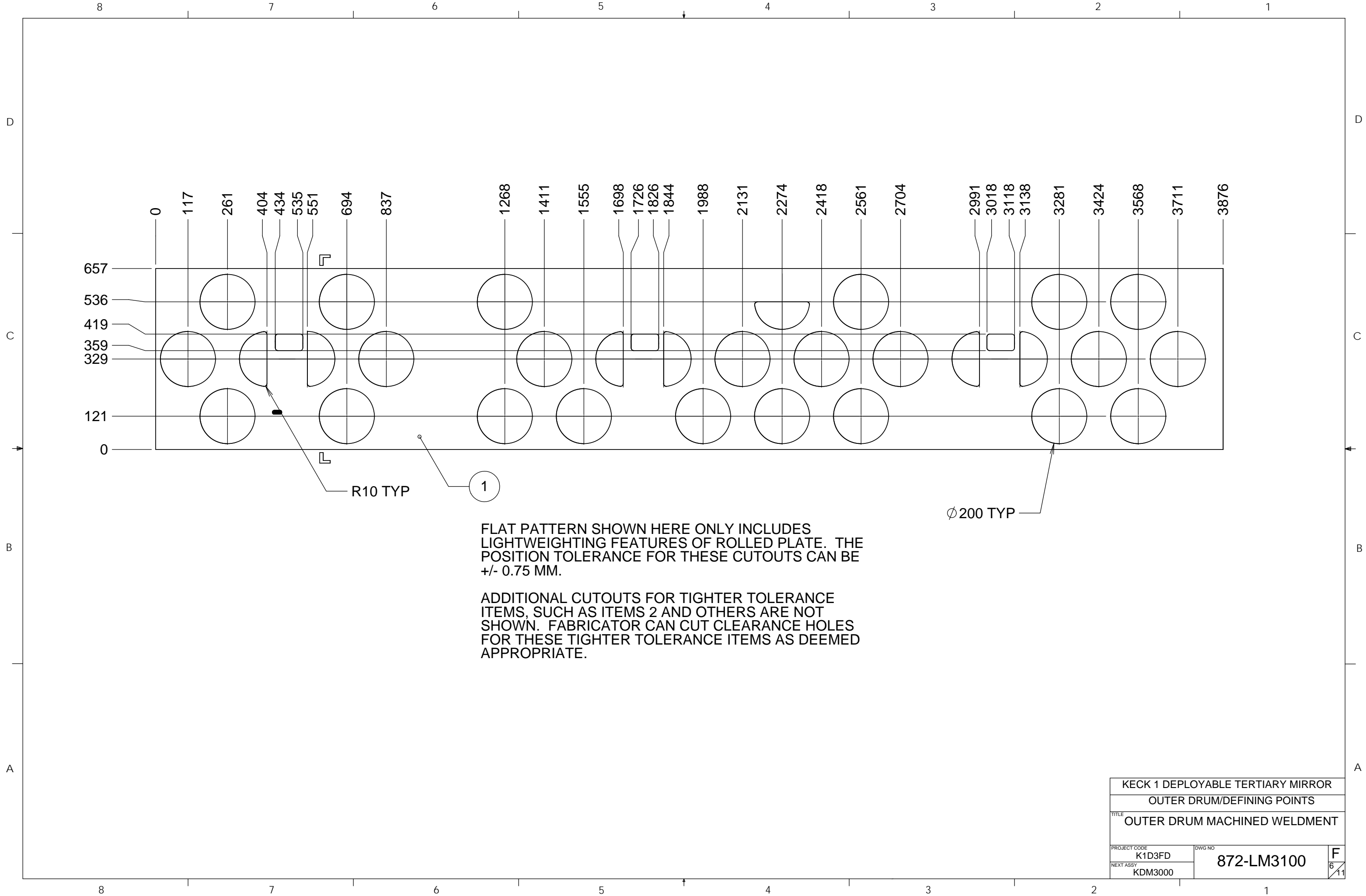
6X Ø 5 ∇ 20
M6X1.0 - 6H ∇ 7.9
□ .2 D

KECK 1 DEPLOYABLE TERTIARY MIRROR
OUTER DRUM/DEFINING POINTS
TITLE
OUTER DRUM MACHINED WELDMENT

PROJECT CODE K1D3FD	DWG NO 872-LM3100	F 4 11
NEXT ASSY KDM3000		



PROJECT CODE		DWG NO
K1D3FD		872-LM3100
NEXT ASSY		
KDM3000		
TITLE		F
KECK 1 DEPLOYABLE TERTIARY MIRROR OUTER DRUM/DEFINING POINTS		5/11
OUTER DRUM MACHINED WELDMENT		

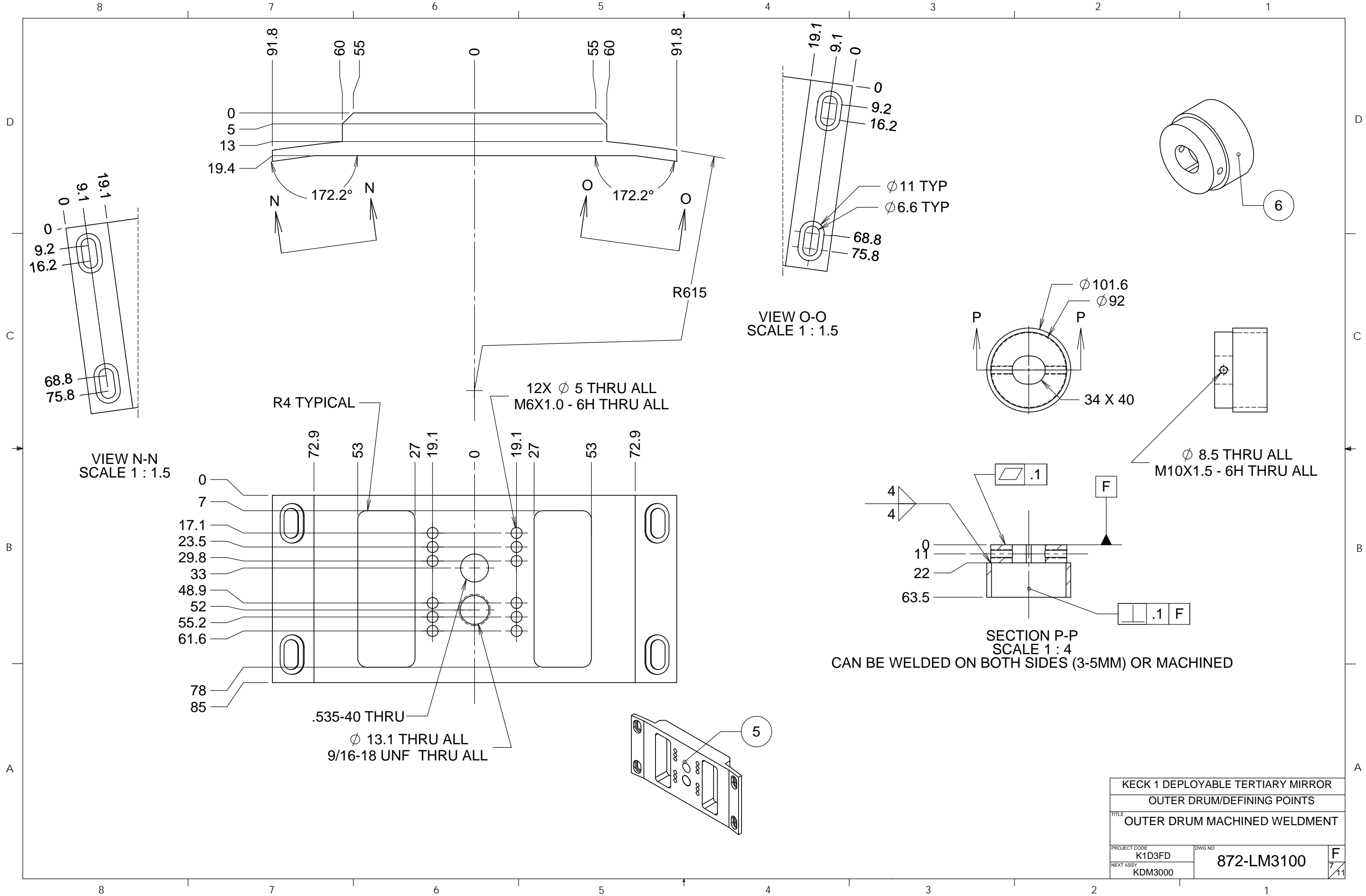


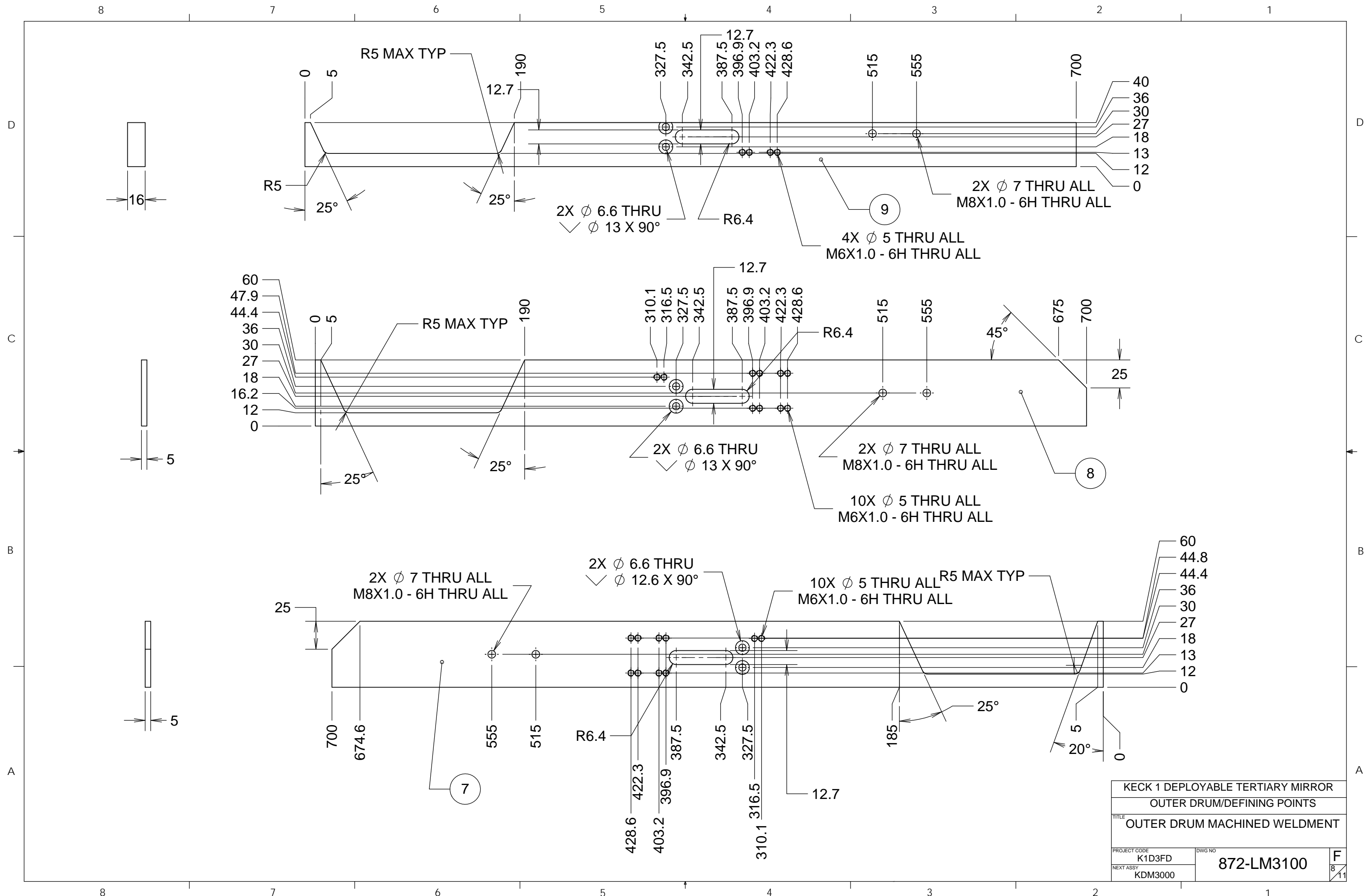
FLAT PATTERN SHOWN HERE ONLY INCLUDES LIGHTWEIGHTING FEATURES OF ROLLED PLATE. THE POSITION TOLERANCE FOR THESE CUTOUTS CAN BE +/- 0.75 MM.

ADDITIONAL CUTOUTS FOR TIGHTER TOLERANCE ITEMS, SUCH AS ITEMS 2 AND OTHERS ARE NOT SHOWN. FABRICATOR CAN CUT CLEARANCE HOLES FOR THESE TIGHTER TOLERANCE ITEMS AS DEEMED APPROPRIATE.

KECK 1 DEPLOYABLE TERTIARY MIRROR
 OUTER DRUM/DEFINING POINTS
 TITLE
 OUTER DRUM MACHINED WELDMENT

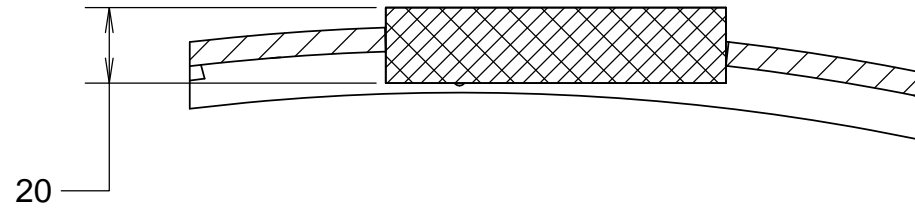
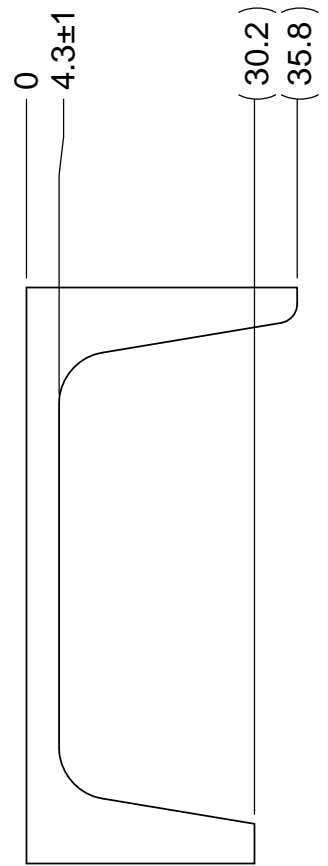
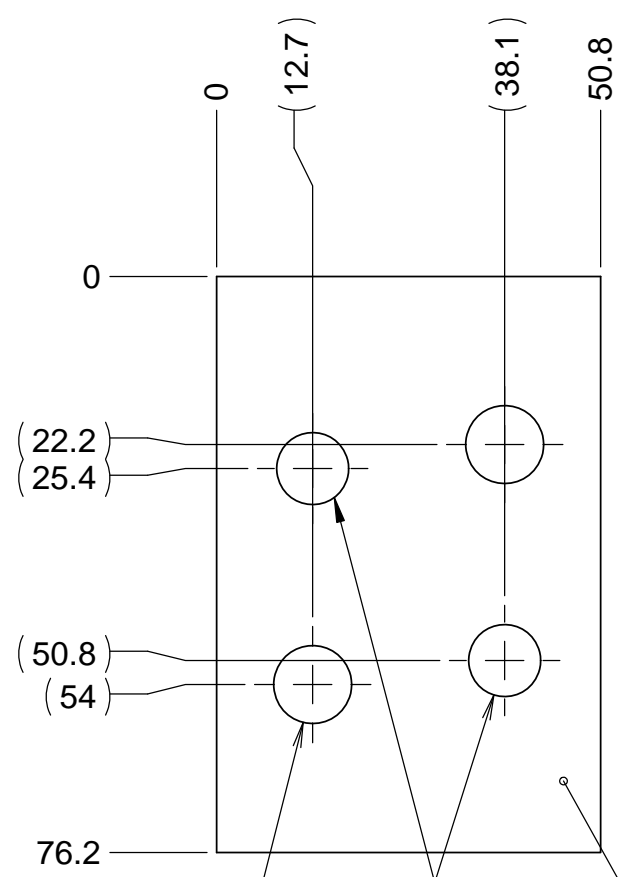
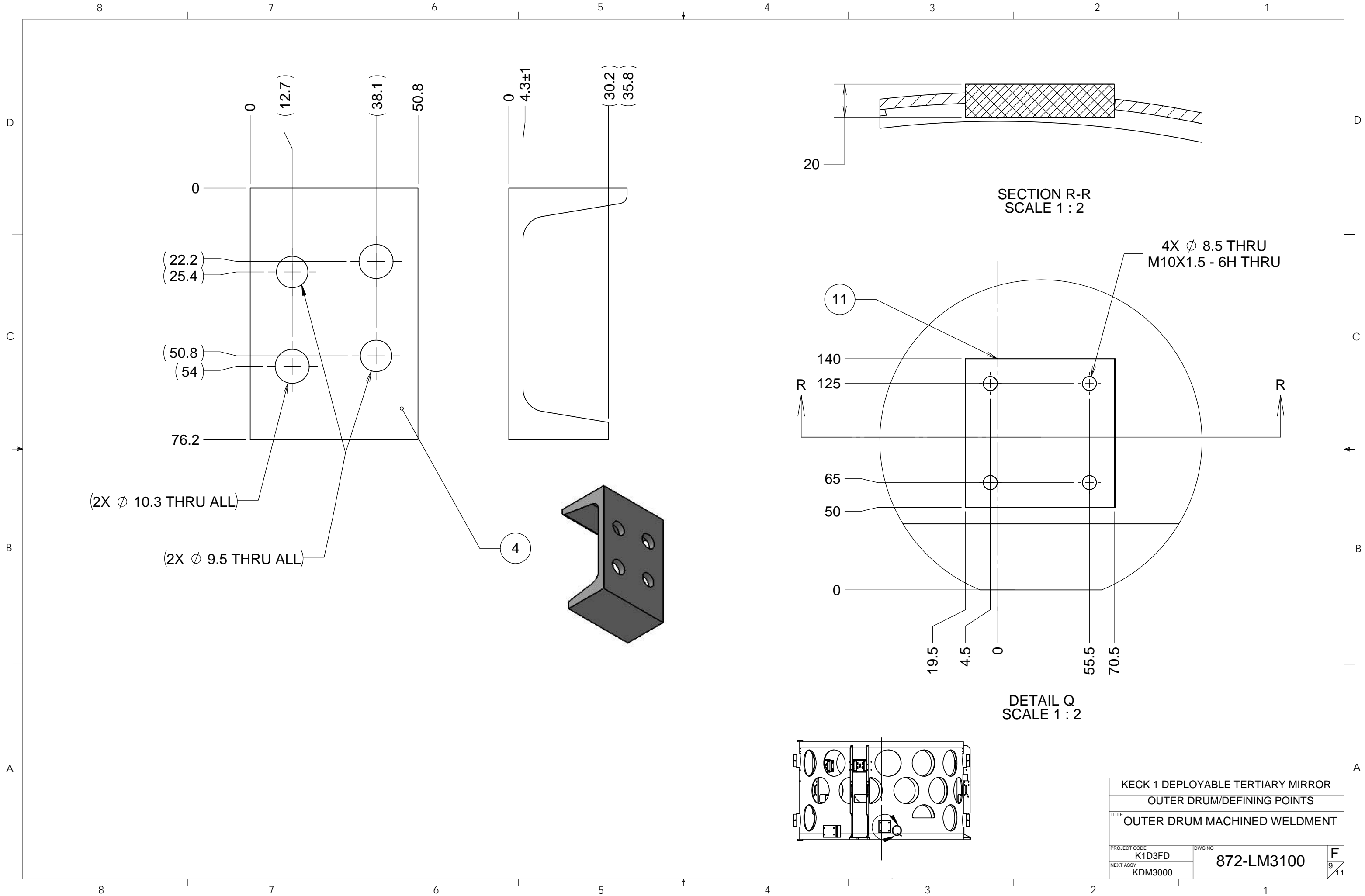
PROJECT CODE K1D3FD	DWG NO 872-LM3100	F 6/11
NEXT ASSY KDM3000		





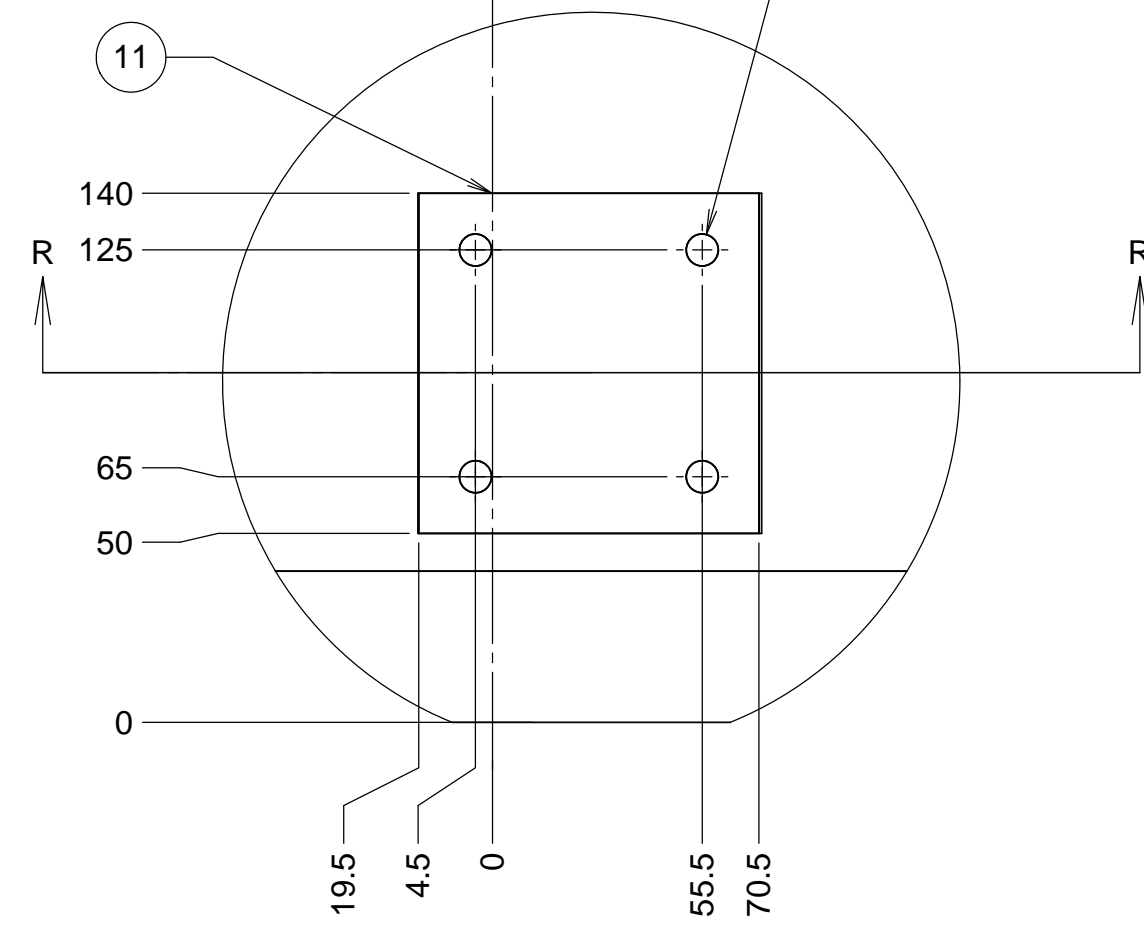
PROJECT CODE		DWG NO	
K1D3FD		872-LM3100	
NEXT ASSY		F	
KDM3000		8/11	

KECK 1 DEPLOYABLE TERTIARY MIRROR
 OUTER DRUM/DEFINING POINTS
 TITLE
 OUTER DRUM MACHINED WELDMENT



SECTION R-R
SCALE 1 : 2

4X ϕ 8.5 THRU
M10X1.5 - 6H THRU

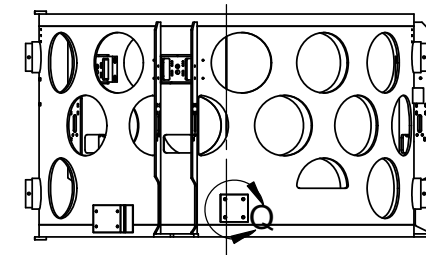
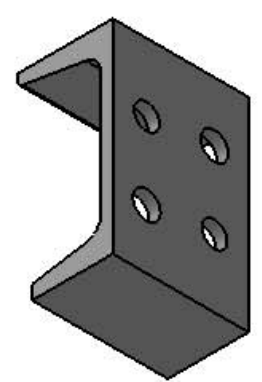


DETAIL Q
SCALE 1 : 2

(2X ϕ 10.3 THRU ALL)

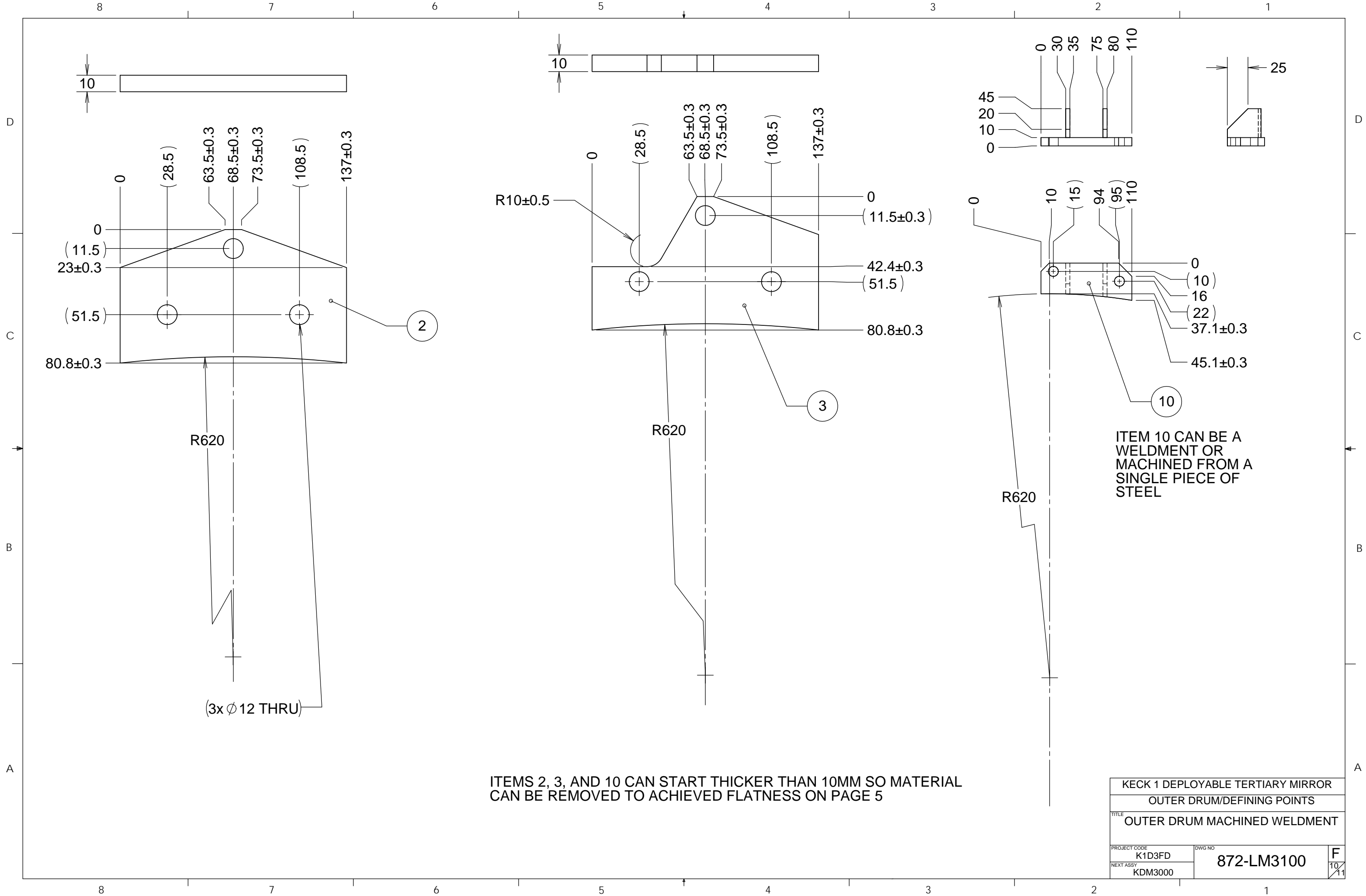
(2X ϕ 9.5 THRU ALL)

4



KECK 1 DEPLOYABLE TERTIARY MIRROR
OUTER DRUM/DEFINING POINTS
TITLE
OUTER DRUM MACHINED WELDMENT

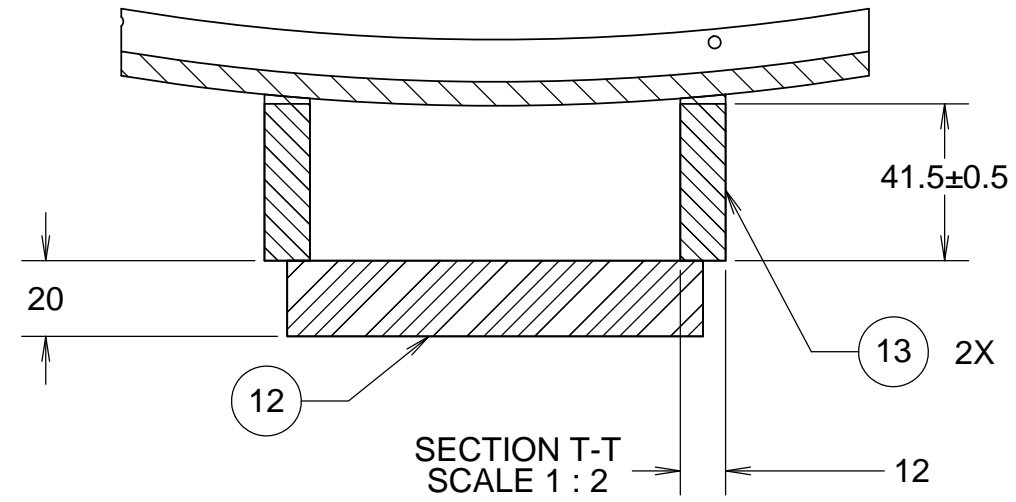
PROJECT CODE K1D3FD	DWG NO 872-LM3100	F 9/11
NEXT ASSY KDM3000		



8 7 6 5 4 3 2 1

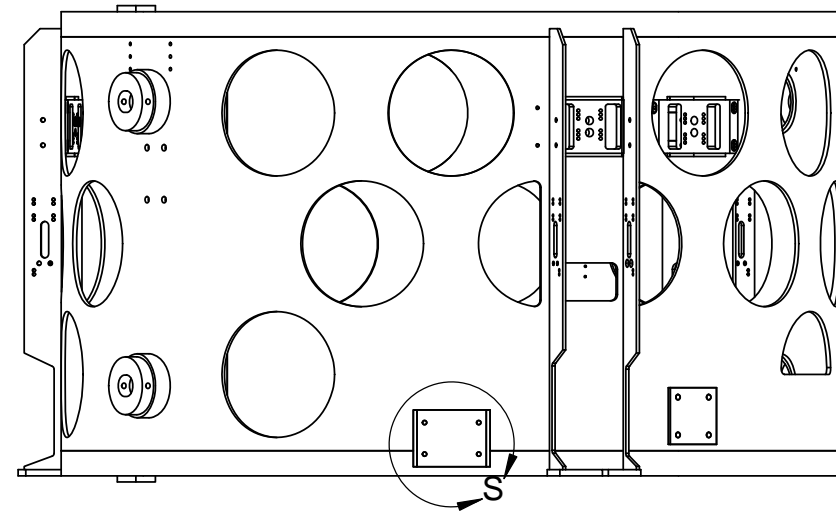
D

D



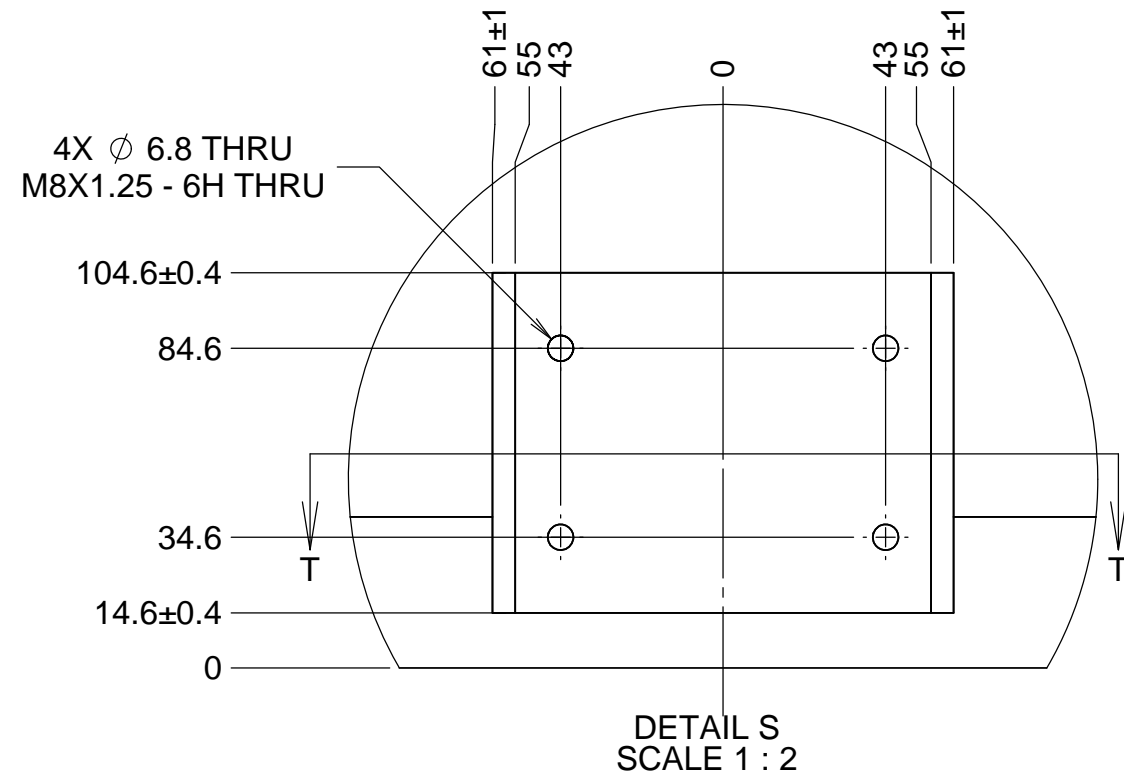
C

C



B

B



B

B

A

A

ITEM 12 CAN START THICKER THAN 20MM TO MEET POST MACHINED TOLERANCE

PROJECT CODE		DWG NO	
K1D3FD		872-LM3100	
NEXT ASSY		F	
KDM3000		11/11	

8 7 6 5 4 3 2 1