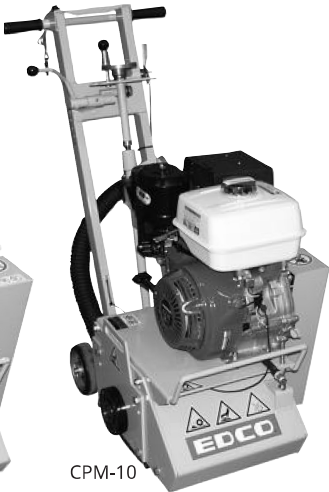




CUTTER DRUM ASSEMBLY PROCEDURES



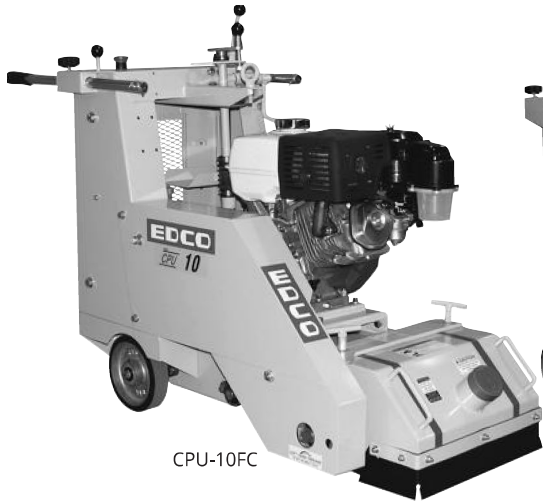
CPM-8



CPM-10



CPL-8



CPU-10FC



CPU-12

EQUIPMENT DEVELOPMENT COMPANY, INC.

100 Thomas Johnson Drive, Frederick, MD 21702 U.S.A.

Ph: 800.638.3326 or 301.663.1600

Fax: 800.447.3326 or 301.663.1607

Watch Cutter Drum Assembly Procedure Videos at: EDCOinc.com

YouTube Search: EDCO Twitter: @EDCOUSA

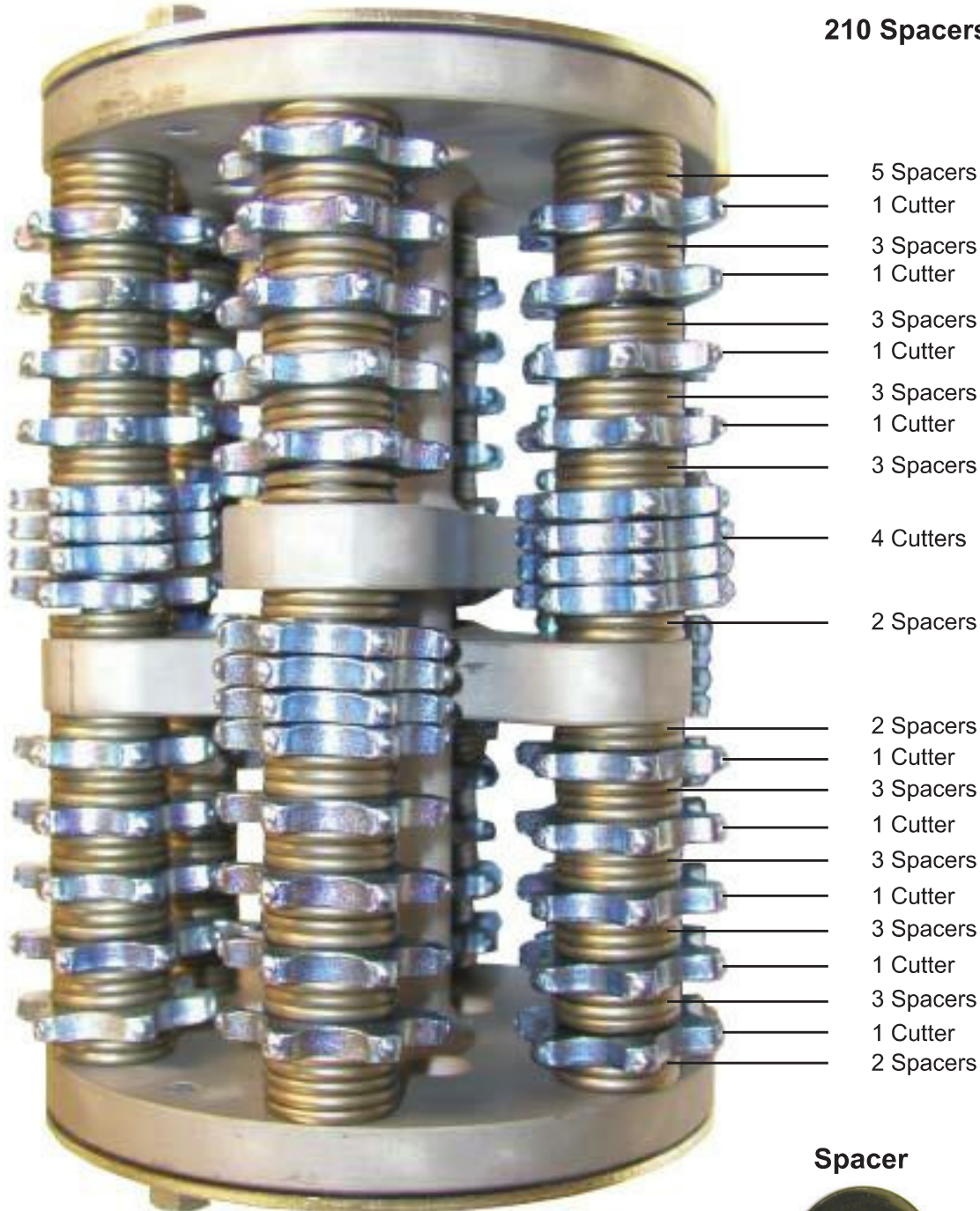
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Contact EDCO for additional Drum Assemblies.

CPM-8, 6-Shaft General Purpose Carbide Cutter Drum Assembly

210 Spacers 78 Cutters



- 5 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 4 Cutters
- 2 Spacers
- 2 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 2 Spacers

Carbide Cutter

Spacer



**CG227
Part# 12230**



**CP206-T
Part# 20156**

Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange

CPM-8, 6-Shaft Fine Carbide Cutter Drum Assembly



174 Spacers 96 Cutters

1 Spacer
 1 Cutter
 2 Spacers
 1 Cutter
 2 Spacers
 1 Cutter
 2 Spacers
 1 Cutter
 2 Spacers
 1 Cutter
 2 Spacers
 1 Cutter
 2 Spacers
 1 Cutter
 2 Spacers
 4 Cutters
 2 Spacers
 1 Spacer
 1 Cutter
 2 Spacers
 1 Cutter
 2 Spacers
 1 Cutter
 2 Spacers
 1 Cutter
 2 Spacers
 1 Cutter
 2 Spacers
 1 Cutter
 2 Spacers
 1 Cutter
 2 Spacers
 1 Cutter
 3 Spacers

Carbide Cutter



Spacer
CG227
Part# 12230



CP206-T
Part# 20156

Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange



CPM-8, 6-Shaft 4" Line Removal Carbide Cutter Drum Assembly



261 Spacers 54 Cutters

Carbide Cutter



CP206-T
Part # 20156

Spacer



CG227
Part # 12230

Instructions:
Repeat the same sequence for the other 3 shafts.

- Loose fit
- One Spacer minimum by each flange

Key:

- 1S** - 1 Spacer
- 2S** - 2 Spacers
- 3S** - 3 Spacers
- 26S** - 26 Spacers
- 34S** - 34 Spacers
- 1C** - 1 Cutter
- 2C** - 2 Cutters
- 5C** - 5 Cutters

CPM-8, 6-Shaft General Purpose Pointed Steel Cutter Drum Assembly



132 Spacers 144 Cutters

3 Spacers
2 Cutters
2 Spacers
2 Cutters
2 Spacers
2 Cutters
2 Spacers
2 Cutters
1 Spacer
1 Cutter
1 Spacer

1 Spacer

5 Cutters

1 Spacer
2 Cutters
2 Spacer
2 Cutters
2 Spacers
2 Cutters
2 Spacers
2 Cutters
2 Spacers
2 Cutters
1 Spacer

Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

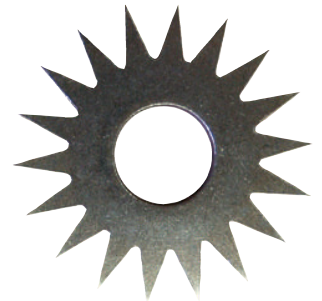
- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange

Spacer



**CG227
Part# 12230**

**Pointed Steel
Cutter**



**JRS-501
Part# 12206**

CPM-8, 6-Shaft Special Milling Carbide Milling Cutter Drum Assembly



174 Spacers 48 Cutters

5 Spacers

1 Cutter

4 Spacers

1 Cutter

4 Spacers

1 Cutter

1 Spacer

2 Spacers

2 Cutters

4 Spacers

1 Cutter

4 Spacers

1 Cutter

4 Spacers

1 Cutter

1 Spacer

**Carbide Milling
Cutter**

Spacer



**CG227
Part# 12230**

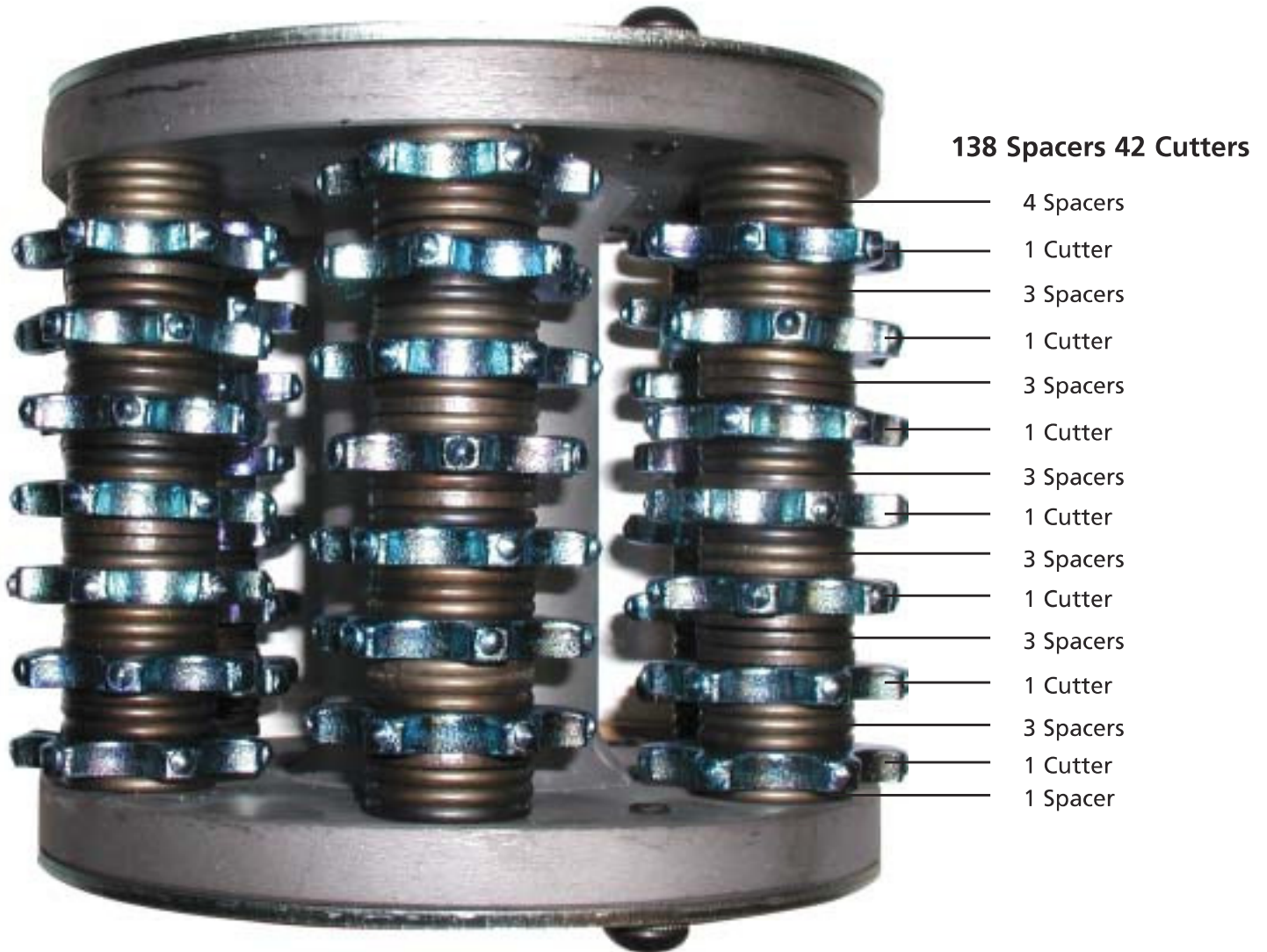


**CP207-T
Part# 20336**

Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange

CPM-8 Edger, 6-Shaft General Purpose Carbide Cutter Drum Assembly



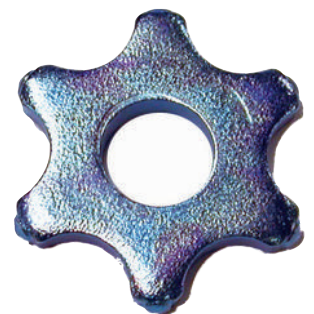
138 Spacers 42 Cutters

Carbide Cutter

Spacer



CG27
Part# 12230



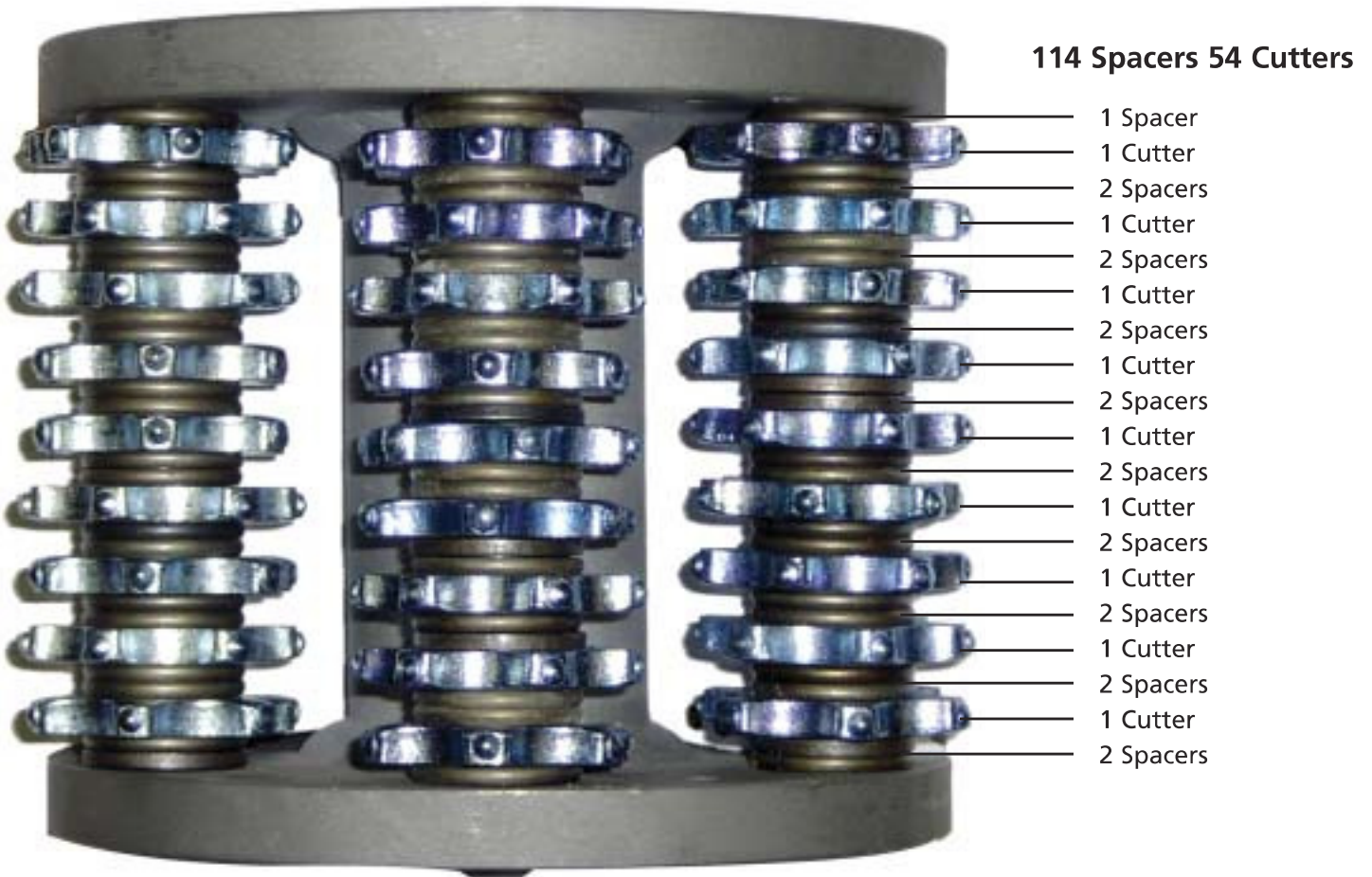
CP206-T
Part# 20156

Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange



CPM-4 or CPM-8 Edger Attachment, 6-Shaft Fine Carbide Cutter Drum Assembly

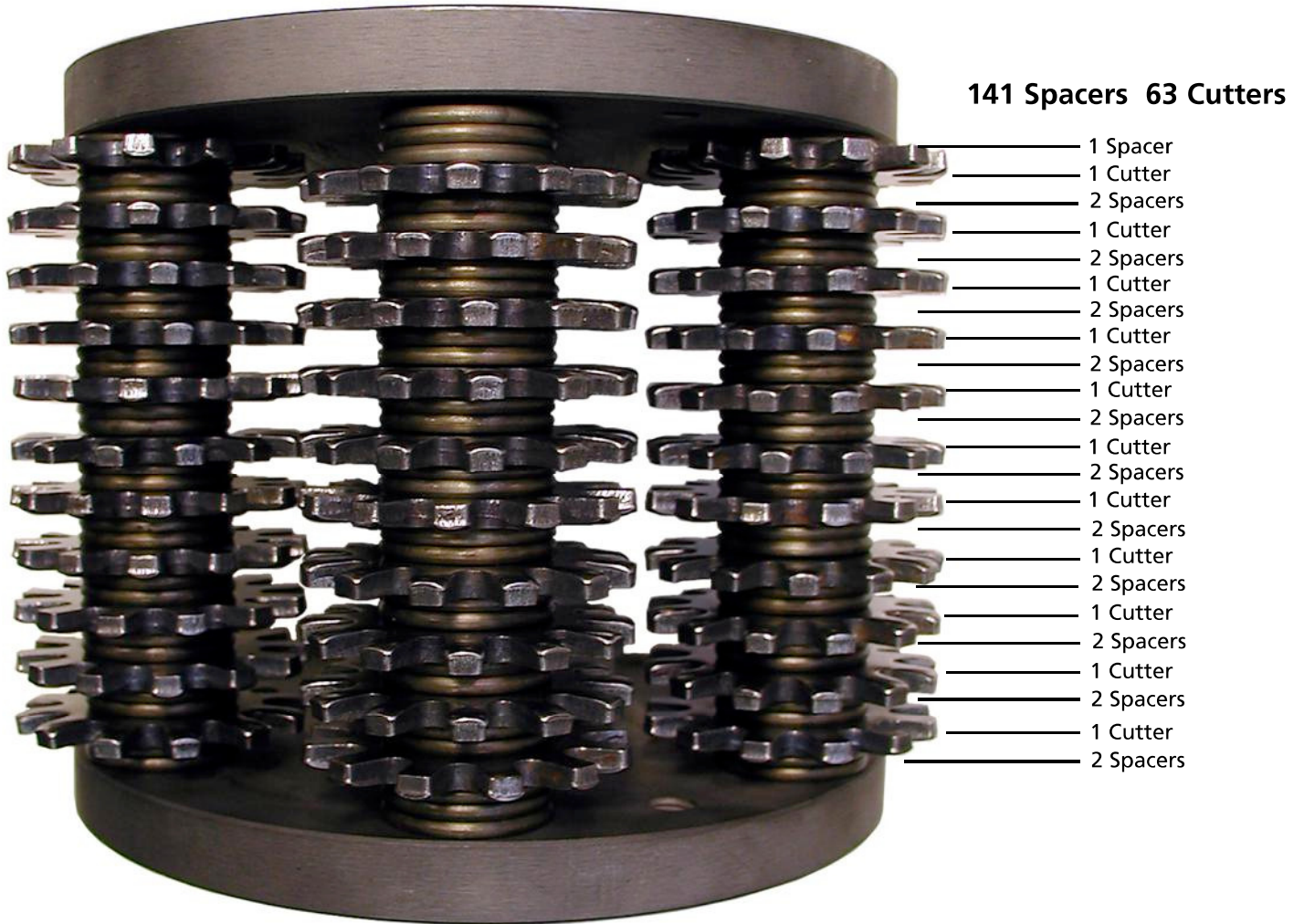


Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange



CPM-4 or CPM-8 Edger Attachment, 6-Shaft Fine Flat-Tip Steel Cutter Drum Assembly



141 Spacers 63 Cutters

- 1 Spacer
- 1 Cutter
- 2 Spacers
- 1 Cutter
- 2 Spacers
- 1 Cutter
- 2 Spacers
- 1 Cutter
- 2 Spacers
- 1 Cutter
- 2 Spacers
- 1 Cutter
- 2 Spacers
- 1 Cutter
- 2 Spacers
- 1 Cutter
- 2 Spacers
- 1 Cutter
- 2 Spacers
- 1 Cutter
- 2 Spacers

Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange



CPM-4 or CPM-8 Edger Attachment, 6-Shaft Super Fine Pointed Steel Cutter Drum Assembly

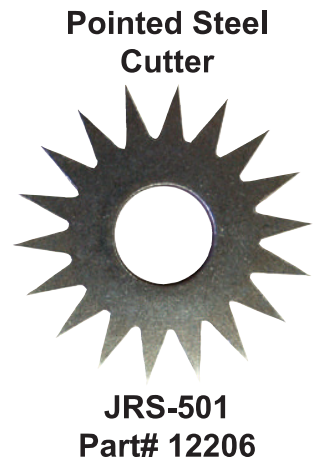


60 Spacers 96 Cutters

- 2 Spacers
- 2 Cutters
- 1 Spacer
- 2 Cutters
- 1 Spacer
- 2 Cutters
- 1 Spacer
- 2 Cutters
- 1 Spacer
- 2 Cutters
- 1 Spacer
- 2 Cutters
- 1 Spacer
- 2 Cutters
- 1 Spacer

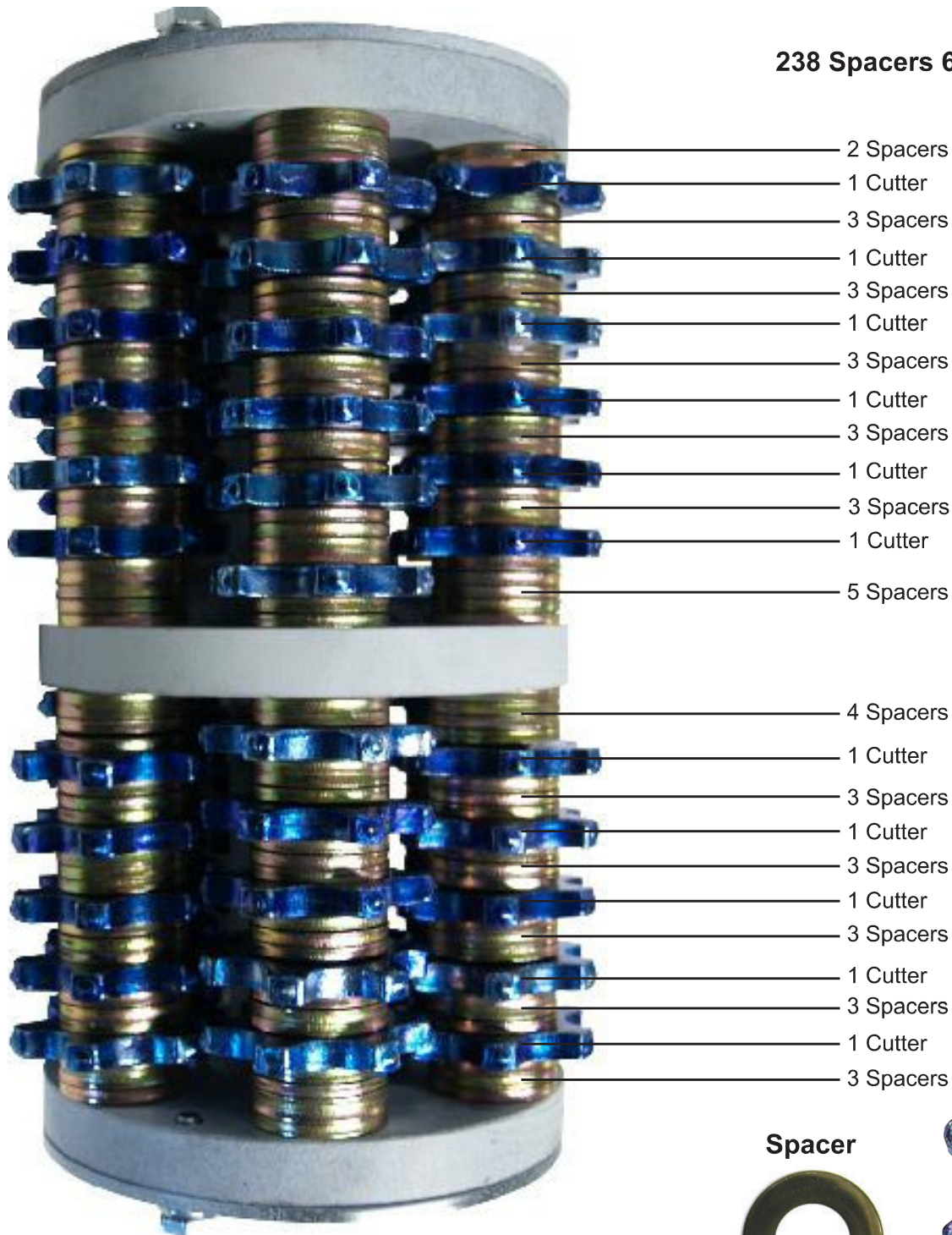
Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange



CPL-8, 6-Shaft General Purpose Carbide Cutter Drum Assembly

238 Spacers 66 Cutters



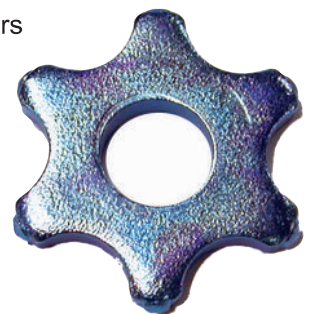
- 2 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 5 Spacers
- 4 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers

Carbide Cutter

Spacer



**CG227
Part# 12230**



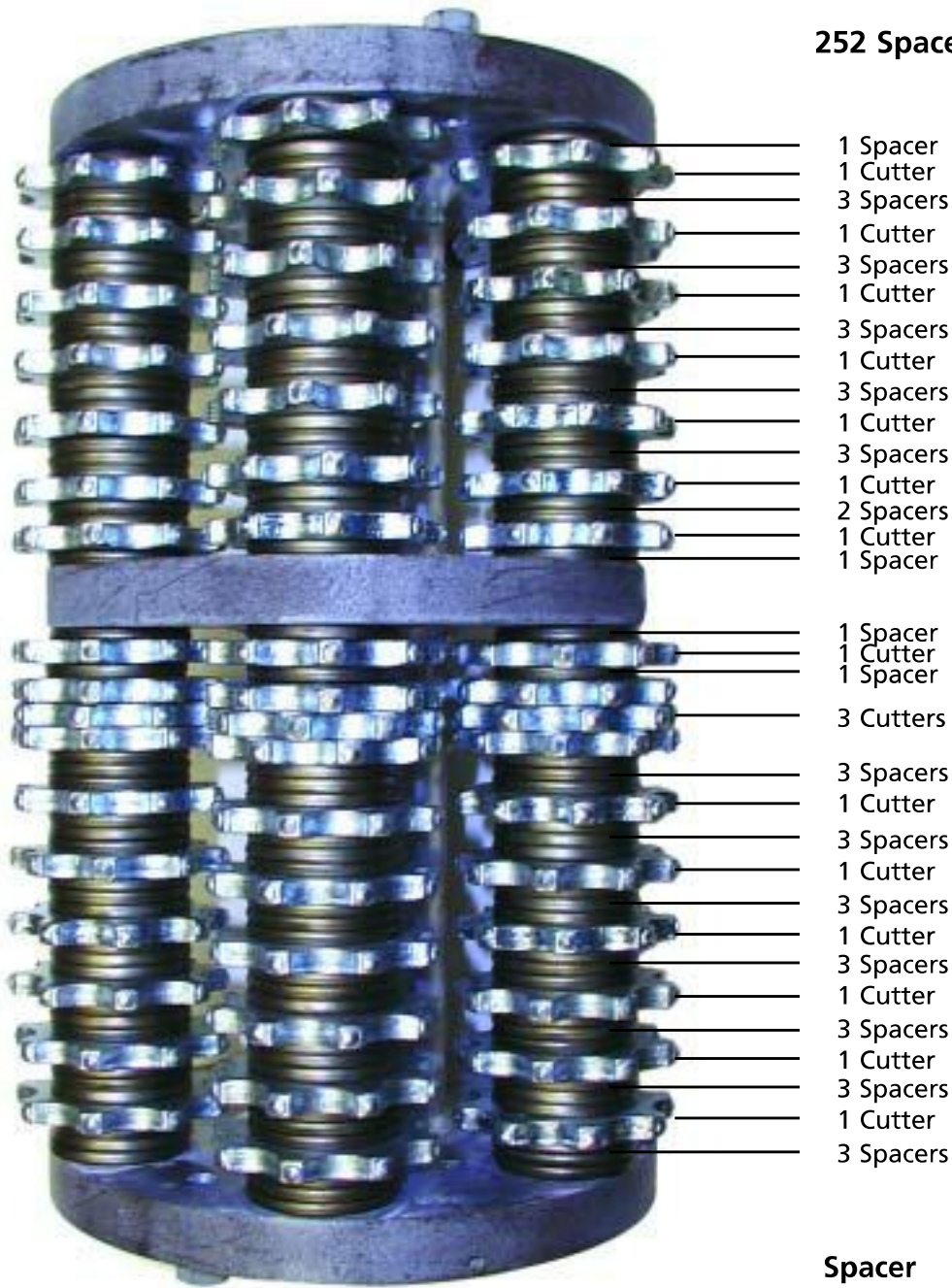
**CP206-T
Part# 20156**

Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange

CPM-10, 6-Shaft General Purpose Carbide Cutter Drum Assembly

252 Spacers 102 Cutters



- 1 Spacer
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 2 Spacers
- 1 Cutter
- 1 Spacer

- 1 Spacer
- 1 Cutter
- 1 Spacer
- 3 Cutters
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers

Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange



CPM-10, 6-Shaft Fine Carbide Cutter Drum Assembly



162 Spacers 150 Cutters

- 1 Spacer
- 1 Cutter
- 2 Spacers
- 2 Cutters
- 2 Spacers
- 2 Cutters
- 2 Spacers
- 2 Cutters
- 2 Spacers
- 2 Cutters
- 2 Spacers
- 1 Cutter
- 2 Spacers
- 4 Cutters
- 2 Spacers
- 1 Spacer
- 1 Cutter
- 1 Spacer
- 2 Cutters
- 2 Spacers
- 2 Cutters
- 2 Spacers
- 2 Cutters
- 2 Spacers
- 2 Cutters
- 2 Spacers
- 2 Cutters
- 2 Spacers



Spacer

**CP403
Part # 20060**



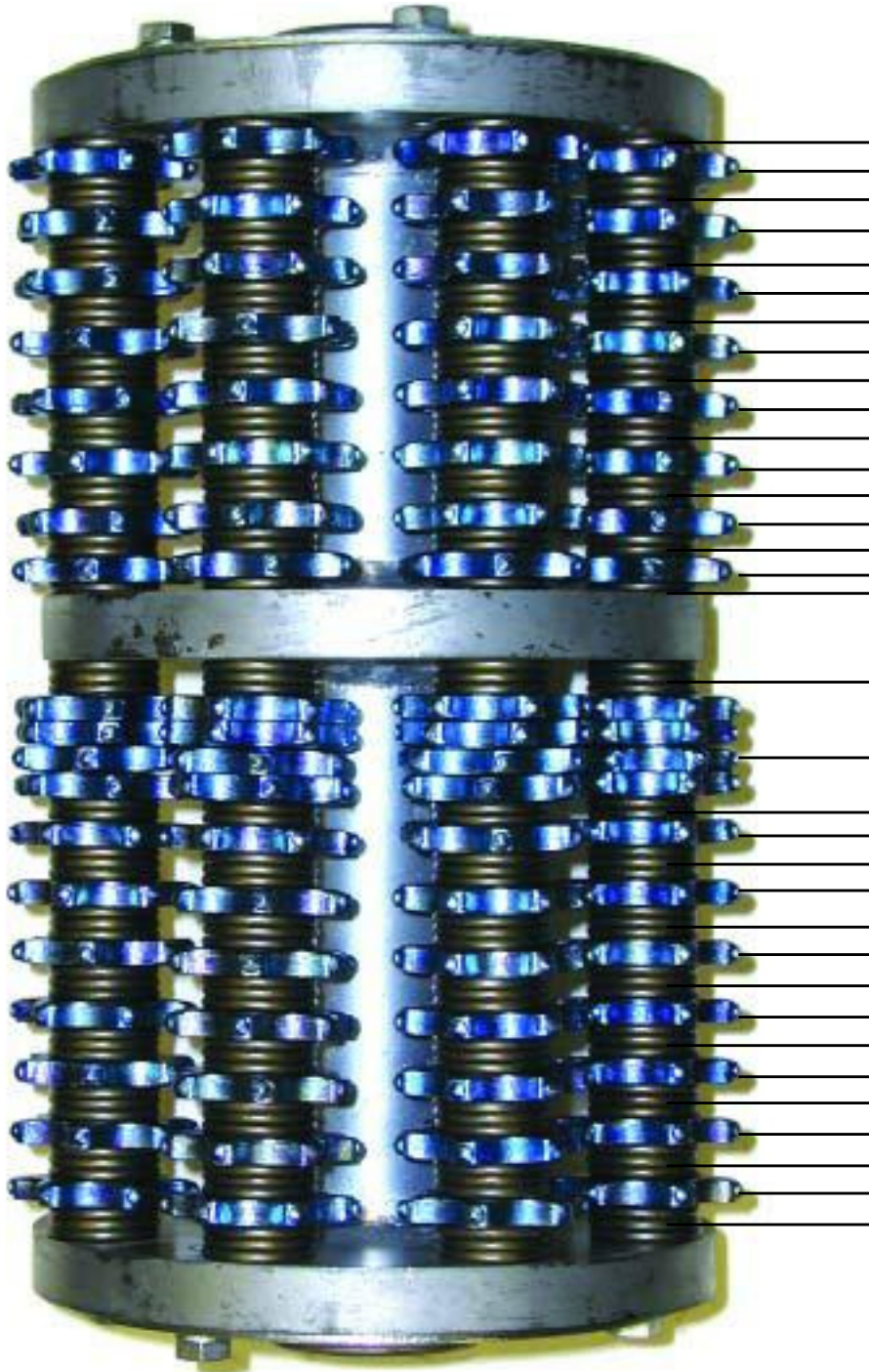
Carbide Cutter

**CP308-T
Part# 20326**

Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange

CPM-10, 8-Shaft General Purpose Carbide Cutter Drum Assembly



384 Spacers 152 Cutters

- 1 Spacer
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 2 Spacers
- 1 Cutter
- 1 Spacer

3 Spacers

4 Cutters

- 2 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers

Carbide Cutter

Spacer



**CG227
Part# 12230**

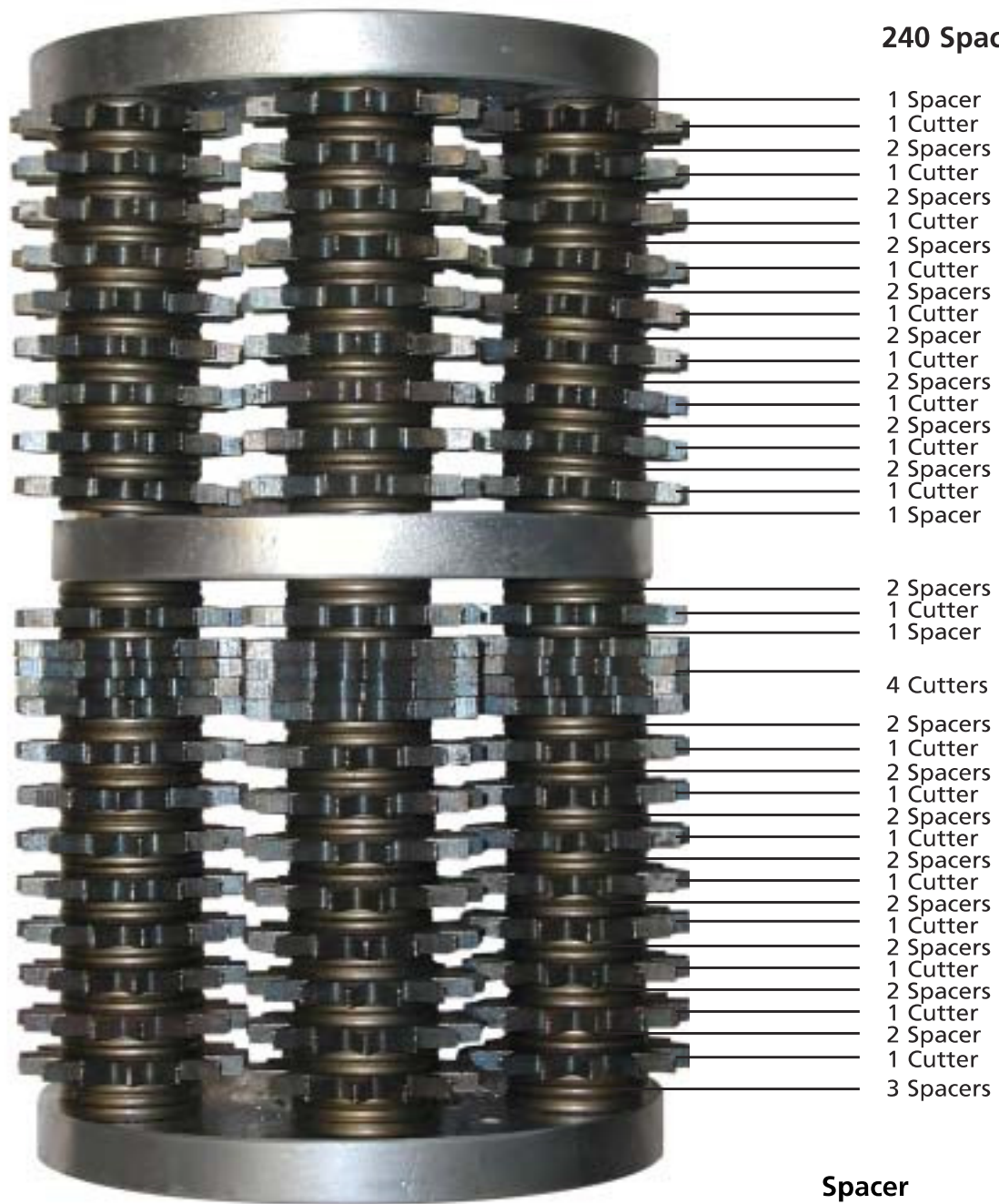


**CP206-T
Part# 20156**

Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange

CPM-10, 6-Shaft Fine Pointed Steel Cutter Drum Assembly



240 Spacers 132 Cutters

1 Spacer
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
1 Spacer

2 Spacers
1 Cutter
1 Spacer

4 Cutters

2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
2 Spacers
1 Cutter
3 Spacers

Pointed Steel
Cutter



Spacer

CP403
Part # 20060



CP404-P6
Part# 20296

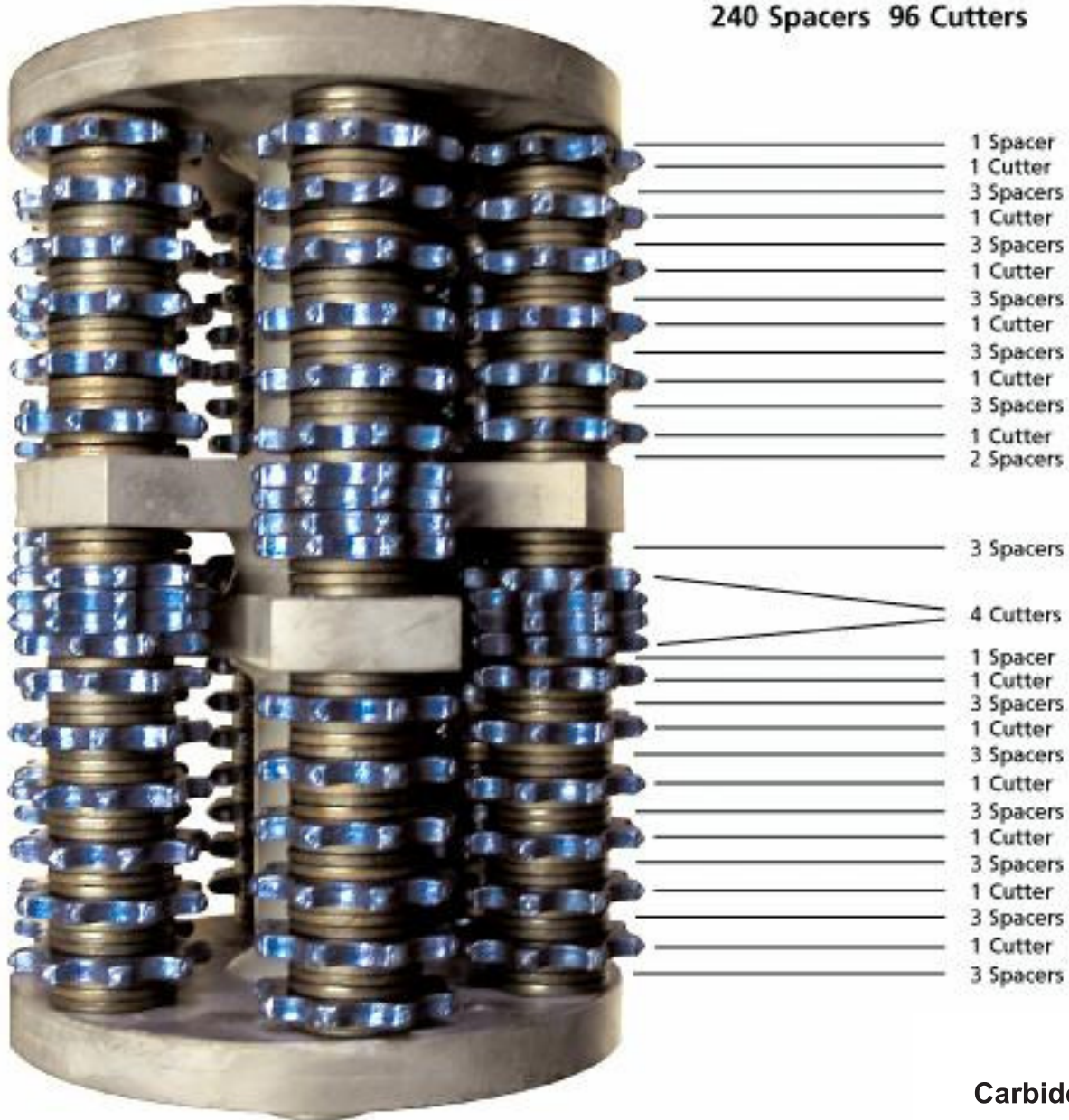
Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange



CPU-10FC, 6-Shaft General Purpose Carbide Cutter Drum Assembly

240 Spacers 96 Cutters

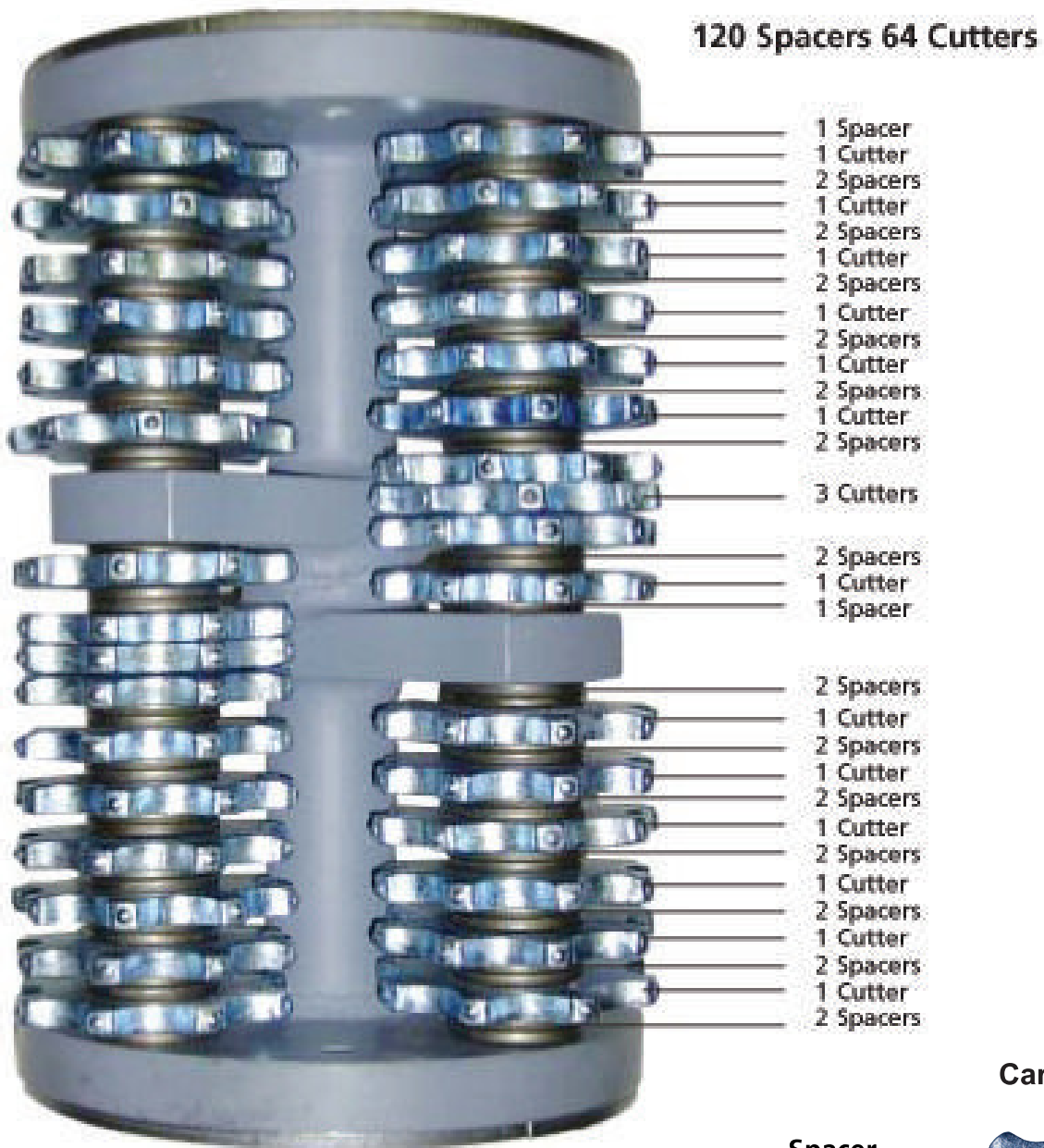


Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange

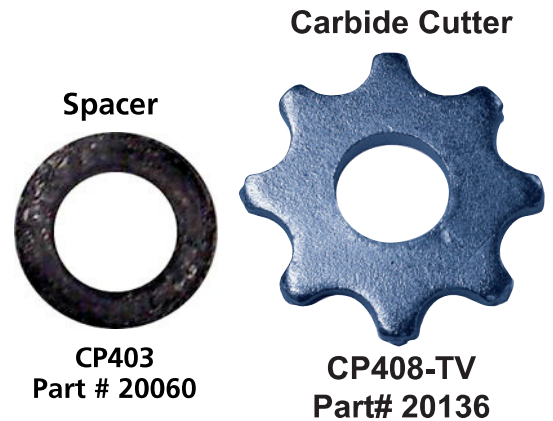


CPU-10FC, 4-Shaft General Purpose Carbide Cutter Drum Assembly



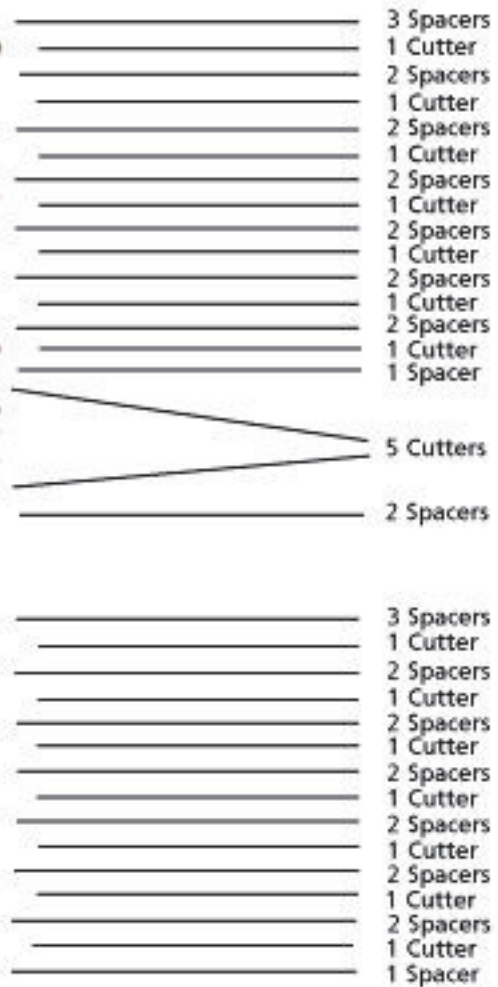
Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange



CPU-10FC, 6-Shaft Fine Set-up Carbide Cutter Drum Assembly

204 Spacers 114 Cutters



Instructions: Repeat this sequence for every other shaft, then rotate the sequence 180° and repeat for the remaining shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange

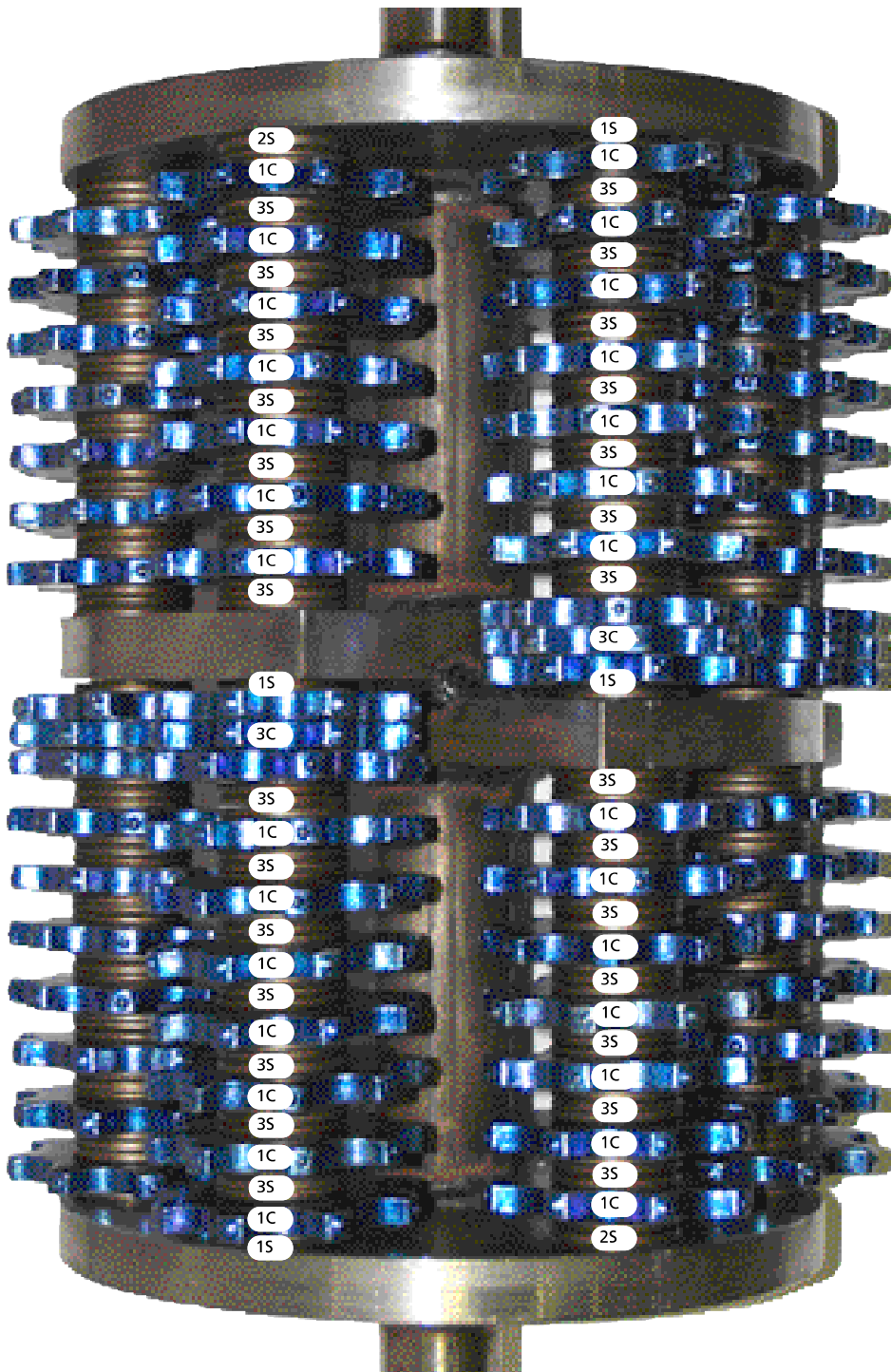


Spacer
CP403
Part # 20060



Carbide Cutter
CP308-T
Part# 20326

CPU-12, 6-Shaft General Purpose Carbide Cutter Drum Assembly



276 Spacers 100 Cutters

Carbide Cutter



CP408-TV
Part # 20136

Spacer



CP403
Part # 20060

Instructions:
Rotate drum 180° and Repeat the same sequence for the other 3 shafts.

- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange

Key:

1S - 1 Spacer
2S - 2 Spacers
3S - 3 Spacers
1C - 1 Cutter
2C - 2 Cutters

