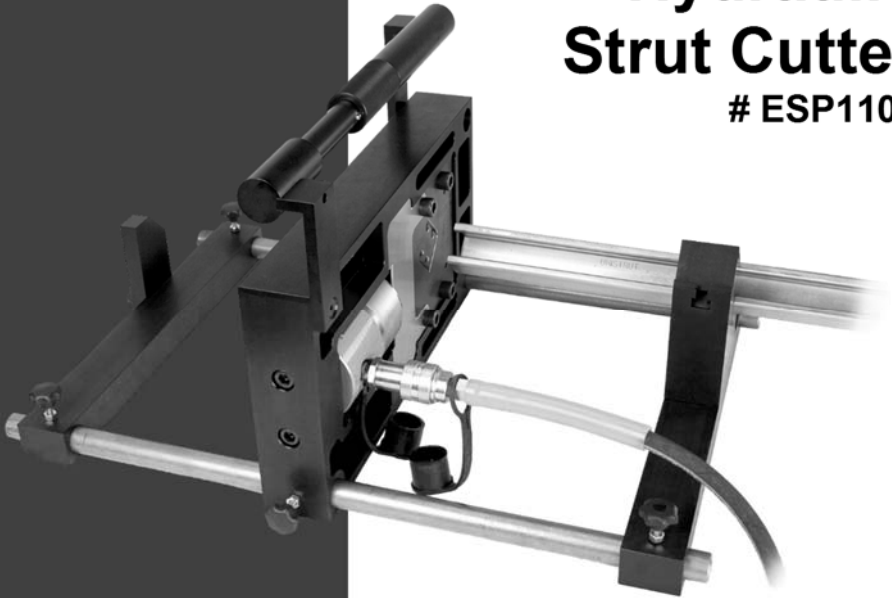




Operating Instructions & Service Parts Manual

Hydraulic Strut Cutter # ESP1100



Record purchase information for quick reference:

Stock No.:

Serial No.:

Purchased from:

Date purchased:

WILTON
427 New Sanford Road
LaVergne, Tennessee 37086
Ph.: 800-373-8206
www.wiltontools.com

Manual No. M-ESP1100
Edition 3
08/2018

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1.0 IMPORTANT SAFETY INSTRUCTIONS

WARNING – To reduce risk of injury:

1. Read and understand all warnings posted on the tool and in this manual. Failure to comply with all of these warnings may cause serious injury.
2. Do not use this strut cutter for other than its intended use.
3. Replace warning labels if they become obscured or removed.
4. Make sure the Wilton Strut Cutter is properly supported by the rods or handle pieces, so that it will not tip over during use.
5. Keep ground or floor around the tool uncluttered and free of scrap material, oil and grease. Wear non-slip footwear.
6. Always wear protective eye wear when operating machinery. Eye wear shall be impact resistant, protective safety glasses with side shields which comply with ANSI Z87.1 specifications. Use of eye wear which does not comply with ANSI Z87.1 specifications could result in severe injury from breakage of eye protection.
7. Wear gloves when handling steel work pieces to prevent possible injury from sharp edges.
8. Keep hands away from cutting area during operation.
9. Always inspect the Strut Cutter before use. Check for misalignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect the tool's operation. If damage is found, repair the tool immediately or replace it.
10. Disconnect from power/hydraulic source before performing any maintenance or cleaning.
11. Have tool serviced only by qualified personnel, using authorized replacement parts.
12. Provide for adequate space surrounding work area and sufficient lighting.
13. Do not use this tool while tired or under the influence of drugs, alcohol or medication.
14. Keep bystanders, especially children, away from the area while using the tool.
15. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
16. Maintain a balanced stance at all times. Do not overreach while performing the work.
17. Do not use power tools in damp or wet location, or expose them to rain.



WARNING: This product can expose you to chemicals including nickel (metallic) which is known to the State of California to cause cancer. For more information go to <http://www.p65warnings.ca.gov>.



WARNING: Some dust, fumes and gases created by power sanding, sawing, grinding, drilling, welding and other construction activities contain chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. Some examples of these chemicals are:

- lead from lead based paint
- crystalline silica from bricks, cement and other masonry products
- arsenic and chromium from chemically treated lumber

Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as dust masks that are specifically designed to filter out microscopic particles. For more information go to <http://www.p65warnings.ca.gov/> and <http://www.p65warnings.ca.gov/wood>.

Familiarize yourself with the following safety notices used in this manual:



This means that if precautions are not heeded, it may result in serious, or even fatal, injury.



This means that if precautions are not heeded, it may result in minor injury and/or possible tool damage.

2.0 About this tool

The WILTON Strut Cutter is a portable hydraulic tool designed to quickly cut common U.S. manufactured brand struts in 12-, 14-, and 16-gauge mild steel. A single set of blades will provide thousands of clean, even cuts, eliminating the need for deburring. Contact WILTON for special application blade and hydraulic sets. This product has been designed and constructed to provide consistent long-term operation, if used in accordance with instructions as set forth in this document. **NOTE:** *This tool is not designed for use with fiberglass, aluminum, or stainless steel struts.*

Register your product using the mail-in card provided, or register online:
<http://www.wiltontools.com/us/en/service-and-support/warranty/registration/>

3.0 About this manual

This manual covers operation and maintenance procedures for the WILTON Strut Cutter. It contains instructions on setup, safety precautions, general operating procedures, maintenance instructions and parts breakdown. If there are questions or comments, please contact your local supplier or WILTON. WILTON can also be reached at our web site: www.wiltontools.com.

Retain this manual for future reference. If the tool transfers ownership, the manual should accompany it.

4.0 Specifications

Model		Wilton Strut Cutter
Stock number		ESP1100
Cutting cycle		3 seconds
Required power supply (not provided)		10,000 PSI hydraulic
Standard die set	Deep strut	1-5/8 x 1-5/8 in. (41.3 x 41.3 mm)
	Shallow strut	1-5/8 x 13/16 in. (41.3 x 20.6 mm)
Maximum capacity		12 gauge mild steel
Cylinder linear force		25 tons
Cylinder stroke		1 in. (25.4 mm)
Main unit material		7075-T651 Black anodized aluminum
Blade set material		S7 heat treated steel
Recommended hydraulic fluid (not provided)		ASTM 215, or equivalent
Assembled dimensions with handle (LxWxH)		17 x 5.5 x 13 in. (431.8 x 139.7 x 330.2 mm)
Shipping dimensions (LxWxH)		18 x 15 x 9 in. (8.1 x 6.8 x 4 kg)
Net weight		63.5 lb. (28.8 kg)
Shipping weight		67 lb. (30.4 kg)

L = length, W = width, H = height

Table 1

The specifications in this manual were current at time of publication, but because of our policy of continuous improvement, Wilton reserves the right to change specifications at any time and without prior notice, without incurring obligations.



WARNING Read and understand the entire contents of this manual before attempting setup or operation of the Strut Cutter. Failure to comply may cause serious injury.

5.0 Setup and Assembly

5.1 Shipping contents

See Figure 1.

- 1 Main unit with hydraulic cylinder and coupling
- 1 Collapsible handle system
- 1 Material rest assembly
- 1 Back stop assembly
- 1 Blade set (installed on main unit)
- 7 Star knobs
- 2 Guide rods 16 in.
- 1 Instructions and parts manual
- 1 Product registration card

Remove all contents from shipping carton, and check for shipping damage or missing parts. If either of these is discovered, contact your dealer or Wilton at the phone number on the cover.



Figure 1: contents

5.2 Handle system

The handle system can be used for carrying the main unit (Figure 1), or as supports during cutting (Figure 2).

To install handle assembly for carrying, place pins of long and short handles into holes on main unit, as shown in Figure 1. Slide knurled collar past ball plunger onto opposite handle to secure. Reverse procedure to collapse handle assembly.

For supports during cutting of lighter gauge (16ga.) material, position handle pieces on opposite sides as shown in Figure 2. Install knobs securely and tighten hex nuts against main unit to prevent knobs from backing out.



CAUTION Supports must be used while operating the Wilton Strut Cutter, to prevent unit from tipping.



Figure 2: handles used as supports

5.3 Support rods

For cutting heavier 14- or 12-gauge struts, or for cutting multiple pieces to the same length:

1. Slide material rest onto the two rods, and insert rods through holes in main unit, as shown in Figure 3. Position material rest about 6 to 8 inches from, and perpendicular to, the cutting die.
2. Adjust height of material rest guide block (1/4-inch hex wrench required) to allow smooth, straight line entry into cutting die. Insert strut through cutting die to test the adjustment. When satisfied, securely tighten screws and knobs.
3. For making multiple cuts to identical length, install back stop (see Figure 3). Measure from surface of cutting die to back stop; then add 3/4-inch (19mm) for final cut length.

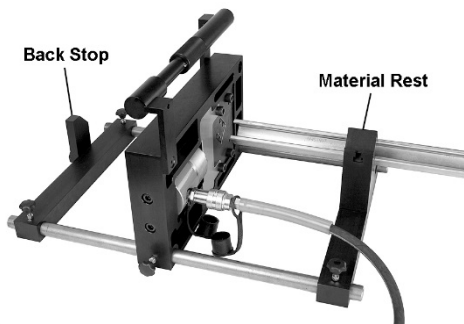


Figure 3: setup for larger materials

NOTE: If longer support is required, use 1-inch O.D. pipe or tube of greater length (not provided) and move material rest and/or back stop farther from cutting die.

6.0 Operation

1. Connect hydraulic power source (not provided) to the universal coupling on the tool. Use clean ASTM 215 or equivalent hydraulic fluid.
2. Turn on hydraulic power source and observe the tool's operation without a strut inserted. The blade set consists of a stationary blade in front and a moving shear blade in back. Watch shear blade motion from rear of tool – it should have smooth movement. When shear blade has returned to rest position, both blades should remain aligned.
3. When correct operation is verified, place strut upon material rest and slide through cutting die. See Figure 4. Make sure strut is clean and straight.

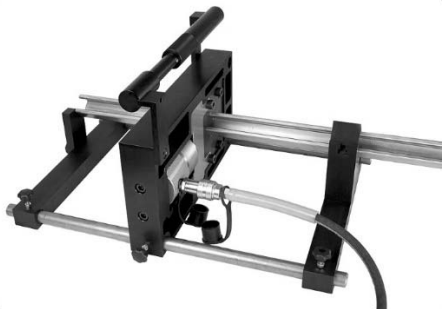


Figure 4: operation

4. Adjust to desired cut length, and activate hydraulic power source. Wait approximately 3 seconds for strut to separate.
5. Release hydraulic pressure to allow blade to return to rest position. Remove cutoff piece from back of unit before making additional cuts.

7.0 User-maintenance

⚠ WARNING Disconnect from power/hydraulic source before performing any cleaning or maintenance of the unit.

Periodically apply a light coat of machine oil to exposed metal areas, such as rods, to inhibit rust.

Periodically inspect tightness of socket head screws which secure cutting die to main unit.

If cutting becomes difficult, remove stationary die and clear away any shavings from cutting area, using vacuum or brush. Do not use bare hands.

7.2 Additional servicing

Any additional servicing should be performed by authorized service personnel.

8.0 Compatibility chart

The Wilton Strut Cutter is compatible with the following products. Contact Wilton for custom blade sets.

Brand	Blade part no.	Compatible strut
Unistrut®	ESP1159 (standard)	P1000, P1000T, P1000SL, P1000HS, P1000H3, P4100, P4100T, P4100SL, P4100HS, PA158
B-Line®	ESP1160	B22, B22SH, B22S, B22H17/8, B22TH, B22S58, B24, B24SH, B24S, B24H17/8, B24TH, B24S58, B52, B52SH, B52S, B52H17/8, B52TH, B52S58, B54, B54SH, B54S, B54H17/8, B54TH, B54S58,
	ESP1161	4D21
	ESP1162	4D22
Powerstrut®	custom	PS200, PS200H, PS200S, PS200EH, PS210, PS210H, PS210S, PS210EH, PS500, PS500H, PS500S, PS500EH, PS520, PS520H, PS520S, PS520EH
Superstrut®	custom	A1200, A1200HS, A1200P, A1200S, A1400, A1400HS, A1400P, A1400S, B1200, B1200HS, B1200P, B1200S, B1400, B1400HS, B1400P, B1400S
Kindorf®	Custom blade sets available	
Erico®	Custom blade sets available	

Table 2

9.0 Troubleshooting Wilton Strut Cutter

Problem	Possible cause	Remedy
Irregular cut.	Material rest not adjusted properly.	Adjust material rest so that strut is perpendicular to cutting die surface. Ensure that knobs are tightened down on rods.
	Bolts which hold blade die in frame of main unit have loosened (possibly from vibration over long-term use).	Check tightness of bolts after about every 500 cuts (3/8 in. hex wrench required).
Shear blade won't return to rest position.	Hydraulic dump valve not functioning.	Inspect and correct dump valve function on hydraulic system.
	Blade movement blocked by obstruction.	Clean debris from blade area.
	Blade return springs worn or damaged.	Inspect and replace if needed.

Table 3

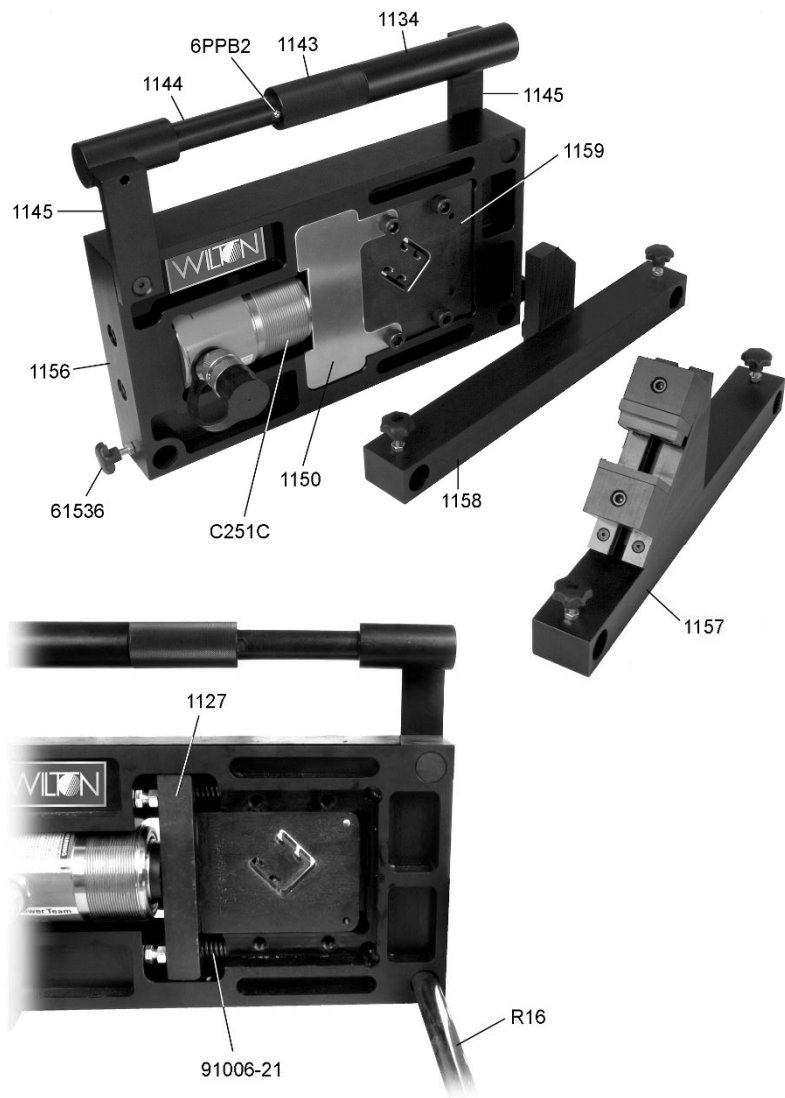
10.0 Replacement Parts

To order parts or reach our service department, call 1-800-373-8206 Monday through Friday, 8AM to 5PM CST. Having the Model Number and Serial Number of your tool available when you call will allow us to serve you quickly and accurately.

Some parts are shown for reference only, and may not be available individually.

Non-proprietary parts, such as fasteners, can usually be found at local hardware stores or may be ordered from Wilton.

10.1 ESP1100 Wilton Strut Cutter – parts breakdown



10.2 ESP1100 Wilton Strut Cutter – parts list

Part No.	Description	Qty	
ESP1156	Main Body	1	
ESP1127	Push Block	1	
ESP1150	Safety Cover	1	
ESP-91006-21	Die Spring	2	
ESP-C251C	Cylinder SPX 25T	1	
ESP-CL-6-PBP-2	Spring Plunger	2	
LM000275	WILTON Decal	1	
ESP-61536	Star Knob	7	
ESP1100-R16	Guide rod Ø1 x 16 in.	2	
ESP1152	Handle Set Assembly	1	
	ESP1133	Handle Standoff Pin	2
	ESP1134	Handle Long	1
	ESP1143	Knurled Slider	1
	ESP1144	Handle Short	1
	ESP1145	Standoff L Bracket	2
	ESP-6PPB2	Ball Plunger Press Fit	1
ESP1157	Material Rest Assembly	1	
	----	Bottom Rail, Slotted	1
	----	Angle Block 45-Degree	1
	----	Guide Block Top/Bottom	1
	----	Plastic Slide Rail 45 Degree	1
	----	Plastic Guide Plate	1
	----	Plastic T-Guide	1
	----	Star Knob (with hex nut)	2
	----	T-Nut	2
ESP1158	Back Stop Assembly	1	
	----	Plastic Stop	1
	----	Bottom Rail	1
	----	Star Knob (with hex nut)	3
	ESP1159	Blade Set Standard	1
	----	Blade Stationary	1
	----	Blade Moving	1

Table 4

10.3 Optional accessories

Part No.		Description
ESP-9754		Hose Kit 6'
ESP-PE302S		Power Pack SPX (includes 6' hose)
ESP1163		Material Rest Assembly 4D21/4D22
	----	T-Guide Kit 4D21/4D22
	----	Guide Block Top/Bottom 4D21/4D22
	----	Plastic Guide Plate 4D21/4D22
	----	Plastic Guide T 4D21/4D22
ESP1160		Blade Set B22/B52
	----	Blade Stationary B22/B52
	----	Blade Moving B22/B52
ESP1161		Blade Set 4D21
	----	Blade Stationary 4D21
	----	Blade Moving 4D21
ESP1162		Blade Set 4D22
	----	Blade Stationary 4D22
	----	Blade Moving 4D22

Table 5

11.0 Warranty and Service

Wilton® warrants every product they sell against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-373-8206, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official Wilton branded website.

- Wilton products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance.

How to Get Technical Support

Please contact Technical Service by calling 1-800-373-8206. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. Wilton has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the Wilton website.

More Information

Wilton is consistently adding new products. For complete, up-to-date product information, check with your local distributor or visit the Wilton website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

WILTON LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

WILTON SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

Wilton sells through distributors only. The specifications listed in Wilton printed materials and on official Wilton branded website are given as general information and are not binding. Wilton reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Wilton Strut Cutter

NOTE: Wilton is a division of JPW Industries, Inc. References in this document to Wilton also apply to JPW Industries, Inc., or any of its successors in interest to the Wilton brand.



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