

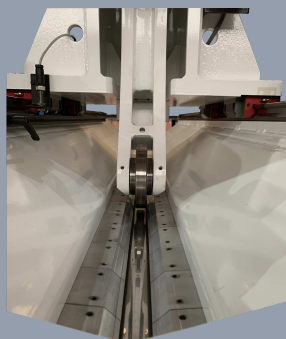
# Weld Roll Planisher



**Switches for  
Clamping of Fingers  
& starting/stopping  
System**



**Safety Motion Sensor  
& Roller Height  
Adjustment Wheel**



**Planishing Roller**



**Start / Clamp**



**Fingers  
Air Pressure  
Roller  
Planishing Pressure**

**MITUSA INC**

6161 Maywood Ave. Huntington Park, CA 90255 USA

Tel: 323.321.2002 || Fax: 323.582.7786

[www.MitusaProducts.com](http://www.MitusaProducts.com)

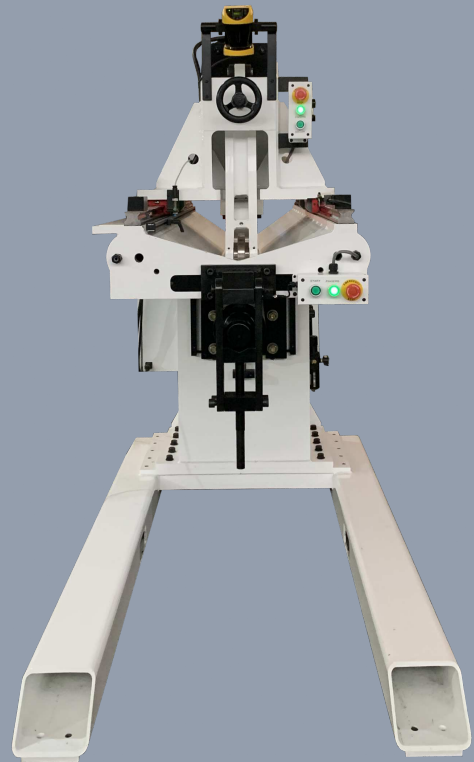
# OVERVIEW

- Weld planisher generates up to 15,000 pounds (6,804 kgs) of force to flatten and cold work the weld bead which eliminates the need for grinding the weld crown reinforcement.
- Used on both ferrous and non-ferrous metals.
- The weld bead is blended into the base material for a flat seam appearance without distorting the part shape.
- Planishing process results in improved cosmetic appearance and greater strength.
- Typically handles ¼ inch (6mm) thick and thinner automated GTAW, PAW, GMAW welds. (For other thickness, processes consult factory)
- The rugged, proven seamer style tabletop design secures the part during operation making alignment easy and allowing the operator to be hands free during planishing.
- All MITUSA planishers include a safety laser sensor that prevents the operator from getting near the active roller and part during use - the unit shuts down if safety space is violated.

Side



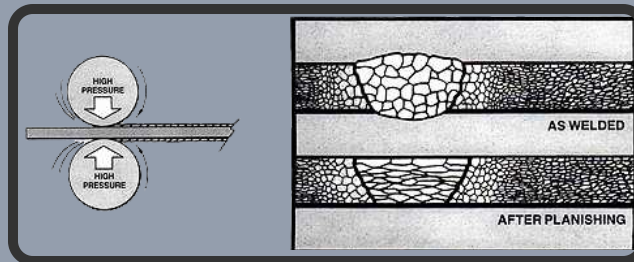
Front



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# How It Works

- The part, tube, or sheet is held in position against a rigid structural mandrel by pneumatically operated fingers.
- Mounted to a motorized gantry is a harden steel roller connected to an air ram.
- This unit rides on linear rails and exerts force on the weld and mandrel support as it rolls the length of the part.
- Both the part holding pressure of the tabletop fingers and the roller planishing force are pneumatically adjustable.
- The travel speed is adjustable up to 110 IPM (2.8m/m) maximum via an AC motor control.
- The operator uses a convenient remote foot pedal to engage the planishing process.
- Standard operation requires a 100 PSI air source and nominal 220VAC single phase electrical power.



## OPTIONS

- Available in lengths up to 20 ft. (6.1m) in increments of 1 ft. (305mm)
- Riser Assembly - Increase diameter capacity up to 10- foot (3m) diameter.(Standard diameter capacity is 40 inches {1,016mm} )
- Material Handling - Part loading arm carriage mounted to base to move tubes in and out of tabletop.
- Enhanced Control - DTS, digital touch screen. Microprocessor with PLC to set and store part specific settings for operation.
- Minimum diameter capacity is 6 inches (152mm) [Contact factor for smaller part size]
- Other design options available dependent on specification.

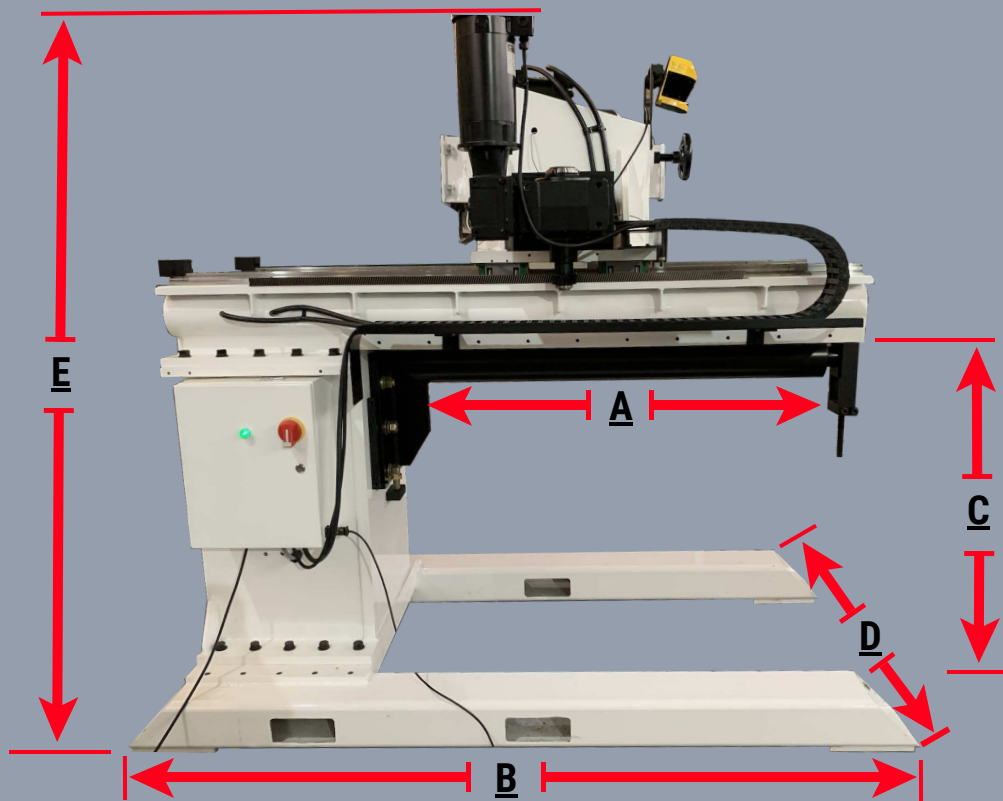


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# Specifications



| MODEL #<br>↓↓↓          | A: Planishing Length | B: Overall Length    | C: Maximum Diameter of Part | D: Overall Width    | E: Overall Height  |
|-------------------------|----------------------|----------------------|-----------------------------|---------------------|--------------------|
| <b><u>GRPST-012</u></b> | 12 inches (305mm)    | 61 inches (1549 mm)  | 40 inches (1016 mm)         | 48 inches (1219 mm) | 81 inches (2048mm) |
| <b><u>GRPST-024</u></b> | 24 inches (610 mm)   | 73 inches (1845 mm)  | 40 inches (1016 mm)         | 48 inches (1219 mm) | 81 inches (2048mm) |
| <b><u>GRPST-036</u></b> | 36 inches (916 mm)   | 85 inches (2159 mm)  | 40 inches (1016 mm)         | 48 inches (1219 mm) | 81 inches (2048mm) |
| <b><u>GRPST-048</u></b> | 48 inches (1219 mm)  | 97 inches (2463 mm)  | 40 inches (1016 mm)         | 48 inches (1219 mm) | 81 inches (2048mm) |
| <b><u>GRPST-060</u></b> | 60 inches (1524 mm)  | 109 inches (2769 mm) | 40 inches (1016 mm)         | 48 inches (1219 mm) | 81 inches (2048mm) |
| <b><u>GRPST-072</u></b> | 72 inches (1829mm)   | 121 inches (3073 mm) | 40 inches (1016 mm)         | 48 inches (1219 mm) | 81 inches (2048mm) |

**\*\*Specifications subject to change, check with manufacturer\*\***