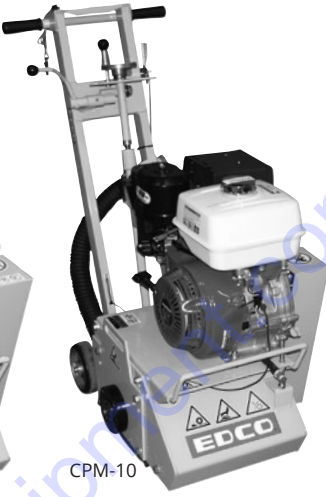




# CUTTER DRUM ASSEMBLY PROCEDURES



CPM-8



CPM-10



CPL-8



CPU-10FC



CPU-12

EQUIPMENT DEVELOPMENT COMPANY, INC.



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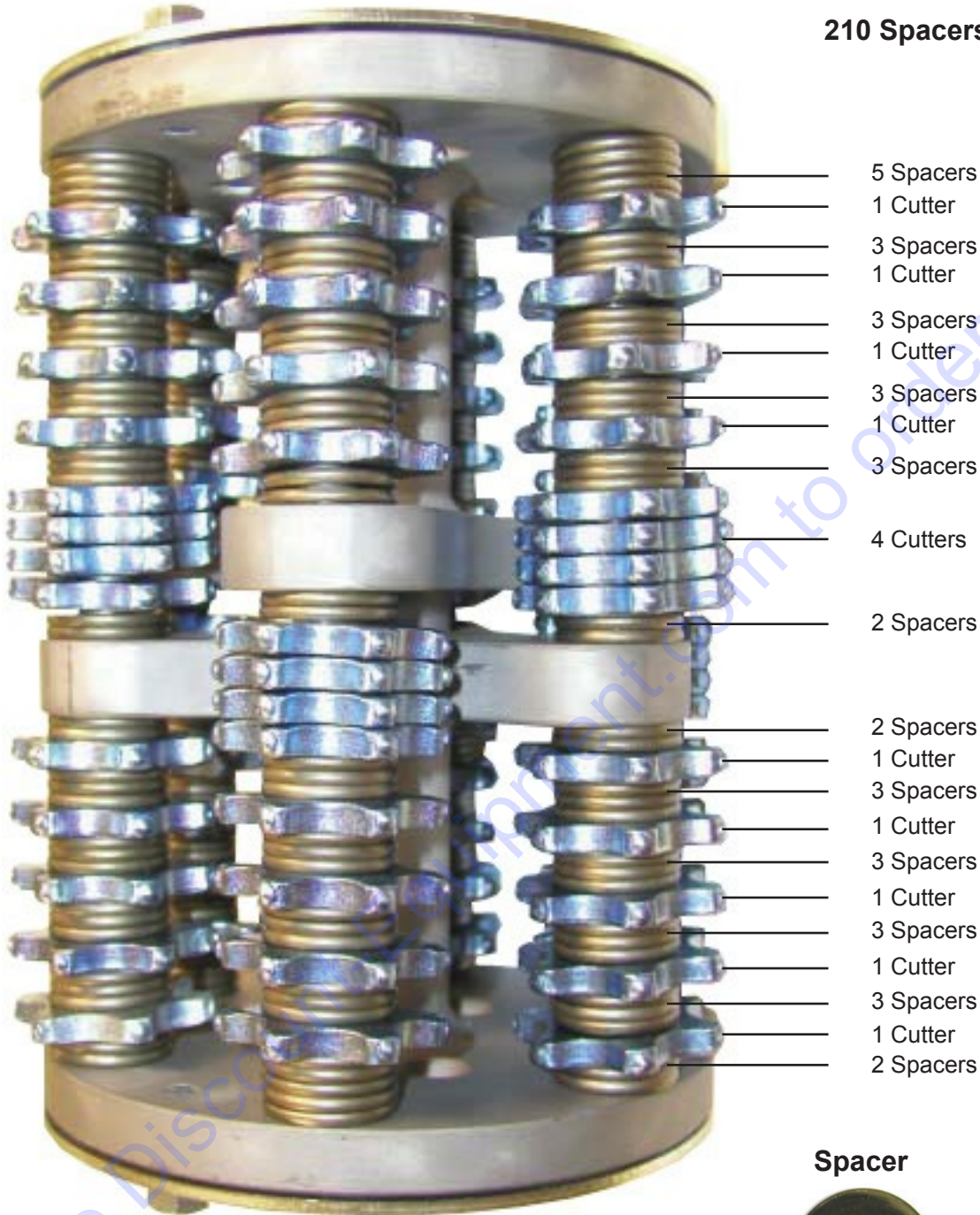
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# CPM-8, 6-Shaft General Purpose Carbide Cutter Drum Assembly

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

**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

**Spacer**



**CG227  
Part# 12230**

**Pointed Steel  
Cutter**



**JRS-501  
Part# 12206**

**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 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



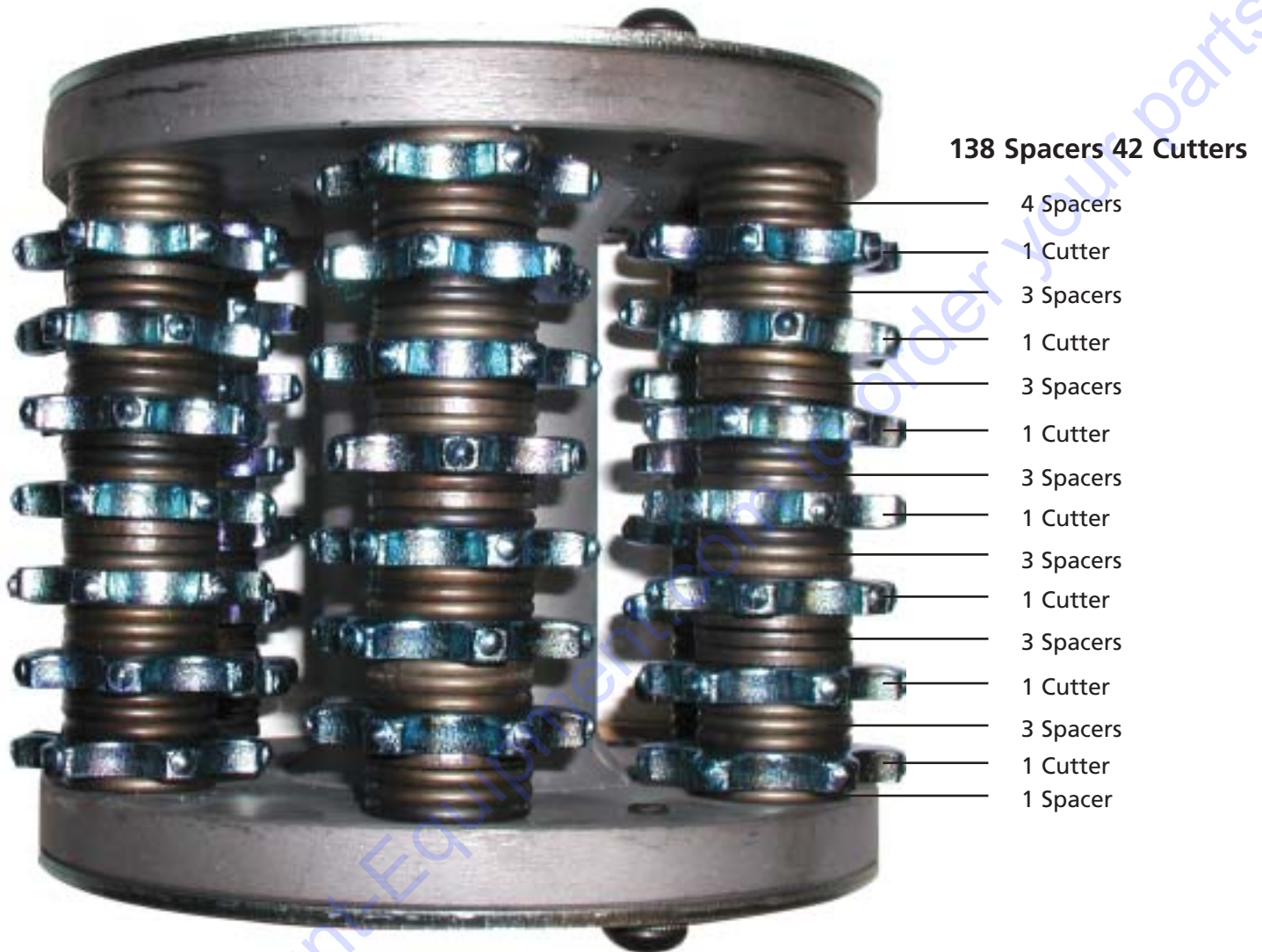
CP207-T  
Part# 20336

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

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

1 Cutter

1 Spacer

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



114 Spacers 54 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

**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

Carbide Cutter



CP206-T  
Part# 20156



# CPM-8 Edger, 6-Shaft Line Removal Carbide Cutter Drum Assembly



102 Spacers 60 Cutters

- 1 Spacer
- 2 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
- 1 Spacer

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

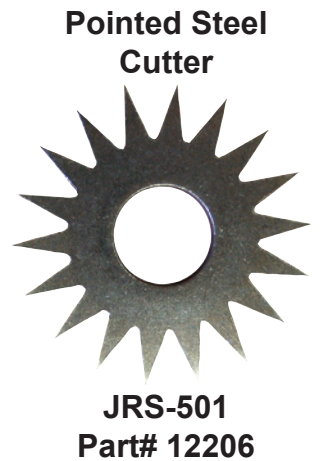


**60 Spacers 96 Cutters**

- 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



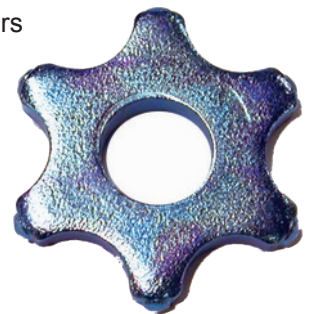
- 2 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 5 Spacers
- 4 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers

**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.

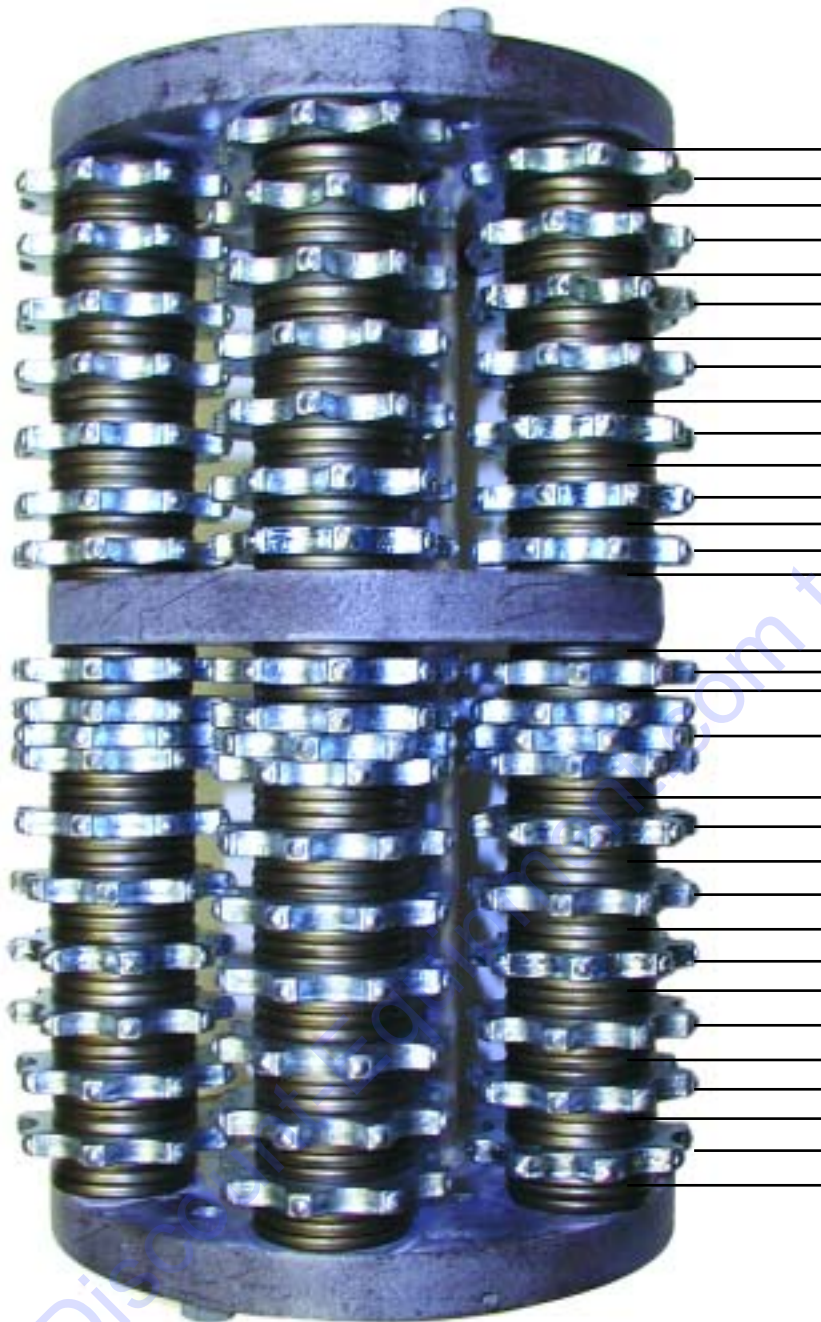
- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange





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

252 Spacers 102 Cutters

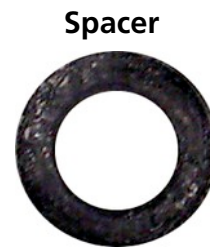


- 1 Spacer
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 3 Spacers
- 1 Cutter
- 2 Spacers
- 1 Cutter
- 1 Spacer

- 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



**Spacer**  
CP403  
Part # 20060



**Carbide Cutter**  
CP308-T  
Part# 20326



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

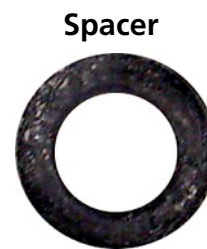


**162 Spacers 150 Cutters**

- 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

**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



# 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
- 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



**Spacer**  
**CG227**  
**Part# 12230**



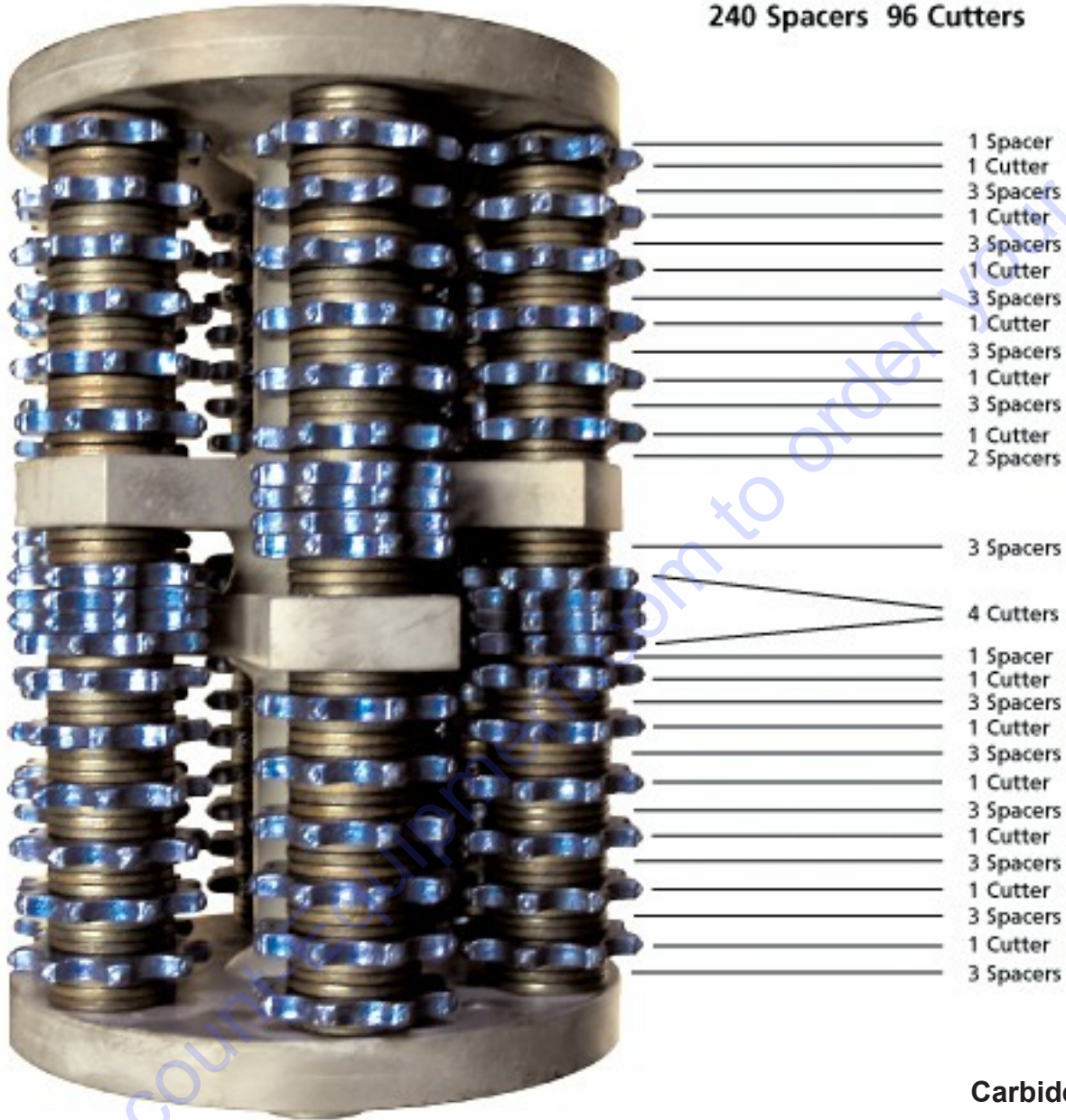
**Carbide Cutter**  
**CP206-T**  
**Part# 20156**





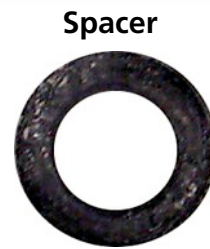
# CPU-10FC, 6-Shaft General Purpose Carbide Cutter Drum Assembly

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



Spacer

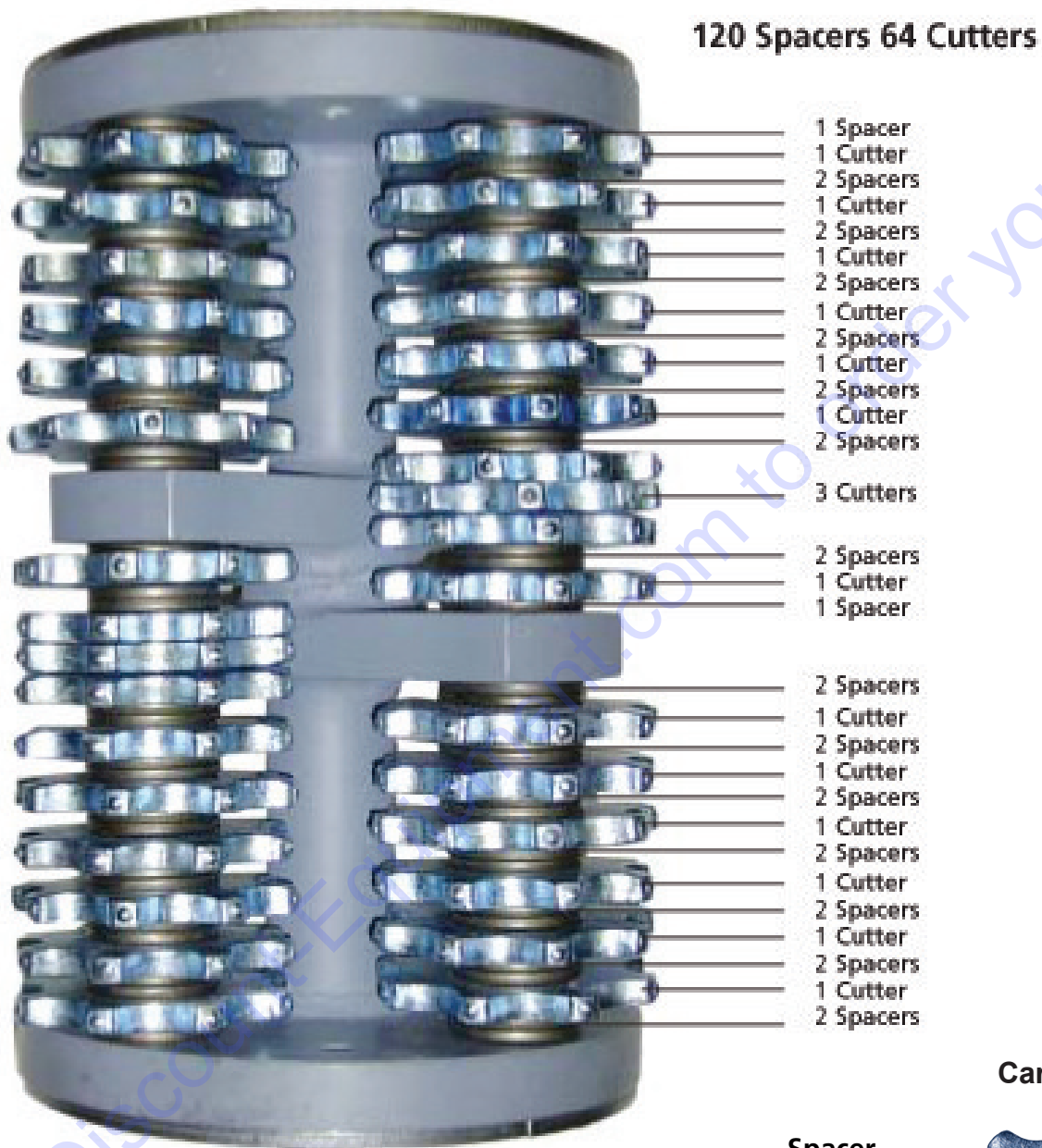
CP403  
Part # 20060



Carbide Cutter

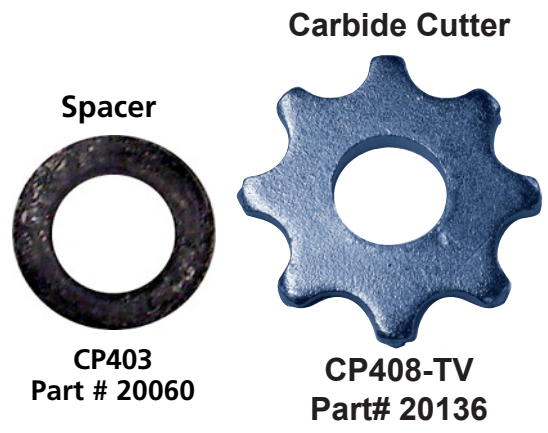
CP308-T  
Part# 20326

# 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.

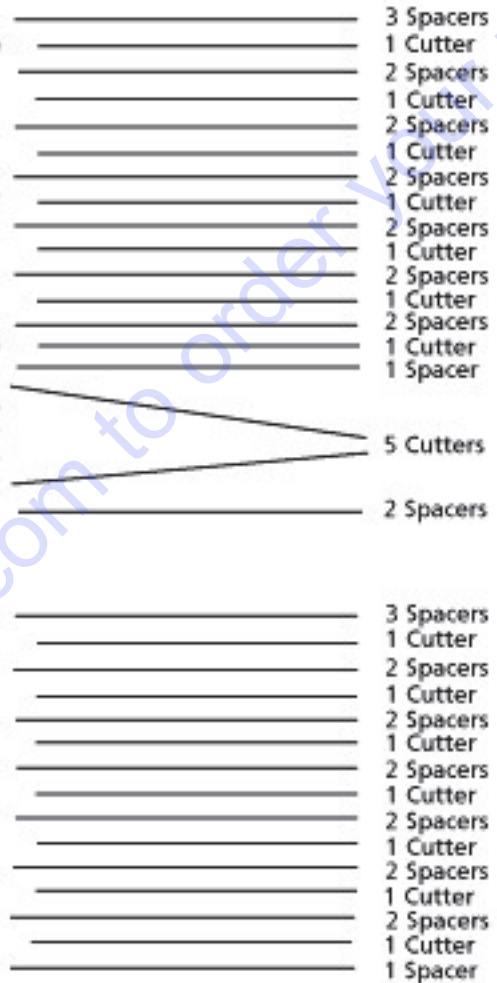
- Rotationally Balanced
- Loose fit
- One Spacer minimum by each flange





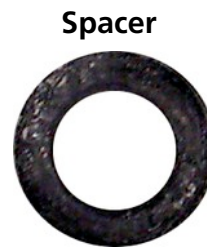
# CPU-10FC, 6-Shaft Fine Set-up Carbide Cutter Drum Assembly

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

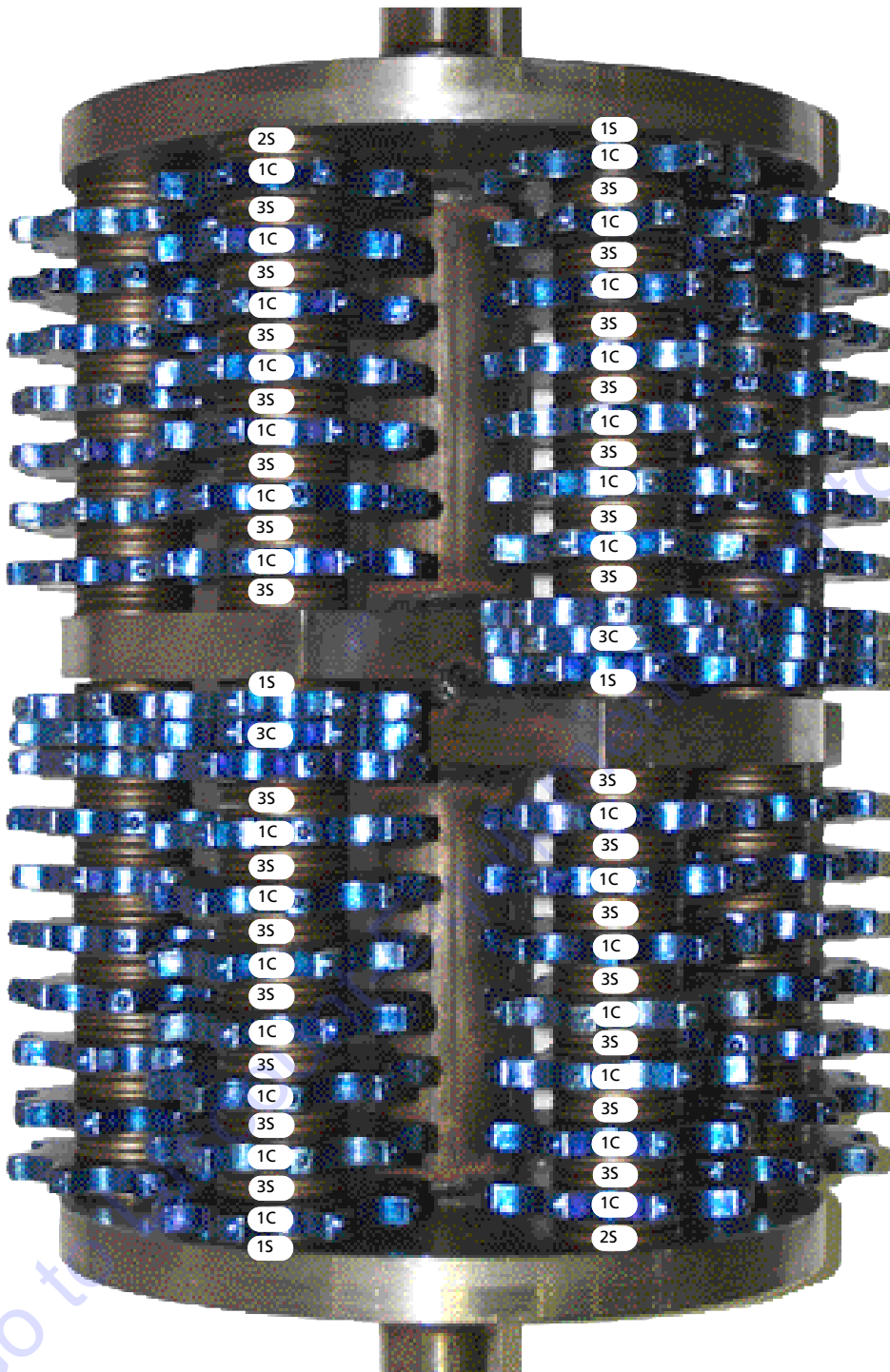


**Spacer**  
CP403  
Part # 20060



**Carbide Cutter**  
CP308-T  
Part# 20326

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



300 Spacers 102 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



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