



MMI **McELROY**
FUSION CATALOG & REFERENCE GUIDE

McElroy began operations in 1954 and has grown from a two person startup in an Oklahoma garage, to the industry expert in the science of joining thermoplastic pipe. The name McElroy is recognized worldwide as the most reliable, rugged and technically advanced fusion equipment in the world. At McElroy we credit our leadership to an unyielding focus on excellence.

McElroy's focus on innovation has always spurred growth. We have expanded countless times over the years. Each expansion had one

primary aim – gain the physical space needed to bring our inventions to life and better meet our customers' demands. Today, McElroy has combined manufacturing and assembly facilities in excess of 575,000 square feet.

Our investment in state-of-the-art technology and commitment to quality work translates to productivity in the field. Rest assured we stand behind our equipment and our customers. **For Distribution, Service and Support . . . make it a McElroy.**



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McElroy Distributor Network

McElroy products are offered through an international network of sales and authorized service center locations. Providing our customers around the globe with the tools to succeed is our number one priority. We are proud that our network can provide you with local service, training and product support.

Delivering customer focused service has always been our goal. We pride ourselves on being easily accessible to our customers through an extensive distributor network. Our machines, service and training are available through our distributors in all areas of the U.S. and around the world.

To find a distributor near you, visit www.mcelroy.com or call us at: 918-836-8611

McElroy Safety

At McElroy, your safety is our number one priority. All of our equipment, literature and training classes are strictly designed with the operators safety in mind. Never operate machinery until you have read the manual completely, and understand the safety and operation sections of your manual. Your safety and the safety of others depends upon care and judgment in the operation of the equipment. All product manuals and assembly drawings are available for downloading from our website at www.mcelroy.com



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New Machines & Accessories



NEW!

TracStar® 500 Series 3 pg66

McElroy's TracStar 500 Series 3 will butt fuse pipe sizes from 6" IPS to 20" OD (180mm - 500mm). The Series 3 incorporates numerous productivity enhancement features usually found in the MegaMc machines.

Features

- Heater and facer mounted on hydraulic indexer
- Fuel saving auto-throttle
- Standard Hydraulic Clamping
- One heater covers entire range of pipe fusion sizes
- DataLogger® compatible
- Available as Manual and Automatic

See For Yourself

Learn to fuse with the new TracStar® 500 Series 3 at McElroy University Online.



See the video today at www.McElroy.com/university



NEW!

MegaMc® PolyHorse® pg98

The MegaMc PolyHorse is a pipe-handling system designed to boost productivity on 20" to 48" OD (500mm to 1200mm) job sites. Consisting of a series of racks and powered pipe stands, it can hold enough pipe for a day's worth of fusion work. With the pipe stored in a single location and ready for use, the MegaMc PolyHorse allows heavy machinery to work in other places on the jobsite. A single operator can dispense pipe onto the stands, maneuver the pipe into alignment, and insert pipe into the fusion machine with the use of a remote control.

Features

- Maximum capacity of 70,000 lbs. (31,751 Kg) with a maximum stick weight of 10,500 lbs. (4,763 Kg).
- One operator can load, align and fuse pipe
- Minimizes wear and tear on fusion machine
- Easier to close jaws of fusion machine when properly aligned
- No double handling of pipe, pipe moves from delivery truck to racks

See For Yourself

See the MegaMc PolyHorse in action today at www.McElroy.com/fusion



NEW! DataLogger® 4 pg108

The McElroy DataLogger® 4 is used to record and document key parameters of the fusion process. This cost-effective device can be used to verify that proper fusion procedures have been followed prior to installation. The DataLogger consists of a rugged, handheld computer as the recording device connected to a pressure sending device.

Features

- FusionGuide™ visual graph interpretation
- Common fusion standards built in
- Available in multiple languages
- Fusion operations up to 3,000 psi
- Familiar Microsoft® Windows® user interface



See For Yourself

See a video on the DataLogger 4 today at www.McElroy.com/fusion

New Machines & Accessories



NEW! **MegaMc® Rollers** pg102

McElroy's MegaMc Rollers are a productivity tool that keeps pipe off the ground as it is being fused and pulled along the right of way. The rollers are designed for 12" IPS through 54" IPS (340mm to 1400mm) pipe.

The pipe and pipe joints roll through the rollers easily, reducing required pulling force. By keeping the pipe off the ground, the pipe is protected from the damage of being pulled on the ground.

Features

- Minimizes drag on the pipe
- Keeps pipe clean and off the ground
- Sealed ball-bearing construction
- Tip-resistant
- Minimizes pipe damage
- Stackable to transport 52 rollers on semi trailer
- Easily lifted with chain, straps or forks



NEW!

Guided Side Bend Tester pg111

McElroy's Guided Side Bend Tester performs a qualitative test of a fusion joint by destructively testing a coupon. The quality assurance device tests the ductility of polyethylene pipe fusion joints in a safe, quick manner. "Bend back" tests have been performed in the field for years. This testing method places the entire wall thickness into tension and gives assurance of the ductility of joints.

Features

- Qualitative testing of the ductility of a joint
- Faster, easier and safer than traditional bend tests
- Can test coupons from up to 7-inch-thick pipe walls
- Field suitable
- Lightweight
- Two-speed hydraulic hand-pump system powers coupon test



NEW!

Heater Caddy

The McElroy TracStar Heater Caddy allows the heater of the fusion machine to tag along for the ride. Simply add the accessory to your TracStar 28, 250, 412 or 618 fusion machines to enjoy this labor-saving device. Newer TracStars feature a modified chassis that makes attaching the new heater caddy easy. Older models can be modified with a retrofit kit that requires a minor amount of welding.

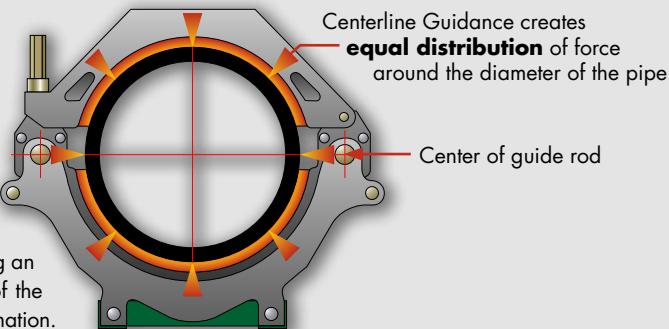
By adding the device, the heater and heater bag frame attach to the TracStar. This relieves the operator from carrying the heater and heater bag from joint to joint.

The McElroy Advantage

Through years of manufacturing fusion equipment we've learned a few things. From the beginning, we made the decision to strive for excellence in customer satisfaction and have settled for nothing less. We've improved upon our designs based on the input and needs of our customers through the years. Those developments and innovations make us the leader in the pipe fusion industry.

Quality Joint After Joint

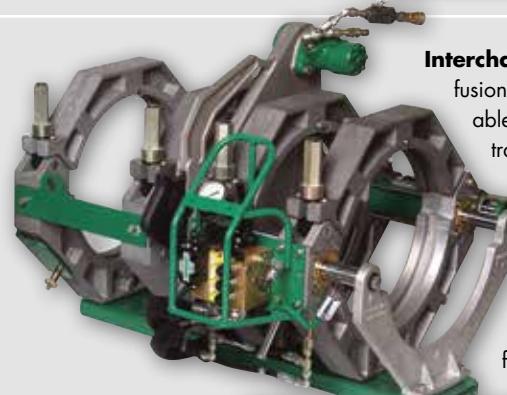
Even Fusion Force – Centerline Guidance is a balanced force system. This patented feature is incorporated in all McElroy fusion machines. The centerline of the pipe clamping jaws is on the same plane as the pipe's centerline. The force being applied during fusion passes through the center of the pipe, giving an equal distribution of force around the diameter of the pipe. This results in an even, continuous bead formation.



Productivity On The Job Site



Mobility – McElroy's wheeled and tracked machines allow greater mobility on the job site for faster set up, shortening fusion cycle times. By raising the pipe lifts, pipe can be pulled through the machine to the next fusion joint. Our TracStar® machines can be easily maneuvered into the tightest locations on any job site and many McElroy machines are "self-contained" so that a generator and separate hydraulic power unit (HPU) are not required.



Interchangeable Jaws – Most McElroy fusion machines incorporate an interchangeable 4-jaw carriage, that will fit on both a tracked or wheeled chassis and can be easily removed for in-ditch fusion as a Pit Bull® package. For tight installations and fittings, the outer fixed jaw and skid can be removed from the carriage converting it to a 3-jaw carriage for an even more compact fusion unit.

Durability & Performance



Superior Design – McElroy prides itself on building the toughest and longest lasting fusion machines in the world. With proper maintenance, many McElroy machines built in the 1970's are still operating today. They are designed to be used anywhere in the world and at interfacial pressures from 15psi to 150psi (0.1MPa to 1.03MPa). For ease of use, McElroy has incorporated many lightweight aluminum components. Critical components such as facers, jaws and inserts are surface hardened so they last for years. Facers have sealed bearings for long life and minimal maintenance. These features combine to provide quality products that have the McElroy Advantage.

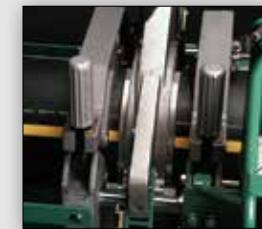


4CU built in 1975 still being used by the Washington County Water Department

We were the first to:

- Incorporate our patented Centerline Guidance System
- Manufacture self-contained fusion machines
- Design a manifold block semi-automatic pressure control system
- Develop highly productive tracked fusion machines

Facing – Each machine has machined facer stops on the clamping jaws and facer. This feature provides precise face-off with both pipe ends being perpendicular to the centerline of the pipe. It also provides controlled minimum standoff, which means the machine is clamping the pipe close to the fusion joint providing precision re-rounding and alignment of the pipe.



The McElroy Advantage



LIMITED WARRANTY:

McElroy Manufacturing, Inc. (McElroy) warrants all products manufactured, sold and repaired by it to be free from defects in materials and workmanship, its obligation under this warranty being limited to repairing or replacing at its factory and new products, within 3 years after shipment, with the exception of purchased items (such as electronic devices, pumps, switches, etc.), in which case that manufacturer's warranty applies. Warranty applies when returned freight is prepaid and which, upon examination, shall disclose to have been defective. This warranty does not apply to

any product or component which has been repaired or altered by anyone other than McElroy or has become damaged due to misuse, negligence or casualty, or has not been operated or maintained according to McElroy's printed instructions and warnings. This warranty is expressly in lieu of all other warranties expressed or implied. The remedies of the Buyer are the exclusive and sole remedies available and Buyer shall not be entitled to receive any incidental or consequential damages. Buyer waives the benefit of any rule that disclaimer of warranty shall be construed against McElroy and agrees that such disclaimers herein shall be construed liberally in favor of McElroy.

RETURN OF GOODS:

Buyer agrees not to return goods for any reason except upon the written consent of McElroy obtained in advance of such return, which consent, if given, shall specify the terms and conditions and charges upon which any such return may be made. Materials returned to McElroy, for warranty work, repair, etc., must have a Return Material Authorization (RMA) number, and be so noted on the package at time of shipment. For assistance, inquiry shall be directed to:

McElroy Manufacturing, Inc.
833 North Fulton Street
Tulsa, Oklahoma 74158-0550
PHONE: (918) 836-8611, FAX: (918) 831-9285, EMAIL: fusion@mcelroy.com

Note: Certain repairs, warranty work, and inquiries may be directed, at McElroy's discretion, to an authorized service center or distributor.

DISCLAIMER OF LIABILITY:

McElroy accepts no responsibility of liability for fusion joints. Operation and maintenance of the product is the responsibility of others. We recommend qualified joining procedures be followed when using McElroy fusion equipment. McElroy makes no other warranty of any kind whatever, express or implied; and all implied warranties of merchantability and fitness for a particular purpose which exceed the afore stated obligation are hereby disclaimed by McElroy.

PRODUCT IMPROVEMENT:

McElroy reserves the right to make any changes in or improvements on its products without incurring any liability or obligation to update or change previously sold machines and/or the accessories thereto.

INFORMATION DISCLOSED:

No information of knowledge heretofore or hereafter disclosed to McElroy in the performance of or in connection with the terms hereof, shall be deemed to be confidential or proprietary, unless otherwise expressly agreed to in writing by McElroy and any such information or knowledge shall be free from restrictions, other than a claim for patent infringement, is part of the consideration hereof.

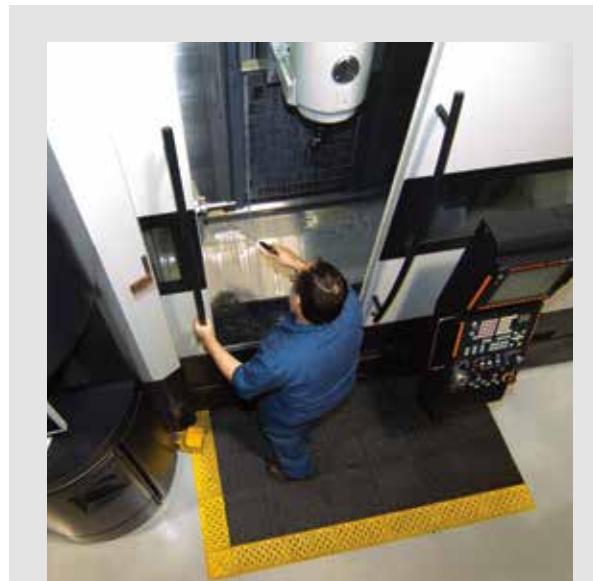
PROPRIETARY RIGHTS:

All proprietary rights pertaining to the equipment or the components of the equipment to be delivered by McElroy hereunder, and all patent rights therein, arising prior to, or in the course of, or as a result of the design or fabrication of the said product, are exclusively the property of McElroy.

LAW APPLICABLE:

All sales shall be governed by the Uniform Commercial Code of Oklahoma, U.S.A.

Register your product online to activate your warranty: www.mcelroy.com/fusion



McElroy Quality

McElroy is dedicated to Total Quality Management throughout the organization. Processes and procedures are documented utilizing our McElroy "SP" (Standard Practice) and "ES" (Engineering Standard) system. Building on our doctrine of empowerment, each process/procedure is the specific responsibility of the team member that performs the task.

Conformance to our Standards is the minimum requirement for any member of McElroy; and it is what allows us as a Company to consistently deliver products that provide the highest quality and performance in the industry. Our fusion machines comply with ISO Standard 12176-1 "Equipment for fusion jointing polyethylene systems."

The McElroy Advantage

McElroy Training

FUSION MACHINES

PRODUCTIVITY TOOLS

ACCESSORIES

REFERENCE



McElroy understands that a fully trained and qualified crew can increase the bottom line on any construction project. That's why since 1981, McElroy has offered basic and advanced fusion training designed for efficiency, productivity and safety.

Operator Training and Qualification

McElroy University Operations classes help students of all levels to develop and refine fusion skills on McElroy Equipment. With an instructional mix of 30% classroom and 70% hands-on, students learn not only the basic mechanics of machine operations but the theory behind it for an overall understanding.

Students take a written/hands-on qualification test. Testing is based on domestic and international qualification standards along with the instruction students receive during operator training. This test serves both as an indicator of their knowledge of industry standards and pipe fusion skill set. On successful completion of the test, students will be given an operator training certificate and operator qualification card good for 2 years.

Troubleshooting and Rebuild Training

As with any piece of equipment, keeping it well maintained is important to protecting your investment. That's why McElroy offers two classes on machine maintenance and overhaul; one for hydraulics and mechanical operation; and the other for electrical systems. These classes will teach your mechanics and technicians how to keep equipment running at peak efficiency.

Fusion Inspector Training

Inspector Qualification School was created to satisfy a demand from the industry for a training course designed for the polyethylene welding inspector. In the school, we will explain the theory of butt fusion of polyethylene pipe and the process used to join it. The information includes the use of inspection checklists and a discussion of the critical factors involved in the fusion welding processes. This includes butt fusion, electro-fusion, and sidewall fusion. Students also receive an in-depth explanation on the use and analysis of McElroy DataLogger® records.

Custom Training

In addition to the standard courses, we offer training customized to fit your unique needs. This training can be conducted at our facility in Tulsa, at your location or on the job site. Instruction is available in multiple languages.

Learn More and Enroll Today

Multiple classes are offered in various machine sizes. For complete descriptions of each class and a training schedule, visit our website at www.mcelroy.com/university



McElroy Training

The McElroy Advantage



TracStar® 500 Series 3



Troubleshooting McElroy Heaters

Using McElroy Equipment for
In-Ditch Fusion Operations

NEW! Online Videos

Now you can easily capitalize on the resources and knowledge base of McElroy at the office, in the field — wherever you are — with the launch of McElroy University Online. At www.McElroy.com/university you can view videos on fusion operations and machine troubleshooting and rebuild on your computer, smartphone or tablet device.

Visit www.McElroy.com/university today for free videos on:

- **Fusion Operations**
- **Troubleshooting & Rebuild**

Log on today at
www.McElroy.com/university

The McElroy Advantage

Certified McElroy Rental

The most reliable fusion machine rentals in the industry.

There are plenty of rental fusion machines in the marketplace, but how do you know if your next rental machine is properly maintained and ready to perform?

To secure a premium rental machine, make sure your next rental is from a Certified McElroy Rental equipment fleet.

There's a reason why Certified McElroy Rental equipment fleets are a step above other rental options:

- Certified McElroy Rental equipment gets better overall care than other rental machines. Your McElroy distributor adheres to a comprehensive checklist for every rental machine in their fleet.
- Machines in the rental program are constantly maintained to be in the best condition possible – all parts of the machine, from top to bottom, are checked. These checks include electrical, hydraulic, facer, heater and much more.
- Factory-trained inspectors look over the machine after each rental. If repairs are needed on a machine, McElroy factory-trained mechanics are on-hand to perform repairs with Genuine McElroy Parts.
- Certified McElroy Rental distributors are audited to ensure that each fleet meets the high expectations of the program.



Enjoy Peace of Mind.

McElroy has a long tradition of standing behind products. To protect your McElroy rental, the Certified McElroy Rental program works daily to maintain rental fleets around the globe. The combination of genuine parts, a factory-trained team and an industry-leading distribution network ensures that you can find a local rental machine that performs to McElroy's expectations...and yours.



Find Your Certified Rental

Certified McElroy Rentals are easy to locate. Visit www.certifiedmcelroy.com to use the Certified McElroy Rental Locator. Locations are spread across the world.

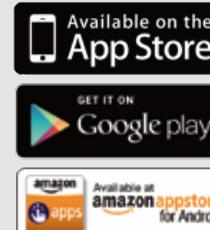
McElroy Support While On-the-go

Find the answers you need while away from your desk. Download the latest McElroy apps for your smartphone or tablet device.



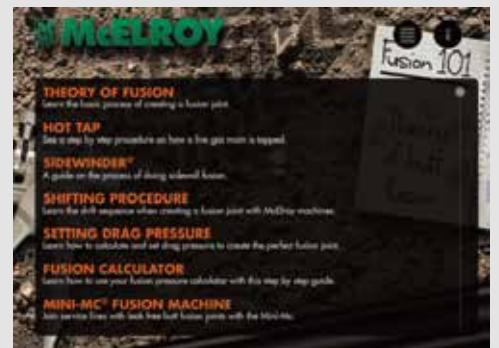
McCalc® Fusion Pressure Calculator

Designed to help you quickly find the correct fusion pressure for your job.



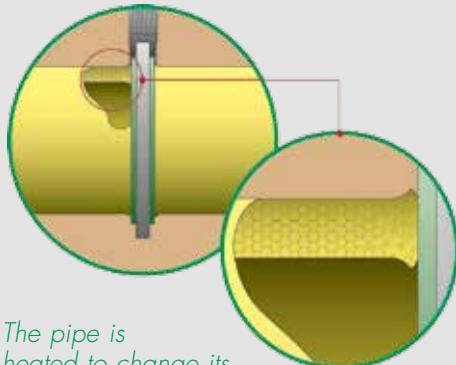
Animations App

A collection of McElroy animations on the basics of pipe fusion, specific fusion products and more.



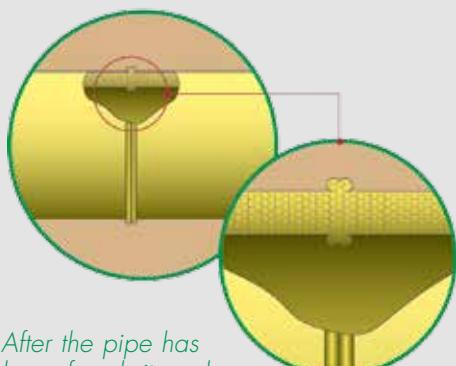
The Theory of Heat Fusion

The principle of heat fusion is to heat two surfaces to a designated temperature, and then fuse them together by application of force. This pressure causes flow of the melted materials, which causes mixing and thus fusion. When the polyethylene pipe is heated, the molecular structure is transformed from a crystalline state into an amorphous condition. When fusion pressure is applied, the molecules from each pipe end mix.



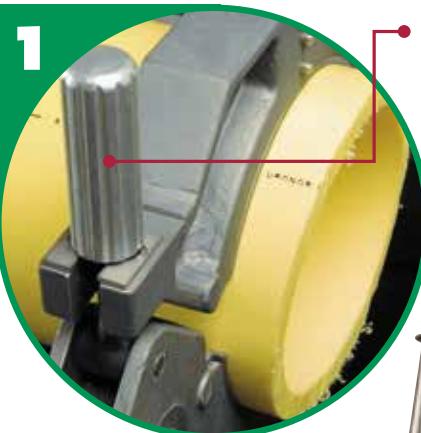
The pipe is heated to change its molecular structure to an amorphous state making it a very pliable material.

As the joint cools, the molecules return to their crystalline form, the original interfaces are gone, and the two pipes have become one homogeneous pipe. The end result is a fusion joint that is as strong or stronger than the pipe itself.



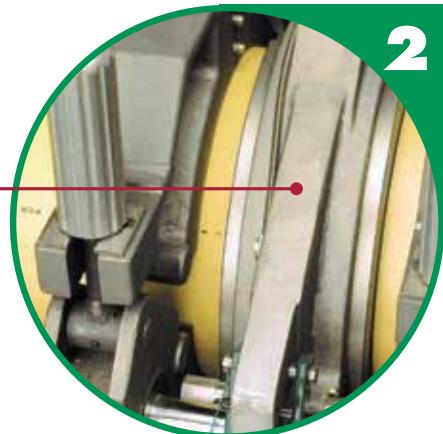
After the pipe has been fused, it cools and returns to a crystalline structure, creating one homogeneous pipe.

Theory of Heat Fusion



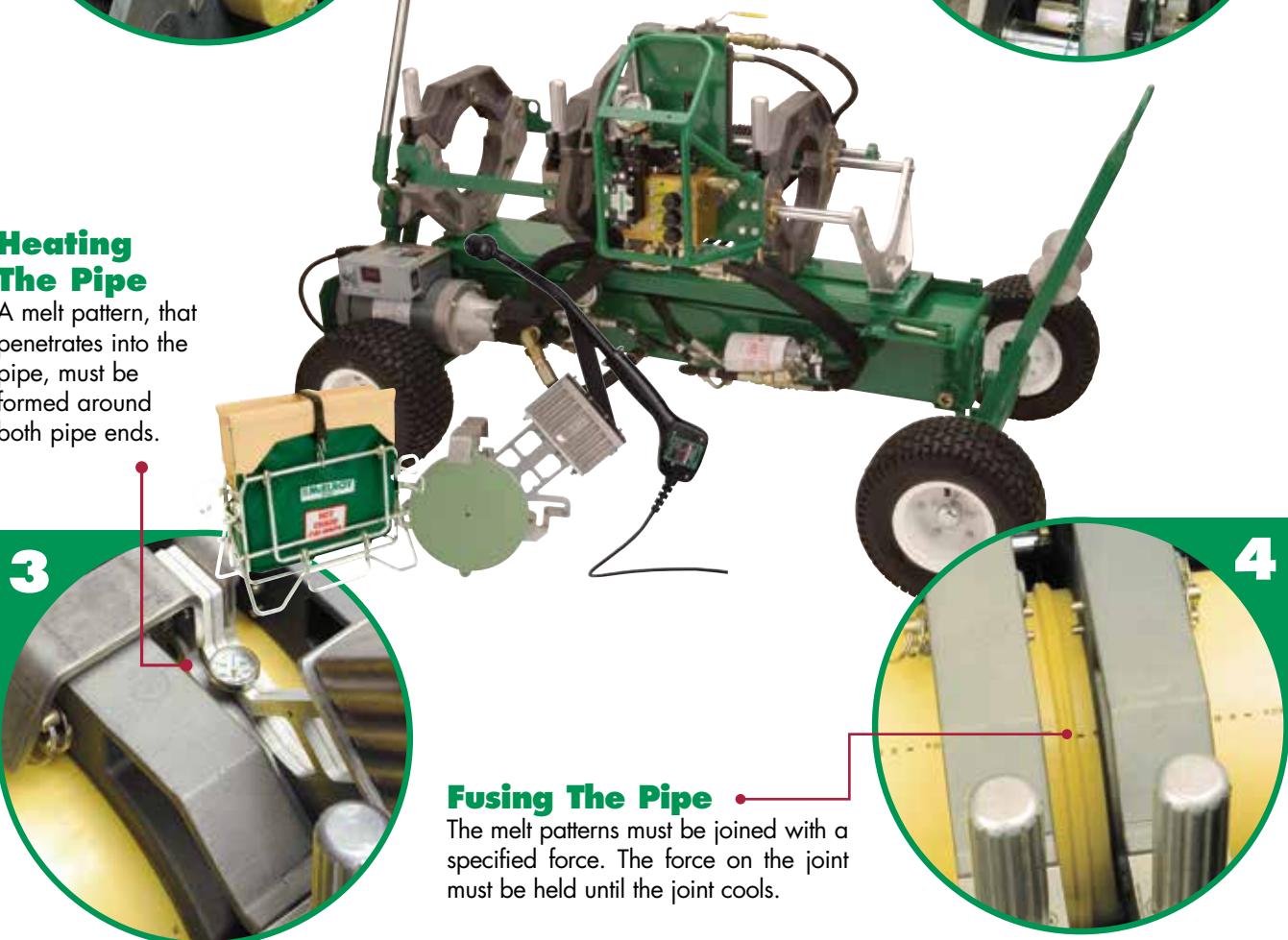
Clamping The Pipe

The pipe pieces are held axially to allow all subsequent operations to take place.



Facing The Pipe

The pipe ends are faced to establish clean, parallel mating surfaces, perpendicular to the centerline of each pipe.



Fusing The Pipe

The melt patterns must be joined with a specified force. The force on the joint must be held until the joint cools.

Mini-Mc® Fusion Machine

Fusion Capability for $\frac{1}{2}$ " CTS – 1" IPS (16mm – 34mm)



Mini-Mc®

McElroy's smallest fusion machine, the **Mini-Mc®**, makes small diameter butt fusion projects simple. They are compact, lightweight, highly reliable, accurate and rugged. Perfect for joining **$\frac{1}{2}$ " CTS to 1" IPS (16mm to 34mm)** service sizes. The Mini-Mc requires only one operator and works in the most difficult conditions. McElroy's patented features and precision engineering provide joint integrity and minimal maintenance. The narrow clamp design provides for butt fusion with precise pipe alignment at the

fusion joint. The heater is thermostatically controlled and has a durable anti-stick coating.

- Compact, lightweight
- Hand-operated
- Thermostatically controlled heater
- 2.3-to-1 mechanical advantage

Mini-Mc

Includes fusion machine and screw/driver kit. Heater, facer, and inserts are sold separately.

Machine Size	Model No.
1" IPS Mini-Mc	CTS07901
32mm Mini-Mc	CTS08001

WHEN WORKING IN TIGHT CONFINES, TRY THE 1LC.

Are you fusing from above? Working in-ditch? Check out the new 1LC, which fuses the same sizes as the Mini-Mc.

See page 14 for more details.



MACHINE PLUG TYPE
To find the right electrical plug type see
Page 140

GENERATOR
To size your generator see
Page 147

ACCESSORIES
To find other related accessories see
Page 128

McElroy Technical Service:

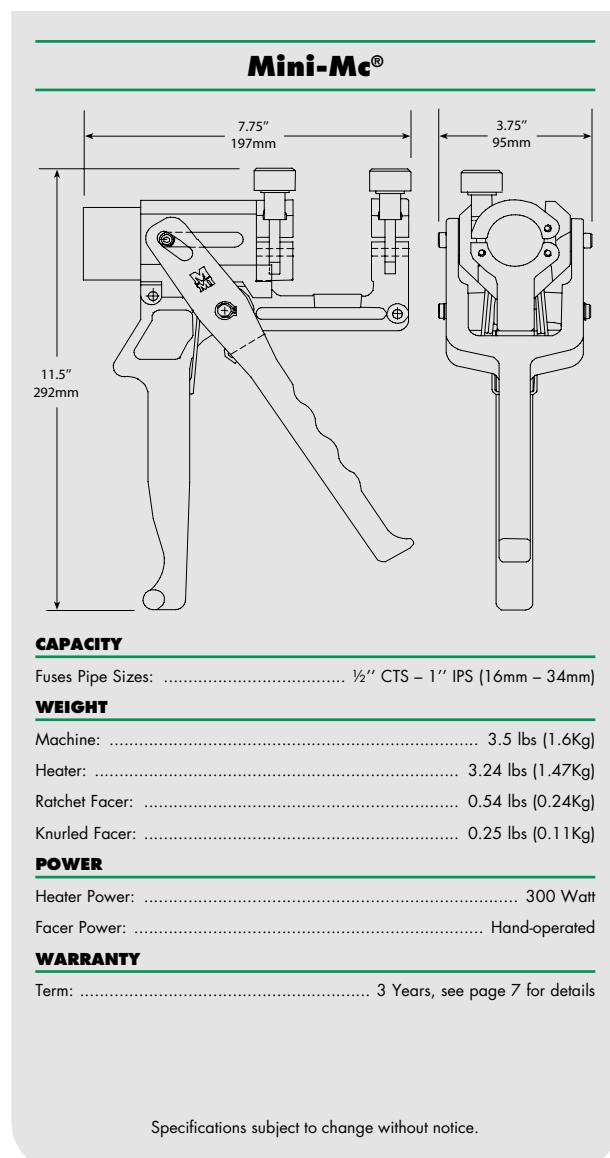
Online or Off

Whether you prefer online documentation, discussion forums, facebook, twitter, or a personal phone call, our technical services staff along with our worldwide distributor network are ready to assist with any technical issue on or off the jobsite.



See page 140 for more details.

Specifications & Accessories Mini-Mc®



Part No.	Description		
Heaters - See legend above for more information.			
	A	CTS00702 100-120V, 50/60Hz, 300 Watt, 1Ph	
	C	CTS00703 200-240V, 50/60Hz, 300 Watt, 1Ph	
Insulated Heater Sling			
	CTS08301	Protects heater and helps maintain a constant temperature.	
Ratchet Facer			
	CTS15014	This facer is designed for increased leverage.	
Knurled Facer			
	CTS01701	This facer is designed for compact use.	
Spare Facer Blade Set			
	CTS06803	Set of two spare facer discs. Compatible with either facer and made of hardened steel.	
Spare Screw/Driver Kit			
	ACTS08201	Spare driver kit with insert screws and wire brush for cleaning serrated jaws and inserts.	
Tubing Shear			
	MMD00009	Used to cut plastic tubing only, up to 1.7" OD capacity.	
Pyrometer Kit			
	A218804	Accurately checks surface temperatures of heater.	
Min-Mc Case			
	MJQ00032	Our strong and durable carrying case will hold a Min-Mc, heater, heater sling, facer, inserts, tubing shear, and other miscellaneous items.	
Min-Mc Facer Insert Set - Set = 2 inserts			
	CTS15017	1" IPS	1.32" OD
	CTS15019	1" CTS	1.13" OD
	CTS15020	3/4" IPS/27mm	1.05" OD
	CTS15021	3/4" CTS	0.88" OD
	CTS15022	1/2" IPS	0.84" OD
	CTS15018	1/2" CTS	0.63" OD
	CTS15030	34mm	1.34" OD
	CTS15028	32mm	1.26" OD
	CTS15026	25mm	0.98" OD
	CTS15024	20mm	0.79" OD
Butt Fusion Insert Set - Set = 4 inserts, screws & wrench			
	Inserts are serrated for maximum grip and are made for one size pipe only. Inserts are required for pipe sizes less than 1" IPS or 32mm.		
	CTS07101	1" CTS	1.13" OD
	CTS07201	3/4" IPS	1.05" OD
	CTS07301	3/4" CTS	0.88" OD
	CTS07401	1/2" IPS	0.84" OD
	CTS07501	1/2" CTS	0.63" OD
	CTS09201	25mm	0.98" OD
	CTS09301*	25mm	0.98" OD
	CTS09101	20mm	0.79" OD
	CTS13501*	20mm	0.79" OD

* For use with CTS08001

1LC Fusion Machine

Fusion Capability for **½" CTS – 1" IPS (16mm – 34mm)**



1LC

The 1LC is the tool of choice for butt fusing **½" CTS to 1" IPS (16mm - 34mm)** service sizes. As an alternative to the Mini-Mc®, the 1LC offers a more conventional style of operation while maintaining the great features of the 2LC. McElroy engineers designed the heater to locate on the guide rods of the unit, similar to the entire line of McElroy fusion machines. The compact design allows for fusing in tight quarters.

1LC

Includes fusion machine, heater, facer, insulated heater sling, ratchet wrench, screw/driver kit and case

Max. Pipe Size	Model No.	Input Voltage Requirements	Plug Type (See pg 140)
1"	ACTS16001	100V-120V, 50/60Hz, 100 Watt, 1Ph	A
1"	ACTS16002	200V-240V, 50/60Hz, 100 Watt, 1Ph	C
32mm	ACTS16003	100V-120V, 50/60Hz, 100 Watt, 1Ph	A
32mm	ACTS16004	200V-240V, 50/60Hz, 100 Watt, 1Ph	C

- Patented Centerline Guidance System for equal distribution of force around the joint
- Locking cam that locks moveable jaw during cooling cycle
- 3.8-to-1 mechanical advantage
- Conventional facer design features ball-bearing construction and gear drive for long life
- Jaws use same inserts as original Mini-Mc®
- Serrated jaws and inserts keep pipe from slipping during fusion process



MACHINE PLUG TYPE

To find the right electrical plug type see [Page 140](#)

GENERATOR

To size your generator see [Page 147](#)

ACCESSORIES

To find other related accessories see [Page 128](#)

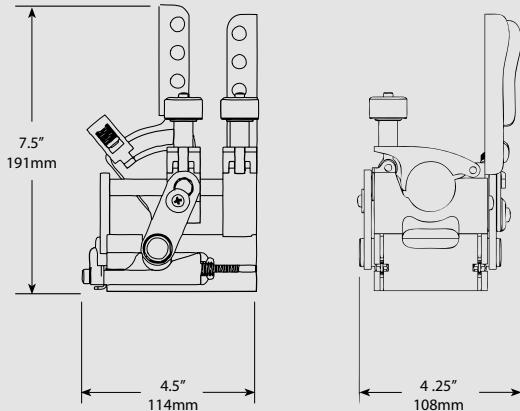
McElroy's International Distribution Network

McElroy products are offered through an international network of sales and authorized service center locations providing our customers around the globe with the tools to succeed.



See page 140 for more details.

Specifications & Accessories 1LC

1LC**CAPACITY**

Fuses Pipe Sizes: 1/2" CTS – 1" IPS (16mm – 34mm)

WEIGHT

Machine: 3 lbs (1.36Kg)

Facer: 1.8 lbs (.82Kg)

Heater: 2.5 lbs (1.13Kg)

POWER

Heater Power: 100 Watt

Facer Power: Hand-operated with 3/8" square drive

WARRANTY

Term: 3 Years, see page 7 for details

Specifications subject to change without notice.

Part No.

Description

Spare Heaters - See legend above for more information.

Micropressor-controlled to maintain heater temperature.		
A	CTS20101	100V-120V, 50/60Hz, 100 Watt, 1Ph
C	CTS20001	200V-240V, 50/60Hz, 100 Watt, 1Ph

Part No.

Description

Spare 1LC Case

CTS15801

Our strong and durable carrying case will hold a 1LC, heater, heater sling, facer, and inserts.

Spare Insulated Heater Sling

CTS08301

Protects heater and helps maintain a constant temperature.

Spare 1LC Facer

CTS17601

Spare facer used to face pipe ends.

Butt Fusion Insert Set - Set = 4 inserts, screws and wrench

Inserts are serrated for maximum grip and are made for one size pipe only. Inserts are required for pipe sizes less than 1" IPS.

CTS07101	1" CTS	1.13" OD
CTS07201	3/4" IPS	1.05" OD
CTS07301	3/4" CTS	0.88" OD
CTS07401	1/2" IPS	0.84" OD
CTS07501	1/2" CTS	0.63" OD
CTS09201	25mm	0.98" OD
CTS09101	20mm	0.79" OD
CTS09301*	25mm	0.98" OD
CTS13501*	20mm	0.79" OD

* For use with ACTS16003 and ACTS16004

Spare Facer Blade Set

CTS21302

Blade set includes 2 blades, attaching screws and wrench.

Spare Screw/Driver Kit

ACTS08201

Spare driver kit with insert screws and wire brush for cleaning serrated jaws and inserts.

Tubing Shear

MMD00009

Used to cut plastic tubing only, up to 1.7" OD capacity.

Pyrometer Kit

A218804

Accurately checks surface temperatures of heater.

Socket Tooling

Socket Fusion Capability for **½" CTS – 4" IPS** pipe (16mm – 125mm)



Socket Tooling

McElroy Socket Tooling is perfect for installing fittings and allows you the ability to socket fuse **½" CTS to 4" IPS (16mm to 125mm)** pipe. These socket tools are designed to meet ASTM standard F1056, ISO 8085-1 and ISO 4437 pipes.

With the new Socket Tooling Kits, you can locate and identify a specific range of socket tooling equipment that fits your needs, instead of ordering each piece separately. All of the included equipment conveniently fits in a specially designed tool box and tray to keep all of your socket tooling in one place.

Parts can be ordered individually or in these convenient kits. Other kits available upon request.



Socket Tooling Kits

Includes tool box, heater, heater adapters, tubing shears/cutters, chamfer tools/depth gauges, screw/driver kit and cold ring tools.

Kit No.	Socket Tooling	Multi-Mc Heater			Socket Fitting Holder (s)	Shears/Cutters	Heater Adapter Sets, Chamfer Tool/Depth Gauge, and Cold Ring Tools
		Size	Voltage Requirements	Plug Type (See pg 140)			
ASW19101	¾" - 2" IPS	2"	100V-120V, 50/60Hz, 800 Watt, 1Ph	A	2" IPS	1.7" & 2.4" OD capacity	¾" IPS, 1" IPS, 1¼" IPS, 1½" IPS, and 2" IPS
ASW19102		2"	200V-240V, 50/60Hz, 800 Watt, 1Ph	C			
ASW19201	½" CTS - 2" IPS	2"	100V-120V, 50/60Hz, 800 Watt, 1Ph	A	2" IPS	1.7" & 2.4" OD capacity	½" CTS, ½" IPS, ¾" CTS, ¾" IPS, 1" CTS, 1" IPS, 1¼" CTS, 1¼" IPS, 1½" IPS & 2" IPS
ASW19202		2"	200V-240V, 50/60Hz, 800 Watt, 1Ph	C			
ASW19301	3" & 4" IPS	4"	100V-120V, 50/60Hz, 1200 Watt, 1Ph	A	3" & 4" IPS	4" Plastic Pipe Cutter	3" IPS, 4" IPS
ASW19302		4"	200V-240V, 50/60Hz, 1200 Watt, 1Ph	C			
ASW19401	¾" & 1¼" IPS	2"	100V-120V, 50/60Hz, 800 Watt, 1Ph	A	N/A	1.7" & 2.4" OD capacity	¾" IPS, 1¼" IPS
ASW19402		2"	200V-240V, 50/60Hz, 800 Watt, 1Ph	C			
ASW19501	16mm - 63mm	2"	100V-120V, 50/60Hz, 800 Watt, 1Ph	A	2" IPS	4" Plastic Pipe Cutter	16mm, 20mm, 25mm, 32mm, 40mm, 50mm, 65mm
ASW19502		2"	200V-240V, 50/60Hz, 800 Watt, 1Ph	C			
ASW19601	75mm - 125mm	4"	100V-120V, 50/60Hz, 800 Watt, 1Ph	A	3" & 4" IPS	1.7" & 2.4" OD capacity	75mm, 90mm, 110mm, 125mm
ASW19602		4"	200V-240V, 50/60Hz, 800 Watt, 1Ph	C			

Specifications & Accessories Socket

Heater Adapter Set



Used to heat pipe and fitting. All adapters have an anti-stick coating. Imperial size heater adapters are manufactured in compliance with ASTM F1056. Metric heater adapters listed below are for ISO 8085-1 socket fusion fittings and ISO 4437 pipes.

Part No.	Pipe Size	
SW02676 ④	4" IPS	4.50" OD
SW02672 ④	3" IPS	3.50" OD
SW02669 ②	2" IPS	2.37" OD
SW02668 ②	1½" IPS	1.90" OD
SW02667 ②	1¼" IPS	1.66" OD
SW02666 ②	1¼" CTS	1.38" OD
SW02665	1" IPS	1.32" OD
SW02662	1" CTS	1.13" OD
SW02664	¾" IPS	1.05" OD
SW02661	¾" CTS	0.88" OD
SW02663	½" IPS	0.84" OD
SW02660	½" CTS	0.63" OD
SW14160 ④	125mm	4.92" OD
SW14159 ④	110mm	4.33" OD
SW14158 ④	90mm	3.54" OD
SW14157 ④	75mm	2.95" OD
SW14156	63mm	2.48" OD
SW14155	50mm	1.97" OD
SW14154	40mm	1.57" OD
SW14153	32mm	1.26" OD
SW14152	25mm	0.98" OD
SW14151	20mm	0.78" OD
SW14150	16mm	0.63" OD

② Requires the 2" Multi-Mc® Heater

④ Requires the 4" Multi-Mc® Heater

Chamfer Tool/Depth Gauge



Used to put the required chamfer on the end of the pipe and is used as a depth gauge.

Part No.	Pipe Size	
SW08736	4" IPS	4.50" OD
SW08734	3" IPS	3.50" OD
SW08701	2" IPS	2.37" OD
SW08703	1½" IPS	1.90" OD
SW08705	1¼" IPS	1.66" OD
SW08713	1¼" CTS	1.38" OD
SW08707	1" IPS	1.32" OD
SW08715	1" CTS	1.13" OD
SW08709	¾" IPS	1.05" OD
SW08717	¾" CTS	0.88" OD
SW08711	½" IPS	0.84" OD
SW08719	½" CTS	0.63" OD
SW14321	125mm	4.92" OD
SW14319	110mm	4.33" OD
SW14317	90mm	3.54" OD
SW14315	75mm	2.95" OD
SW14313	63mm	2.48" OD
SW14311	50mm	1.97" OD
SW14309	40mm	1.57" OD
SW14307	32mm	1.26" OD
SW14305	25mm	0.98" OD
SW14303	20mm	0.78" OD
SW14301	16mm	0.63" OD

Heater Size	Model No.	Input Voltage Requirements	Plug Type (See pg 140)
2"	214905	100V-120V, 50/60Hz, 800 Watt, 1Ph	A
2"	214906	200V-240V, 50/60Hz, 800 Watt, 1Ph	C
4"	424315	100V-120V, 50/60Hz, 1200 Watt, 1Ph	A
4"	424316	200V-240V, 50/60Hz, 1200 Watt, 1Ph	C

Multi-Mc® Heaters - Microprocessor control and dial thermometer to monitor temperature. Heater adapters sold separately



2"	214905	100V-120V, 50/60Hz, 800 Watt, 1Ph	A
2"	214906	200V-240V, 50/60Hz, 800 Watt, 1Ph	C
4"	424315	100V-120V, 50/60Hz, 1200 Watt, 1Ph	A
4"	424316	200V-240V, 50/60Hz, 1200 Watt, 1Ph	C

Cold Ring Tool



Used with the depth gauge to clamp at the proper depth and to round and hold the pipe to be fused.

Part No.	Pipe Size	
SW02724	4" IPS	4.50" OD
SW02723	3" IPS	3.50" OD
SW02710	2" IPS	2.37" OD
SW02722	1½" IPS	1.90" OD
SW02721	1¼" IPS	1.66" OD
SW02717	1¼" CTS	1.38" OD
SW02720	1" IPS	1.32" OD
SW02716	1" CTS	1.13" OD
SW02719	¾" IPS	1.05" OD
SW02715	¾" CTS	0.88" OD
SW02718	½" IPS	0.84" OD
SW02714	½" CTS	0.63" OD
SW14211	125mm	4.92" OD
SW14210	110mm	4.33" OD
SW14209	90mm	3.54" OD
SW14208	75mm	2.95" OD
SW14207	63mm	2.48" OD
SW14206	50mm	1.97" OD
SW14205	40mm	1.57" OD
SW14204	32mm	1.26" OD
SW14203	25mm	0.98" OD
SW14202	20mm	0.78" OD
SW14201	16mm	0.63" OD

Part No.

Description

Insulated Heater Sling



SW08601

Insulated heater sling protects heater and helps maintain a constant temperature.

Socket Fitting Holder - Required for 2" and larger fittings



SW07101

2" Holder

SW10601

3" Holder

SW11201

4" Holder

Auxiliary Handle Kit - Includes attaching screws



Suggested for 1¼" fittings and larger.

SW02804

For 2" Multi-Mc® heater.

SW02806

For 4" Multi-Mc® heater.

Spare Screw/Driver Kit - For use with Multi-Mc® heaters



A214102

For 2" Multi-Mc® heater.

A424901

For 4" Multi-Mc® heater.

Spare Chamfer Blade



SW08731

Spare blade for the depth gauge/chamfer tool.

Socket Tooling Storage Box



ASW15901

Storage box for socket tooling and accessories. Includes universal storage tray to organize tooling.

Pyrometer Kit



A218804

Accurately checks surface temperatures of heater.

2LC & 2CU Fusion Machine

Fusion Capability for $\frac{1}{2}$ " CTS – 2" IPS (16mm – 60mm)

2LC

The **2LC** employs a semi-automatic locking cam (LC) system to lock the movable jaw in place during the cooling cycle. It will butt fuse **$\frac{1}{2}$ " CTS to 2" IPS (16mm to 60mm)** pipe. The 2LC incorporates McElroy's patented Centerline Guidance System, and is designed to butt fuse tees, ells and other fittings. The machine is made primarily of surface-hardened aluminum for light weight and durability. The jaws and inserts have multiple serrations for maximum grip on the pipe. Raise the machine to a comfortable level with the optional manual fusion machine stand.



2CU

The **2CU** Machine will butt fuse **$\frac{1}{2}$ " CTS to 2" IPS (16mm to 60mm)** pipe, tees, ells and other fittings. This combination unit (CU) incorporates McElroy's patented combination sidewall feature. Sidewall clamps with chain vise allow the unit to be attached on the centerline of a pipe main for sidewall fusion of $\frac{1}{2}$ " to 2" service saddles, round base branch saddles and small tapping tees. The 2CU is equipped with chain lengths that will clamp up to 8" IPS pipe. Additional chain lengths are available for larger main sizes. For additional sidewall fusion accessories, see page 118-119.



2LC

Includes fusion machine, heater, facer, insulated heater/facer stand and screw/driver kit.

Machine Type	Model No.	Input Voltage Requirements	Plug Type (See pg 140)
Manual	A217201	100V-120V, 50/60Hz, 800 Watt, 1Ph	A
Manual	A217202	200V-240V, 50/60Hz, 800 Watt, 1Ph	C



2CU

Includes fusion machine, heater, facer, insulated heater/facer stand and screw/driver kit.

Machine Type	Model No.	Input Voltage Requirements	Plug Type (See pg 140)
Combination Unit	A200101	100V-120V, 50/60Hz, 800 Watt, 1Ph	A
Combination Unit	A200102	200V-240V, 50/60Hz, 800 Watt, 1Ph	C

2LC

- Compact and durable
- Semi-automatic locking cam to lock moveable jaw
- Butt fusion of pipe and fittings
- 5.8-to-1 mechanical advantage

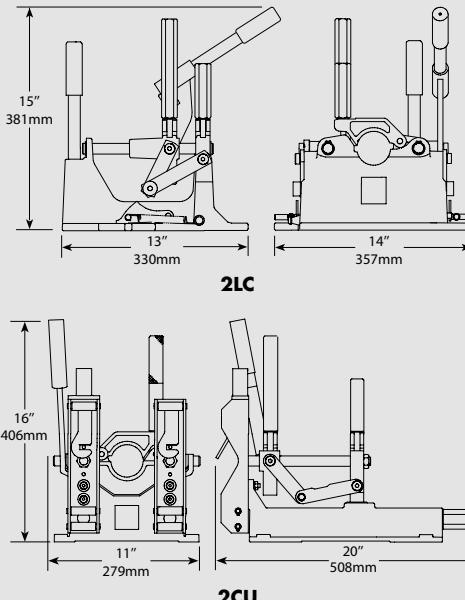
2CU

- Operator maintains fusion force
- Sidewall capabilities for $\frac{1}{2}$ " to 2" fittings
- Butt fuses a variety of fittings and pipe



Specifications & Accessories 2LC & 2CU

2LC & 2CU



CAPACITY

Fuses Pipe Sizes: ½" CTS – 2" IPS (16mm – 60mm)

WEIGHT

2LC Machine: 23 lbs (10.4Kg)

2CU Machine: 28 lbs (12.7Kg)

Facer: 7.9 lbs (3.54Kg)

Heater: 7.24 lbs (3.28Kg)

POWER

Heater Power: 800 Watt

Facer Power: Hand-operated

WARRANTY

Term: 3 Years, see page 7 for details

Specifications subject to change without notice.
Additional dimensions available on page 144.

Spare Heater Plate Kit



A215701

Plates have an anti-stick coating and are required for butt fusion. The kit includes 2 plates, attaching screws and wrench.

Part No.

Description

Spare Facer Blades



205702

Blade set includes 4 blades, attaching screws and wrench.

Spare Multi-Mc® Heater Kits



Kit includes heater plates.

A215505 100V-120V, 50/60Hz, 1Ph

A215506 200V-240V, 50/60Hz, 1Ph

Spare Facer



216101

Spare facer used to face pipe ends to be fused.

Spare Stand with Heater Bag



218301

Holds facer and heater for easier carrying and protection. Heater bag helps the heater maintain a constant temperature.

Spare Screw/Driver Kit



A214201

Spare driver kit with insert screws and wire brush for cleaning serrated jaws and inserts.

Pyrometer Kit



A218804

Accurately checks surface temperatures of heater.

Heat Shield



203004

For fusing two materials with different melt rates. Shields the faster melt rate materials from over melting.

Part No.

Description

Storage Box



MJQ00193

Storage box for 2LC fusion machine, inserts and adapters.

MJQ00194

Storage box for 2CU fusion machine, inserts and adapters.

Insert & Adapter Box



ASW15902

Storage box for organizing your inserts and adapters for safe keeping.

2LC Manual Fusion Machine Stand - See page 24



439001

Expands to a comfortable operator height equal to our other pipe supports. Folds for easy storage and has wheels for easy transporting.

Butt Fusion Insert Set - Set = 4 inserts, screws and wrench



All inserts are surface hardened for longer life and are serrated for maximum grip on the pipe. Inserts are made for one size pipe only and are required for pipe sizes less than 2" IPS. Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs.

For JIS insert sizes, see page 127.

207515	1½" IPS	1.90" OD
207533	1½" CTS	1.63" OD
207514	1¼" IPS	1.66" OD
207519	1¼" CTS	1.38" OD
207513	1" IPS	1.32" OD
207518	1" CTS	1.13" OD
207512	¾" IPS	1.05" OD
207517	¾" CTS	0.88" OD
207521	½" IPS	0.84" OD
207516	½" CTS	0.63" OD
207531	50mm	1.97" OD
207529	40mm	1.57" OD
207527	32mm	1.26" OD
207525	25mm	0.98" OD
207523	20mm	0.79" OD

Sidewinder® Fusion Machine

Fusion Capability up to 4" Branch Saddles, Tapping Tees, & Service Saddle Fittings onto all Main Sizes

Sidewinder

The McElroy Sidewinder® fusion machines give you the ability to saddle fuse 4" IPS and smaller branch saddles, tapping tees and service saddle fittings onto 1½" IPS and larger main sizes. The Sidewinder comes in two configurations: the Jaw Clamp and Chain Clamp. The Jaw Clamp Sidewinder is used for fusing branch saddles, tapping tees and service saddle fittings onto 1½" to 4" IPS main sizes. The Chain Clamp Sidewinder gives you the ability to fuse onto main sizes larger than 4" IPS. Both Sidewinders are DataLogger® compatible.



The standard size Sidewinders are designed to fuse a full range of fittings. The compact Sidewinders are designed for tighter confines and smaller fittings.

- Quick Release System
- Manually operated
- Microprocessor-controlled heater
- Fuses a variety of fittings
- DataLogger® compatible

Sidewinders For Sidewall Tooling, see pages 122-126

Includes fusion machine, 3" pivot master and screw/driver kit. Heaters and adapters are sold separately.

Model	300 PSI Gauge *	600 PSI Gauge *	1000 PSI Gauge *	1500 PSI Gauge *
Chain Clamp	ASW00113	ASW00112	ASW00111	ASW00110
Compact Chain Clamp	ASW00123	ASW00122	ASW00121	ASW00120
Jaw Clamp	ASW00133	ASW00132	ASW00131	ASW00130
Compact Jaw Clamp	ASW00143	ASW00142	ASW00141	ASW00140

* Choose the gauge option to best suit the fittings you plan to fuse. Lower pressure gauges offer smaller increments for a more precise pressure reading. Your fitting manufacturer can recommend the proper fusion pressures.



GENERATOR

To size your generator see
Page 147

DataLogger

To learn more about the DataLogger see
Page 108

SIDEWALL ACCESSORIES

To find sidewall fusion accessories see
Pages 120-124

McElroy Technical Service:

Online or Off Whether you prefer online documentation, discussion forums, facebook, twitter, or a personal phone call, our technical services staff along with our worldwide distributor network are ready to assist with any technical issue on or off the jobsite.



SPARE HEATER LEGEND

A Plug type A C Plug type C

See page 140 for more details.

Part No.	Description
2" Multi-Mc® Heaters - Heater adapters sold separately. See legend above for more information.	
	Microprocessor-controlled to maintain heater temperature.
A 214905	100-120V, 50/60Hz, 800 Watt, 1Ph
C 214906	200-240V, 50/60Hz, 800 Watt, 1Ph

Part No.	Description
4" Multi-Mc® Heaters - Heater adapters sold separately. See legend above for more information.	
	Microprocessor-controlled to maintain heater temperature.
A 424315	100-120V, 50/60Hz, 1200 Watt, 1Ph
C 424316	200-240V, 50/60Hz, 1200 Watt, 1Ph

Pivot Release Master		
	SW04701	3" IPS pivot master (Included with Sidewinder).
	SW07301	4" IPS pivot master.

Conversion Clamp Kits		
	ASW10301	Chain clamp kit.
	ASW10201	Jaw clamp kit.

Insulated Heater Sling		
	SW08601	Protects heater and helps maintain constant temperature.

Sidewinder Conversion Kits		
	SW13602	Converts Sidewinder from a standard to compact configuration.
	SW13601	Converts Sidewinder from a compact to standard configuration.

Chain Extension Kit		
	A213601	30" chain extensions for main sizes larger than 8" IPS. Requires a minimum of two.

Part No.	Description
Spare Screw/Driver Kit	
	ASW07801

Part No.	Description
DataLogger® - To learn more, see page 108	
	Used to record and document fusion process parameters.
DL6303	Wireless DataLogger
DL6304	Wired DataLogger
DL13501	NEW! DataLogger 4 English Package*

* Other languages available. See page 108 for details.

Part No.	Description
	ADL6603 DataLogger adapter kit for Sidewinder. For more information, see page 109.

Part No.	Description
	203005 For fusing two materials with different melt rates. Shields the faster melt rate materials from over melting.

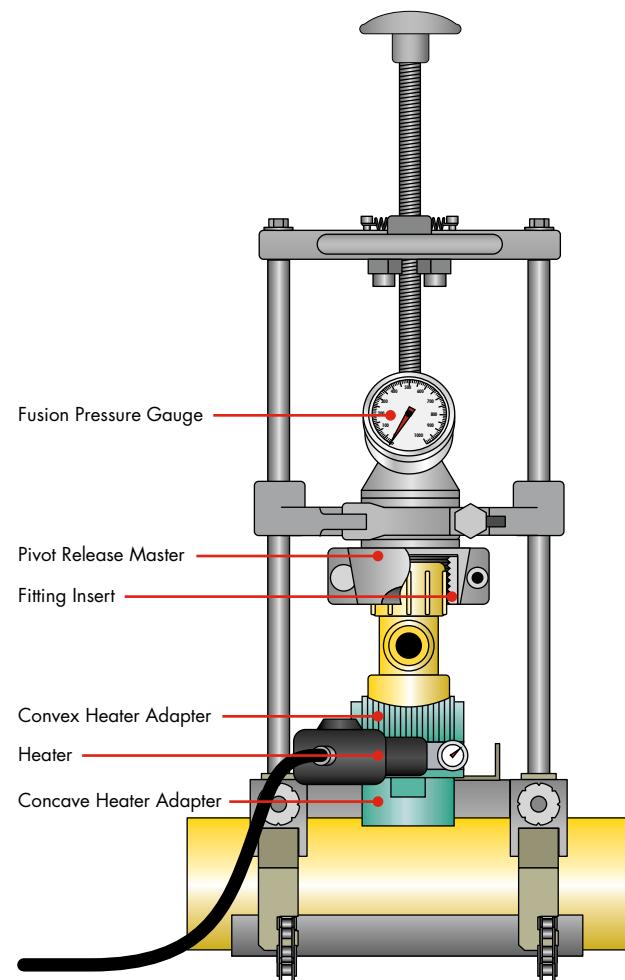
Part No.	Description
	A218804 Accurately checks surface temperatures of heater.

Part No.	Description
	ASW15902 Storage box with universal storage tray to organize tooling.

Part No.	Description
	MJQ00191 Storage box for Sidewinder fusion machines, inserts and adapters.

Accessories **Sidewinder®**

Part No.	Description
Spare Gauge Kit	
ASW13104	300 PSI Kit
ASW13102	600 PSI Kit
ASW13105	1000 PSI Kit
ASW13103	1500 PSI Kit



For Sidewall Tooling: See pages 120-124

To see a video of the Sidewinder go to:
www.mcelroy.com/fusion/videos.htm

14 Fusion Machine

Fusion Capability for 1" IPS – 4" DIPS pipe (32mm – 110mm)



Pit Bull® 14

The McElroy **Pit Bull 14** is a compact, lightweight, highly reliable and rugged machine. It fuses **1" IPS to 4" DIPS (32mm to 110mm)** pipe. The machine incorporates McElroy's patented Centerline Guidance System, and is designed to butt fuse tees, ell and other fittings with consistent, high-quality results. The machine has a semi-automatic locking cam that locks the movable jaw in place during the cooling cycle.

The machine is primarily made of surface-hardened aluminum for light weight and durability. Features include reversible jaws, clamp knobs and facer. An optional 4-wheel cart with outrigger pipe supports or a manual fusion machine stand is available. The stand raises the machine to a comfortable level and folds for easy transport.

- Lightweight and Durable
- Semi-automatic locking cam to lock moveable jaw
- Designed to fuse a variety of fittings
- 15-to-1 mechanical advantage

14

Includes fusion machine, facer, heater, insulated heater/facer stand and screw/driver kit.

Model No.	Input Voltage Requirements	Minimum Power Requirements *	Plug Type (See pg 140)
A430101	100V-120V, 50/60Hz, 1Ph	3 KVA, 2.5 KW	A
A430102	200V-240V, 50/60Hz, 1Ph	3 KVA, 2.5 KW	C

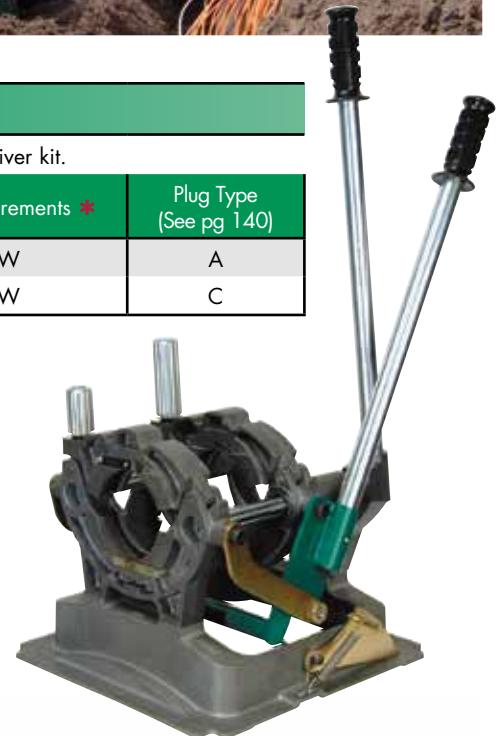
* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on 147.

14 Productivity Package

A441501-120V A441502-240V

What you get: 1 14, 1 Manual Fusion Machine Stand and 2 PolyPorters®.

This package is for the contractor that wants to save time and money with the benefit of having all of these labor-saving devices in one cost-efficient package.



GENERATOR

To size your generator see
Page 147



Manual Fusion Machine Stand

Expands to a comfortable operator height equal to our other pipe supports. Folds for easy storage and has wheels for easy transporting. See page 24 for more information.

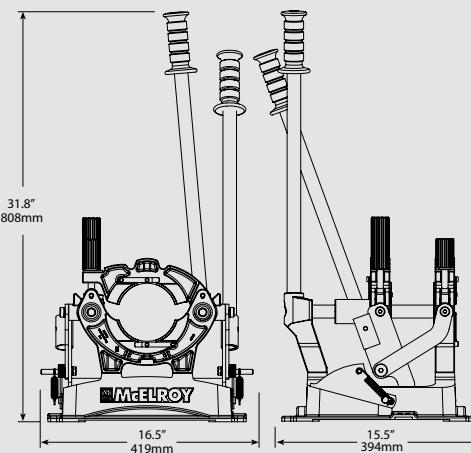
IN-CLASS FUSION TRAINING

Operator Training and Qualification, or Troubleshooting and Rebuild courses are available.
www.mcelroy.com/university



ONLINE RESOURCES

Videos available on your desktop, or mobile device.
www.mcelroy.com/university

**CAPACITY**

Fuses Pipe Sizes: 1" IPS – 4" DIPS pipe (32mm – 110mm)

WEIGHT

Carriage: 35 lbs (15.9Kg)

Facer: 21.56 lbs (9.78Kg)

Heater: 10 lbs (4.53Kg)

POWER

Heater Power: 1200 Watt

Facer Power: 0.5HP, 7Amp, 120V/3.5Amp, 240V

WARRANTY

Term: 3 Years, see page 7 for details

Specifications subject to change without notice.
Additional dimensions available on page 144.**Spare Heater Plate Kit**

A425201

Plates have an anti-stick coating and are required for butt fusion. The kit includes 2 plates and attaching screws.

Spare Facer Blades

413702

Blade set includes 4 blades, attaching screws and wrench.

Spare Multi-Mc® Heater Kits

Kit includes heater plates

A424317

100V-120V, 50/60Hz, 1Ph

A424318

200V-240V, 50/60Hz, 1Ph

Part No.

Description

Spare Facer

433701

100V-120V, 50/60Hz, 1Ph

433702

200V-240V, 50/60Hz, 1Ph

Part No.

Description

Pipe Support Stand - See page 100 for more information

422801

Adjustable height to support, position and align pipe.

812501

For use with the 14 Cart only.

For use with manual machine stand

Spare Heater/Facer Stand

433104

Holds facer and heater for easier carrying and protection. Heater bag helps the heater maintain a constant temperature.

Spare Screw/Driver Kit

A214201

Spare driver kit with insert screws and wire brush for cleaning serrated jaws and inserts.

Pyrometer Kit

A218804

Accurately checks surface temperatures of heater.

Stub End Holder - To learn more, see 117

410601

Holds stub end for butt fusion.

Torque Wrench Adapter

410802

Used to adapt to a torque wrench when a specified interfacial pressure is required. Requires a 1/2" Drive 100 ft.lb. 15" torque wrench.

Heat Shield

203005

For fusing two materials with different melt rates. Shields the faster melt rate materials from over melting.

Part No.

Description

Pit Bull® 14 Cart

434001

Cart and outrigger pipe supports for added mobility and handling of pipe.

Manual Fusion Machine Stand - See page 24

439001

Expands to a comfortable operator height equal to our other pipe supports. Folds for easy storage and has wheels for easy transporting.

PolyPorter® - To learn more, see page 103

864201

Designed to aid in lifting of pipe into the fusion machine, as well as perform as a pipe stand.

PolyHorse® - To learn more, see page 96

1875502

PolyHorse with PowerAssist

1875501

Standard PolyHorse

Pit Bull® 14 Shipping Container

423601

Shipping container for Pit Bull 14 fusion machine, inserts and adapters.

Insert & Adapter Box

ASW15902

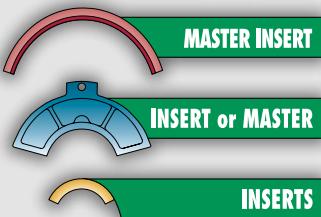
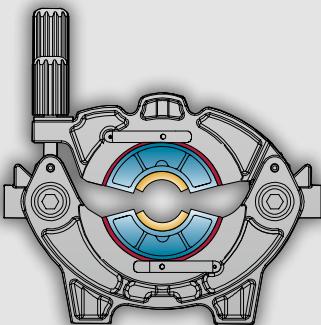
Storage box with universal storage tray to organize tooling.

14 Butt Fusion & Mitered Inserts

Butt Fusion Inserts

Our inserts have been surface-hardened for longer life. All inserts are serrated for maximum grip on the pipe. Inserts are made for one size pipe only. Not all inserts fit directly in the jaws. Some inserts nest inside other inserts, called master inserts.

For JIS insert sizes, see page 127.



NOTE: Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs.

Butt Fusion Inserts Set = 4 Inserts

All inserts below fit in 4" DIPS 4.80 (122mm) Jaws

Inserts	Pipe OD	Set No.
4" IPS Master	4.50 (114mm)	Incl. w/Pkg.

All inserts below require 4" Master Inserts

110mm	4.33 (110mm)	410105
3" DIPS	3.96 (101mm)	410115
90mm	3.54 (90mm)	410107
3" IPS	3.50 (89mm)	410103
75mm	2.95 (75mm)	410021
2.5" IPS	2.88 (73mm)	410008
63mm	2.48 (63mm)	410019
2" CTS	2.13 (54mm)	428302
2" IPS Master	2.38 (60mm)	410007

All inserts below require 2" Master Inserts

50mm	1.97 (50mm)	207531
1 1/2" IPS	1.90 (48mm)	207515
1 1/4" IPS	1.66 (42mm)	207514
1 1/2" CTS	1.63 (41mm)	207533
40mm	1.57 (40mm)	207529
1 1/4" CTS	1.38 (35mm)	207519
1" IPS	1.32 (34mm)	207513
32mm	1.26 (32mm)	207527

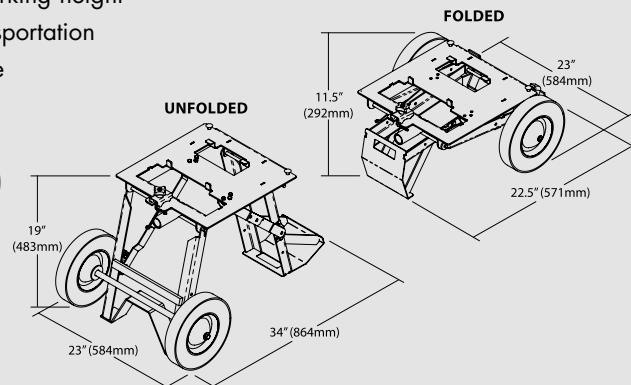
Manual Fusion Machine Stand

Overview

The Manual Fusion Machine Stand makes working with the 14, 2LC and 26 much easier. This stand expands to a comfortable operator level. The height corresponds to the McElroy pipe stands, PolyPorter® and PolyHorse® for easy pipe loading into the machine. When you are finished, it folds for easy storage and has wheels for transporting your machine to the next site.

Features

- Designed for use with the 14, 2LC and 26 fusion machines
- Compatible with McElroy pipe stands, PolyHorse and PolyPorter
- Locks in both folded and open positions
- More comfortable working height
- Wheels for easy transportation
- Folds for easy storage



Specifications

Weight – 50 lbs (23Kg)

Part No.

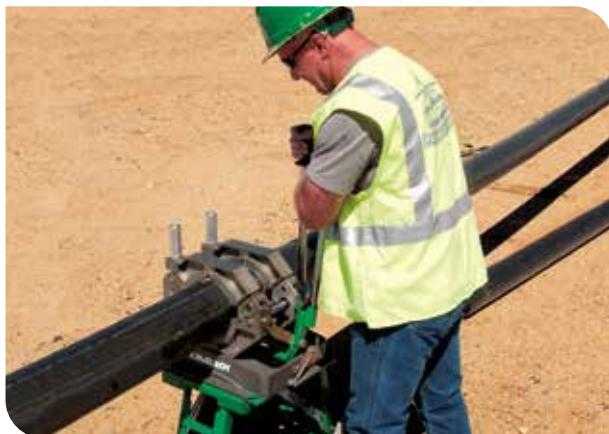
439001





26 Fusion Machine

Fusion Capability for 2" IPS – 6" DIPS pipe (63mm – 180mm)



Pit Bull® 26

The **Pit Bull 26** fuses **2" IPS to 6" DIPS** and **2" IPS to 180mm** depending upon model. Both models of the Pit Bull 26 come standard with a 6" IPS insert set.

The Pit Bull 26 incorporates the patented Centerline Guidance System, and is capable of butt fusing tees, ell's and other fittings. The machine has a semi-automatic locking cam that locks the movable jaw in place during the cooling cycle. An electric facer offers fast, efficient facing with an advanced blade design for smooth face offs and longer life.

- Semi-automatic locking cam to lock moveable jaw
- Hard anodized aluminum wear surfaces for corrosion resistance
- Reversible jaws, clamp knobs, levers and facer allow operator to fuse from either side of the machine
- Thrust bearing equipped clamp knobs to minimize torque required to clamp and round pipe
- 17-to-1 mechanical advantage

26

Includes fusion machine, facer, heater, insulated heater stand, facer stand, 6" IPS insert set and screw/driver kit.

Model No.	Machine Size	Input Voltage Requirements	Min. Power Reqs.*	Plug Type (See pg 140)
A708502	6" DIPS	100V-120V, 50/60Hz, 1Ph	3 KVA, 2.5 KW	A
A708505	6" DIPS	220V-240V, 50/60Hz, 1Ph	3 KVA, 2.5 KW	C
A708504	180mm	220V-240V, 50/60Hz, 1Ph	3 KVA, 2.5 KW	C

* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 147.

26 Productivity Package

A708402 – 120V, 6" DIPS A708405 – 240V, 6" DIPS A708404 – 180mm

What you get: 1 Pit Bull 26, 1 Manual Fusion Stand and 2 PolyPorters®

This package is for the contractor that wants to save time and money with the benefit of having all of these labor-saving devices in one cost-efficient package.



MACHINE PLUG TYPE
To find the right electrical plug type see
Page 140



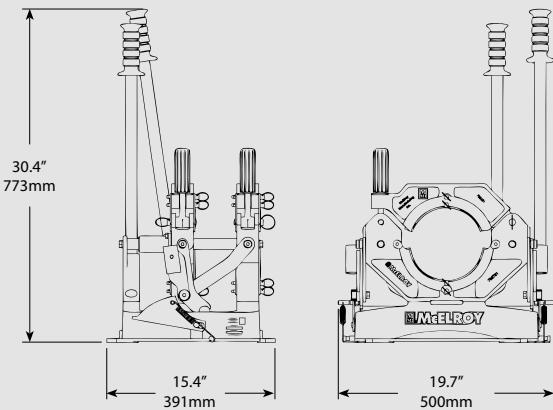
GENERATOR
To size your generator see
Page 147

McElroy Technical Service:

Online or Off Whether you prefer online documentation, discussion forums, facebook, twitter, or a personal phone call, our technical services staff along with our worldwide distributor network are ready to assist with any technical issue on or off the jobsite.



See page 140 for more details.

26**CAPACITY**

Fuses Pipe Sizes: 2" IPS – 6" DIPS pipe (63mm – 180mm)

WEIGHT

Carriage: 50 lbs (22.7Kg)

Facer: 32 lbs (14.5Kg)

Heater: 14 lbs (6.4Kg)

POWER

Heater Power: 1200 Watt

120V Facer Power: 0.5HP, 7Amp, 120V

240V Facer Power: 1.6HP, 5Amp, 240V

WARRANTY

Term: 3 Years, see page 7 for details

Specifications subject to change without notice.
Additional dimensions available on page 144.

Part No.	Description
----------	-------------

Spare Heater Plate Kit

A707901

Plates have an anti-stick coating and are required for butt fusion. The kit includes 2 plates and attaching screws.

Spare Facer Blades

710602

Blade set includes 6 blades, attaching screws and wrench.

Spare Heaters - See legend above for more information.

Microprocessor-controlled with dial thermometer

A	707701	100V-120V, 50/60Hz, 1200 Watt, 1Ph
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C	707601	220V-240V, 50/60Hz, 1200 Watt, 1Ph
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Spare Facer - See legend above for more information.

A 709601

100V-120V, 50/60Hz, 1Ph

C 711601

220V-240V, 50/60Hz, 1Ph

Spare Facer Stand

711801

Facer stand provides a convenient place to protect and store your facer out of the dirt and mud.

Spare Heater Stand

712001

Holds heater for easier carrying and protection. Heater bag helps the heater maintain a constant temperature.

Pyrometer Kit

A218804

Accurately checks surface temperatures of heater.

Part No.	Description
----------	-------------

Torque Wrench Adapter

410802

Used to adapt to a torque wrench when a specified interfacial pressure is required. Requires a 1/2" Drive 100 ft.lb. 15" torque wrench.

Pipe Support Stand - See page 100 for more information

812501

For use with manual machine stand

Manual Fusion Machine Stand - See page 28

439001

Expands to a comfortable operator height equal to our other pipe supports. Folds for easy storage and has wheels for easy transporting.

Low Profile Rollers - To learn more, see page 101

A1867501

Aids by reducing the drag on 4" to 18" pipe and protecting the pipe from damage. Case includes 40 complete roller assemblies.

PolyPorter® - To learn more, see page 103

864201

Designed to aid in lifting of pipe into the fusion machine, as well as perform as a pipe stand.

PolyHorse® - To learn more, see page 96

1875502

PolyHorse with PowerAssist

1875501

Standard PolyHorse

Toolbox with Tray

SW16001

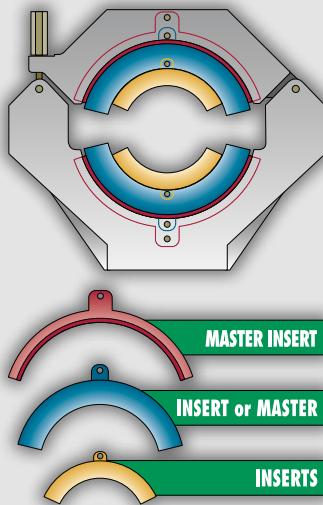
For organizing your inserts and adapters for safe keeping.

26 Butt Fusion & Mitered Inserts

Butt Fusion Inserts

Our inserts have been surface-hardened for longer life. All inserts are serrated for maximum grip on the pipe. Inserts are made for one size pipe only. Not all inserts fit directly in the jaws. Some inserts nest inside other inserts, called master inserts.

For JIS insert sizes, see page 127.



NOTE: Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs.

Butt Fusion Inserts

Set = 4 Inserts

All inserts below fit in 6" DIPS 6.90" (175mm) Jaws

Inserts	Pipe OD	Set No.
6" IPS Master	6.63 (168mm)	Incl. w/Pkg.

All inserts below fit in 180mm jaws

6" IPS/180mm Master	6.63 (168mm)	Incl. w/ Pkg.
160mm/180mm	6.30 (160mm)	709310
160mm/6" DIPS	6.30 (160mm)	709313

All inserts below require 6" IPS/180mm or 6" IPS/DIPS Masters

5" IPS	5.56 (142mm)	809435
140mm	5.51 (140mm)	809439
5.375" OD	5.38 (137mm)	809437
5.25" OD	5.25 (133mm)	809436
125mm	4.92 (125mm)	809438
4" DIPS	4.80 (122mm)	809327
4" IPS/100mm JIS	4.50 (114mm)	809434
110mm	4.33 (110mm)	809324
3" DIPS	3.96 (101mm)	809326
90mm	3.54 (90mm)	809325
3" IPS	3.50 (89mm)	809323
75mm	2.95 (75mm)	809217
63mm	2.48 (63mm)	809216
2" IPS	2.38 (60mm)	809215

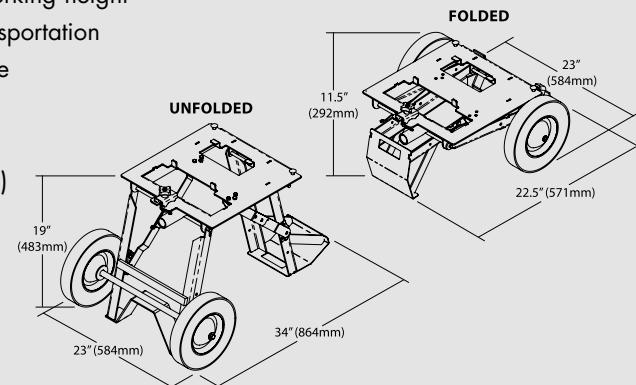
Manual Fusion Machine Stand

Overview

The Manual Fusion Machine Stand makes working with the 14, 2LC and 26 much easier. This stand expands to a comfortable operator level. The height corresponds to the McElroy pipe stands, PolyPorter® and PolyHorse® for easy pipe loading into the machine. When you are finished, it folds for easy storage and has wheels for transporting your machine to the next site.

Features

- Designed for use with the 14, 2LC and 26 fusion machines
- Compatible with McElroy pipe stands, PolyHorse and PolyPorter
- Locks in both folded and open positions
- More comfortable working height
- Wheels for easy transportation
- Folds for easy storage



Specifications

Weight – 50 lbs (23Kg)

Part No.

439001





28 Fusion Machines

Fusion Capability for 2" IPS – 8" DIPS pipe (63mm – 225mm)

Patent No's. 5,814,182 6,212,748 6,212,747 6,021,832 Japanese Patent No 4285806 European Patent No 0903215



28

The 28 line of fusion machines now come in multiple model configurations to assure your pipe fusion needs are covered. They will butt fuse pipe sizes from **2" IPS to 8" DIPS (63mm to 225mm)**.

The **Rolling 28** has staked its claim as the industry standard since 1975. Its ease of use and rugged quality construction opened the door for the most extensive line of 8-inch fusion machines on the market. The **TracStar® 28** offers a self-contained, self-propelled, track-mounted vehicle that can handle grades up to 30%. It is the number one choice on the job site for its ease of maneuverability and productivity gains. The **Pit Bull® 28** is used for special applications where the wheeled or tracked vehicle is not needed.

The TracStar 28 has an option that allows automated control and monitoring over the heat, soak, fuse and cool cycles. The **Automated TracStar 28** guides the operator through a step-by-step procedure for fusing pipe. It has a built-in data logging feature that keeps a record of each fusion joint, which allows you to verify joint integrity.

Rolling, TracStar and Pit Bull models incorporate the interchangeable 28 4-jaw carriage, which can be easily removed for in-ditch fusion. For tight installations, the outer fixed jaw and skid can be removed from the

carriage converting it to a 3-jaw carriage for an even more compact fusion unit. Several of these units offer saddle fusion capability in the form of a Combination Unit (CU) that allows fusion of branch saddles with a maximum base diameter of 9.63" onto any size main.

For in-ditch and close-quarter fusion, the **DynaMc®**

line of 28 machines pack a lot of power into small packages. The machines combine the robust, patented features of standard McElroy machines into smaller units for use in tight working environments.

The **DynaMc® 28 HP (Hand Pump)** machine butt fuses pipe with a hand-powered pump. The 28 HP is available in 2- and 4-Jaw models.

The **DynaMc® 28 EP** is powered by the DynaMc Electric Pump HPU, which is a common HPU for a variety of DynaMc EP fusion machines, such as the Sidewall 28 and Compact 28 Vertical. The HPU uses a hydraulic accumulator to maintain fusion pressures and reduce power consumption.

Rolling 28

- Wheeled vehicle for easy maneuvering on the job site
- Carriage can be easily removed for in-ditch use
- Available in a Combination Unit (CU) for sidewall fusion
- DataLogger® compatible
- Hand-pump model available

TracStar® 28

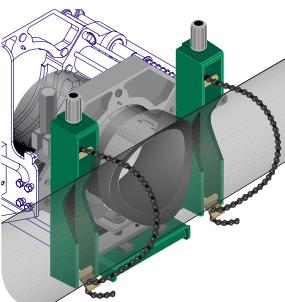
- Self-contained, self-propelled, all-terrain
- Carriage can be easily removed for in-ditch use
- On-board generator for powering heater
- Available in a Combination Unit (CU) for sidewall fusion
- DataLogger® compatible
- Also available as an Automated fusion machine

Pit Bull® 28

- Compact fusion for special applications
- Hydraulic Power Unit (HPU) sold separately
- DataLogger® compatible
- Available in a Combination Unit (CU) for sidewall fusion

DynaMc® 28 HP

- Features a double-action hand pump for fast carriage speeds
- Capable of up to 1500 PSI fusion pressure
- DataLogger® compatible
- Rugged and compact



Example of Saddle Fusion

DynaMc® 28 EP

- Features a common Electric Pump that powers a variety of fusion machines
- Utilizes a hydraulic accumulator to maintain fusion pressure and reduce power consumption
- Capable of up to 1500 PSI fusion pressure
- DataLogger® compatible

Machine Type	Model No.	Cylinder Force	Input Voltage Requirements	Minimum Power Requirements *	Plug Type (See pg 140)
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Rolling 28

Includes fusion machine, facer, heater and insulated heater stand.



Rolling	A860805	High	120V, 60Hz, 1Ph	3.4KVA, 3.2KW	A
Rolling	A860810	Low	120V, 60Hz, 1Ph	3.4KVA, 3.2KW	A
Rolling	A860806	High	208V - 240V, 60Hz, 1Ph	3.5KVA, 3.2KW	C
Rolling	A860811	Low	110V, 50Hz, 1Ph	3.4KVA, 3.2KW	A
Rolling CU	A860801	High	120V, 60Hz, 1Ph	3.4KVA, 3.2KW	A
Rolling CU	A860808	High	208V - 240V, 60Hz, 1Ph	3.5KVA, 3.2KW	C
Rolling CU	A860803	Low	100V, 50/60Hz, 1Ph	4.1KVA, 3.7KW	B
Rolling Hand Pump	A897601	Low	120V, 50/60Hz, 1Ph	3.28KVA, 3KW	A

TracStar® 28

Includes fusion machine, facer, heater, insulated heater stand and lifting assembly.



Tracked	AT800105	High	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A
Tracked	AT800107	Low	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A
Tracked CU	AT800106	High	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A
Tracked CU	AT800108	Low	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A
Automated Tracked	AT806101	High	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A
Automated Tracked	AT806103	Low	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A

Super 28

Diesel-powered 28 carriage on a TracStar 412/618 machine. Includes fusion machine, facer, heater, insulated heater stand and lifting assembly.

Tracked	AT800110	High	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
Tracked CU	AT800109	High	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A

Pit Bull® 28

Includes fusion carriage, heater, facer, and insulated heater stand. HPU which includes extension hoses and lifting assembly sold separately.



In-ditch	AT805501	High	220V - 240V, 50/60Hz, 1Ph	1.75 KW	C
In-ditch	AT805503	Low	220V - 240V, 50/60Hz, 1Ph	1.75 KW	C
In-ditch CU	AT805502	High	220V - 240V, 50/60Hz, 1Ph	1.75 KW	C
In-ditch CU	AT805504	Low	220V - 240V, 50/60Hz, 1Ph	1.75 KW	C
HPU	T1810901	N/A	240V, 60Hz, 1Ph	HPU 4.9KVA/4.8KW, Pit Bull + HPU 6.6KVA/6.6KW	G
HPU	T1810902	N/A	220V - 240V, 50/60Hz, 3Ph	HPU 5.2KVA/4.5KW, Pit Bull + HPU 6.6KVA/6.2KW	D

* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 147.

28 Fusion Machines

Fusion Capability for 2" IPS to 8" DIPS (63mm - 225mm)

Machine Type	Model No.	Cylinder Force	Input Voltage Requirements	Minimum Power Requirements *	Plug Type (See pg 140)
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DynaMc® 28 HP

Includes fusion carriage, facer, facer stand, heater and insulated heater stand.



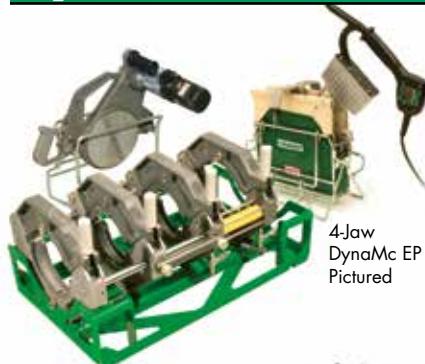
2-Jaw DynaMc
HP Pictured

2 Jaw	A881701	Low	100V-120V, 50/60Hz, 1Ph	3KVA, 2.9KW	A
	A881702	Low	220V-240V, 50/60Hz, 1Ph	3KVA, 2.9KW	C
4 Jaw	A881401	Low	100V-120V, 50/60Hz, 1Ph	3KVA, 2.9KW	A
	A881402	Low	220V-240V, 50/60Hz, 1Ph	3KVA, 2.9KW	C

Machine Type	Model No.	Cylinder Force	Facer Voltage Requirements	Heater Voltage Reqs.	Min. Power Reqs. *	Plug Type (See pg 140)
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DynaMc® 28 EP

Includes fusion carriage, facer, facer stand, heater and insulated heater stand. Electric Pump is sold separately.



4-Jaw
DynaMc EP
Pictured

2 Jaw	A900201	Low	100V-120V, 50/60Hz, 1Ph	100V-120V, 50/60Hz, 1Ph	3KVA, 2.9KW	A/A
	A900203	Low	100V-120V, 50/60Hz, 1Ph	220V-240V, 50-60Hz, 1Ph	3KVA, 2.9KW	A/C
	A900202	Low	220V-240V, 50/60Hz, 1Ph	100V-120V, 50/60Hz, 1Ph	3KVA, 2.9KW	C/A
	A900204	Low	220V-240V, 50/60Hz, 1Ph	220V-240V, 50-60Hz, 1Ph	3KVA, 2.9KW	C/C
4 Jaw	A900101	Low	100V-120V, 50/60Hz, 1Ph	100V-120V, 50/60Hz, 1Ph	3KVA, 2.9KW	A/A
	A900103	Low	100V-120V, 50/60Hz, 1Ph	220V-240V, 50-60Hz, 1Ph	3KVA, 2.9KW	A/C
	A900102	Low	220V-240V, 50/60Hz, 1Ph	100V-120V, 50/60Hz, 1Ph	3KVA, 2.9KW	C/A
	A900104	Low	220V-240V, 50/60Hz, 1Ph	220V-240V, 50-60Hz, 1Ph	3KVA, 2.9KW	C/C

Machine Type	Model No.	Input Voltage Requirements	Minimum Power Requirements *	Plug Type (See pg 140)
Electric Pump (HPU)	1272701	120V, 60Hz, 1Ph	1.56KVA, 1.25KW	A
	1272702	208V-240V, 60Hz, 1Ph	1.56KVA, 1.25KW	C
	1272703	220V-240V, 50/60Hz, 1Ph	1.65KVA, 1.24KW	M
	1272704	100V, 50/60Hz, 1Ph	1.65KVA, 1.24KW	B

Machine Type

Model No.

DynaMc® 28 Sidewall

Includes fusion carriage. See page 125 for accessories. Heater and Electric Pump is sold separately.



1 Jaw/tailstock

898101

* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 147.

Compact Vertical

McElroy developed the 28 Vertical Fusion Machine to specifically address the challenge of performing vertical fusions.

- Use in conjunction with the Electric Pump HPU
- Counterbalanced, pivoting heater
- Pivoting electric facer
- Capable of horizontal fusions
- Accounts for negative drag
- Incorporated wheels and lifting eyes for easier transportation



Machine Type	Model No.	Cylinder Force	Input Voltage Requirements	Minimum Power Requirements *	Plug Type (See pg 140)
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Dyna-Mc® Vertical Compact 28 EP

Includes fusion carriage, facer, facer stand, heater and insulated heater stand. Electric Pump is sold separately.

3 Jaw	A893001	Low	100V-120V, 50/60Hz, 1Ph	3KVA, 2.9KW	A
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Machine Type	Model No.	Input Voltage Requirements	Minimum Power Requirements *	Plug Type (See pg 140)
Electric Pump (HPU)	1272701	120V, 60Hz, 1Ph	1.56KVA, 1.25KW	A
	1272702	208V-240V, 60Hz, 1Ph	1.56KVA, 1.25KW	C
	1272703	220V-240V, 50/60Hz, 1Ph	1.65KVA, 1.24KW	M
	1272704	100V, 50/60Hz, 1Ph	1.65KVA, 1.24KW	B

* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 147.

28 Accessories

SPARE HEATER LEGEND  Heater for 28, Pit Bull, TracStar 28 & DynaMc 28 HP/EP  Heater for Automated TracStar 28

Part No.	Description
Spare Facer Blade Set - Includes 4 blades, screws and wrench	
	T1208602 Standard blades.
T1208602C	Extended life blades.
T1208602T	Carbide blades for abrasive materials.
Spare Heater Plate Kit	
	A848706 Set of 2 plates with anti-stick coating required for butt fusion. Kit includes attaching screws and wrench.
Pipe Support Stand - See page 100 for more information	
	812501 Adjustable pipe stand to properly support, position and align pipe to be fused.
PolyPorter® - To learn more, see page 103	
	864201 Designed to aid in lifting of pipe into the fusion machine, as well as perform as a pipe stand.
PolyHorse® - To learn more, see page 96	
	1875502 PolyHorse with PowerAssist
1875501	Standard PolyHorse
Low Profile Rollers - To learn more, see page 101	
	A1867501 Aids by reducing the drag on 4" to 18" pipe and protecting the pipe from damage. Case includes 40 complete roller assemblies.
Spare Facer Stand	
	T1201101 Facer stand provides a convenient place to protect and store your facer out of the dirt and mud.

Part No.	Description
DataLogger® - To learn more, see page 108	
	Used to record and document fusion process parameters.
DL6303	Wireless DataLogger
DL6304	Wired DataLogger
DL13501	NEW! DataLogger 4 English Package*
* Other languages available. See page 108 for details.	
Stub End Holder - To learn more, see page 116	
	885001 Self-centering stub end holder to hold stub end for butt fusion.
Spare Heater 100-120, 50/60Hz, 1Ph See legend above	
	S 848709 Microprocessor-controlled with dial thermometer to monitor temperature. Includes heater plates insulated heater stand and stripper bars.
A	N/A
Spare Heater 220-240, 50/60Hz, 1Ph See legend above	
	S 848803 Microprocessor-controlled with dial thermometer to monitor temperature. Includes heater plates insulated heater stand and stripper bars.
A	T806201
Pyrometer Kit	
	A218804 Accurately checks surface temperatures of heater.
25' Hydraulic Extension Hoses	
	1219105 Set of four 25' hydraulic extension hoses required for in-ditch fusion. Extension hoses are included with Pit Bull HPU.
NEW! Heater Caddy	
	AT808902 Allows the heater and heater bag frame to attach to a TracStar.
AT808901	Retrofit Kit for TracStar 28 machines built before 9/2010.

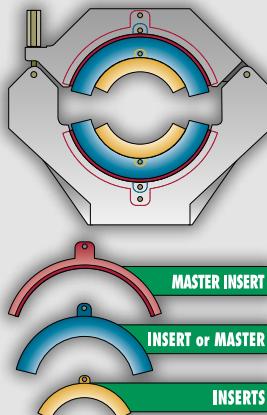
Part No.	Description
Insert & Adapter Box	
	SW16001 For organizing your inserts and adapters for safe keeping.
Heat Shield	
	203006 For fusing two materials with different melt rates. Shields the faster melt rate materials from over melting.
Reusable Shipping Container	
	817902 Container for Rolling 28.
T5009101	Container for TracStar 28.
Auto-Only Accessories	
Spare Automated Pendant	
	T5007109 Spare user interface for Automated TracStars 28, 250, 412 and 618.
Spare Automated Control Box	
	T5001808 Spare control box for quick replacement. For use with Automated TracStars 28, 250, 412 and 618.
Automated In-Ditch Extension Kit	
	T5002003 Set of four 25' hydraulic extension hoses, extension cable and pendant strap. This kit is required for automated in-ditch fusion.
Spare Automated USB Thumb Drive & Adapter	
	AT5040101 Used for downloading fusion records from the Automated Pendant to a USB thumb drive.

Butt Fusion Inserts

Our cast inserts have been surface-hardened for longer life. All inserts are serrated for maximum grip on the pipe. Inserts are made for one size pipe only. Not all inserts fit directly in the jaws. Some inserts nest inside other inserts, called master inserts.

NOTE: Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs.

For JIS insert sizes, see page 127.



Mitered Inserts

Mitered inserts are used to fabricate segmented ellipses. Our standard miter is $11\frac{1}{4}^\circ$, other mitered angles are available upon request.

**Standard Ell Configuration
90° Ell $11\frac{1}{4}^\circ$ miter shown**



Butt Fusion Insert Sets 2-jaw set = 4 inserts, 4-jaw set = 8 inserts

All inserts below fit in 8" DIPS 9.05" (230mm) jaws

Inserts	Pipe OD	2 Jaw Set *	4 Jaw Set
225mm	8.86 (225mm)	851208	851201
8" IPS/DIPS Master	8.63 (219mm)	Inc w/pkg	Inc w/pkg

All inserts below require 8" IPS/DIPS or 8" IPS/250mm Masters

200mm	7.87 (200mm)	801548	801511
7.125"/180mm OD	7.13 (181mm)	801549	801513
6" DIPS	6.90 (175mm)	801550	801525
6" IPS Master	6.63 (168mm)	801547	801510
160mm	6.30 (160mm)	8078148	807813

All inserts below require 6" IPS & 8" IPS/DIPS or 6" IPS & 8" IPS/250mm Masters

5" IPS	5.56 (142mm)	809435	809409
140mm	5.51 (140mm)	809439	809428
5.375" OD	5.38 (137mm)	809437	809411
5.25" OD	5.25 (133mm)	809436	809410
125mm	4.92 (125mm)	809438	809413
4" DIPS	4.80 (122mm)	809327	809315
4" IPS/100mm JIS	4.50 (114mm)	809434	809408
110mm	4.33 (110mm)	809324	809305
3" DIPS	3.96 (101mm)	809326	809313
90mm	3.54 (90mm)	809325	809309
3" IPS	3.50 (89mm)	809323	809304
75mm	2.95 (75mm)	809217	809211
63mm	2.48 (63mm)	809216	809209
2" IPS	2.38 (60mm)	809215	809204

* Applicable only to DynaMc® 28 machines



NOTE: See page 125 for all Combination Unit inserts and accessories.

11 1/4° Mitered Inserts Set = 4 Inserts & 1 Template

All inserts below fit in 8" DIPS 9.05 (230mm) DIPS jaws

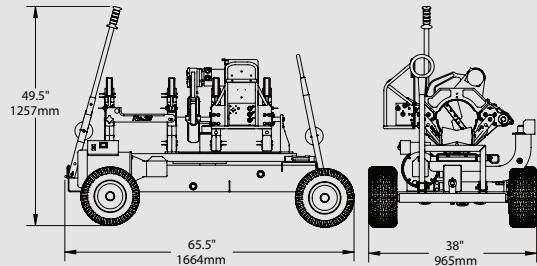
Inserts	Pipe OD	Set No.
8" IPS Master	8.63 (219mm)	Inc. w/pkg

All inserts below require 8" IPS Master inserts

180mm	7.09 (180mm)	8078111
6" DIPS	6.90 (175mm)	8078108
6" IPS	6.63 (168mm)	807810
160mm	6.30 (160mm)	807817
5" IPS	5.56 (141mm)	807809
140mm	5.51 (140mm)	8078135
125mm	4.92 (125mm)	807896
4" DIPS	4.80 (122mm)	807899
4" IPS	4.50 (114mm)	807808
110mm	4.33 (110mm)	807893
90mm	3.54 (90mm)	811301

28 Specifications

Rolling 28



CAPACITY

Fuses Pipe Sizes: 2"IPS – 8"DIPS (63mm – 225mm)

WEIGHT

Machine: 575 lbs (260.8Kg)

4 Jaw Carriage Configuration: 219 lbs (99.3Kg)

4 Jaw CU Carriage Configuration: 247 lbs (112Kg)

3 Jaw Carriage Configuration: 140 lbs (63.5Kg)

3 Jaw CU Carriage Configuration: 168 lbs (76.2Kg)

Facer: 37 lbs (16.8Kg)

Heater: 21 lbs (9.5Kg)

HYDRAULICS

System Pressure: 900 PSI (62 BAR) - (1200 PSI (82.7 BAR) Max.)

Hydraulic Reservoir Capacity: 5 Gallons (18.92 Liters)

POWER

Butt Fusion Heater: 1750 Watt

Sidewall Heater: 2270 Watt

Facer Power: Hydraulic

Electric Motor: 1.5 HP

CHASSIS

Frame: Welded steel tube construction

Front Axle: Articulating

Brake: Mechanical

MOBILITY

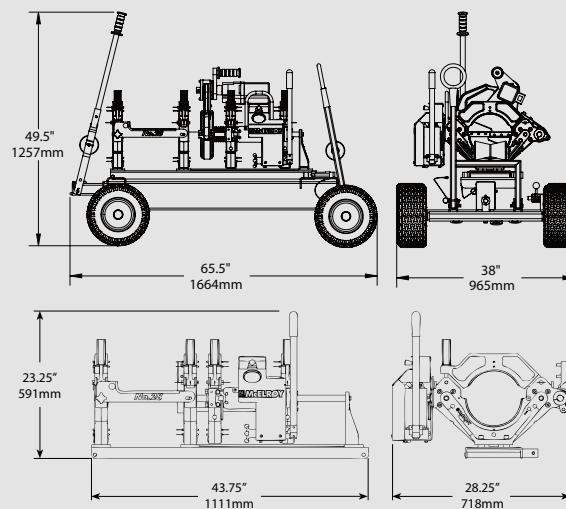
Tires: High-flotation inflatable tires

Transportation: Pulled via towing ring

WARRANTY

Term: 3 Years, see page 7 for details

Rolling 28 Hand Pump



CAPACITY

Fuses Pipe Sizes: 2"IPS – 8"DIPS (63mm – 225mm)

WEIGHT

Machine: 475 lbs (215.4Kg)

4 Jaw Carriage Configuration: 229 lbs (103.9Kg)

3 Jaw Carriage Configuration: 150 lbs (68Kg)

Facer: 37 lbs (16.8Kg)

Heater: 21 lbs (9.5Kg)

ELECTRICAL

Heater Power: 1750 Watt

Facer Power: 1.6 HP, 10 Amp @ 120V / 5 Amp @ 240V

CHASSIS

Frame: Welded steel tube construction

Front Axle: Articulating

Brake: Mechanical

MOBILITY

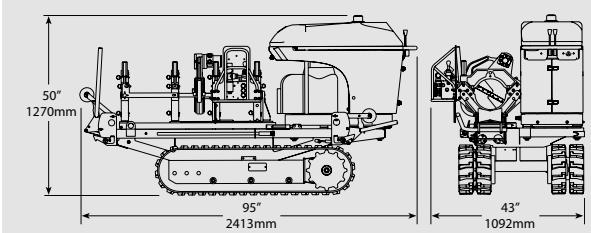
Tires: High-flotation inflatable tires

Transportation: Pulled via towing ring

WARRANTY

Term: 3 Years, see page 7 for details

TracStar® 28



CAPACITY

Fuses Pipe Sizes: 2"IPS – 8"DIPS (63mm – 225mm)

WEIGHT

Machine: 1320 lbs (598.7Kg)

4 Jaw Carriage Configuration: 219 lbs (99.3Kg)

4 Jaw CU Carriage Configuration: 247 lbs (112Kg)

3 Jaw Carriage Configuration: 140 lbs (63.5Kg)

3 Jaw CU Carriage Configuration: 168 lbs (76.2Kg)

Facer: 37 lbs (16.8Kg)

Heater: 21 lbs (9.5Kg)

HYDRAULICS

System Pressure: 1600 PSI (110.3 BAR) Max.

Hydraulic Reservoir Capacity: 8 Gallons (30.28 Liters)

ENGINE

Engine Type: 13 HP air cooled

Fuel Type: Gasoline

Fuel Tank Capacity: 5 Gallons (18.92 Liters)

Operational Tank Capacity: 8 Hours

Starting System: Electric and recoil

ELECTRICAL

Input: None, self-contained

AC Output: 2 receptacles 120V & 240V, 60Hz, 15 Amp

CHASSIS

Frame: Welded steel construction

MOBILITY

Tracked: Rubber crawler tracks

Transportation: Self-propelled, fits in long bed truck

Vehicle speed: 1.0 Mph max.

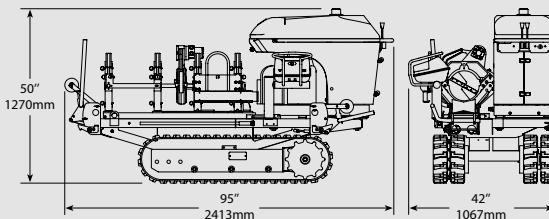
Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Note: All carriage weights are without facer and heater. Specifications subject to change without notice. **Additional dimensions available on page 144.**

Automated TracStar® 28



CAPACITY

Fuses Pipe Sizes: 2"IPS – 8"DIPS (63mm – 225mm)

WEIGHT

Machine: 1320 lbs (598.7Kg)
 4 Jaw Carriage Configuration: 219 lbs (99.3Kg)
 3 Jaw Carriage Configuration: 140 lbs (63.5Kg)
 Facer: 37 lbs (16.8Kg)
 Heater: 21 lbs (9.5Kg)

HYDRAULICS

System Pressure: 1600 PSI (110.3 BAR) Max.
 Hydraulic Reservoir Capacity: 8 Gallons (30.28 Liters)

ENGINE

Engine Type: 13 HP air cooled
 Fuel Type: Gasoline
 Fuel Tank Capacity: 5 Gallons (18.92 Liters)
 Operational Tank Capacity: 8 Hours
 Starting System: Electric and recoil

ELECTRICAL

Input: None, self-contained

CHASSIS

Frame: Welded steel construction

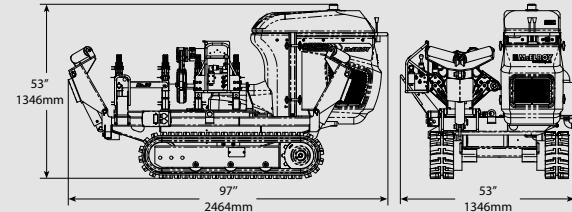
MOBILITY

Tracked: Rubber crawler tracks
 Transportation: Self-propelled, fits in long bed truck
 Vehicle speed: 1.0 Mph max.
 Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Super 28



CAPACITY

Fuses Pipe Sizes: 2"IPS – 8"DIPS (63mm – 225mm)

WEIGHT

Machine: 1825 lbs (827.8Kg)
 4 Jaw Carriage Configuration: 201 lbs (91.2Kg)
 4 Jaw CU Carriage Configuration: 247 lbs (112Kg)
 3 Jaw Carriage Configuration: 122 lbs (55.3Kg)
 3 Jaw CU Carriage Configuration: 168 lbs (76.2Kg)
 Facer: 44 lbs (19.9Kg)
 Heater: 27 lbs (12.2Kg)

HYDRAULICS

System Pressure: 2000 PSI (137.90 BAR) Max.
 Hydraulic Reservoir Capacity: 8 Gallons (30.28 Liters)

ENGINE

Engine Type: 20 HP liquid cooled
 Fuel Type: Diesel
 Fuel Tank Capacity: 5 Gallons (18.92 Liters)
 Operational Tank Capacity: 8 Hours
 Starting System: Electric

ELECTRICAL

Input: None, self-contained
 AC Output: 120V & 240V, 60Hz, 15Amp

POWER

Heater Power: 3000 Watt
 Facer Power: Hydraulic

CHASSIS

Frame: Welded steel construction
 Brake: Self-locking

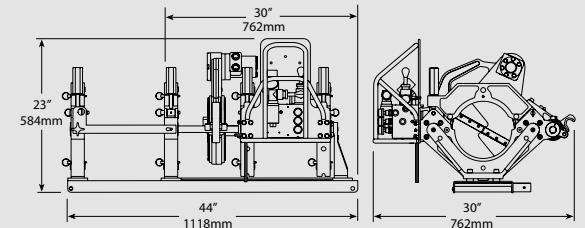
MOBILITY

Tracked: Rubber crawler tracks
 Transportation: Self-propelled
 Vehicle speed: 1.5 Mph Max.
 Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Pit Bull® 28



CAPACITY

Fuses Pipe Sizes: 2"IPS – 8"DIPS (63mm – 225mm)

WEIGHT

4 Jaw Carriage Configuration: 219 lbs (99.3Kg)
 4 Jaw CU Carriage Configuration: 247 lbs (112Kg)
 3 Jaw Carriage Configuration: 140 lbs (63.5Kg)
 3 Jaw CU Carriage Configuration: 168 lbs (76.2Kg)
 Facer: 37 lbs (16.8Kg)
 Heater: 21 lbs (9.5Kg)

POWER

Butt Fusion Heater: 1750 Watt
 Sidewall Heater: 2270 Watt

Facer Power: Hydraulic

CHASSIS

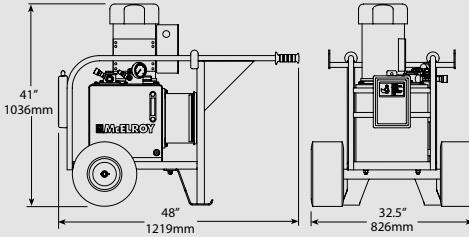
Frame: Welded steel construction

WARRANTY

Term: 3 Years, see page 7 for details

28 Specifications

Pit Bull® HPU (Hydraulic Power Unit)



WEIGHT

Machine: 390 lbs (176.9Kg)

HYDRAULICS

System Pressure: 1500 PSI Max.
 Hydraulic Reservoir Capacity: 10 Gallons (37 Liters)
 Pump Flow Rate 60 Hz: 6.1 gpm (23.1 Lpm)
 Pump Flow Rate 50 Hz: 5.0 gpm (18.9 Lpm)
 Filtration: 10 micron absolute

POWER

Power Requirement: 5.2KVA/4.5Watt

MOTOR

Electric: 5 HP

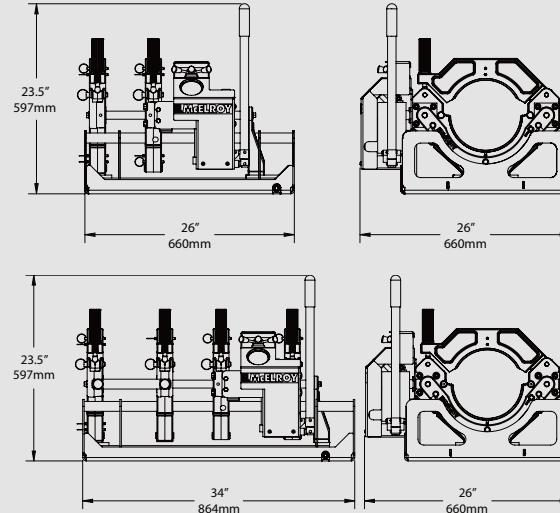
MOBILITY

Tires: High-flotation inflatable tires
 Transportation: Two wheel cart

WARRANTY

Term: 3 Years, see page 7 for details

DynaMc® 28 HP



CAPACITY

Fuses Pipe Sizes: 2"IPS – 8"DIPS (63mm – 225mm)

WEIGHT

2 Jaw Machine: 108 lbs (49Kg)
 4 Jaw Machine: 155 lbs (70Kg)
 Facer: 39 lbs (17.7Kg)
 Heater: 21 lbs (9.5Kg)

HYDRAULICS

System Pressure: 1500 PSI (103 BAR) Max.

POWER

Heater Power: 1750 Watt
 Facer Power: 1.6 HP, 10 Amp @ 120V / 5 Amp @ 240V

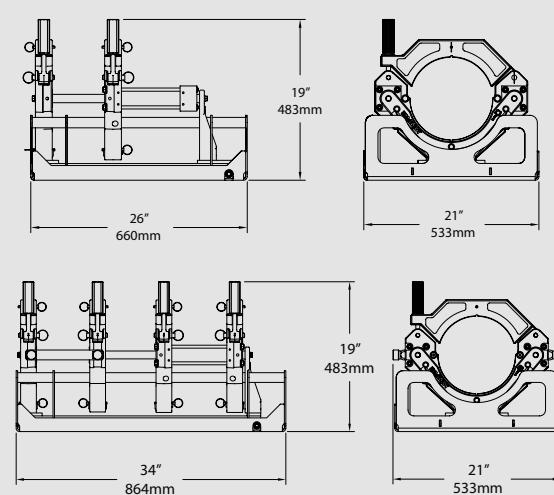
CHASSIS

Frame: Welded aluminum construction

WARRANTY

Term: 3 Years, see page 7 for details

DynaMc® 28 EP



CAPACITY

Fuses Pipe Sizes: 2"IPS – 8"DIPS (63mm – 225mm)

WEIGHT

2 Jaw Machine: 78 lbs (36Kg)
 4 Jaw Machine: 125 lbs (57Kg)
 Facer: 39 lbs (17.7Kg)
 Heater: 21 lbs (9.5Kg)

POWER

Heater Power: 1750 Watt
 Facer Power: 1.6 HP, 10 Amp @ 120V / 5 Amp @ 240V

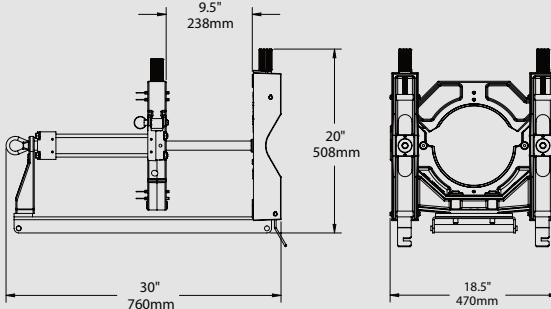
CHASSIS

Frame: Welded aluminum construction

WARRANTY

Term: 3 Years, see page 7 for details

DynaMc® 28 EP Sidewall



SADDLE FUSION CAPACITY

Max Fitting Base Diameter: 9.63" (245mm)

WEIGHT

Machine: 88 lbs (40Kg)

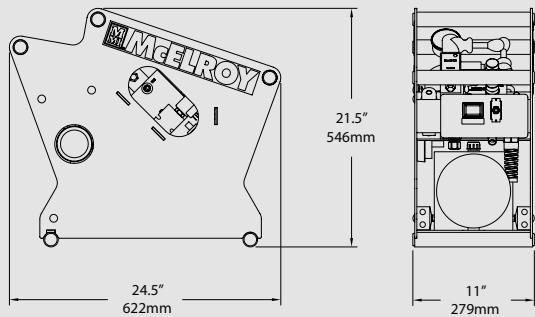
CHASSIS

Frame: Welded aluminum construction

WARRANTY

Term: 3 Years, see page 7 for details

DynaMc® EP HPU



WEIGHT

Machine: 115 lbs (52.1Kg)

HYDRAULICS

System Pressure: 1500PSI (103 BAR) Max.

POWER

Power: 2.2 HP, 14 Amp @ 120V / 7 Amp @ 240V

CHASSIS

Frame: Welded aluminum construction

WARRANTY

Term: 3 Years, see page 7 for details

250 Fusion Machines

Fusion Capability for 63mm – 250mm pipe (2" IPS – 8" DIPS)

Patent No's. 5,814,182 6,212,748 6,212,747 6,021,832 Japanese Patent No 4285806 European Patent No 0903215



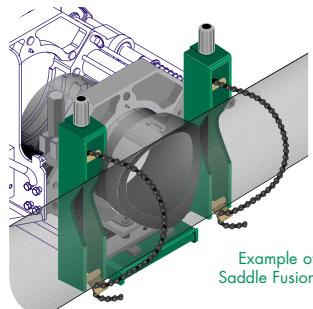
250

The McElroy 250 was designed in response to international metric pipe needs. The 250 fusion machines now come in multiple model configurations to assure your metric pipe fusion needs are covered. They will butt fuse pipe sizes from **63mm to 250mm (2" IPS to 8" DIPS)**.

The **Rolling 250** is based on the 28 which has been the industry standard for numerous years. The **TracStar® 250** offers a self-contained, self-propelled, track-mounted vehicle that can handle grades up to 30%. It is the number one choice on the job site for its ease of maneuverability and productivity gains. The **Pit Bull® 250** is used for special applications where the wheeled or tracked vehicle is not needed.

The TracStar 250 has an option that allows automated control and monitoring over the heat, soak, fuse and cool cycles. The **Automated TracStar 250** guides the operator through a step-by-step procedure for fusing pipe. It has a built-in data logging feature that keeps a record of each fusion joint, which allows you to verify joint integrity.

Rolling, TracStar and Pit Bull models incorporate the interchangeable 250 4-jaw carriage, which can



be easily removed for in-ditch fusion. For tight installations, the outer fixed jaw and skid can be removed from the carriage converting it to a 3-jaw carriage for an even more compact fusion unit. Several of these units offer saddle fusion capability in the form of a Combination Unit (CU) that allows fusion of branch saddles with a maximum base diameter of 9.63" onto any size main.

For in-ditch and close-quarter fusion, the **DynaMc®** line of 250 machines pack a lot of power into small packages. The machines combine the robust, patented features of standard McElroy machines into smaller units for use in tight working environments.

The **DynaMc® 250 HP (Hand Pump)** machine butt fuses pipe with a hand-powered pump. The 250 HP is available in 2- and 4-Jaw models.

The **DynaMc® 250 EP** is powered by the DynaMc Electric Pump HPU, which is a common HPU for a variety of DynaMc EP fusion machines. The HPU uses a hydraulic accumulator to maintain fusion pressures and reduce power consumption.

The **DynaMc® 250 Auto** is an automatic fusion machine offering a powerful mix of features and operates within gas industry specification PL2-3:2006 and water industry specification 4-32-08, as well as other specifications.

Rolling 250

- Wheeled vehicle for easy maneuvering on the job site
- Carriage can be easily removed for in-ditch use
- Available in a Combination Unit (CU) for sidewall fusion
- DataLogger® compatible

TracStar® 250

- Self-contained, self-propelled, all-terrain
- Carriage can be easily removed for in-ditch use
- On-board generator for powering heater
- Available in a Combination Unit (CU) for sidewall fusion
- DataLogger® compatible
- Automated version available

Pit Bull® 250

- Compact fusion for special applications
- Hydraulic Power Unit (HPU) sold separately
- DataLogger® compatible
- Available in a Combination Unit (CU) for sidewall fusion

DynaMc® 250 HP

- Double-action hand pump and high-velocity cylinders create fast carriage speed for opens and closes during fusion processes
- Detachable easy-lift cradle can be removed for maneuvering into tight spaces
- DataLogger® compatible

DynaMc® 250 EP

- Features a common Electric Pump
- Utilizes a hydraulic accumulator to maintain fusion pressure and reduce power consumption
- DataLogger® compatible

DynaMc® 250 Auto

- Automatic fusion machine
- Five component system designed for easy storage and transportation to and from job site
- USB port for downloading fusion reports and uploading firmware updates

Machine Type	Model No.	Cylinder Force	Input Voltage Requirements	Minimum Power Requirements *	Plug Type (See pg 140)
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Rolling 250

Includes fusion machine, facer, heater and insulated heater stand.



Rolling	A866001	High	220V - 204V, 50Hz, 1Ph	5.2KVA, 4.8KW	M
Rolling	A866003	Low	220V, 50Hz, 1Ph	5.2KVA, 4.8KW	M
Rolling CU	A866002	High	220V, 50Hz, 1Ph	5.2KVA, 4.8KW	M
Rolling CU	A866004	Low	220V, 50Hz, 1Ph	5.2KVA, 4.8KW	M

TracStar® 250

Includes fusion machine, facer, heater, insulated heater stand and lifting assembly.



Tracked	AT2500103	High	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A
Tracked	AT2500102	Low	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A
Tracked CU	AT2500105	High	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A
Tracked CU	AT2500104	Low	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A
Automated Tracked	AT2506101	High	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A
Automated Tracked	AT2506103	Low	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A

Super 250

Diesel-powered 250 carriage on a TracStar 412/618 machine. Includes fusion machine, facer, heater, insulated heater stand and lifting assembly.

Tracked	AT2500106	High	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
Tracked CU	AT2506108	High	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A

Pit Bull® 250

Includes fusion carriage, facer, heater and insulated heater stand. HPU which includes extension hoses and lifting assembly sold separately.



In-ditch	AT2505501	High	220V - 240V, 50/60Hz, 1Ph	3KW	C
In-ditch	AT2505503	Low	220V - 240V, 50/60Hz, 1Ph	3KW	C
In-ditch CU	AT2505502	High	220V - 240V, 50/60Hz, 1Ph	3KW	C
In-ditch CU	AT2505504	Low	220V - 240V, 50/60Hz, 1Ph	3KW	C
HPU	T1810901	N/A	240V, 60Hz, 1Ph	HPU 4.9KVA/4.8KW, Pit Bull + HPU 7.9KVA/7.8KW	G
HPU	T1810902	N/A	220 - 240V, 50/60Hz, 3Ph	HPU 5.2KVA/4.5KW, Pit Bull + HPU 8.2KVA/7.5KW	D

* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 147.

250 Fusion Machines

Fusion Capability for 63mm – 250mm pipe (2" IPS – 8" DIPS)

Machine Type	Model No.	Cylinder Force	Facer Voltage Requirements	Heater Voltage Reqs.	Min. Power Reqs. *	Plug Type (See pg 140)
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DynaMc® 250 HP

Includes fusion carriage, facer, facer stand, heater and insulated heater stand.

4-Jaw
DynaMc HP
Pictured



2 Jaw	A882701	Low	100V-120V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	A/C
	A882702	Low	220V-240V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	C/C
4 Jaw	A882601	Low	100V-120V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	A/C
	A882602	Low	220V-240V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	C/C

DynaMc® 250 EP

Includes fusion carriage, facer, facer stand, heater and insulated heater stand. Electric Pump is sold separately.

4-Jaw
DynaMc EP
Pictured



2 Jaw	A900401	Low	100V-120V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	A/C
	A900402	Low	220V-240V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	C/C
4 Jaw	A900301	Low	100V-120V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	A/C
	A900302	Low	220V-240V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	C/C

Machine Type	Model No.	Input Voltage Requirements		Minimum Power Requirements *	Plug Type (See pg 140)
Electric Pump (HPU)	1272701	120V, 60Hz, 1Ph		1.56KVA, 1.25KW	A
	1272702	208V-240V, 60Hz, 1Ph		1.56KVA, 1.25KW	C
	1272703	220V-240V, 50-60Hz, 1Ph		1.65KVA, 1.24KW	M
	1272704	100V, 50/60Hz, 1Ph		1.65KVA, 1.24KW	B

Machine Type	Model No.	Cylinder Force	Input Voltage Requirements	Minimum Power Requirements *	Plug Type (See pg 140)
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DynaMc® 250 Auto

Includes auto power unit, control unit, carriage, facer, facer stand and heater assembly



4 Jaw Automatic	A887001	Low	110V-120V, 50/60Hz, 1Ph	3KVA, 3KW	N
4 Jaw Automatic	A887002	Low	220V-240V, 50/60Hz, 1Ph	3KVA, 3KW	N

* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 147.

SPARE HEATER LEGEND

S Heater for 250, Pit Bull, TracStar 250 & DynaMc 250 HP/EP

A Heater for Automated TracStar 250

Accessories 250

Part No.	Description
Spare Facer Blade Set - Includes 4 blades, screws and wrench	
	T1208602 Standard blades.
T1208602C	Extended life blades.
T1208602T	Carbide blades for abrasive materials.

Part No.	Description
Spare Heater Plate Kit	
	AT2501101 Set of 2 plates with anti-stick coating required for butt fusion. Kit includes attaching screws and wrench.

Part No.	Description
Spare Heater 220-240, 50/60Hz, 1Ph See legend above	
	
S T2501002	Micropressor-controlled with dial thermometer to monitor temperature. Includes heater plates insulated heater stand and stripper bars.
A T2506201	

Part No.	Description
Low Profile Rollers - To learn more, see page 101	
	A1867501 Aids by reducing the drag on 4" to 18" pipe and protecting the pipe from damage. Case includes 40 complete roller assemblies.

Part No.	Description
PolyPorter® - To learn more, see page 103	
	864201 Designed to aid in lifting of pipe into the fusion machine, as well as perform as a pipe stand.



Part No.	Description
Pipe Support Stand - See page 100 for more information	
	812501 Adjustable pipe stand to properly support, position and align pipe to be fused.

Part No.	Description
PolyHorse® - To learn more, see page 96	
	
1875502	PolyHorse with PowerAssist
1875501	Standard PolyHorse

Part No.	Description
NEW! Heater Caddy	
	
AT808902	Allows the heater and heater bag frame to attach to a TracStar.
AT808901	Retrofit Kit for TracStar 28 machines built before 9/2010.

Part No.	Description
Stub End Holder - To learn more, see page 116	
	
885001	Self-centering stub end holder to hold stub end for butt fusion. Requires 8" IPS butt fusion insert.

Part No.	Description
DataLogger® - To learn more, see page 108	
	
Used to record and document fusion process parameters.	
DL6303	Wireless DataLogger
DL6304	Wired DataLogger
DL13501	NEW! DataLogger 4 English Package*

* Other languages available. See page 108 for details.

Part No.	Description
25' Hydraulic Extension Hoses	
	1219105 Set of four 25' hydraulic extension hoses required for in-ditch fusion. Extension hoses are included with Pit Bull HPU.

Part No.	Description
Spare Facer Stand	
	
T1201101	Facer stand provides a convenient place to protect and store your facer out of the dirt and mud.

Part No.	Description
Insert & Adapter Box	
	
SW16001	For organizing your inserts and adapters for safe keeping.

Part No.	Description
Heat Shield	
	
203006	For fusing two materials with different melt rates. Shields the faster melt rate materials from over melting.

Part No.	Description
Shipping Container	
	
817902	Container for Rolling 250
T5009101	Container for TracStar 250

Part No.	Description
Pyrometer Kit	
	
A218804	Accurately checks surface temperatures of heater.

The New DataLogger® 4 Record and document the parameters of the pipe fusion process with the latest generation of DataLogger. The DataLogger 4 is small in size, has a rechargeable internal battery, double the screen resolution of previous DataLoggers, and has a pressure sensor with a 0 to 3,000 PSI pressure range. It also has worldwide appeal, with multilingual support and recognition of many international fusion standards.

See page 108 for more information

250 Accessories

TracStar® Auto-Only Accessories

Automated In-Ditch Extension Kit



T5002003

Set of four 25' hydraulic extension hoses, extension cable and pendant strap. This kit is required for automated in-ditch fusion.

Spare Automated Pendant



T5007109

Spare user interface for Automated TracStars 28, 250, 412 and 618.

Spare Automated Control Box



T5001808

Spare control box for quick replacement. For use with Automated TracStars 28, 250, 412 and 618.

Spare Automated USB Thumb Drive & Adapter



AT5040101

Used for downloading fusion records from the Automated Pendant to a USB thumb drive.

DynaMc® Auto-Only Accessories

Spare DynaMc Auto Power Box Assembly



1267301

110V-120V

1269401

220V-240V

Spare DynaMc Auto Operator Control Box



1266701

Spare Control Box for use with DynaMc Auto 250 and 412.

Spare DynaMc 250 Auto 120V Heater Assembly



889201

Spare heater for the DynaMc 250 Auto.

Spare DynaMc 250 Auto 240V Heater Assembly



889101

Spare heater for the DynaMc 250 Auto.



To find the right electrical plug type see
Page 140

GENERATOR

To size your generator see
Page 147



For help selecting a cylinder force see
Page 131

McElroy's International Distribution Network

McElroy products are offered through an international network of sales and authorized service center locations providing our customers around the globe with the tools to succeed.

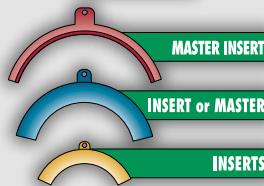
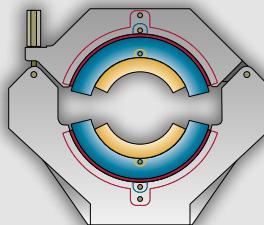


Butt Fusion Inserts

Our cast inserts have been surface-hardened for longer life. All inserts are serrated for maximum grip on the pipe. Inserts are made for one size pipe only. Not all inserts fit directly in the jaws. Some inserts nest inside other inserts, called master inserts.

NOTE: Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs.

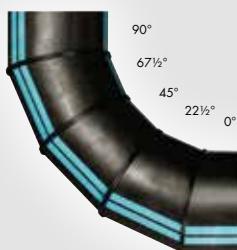
For JIS insert sizes, see page 127.



Mitered Inserts

Mitered inserts are used to fabricate segmented ellipses. Our standard miter is 11 1/4°, other mitered angles are available upon request.

Standard Ell Configuration 90° Ell 11 1/4° miter shown



Butt Fusion Insert Sets 2-jaw set = 4 inserts, 4-jaw set = 8 inserts

All inserts below fit in 9.84" (250mm) jaws

Inserts	Pipe OD	2 Jaw Set	4 Jaw Set
225mm/250mm	8.86 (225mm)	T2503517	T2503507
8" IPS/250mm Master	8.63 (219mm)	T2503516	T2503504

All inserts below fit in 8" DIPS 9.05" (230mm) jaws

225mm	8.86 (225mm)	851208	851201
8" IPS/DIPS Master	8.63 (219mm)	Inc w/pkg	Inc w/pkg

All inserts below require 8" IPS/DIPS or 8" IPS/250mm Masters

200mm	7.87 (200mm)	801548	801511
7.125"/180mm OD	7.13 (181mm)	801549	801513
6" DIPS	6.90 (175mm)	801550	801525
6" IPS Master	6.63 (168mm)	801547	801510
160mm	6.30 (160mm)	8078148	807813

All inserts below require 6" IPS & 8" IPS/DIPS or 6" IPS & 8" IPS/250mm Masters

5" IPS	5.56 (142mm)	809435	809409
140mm	5.51 (140mm)	809439	809428
5.375" OD	5.38 (137mm)	809437	809411
5.25" OD	5.25 (133mm)	809436	809410
125mm	4.92 (125mm)	809438	809413
4" DIPS	4.80 (122mm)	809327	809315
4" IPS/100mm JIS	4.50 (114mm)	809434	809408
110mm	4.33 (110mm)	809324	809305
3" DIPS	3.96 (101mm)	809326	809313
90mm	3.54 (90mm)	809325	809309
3" IPS	3.50 (89mm)	809323	809304
75mm	2.95 (75mm)	809217	809211
63mm	2.48 (63mm)	809216	809209
2" IPS	2.38 (60mm)	809215	809204

11 1/4° Mitered Inserts Set = 4 Inserts & 1 Template

All inserts below fit in 9.84" (250mm) jaws

Inserts	Pipe OD	Set No.
225mm/250mm x 11-1/4	8.86 (225mm)	T2503510
200mm/250mm x 11-1/4	7.87 (200mm)	T2503513
8" IPS/250mm Master	8.63 (219mm)	T2503504

All inserts below fit in 9.05" (230mm) jaws

8" IPS/DIPS Master	8.63 (219mm)	Inc w/pkg
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All inserts below require 8" IPS/DIPS or 8" IPS/250mm Masters

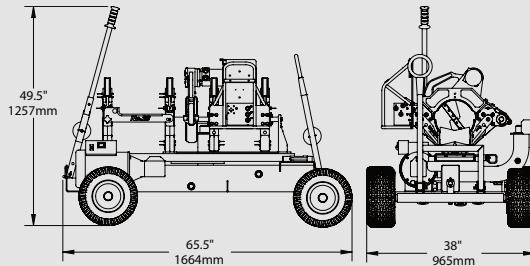
180mm x 11-1/4	7.13 (180mm)	8078111
6" DIPS x 11-1/4	6.90 (175mm)	8078108
6" IPS x 11-1/4	6.63 (168mm)	807810
160mm x 11-1/4	6.30 (160mm)	807817
5" IPS x 11-1/4	5.56 (1421mm)	807809
140mm x 11-1/4	5.51 (140mm)	8078135
125mm x 11-1/4	4.92 (125mm)	807896
4" DIPS x 11-1/4	4.80 (122mm)	807899
4" IPS x 11-1/4	4.50 (114mm)	807808
110mm x 11-1/4	4.33 (110mm)	807893
90mm x 11-1/4	3.54 (90mm)	811301



NOTE: See page 125 for all Combination Unit inserts and accessories.

250 Specifications

Rolling 250



CAPACITY

Fuses Pipe Sizes: 63mm – 250mm (2"IPS – 8"DIPS)

WEIGHT

Machine: 575 lbs (260.8Kg)

4 Jaw Carriage Configuration: 201 lbs (91.2Kg)

4 Jaw CU Carriage Configuration: 229 lbs (104Kg)

3 Jaw Carriage Configuration: 122 lbs (55.3Kg)

3 Jaw CU Carriage Configuration: 150 lbs (68Kg)

Facer: 44 lbs (20Kg)

Heater: 27 lbs (12.2Kg)

HYDRAULICS

System Pressure: 900 PSI (62 BAR) - 1200 PSI (82.7 BAR) Max.

Hydraulic Reservoir Capacity: 5 Gallons (18.92 Liters)

POWER

Butt Fusion Heater: 3000 Watt

Sidewall Heater: 2270 Watt

Facer Power: Hydraulic

Electric Motor: 1.5 HP

CHASSIS

Frame: Welded steel tube construction

Front Axle: Articulating

Brake: Mechanical

MOBILITY

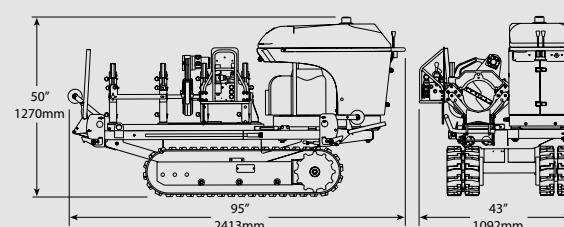
Tires: High-flotation inflatable tires

Transportation: Pulled via towing ring

WARRANTY

Term: 3 Years, see page 7 for details

TracStar® 250



CAPACITY

Fuses Pipe Sizes: 63mm – 250mm (2"IPS – 8"DIPS)

WEIGHT

Machine: 1320 lbs (598.7Kg)

4 Jaw Carriage Configuration: 229 lbs (104Kg)

3 Jaw Carriage Configuration: 150 lbs (68Kg)

Facer: 44 lbs (20Kg)

Heater: 27 lbs (12.2Kg)

HYDRAULICS

System Pressure: 1600 PSI (110.3 BAR) Max.

Hydraulic Reservoir Capacity: 8 Gallons (30.28 Liters)

ENGINE

Engine Type: 13 HP air cooled

Fuel Type: Gasoline

Fuel Tank Capacity: 5 Gallons (18.92 Liters)

Operational Tank Capacity: 8 Hours

Starting System: Electric and recoil

ELECTRICAL

Input: None, self-contained

AC Output: 2 receptacles 120V & 240V, 60Hz, 15 Amp

CHASSIS

Frame: Welded steel construction

MOBILITY

Tracked: Rubber crawler tracks

Transportation: Self-propelled, fits in long bed truck

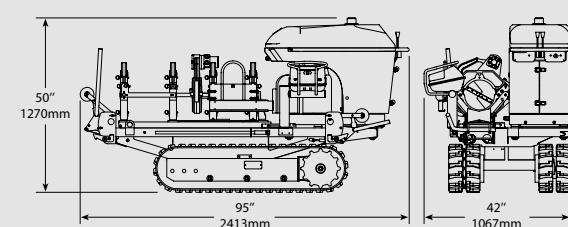
Vehicle speed: 1.0 Mph Maximum

Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Automated TracStar® 250



CAPACITY

Fuses Pipe Sizes: 63mm – 250mm (2"IPS – 8"DIPS)

WEIGHT

Machine: 1320 lbs (598.7Kg)

4 Jaw Carriage Configuration: 201 lbs (91.2Kg)

3 Jaw Carriage Configuration: 122 lbs (55.3Kg)

Facer: 44 lbs (20Kg)

Heater: 27 lbs (12.2Kg)

HYDRAULICS

System Pressure: 1600 PSI (110.3 BAR) Max.

Hydraulic Reservoir Capacity: 8 Gallons (30.28 Liters)

ENGINE

Engine Type: 13 HP air cooled

Fuel Type: Gasoline

Fuel Tank Capacity: 5 Gallons (18.92 Liters)

Operational Tank Capacity: 8 Hours

Starting System: Electric and recoil

ELECTRICAL

Input: None, Self-contained

CHASSIS

Frame: Welded steel construction

MOBILITY

Tracked: Rubber crawler tracks

Transportation: Self-propelled, fits in long bed truck

Vehicle speed: 1.0 Mph Maximum

Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Note: All carriage weights are without facer and heater. Specifications subject to change without notice. **Additional dimensions available on page 144.**

Specifications 250

Super 250

CAPACITY

Fuses Pipe Sizes: 63mm – 250mm (2"IPS – 8"DIPS)

WEIGHT

Machine: 1825 lbs (827.8Kg)

4 Jaw Carriage Configuration: 201 lbs (91.2Kg)

3 Jaw Carriage Configuration: 122 lbs (55.3Kg)

Facer: 44 lbs (19.9Kg)

Heater: 27 lbs (12.2Kg)

HYDRAULICS

System Pressure: 2000 PSI (137.90 BAR) Max.

Hydraulic Reservoir Capacity: 8 Gallons (30.28 Liters)

ENGINE

Engine Type: 20 HP liquid cooled

Fuel Type: Diesel

Fuel Tank Capacity: 5 Gallons (18.92 Liters)

Operational Tank Capacity: 8 Hours

Starting System: Electric

ELECTRICAL

Input: None, self-contained

AC Output: 120V & 240V, 60Hz, 15Amp

POWER

Heater Power: 3000 Watt

Facer Power: Hydraulic

CHASSIS

Frame: Welded steel construction

Brake: Self-locking

MOBILITY

Tracked: Rubber crawler tracks

Transportation: Self-propelled

Vehicle speed: 1.5 Mph Max.

Lifting: Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Pit Bull® 250

CAPACITY

Fuses Pipe Sizes: 63mm – 250mm (2"IPS – 8"DIPS)

4 Jaw Carriage Configuration: 201 lbs (91.2Kg)

4 Jaw CU Carriage Configuration: 229 lbs (104kg)

3 Jaw Carriage Configuration: 122 lbs (55.3Kg)

3 Jaw CU Carriage Configuration: 150 lbs (68Kg)

Facer: 44 lbs (20Kg)

Heater: 27 lbs (12.2Kg)

POWER

Butt Fusion Heater: 3000 Watt

Sidewall Heater: 2270 Watt

Facer Power: Hydraulic

CHASSIS

Frame: Welded steel construction

WARRANTY

Term: 3 Years, see page 7 for details

Pit Bull® HPU (Hydraulic Power Unit)

WEIGHT

Machine: 390 lbs (176.9Kg)

HYDRAULICS

System Pressure: 1500 PSI Max.

Hydraulic Reservoir Capacity: 10 Gallons (37 Liters)

Pump Flow Rate 60 Hz: 6.1 gpm (23.1 Lpm)

Pump Flow Rate 50 Hz: 5.0 gpm (18.9 Lpm)

Filtration: 10 micron absolute

POWER

Power Requirement: 5.2KVA/4.5Watt

MOTOR

Electric: 5 HP

MOBILITY

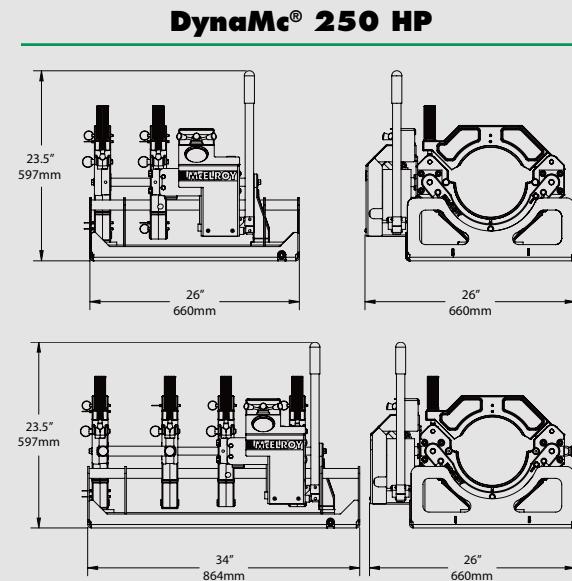
Tires: High-flotation inflatable tires

Transportation: Two wheel cart

WARRANTY

Term: 3 Years, see page 7 for details

250 Specifications



CAPACITY

Fuses Pipe Sizes: 63mm – 250mm (2"IPS – 8"DIPS)

WEIGHT

2 Jaw Machine: 108 lbs (49Kg)

4 Jaw Machine: 155 lbs (70Kg)

Facer: 39 lbs (17.7Kg)

Heater: 21 lbs (9.5Kg)

HYDRAULICS

System Pressure: 1500 PSI (103 BAR) Max.

POWER

Heater Power: 3000 Watt @ 240V/1750 Watt @ 120V

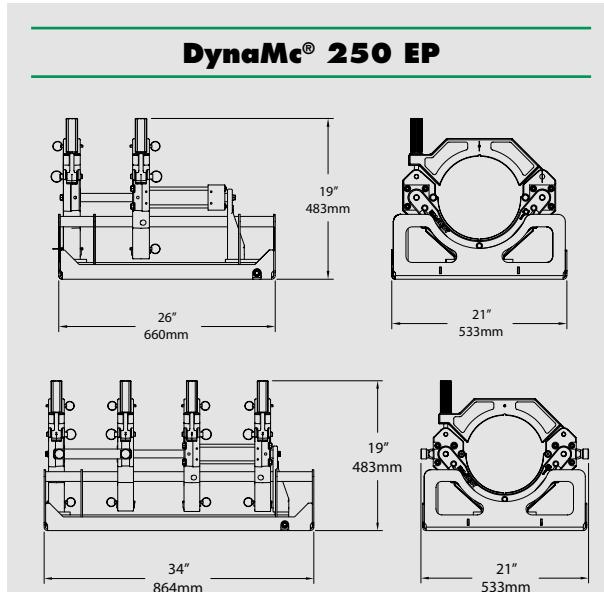
Facer Power: 1.6 HP, 10 Amp @ 120V / 5 Amp @ 240V

CHASSIS

Frame: Welded aluminum construction

WARRANTY

Term: 3 Years, see page 7 for details



CAPACITY

Fuses Pipe Sizes: 63mm – 250mm (2"IPS – 8"DIPS)

WEIGHT

2 Jaw Machine: 78 lbs (36Kg)

4 Jaw Machine: 125 lbs (57Kg)

Facer: 39 lbs (17.7Kg)

Heater: 21 lbs (9.5Kg)

POWER

Heater Power: 3000 Watt @ 240V/1750 Watt @ 120V

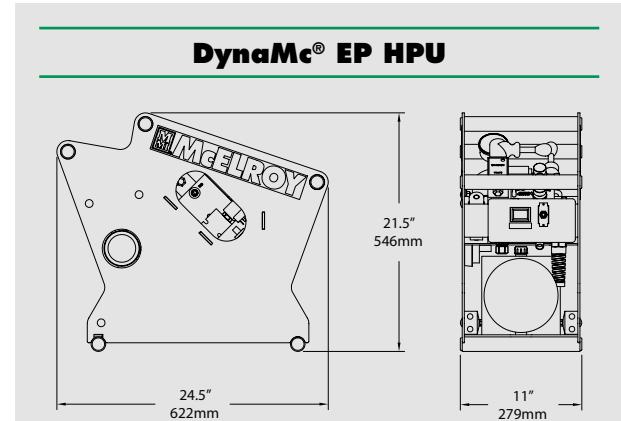
Facer Power: 1.6 HP, 10 Amp @ 120V / 5 Amp @ 240V

CHASSIS

Frame: Welded aluminum construction

WARRANTY

Term: 3 Years, see page 7 for details



WEIGHT

Machine: 115 lbs (52.1Kg)

HYDRAULICS

System Pressure: 1500PSI (103 BAR) Max.

POWER

Power: 2.2 HP, 14 Amp @ 120V / 7 Amp @ 240V

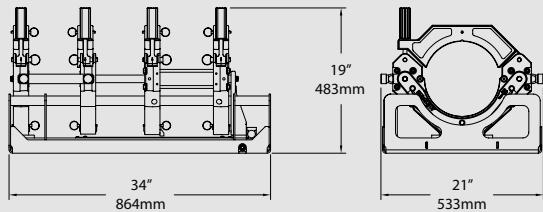
CHASSIS

Frame: Welded aluminum construction

WARRANTY

Term: 3 Years, see page 7 for details

DynaMc® 250 Auto



CAPACITY

Fuses Pipe Sizes: 63mm – 250mm (2"IPS – 8"DIPS)

WEIGHT

Carriage: 54 Kg (119 lbs)

Facer: 21.3 Kg (47 lbs)

Heater: 19.5 Kg (43 lbs)

POWER

Heater Power: 3000 Watt

Facer Power: Hydraulic

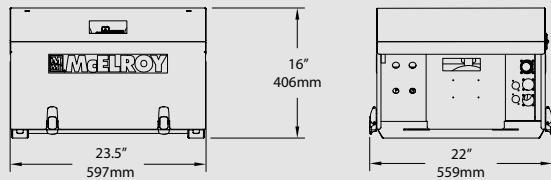
CHASSIS

Frame: Welded aluminum construction

WARRANTY

Term: 3 Years, see page 7 for details

DynaMc® Auto HPU



WEIGHT

Machine: 75.3Kg (166 lbs)

HYDRAULICS

System Pressure: 83 BAR (1200 PSI) Max.

POWER

Power: 4.0 HP, 28 Amp @ 110V / 14 Amp @ 220V

CHASSIS

Frame: Welded aluminum construction

WARRANTY

Term: 3 Years, see page 7 for details

412 Fusion Machines

Fusion Capability for 4" IPS – 12" DIPS pipe (110mm – 340mm)

Patent No's. 5,814,182 6,212,748 6,212,747 6,021,832 Japanese Patent No 4285806 European Patent No 0903215



412

McElroy's 412 line of fusion machines come in multiple model configurations to meet the demands of your pipeline project. They will butt fuse pipe sizes from **4" IPS to 12" DIPS (110mm to 340mm)**. The **Rolling 412** changed the industry when introduced as the first fully self-contained fusion machine in the world. The **TracStar® 412** added all-terrain mobility to the unit setting a new industry standard.

The TracStar 412 offers a self-contained, self-propelled track-mounted vehicle that can handle grades up to 30%. It is the number one choice on the job site for its ease of maneuverability and productivity gains. The **Pit Bull® 412** is used for special applications where the wheeled or tracked vehicle is not needed.

The Rolling, TracStar and Pit Bull units incorporate the interchangeable 412 4-jaw carriage, which can be easily removed for in-ditch fusion. For tight installations, the outer fixed jaw and skid can be removed from the carriage converting it to a 3-jaw carriage for an even more compact fusion unit. These machines can fabricate segmented ells with optional mitered inserts and are DataLogger® compatible.

The TracStar 412 has an option that allows automated control and monitoring over the heat, soak, fuse and cool cycles. The **Automated TracStar 412** system guides the operator through a step-by-step procedure for fusing pipe. It has a built-in data logging feature that keeps a record of each fusion joint, which allows you to verify joint integrity.

For in-ditch and close-quarter fusion, the **DynaMc®** line of 412 machines pack a lot of power into small packages. The machines combine the robust, patented features of standard McElroy machines into smaller units for use in tight working environments.

The **DynaMc® 412 HP (Hand Pump)** machine butt fuses pipe with a hand-powered pump. The 412 HP is available in 2- and 4-jaw models.

The **DynaMc® 412 EP** is powered by the DynaMc Electric Pump HPU, which is a common HPU for a variety of DynaMc EP fusion machines. The HPU uses a hydraulic accumulator to maintain fusion pressures and reduce power consumption.

The **DynaMc® 412 Auto** is an automatic fusion machine offering a powerful mix of features and operates within gas industry specification PL2-3:2006 and water industry specification 4-32-08, as well as other specifications.

Rolling 412

- Wheeled vehicle for easy maneuvering on the job site
- Carriage can be easily removed for in-ditch use
- Gas-powered self-contained or electric models available
- DataLogger® compatible

TracStar® 412

- Self-contained, self-propelled, all-terrain
- Carriage can be easily removed for in-ditch use
- Dual hydraulic pipe lifts aid in handling pipe
- DataLogger® compatible
- Also available as an Automated machine

Pit Bull® 412

- Compact fusion for special applications
- Hydraulic Power Unit (HPU) sold separately
- DataLogger® compatible

DynaMc® 412 HP

- Double-action hand pump creates fast carriage speed
- Detachable easy-lift cradle can be removed for maneuvering into tight spaces
- DataLogger® compatible

DynaMc® 412 EP

- Features a common Electric Pump (HPU)
- Utilizes a hydraulic accumulator to maintain fusion pressure and reduce power consumption
- DataLogger® compatible

DynaMc® 412 Auto

- Automatic fusion machine
- Modular design for easy storage and transport
- USB port for downloading fusion reports and uploading firmware updates
- Meets UK gas industry spec PL2-3:2006, UK water 4-32-08, DVS2207-1, ISO 21307, as well as other specifications.

Machine Type	Model No. *	Cylinder Force	Input Voltage Requirements	Minimum Power Requirements **	Plug Type (See pg 140)
Rolling 412 Includes fusion machine, facer, heater, insulated heater stand, 12" IPS butt fusion inserts and lifting assembly.					
	Rolling	A1248101	High	N/A, On-Board Generator	N/A, Self-Contained Gasoline
	Rolling	A1248102	Medium	N/A, On-Board Generator	N/A, Self-Contained Gasoline
	Rolling	A1248103	Low	N/A, On-Board Generator	N/A, Self-Contained Gasoline
	Rolling Electric	A1248104	High	220V - 240V, 50/60Hz, 3Ph	6.2KVA/5.8KW
	Rolling Electric	A1248105	Medium	220V - 240V, 50/60Hz, 3Ph	6.2KVA/5.8KW
	Rolling Electric	A1248106	Low	220V - 240V, 50/60Hz, 3Ph	6.2KVA/5.8KW

* A Hydraulic Clamping kit is available for all rolling 412 models, to purchase a machine equipped with this add **HC** to the end of the part number. For more information, see page 106.

	Tracked	AT1212902	High	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
	Tracked	AT1212901	Medium	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
	Tracked	AT1212903	Low	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
	Automated Tracked	AT1213202	High	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
	Automated Tracked	AT1213201	Medium	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
	Automated Tracked	AT1213203	Low	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A

* A Hydraulic Clamping kit is available for all TracStar 412 models, to purchase a machine equipped with this add **HC** to the end of the part number. For more information, see page 106.

	In-ditch	AT1213002	High	240V, 50/60Hz, 1Ph	3KW	C
	In-ditch	AT1213001	Medium	240V, 50/60Hz, 1Ph	3KW	C
	In-ditch	AT1213003	Low	240V, 50/60Hz, 1Ph	3KW	C
	HPU	T1810901	N/A	240V, 60Hz, 1Ph	HPU 4.9KVA/4.8KW, Pit Bull + HPU 7.9KVA/7.8KW	G
	HPU	T1810902	N/A	220V - 240V, 50/60Hz, 3Ph	HPU 5.2KVA/4.5KW, Pit Bull + HPU 8.2KVA/7.5KW	D

** This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 147.



Save Time and Increase Productivity

One of the more popular features of large-diameter MegaMc® fusion machines is the hydraulic clamping that tightens the jaw clamps. Now, users can retrofit their Rolling and TracStar 412s, as well as their Rolling and TracStar 618s and TracStar 500 Series IIs, with hydraulic clamping that replaces the standard manual crank clamp knobs.

See page 106 for more information

412 Fusion Machines

Fusion Capability for 4" IPS – 12" DIPS pipe (110mm – 340mm)

Machine Type	Model No.	Cylinder Force	Facer Voltage Requirements	Heater Voltage Reqs.	Min. Power Reqs. *	Plug Type (See pg 140)
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DynaMc® 412 HP Includes fusion carriage, facer, facer stand, heater and insulated heater stand.



2-Jaw DynaMc HP Pictured

Facer/Heater						
2 Jaw	A1263601	Low	100V-120V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	A/C
	A1263602	Low	220V-240V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	C/C
4 Jaw	A1262901	Low	100V-120V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	A/C
	A1262902	Low	220V-240V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	C/C

Machine Type	Model No.	Cylinder Force	Facer Voltage Requirements	Heater Voltage Reqs.	Min. Power Reqs. *	Plug Type (See pg 140)
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DynaMc® 412 EP Includes fusion carriage, facer, facer stand, heater and insulated heater stand. Electric Pump is sold separately.



4-Jaw
DynaMc EP
Pictured

Facer/Heater						
2 Jaw	A1274901	Low	100V-120V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	A/C
	A1274902	Low	220V-240V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	C/C
4 Jaw	A1274801	Low	100V-120V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	A/C
	A1274802	Low	220V-240V, 50/60Hz, 1Ph	220V-240V, 50/60Hz, 1Ph	4.2KVA, 4.2KW	C/C

Machine Type	Model No.	Input Voltage Requirements		Minimum Power Requirements *	Plug Type (See pg 140)
Electric Pump (HPU)	1272701	120V, 60Hz, 1Ph		1.56KVA, 1.25KW	A
	1272702	208V-240V, 60Hz, 1Ph		1.56KVA, 1.25KW	C
	1272703	220V-240V, 50-60Hz, 1Ph		1.65KVA, 1.24KW	M
	1272704	100V, 50/60Hz, 1Ph		1.65KVA, 1.24KW	B

Machine Type	Model No.	Cylinder Force	Input Voltage Requirements	Minimum Power Requirements *	Plug Type (See pg 140)
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DynaMc® 412 Auto Includes auto power unit, control unit, carriage, facer, facer stand and heater assembly



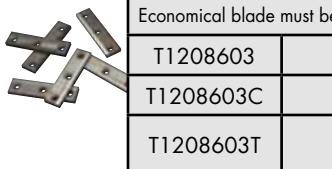
4 Jaw Automatic	A1252701	Low	110V-120V, 50/60Hz, 1Ph	3KVA, 3KW	N
4 Jaw Automatic	A1252702	Low	220V-240V, 50/60Hz, 1Ph	3KVA, 3KW	N

* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 147.

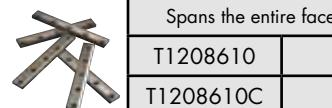
SPARE HEATER LEGEND
S Heater for 412, Pit Bull, TracStar 412 & DynaMc 412 HP/EP

A Heater for Automated TracStar 412

Part No.	Description
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Spare 4.63" Facer Blade Set - 6 blades, screws and wrench


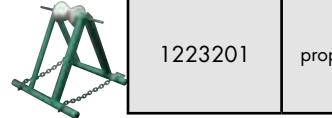
Economical blade must be positioned for different pipe sizes.	
T1208603	Standard blades.
T1208603C	Extended-life blades.
T1208603T	Carbide blades for abrasive materials.

Spare 6.13" Facer Blade Set - 6 blades, screws and wrench


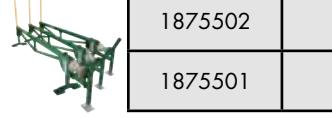
Spans the entire facer range without repositioning.	
T1208610	Standard blades.
T1208610C	Extended-life blades.

Spare Heater Plate Kit


A1242108	Set of 2 plates with anti-stick coating required for butt fusion. Kit includes attaching screws and wrench.
----------	---

Pipe Support Stand - See page 100 for more information


1223201	Adjustable pipe stand to properly support, position and align pipe to be fused.
---------	---

PolyHorse® - To learn more, see page 96


1875502	PolyHorse with PowerAssist
1875501	Standard PolyHorse


The New McElroy Heater Caddy for TracStar® Machines

Let your heater tag along for the ride. Add the new Heater Caddy to your TracStar 28, 250, 412 or 618 fusion machine to enjoy this labor-saving device.

AT1818602 Heater Caddy for models built after 9/2010

AT1818601 Retrofit Kit for TracStars built before 9/2010

Part No.	Description
1219002	For use with non-automated machines when fusing in-ditch. Plug type C.

Part No.	Description
----------	-------------

Low Profile Rollers - To learn more, see page 101

A1867501	Aids by reducing the drag on 4" to 18" pipe and protecting the pipe from damage. Case includes 40 complete roller assemblies.
----------	---

Spare Heater 220-240V, 50/60Hz, 1Ph See legend above

S 1242112	Microprocessor controlled with dial thermometer to monitor temperature. Includes heater plates insulated heater stand and stripper bars.
A T1213301	

DataLogger® - To learn more, see page 108

Used to record and document fusion process parameters.	
DL6303	Wireless DataLogger
DL6304	Wired DataLogger
DL13501	NEW! DataLogger 4 English Package*

* Other languages available. See page 108 for details.

Pyrometer Kit

A218804	Accurately checks surface temperatures of heater.
---------	---

25' Hydraulic Extension Hoses

1219105	Set of four 25' hydraulic extension hoses required for in-ditch fusion. Extension hoses are included with Pit Bull HPU.
---------	---

Part No.	Description
----------	-------------

25' Heater Extension Cord 240V, 1Ph, 15A

1219002	For use with non-automated machines when fusing in-ditch. Plug type C.
---------	--

Spare Facer Stand

T1201101	Facer stand provides a convenient place to protect and store your facer out of the dirt and mud.
----------	--

NEW! Heater Caddy

AT1818602	Allows the heater and heater bag frame to attach to a TracStar.
AT1818601	Retrofit Kit for TracStar 412 machines built before 9/2010.

Heat Shield

203007	For fusing two materials with different melt rates. Shields the faster melt rate materials from over melting.
--------	---

Stub End Holder - To learn more, see page 116

1270101	Self-centering stub end holder to hold stub end for butt fusion.
---------	--

Reusable Shipping Container

1816502	For Rolling 412.
T5009101	For TracStar 412.

412 Accessories

TracStar® Auto-Only Accessories

Automated In-Ditch Extension Kit



T5002003

Set of four 25' hydraulic extension hoses, extension cable and pendant strap. This kit is required for automated in-ditch fusion.

Spare Automated Pendant



T5007109

Spare user interface for Automated TracStars 28, 250, 412 and 618.

Spare Automated Control Box



T5001808

Spare control box for quick replacement. For use with Automated TracStars 28, 250, 412 and 618.

Spare Automated USB Thumb Drive & Adapter



AT5040101

Used for downloading fusion records from the Automated Pendant to a USB thumb drive.

DynaMc® Auto-Only Accessories

Spare DynaMc Auto Power Box Assembly



1267301

110V-120V

1269401

220V-240V

Spare DynaMc Auto Operator Control Box



1266701

Spare Control Box for use with DynaMc Auto 250 and 412.

Spare DynaMc 412 Auto 120V Heater Assembly



1256001

Spare heater for the DynaMc 412 Auto.

Spare DynaMc 412 Auto 240V Heater Assembly



1260101

Spare heater for the DynaMc 412 Auto.

MACHINE PLUG TYPE

To find the right electrical plug type see
[Page 140](#)

GENERATOR

To size your generator see
[Page 147](#)

CYLINDER FORCE

For help selecting a cylinder force see
[Page 132](#)

IN-CLASS FUSION TRAINING

Operator Training and Qualification, or Troubleshooting and Rebuild courses are available.
[www.mcelroy.com/university](#)



ONLINE RESOURCES

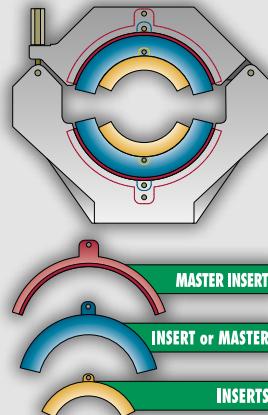
Videos available on your desktop, or mobile device.
[www.mcelroy.com/university](#)

Butt Fusion Inserts

Our cast inserts have been surface-hardened for longer life. All inserts are serrated for maximum grip on the pipe. Inserts are made for one size pipe only. Not all inserts fit directly in the jaws. Some inserts nest inside other inserts, called master inserts.

NOTE: Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs.

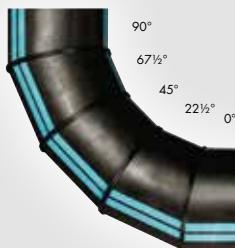
For JIS insert sizes, see page 127.



Mitered Inserts

Mitered inserts are used to fabricate segmented ellipses. Our standard miter is 11 1/4°, other mitered angles are available upon request.

**Standard Ell Configuration
90° Ell 11 1/4° miter shown**



Butt Fusion Insert Sets 2-jaw set = 4 inserts, 4-jaw set = 8 inserts

All inserts below fit in 12" DIPS 13.20" (335mm) Jaws

Inserts	Pipe OD	2 Jaw Sets	4 Jaw Sets
12" IPS/DIPS Master	12.75 (324mm)	Inc w/pkg	Inc w/pkg

All inserts below require 12" IPS/DIPS Master insert

315mm	12.40 (315mm)	1211206	1211202
10" DIPS	11.10 (282mm)	1207231	1207221
280mm	11.02 (280mm)	1207230	1207205
10" IPS	10.75 (273mm)	1207229	1207204
250mm	9.84 (250mm)	1213512	1213503
8" DIPS	9.05 (230mm)	1207109	1207107
225mm	8.86 (225mm)	1207046	1207010
8" IPS	8.63 (219mm)	1207108	1207104
200mm	7.87 (200mm)	1207045	1207009
7.125" OD/180mm	7.13 (181mm)	1207044	1207008
6" DIPS	6.90 (175mm)	1207048	1207020
6" IPS Master	6.63 (168mm)	1207043	1207007
160mm	6.30 (160mm)	1207047	1207011

All inserts below require 6" IPS' & 12" IPS/DIPS Master inserts

5" IPS	5.56 (142mm)	809435	809409
140mm	5.51 (140mm)	809439	809428
5.375 OD	5.38 (137mm)	809437	809411
5.25 OD	5.25 (133mm)	809436	809410
125mm	4.92 (125mm)	809438	809413
4" DIPS	4.80 (122mm)	809327	809315
4" IPS/100mm JIS	4.50 (114mm)	809434	809408
110mm	4.33 (110mm)	809324	809305

11 1/4° Mitered Inserts Set = 4 Inserts & 1 Template

All inserts below fit in 12" DIPS 13.20" (335mm) Jaws

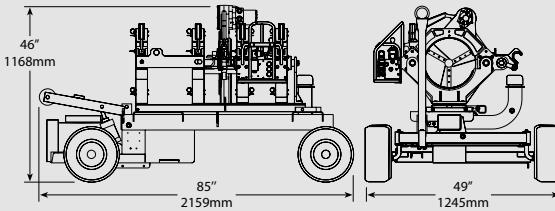
Inserts	Pipe OD	Set No.
12" IPS/DIPS Master	12.75 (324mm)	Inc w/pkg

All inserts below require 12" IPS Master insert

280mm x 11.25	11.02 (280mm)	1214284
10" IPS x 11.25	10.75 (273mm)	1214232
250mm x 11.25	9.84 (250mm)	1214235
8" DIPS x 11.25	9.05 (230mm)	1214269
225mm x 11.25	8.86 (225mm)	1214281
8" IPS x 11.25	8.63 (219mm)	1214230
200mm x 11.25	7.87 (200mm)	1214234
180mm x 11.25	7.13 (180mm)	1214290
6" DIPS x 11.25	6.90 (175mm)	1214275
6" IPS x 11.25	6.63 (168mm)	1214228
160mm x 11.25	6.30 (160mm)	1214239
5" IPS/140mm x 11.25	5.56 (141mm)	1214242
125mm x 11.25	4.92 (125mm)	12142108
4" DIPS x 11.25	4.80 (122mm)	1214287
4" IPS x 11.25	4.50 (114mm)	1214226
110mm x 11.25	4.33 (110mm)	1214255

412 Specifications

Rolling 412 Gas Powered



CAPACITY

Fuses Pipe Sizes: 4"IPS – 12"DIPS (110mm – 340mm)

WEIGHT

Machine: 1225 lbs (556Kg)
4 Jaw Carriage Configuration: 359 lbs (163Kg)
3 Jaw Carriage Configuration: 261 lbs (118.4Kg)
Facer: 62 lbs (28.1Kg)
Heater: 24 lbs (10.9Kg)

HYDRAULICS

System Pressure: 1200 PSI (82.74 BAR) Max.
Hydraulic Reservoir Capacity: 6 Gallons (22.71 Liters)

ENGINE

Engine Type: 18HP Air Cooled V-Twin
Fuel Type: Gasoline
Fuel Tank Capacity: 5 Gallons (18.92 Liters)
Operational Tank Capacity: 8 Hours
Starting System: Electric

ELECTRICAL

Input: None, self-contained
AC Output: 2 receptacles 240V each

POWER

Heater Power: 3000 Watt
Facer Power: Hydraulic

CHASSIS

Frame: Welded steel tube construction
Front Axle: Articulating
Brake: Mechanical

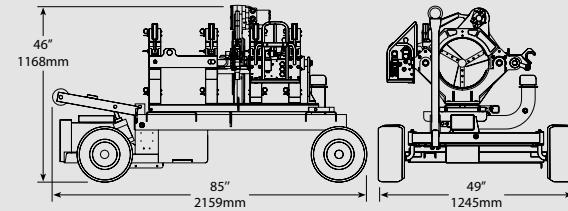
MOBILITY

Tires: High-flotation Inflatable Tires
Transportation: Pulled via towing ring
Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Rolling 412 Electric Powered



CAPACITY

Fuses Pipe Sizes: 4"IPS – 12"DIPS (110mm – 340mm)

WEIGHT

Machine: 915 lbs (415Kg)
4 Jaw Carriage Configuration: 359 lbs (163Kg)
3 Jaw Carriage Configuration: 261 lbs (118.4Kg)
Facer: 62 lbs (28.1Kg)
Heater: 24 lbs (10.9Kg)

HYDRAULICS

System Pressure: 1200 PSI (82.74 BAR) Max.
Hydraulic Reservoir Capacity: 6 Gallons (22.71 Liters)

ELECTRICAL

Input: 6.2KVA/5.2KW @ 220V-240V, 50/60Hz, 3Ph

POWER

Heater Power: 3000 Watt
Facer Power: Hydraulic
Electric Motor: 3 HP

CHASSIS

Frame: Welded steel tube construction
Front Axle: Articulating
Brake: Mechanical

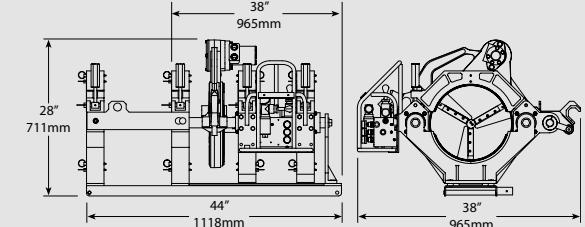
MOBILITY

Tires: High-flotation Inflatable Tires
Transportation: Pulled via towing ring
Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Pit Bull® 412



CAPACITY

Fuses Pipe Sizes: 4"IPS – 12"DIPS (110mm – 340mm)

WEIGHT

4 Jaw Carriage Configuration: 359 lbs (163Kg)
3 Jaw Carriage Configuration: 261 lbs (118.4Kg)
Facer: 62 lbs (28.1Kg)
Heater: 24 lbs (10.9Kg)

POWER

Heater Power: 3000 Watt
Facer Power: Hydraulic

CHASSIS

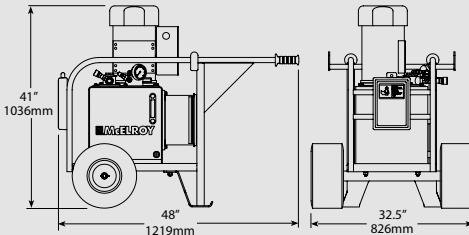
Frame: Welded steel construction

WARRANTY

Term: 3 Years, see page 7 for details

Note: All carriage weights are without facer and heater. Specifications subject to change without notice. **Additional dimensions available on page 144.**

Pit Bull® HPU (Hydraulic Power Unit)



WEIGHT

Machine: 390 lbs (176.9Kg)

HYDRAULICS

System Pressure: 1500 PSI (103.42 BAR) Max.
Hydraulic Reservoir Capacity: 10 Gallons (37 Liters)
Pump Flow Rate 60 Hz: 6.1 gpm (23.1 Lpm)
Pump Flow Rate 50 Hz: 5.0 gpm (18.9 Lpm)
Filtration: 10 micron absolute

POWER

Power Requirement: 5.2KVA/4.5KW @ 240V, 3Ph

MOTOR

Electric: 5 HP

MOBILITY

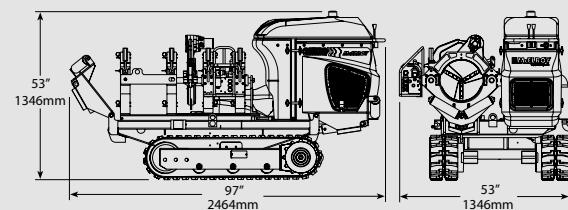
Tires: High-flotation Inflatable Tires

Transportation: Two wheel cart

WARRANTY

Term: 3 Years, see page 7 for details

TracStar® 412



CAPACITY

Fuses Pipe Sizes: 4"IPS – 12"DIPS (110mm – 340mm)

WEIGHT

Machine: 2000 lbs (907Kg)
4 Jaw Carriage Configuration: 359 lbs (163Kg)
3 Jaw Carriage Configuration: 261 lbs (118.4Kg)
Facer: 62 lbs (28.1Kg)
Heater: 24 lbs (10.9Kg)

HYDRAULICS

System Pressure: 2000 PSI (137.90 BAR) Max.

Hydraulic Reservoir Capacity: 8 Gallons (30.28 Liters)

ENGINE

Engine Type: 20 HP liquid cooled
Fuel Type: Diesel
Fuel Tank Capacity: 5 Gallons (18.92 Liters)
Operational Tank Capacity: 8 Hours
Starting System: Electric

ELECTRICAL

Input: None, self-contained
AC Output: 120V & 240V, 60Hz, 15Amp

POWER

Heater Power: 3000 Watt
Facer Power: Hydraulic

CHASSIS

Frame: Welded steel construction
Brake: Self-locking

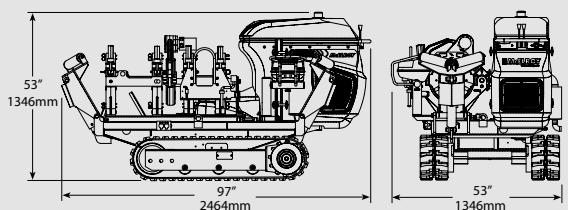
MOBILITY

Tracked: Rubber crawler tracks
Transportation: Self-propelled
Vehicle speed: 1.5 Mph Max.
Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Automated TracStar® 412



CAPACITY

Fuses Pipe Sizes: 4"IPS – 12"DIPS (110mm – 340mm)

WEIGHT

Machine: 2000 lbs (907Kg)
4 Jaw Carriage Configuration: 359 lbs (163Kg)
3 Jaw Carriage Configuration: 261 lbs (118.4Kg)
Facer: 62 lbs (28.1Kg)
Heater: 24 lbs (10.9Kg)

HYDRAULICS

System Pressure: 2000 PSI (137.90 BAR) Max.

Hydraulic Reservoir Capacity: 8 Gallons (30.28 Liters)

ENGINE

Engine Type: 20 HP liquid cooled
Fuel Type: Diesel
Fuel Tank Capacity: 5 Gallons (18.92 Liters)
Operational Tank Capacity: 8 Hours
Starting System: Electric

ELECTRICAL

Input: None, Self-contained

POWER

Heater Power: 3000 Watt
Facer Power: Hydraulic

CHASSIS

Frame: Welded steel construction
Brake: Self-locking

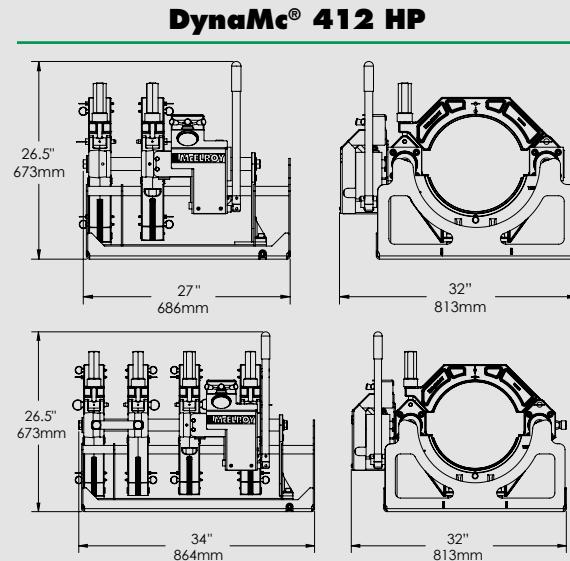
MOBILITY

Tracked: Rubber crawler tracks
Transportation: Self-propelled
Vehicle speed: 1.5 Mph Max.
Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

412 Specifications

**CAPACITY**

Fuses Pipe Sizes: 4" IPS – 12" DIPS (110mm - 340mm)

WEIGHT

2 Jaw Machine: 200 lbs (90 kg)

4 Jaw Machine: 293 lbs (132Kg)

Facer: 54 lbs (24.5 kg)

Heater: 24 lbs (10.9Kg)

HYDRAULICS

System Pressure: 1500 PSI (103 BAR) Max.

POWER

Heater Power: 3000 Watt

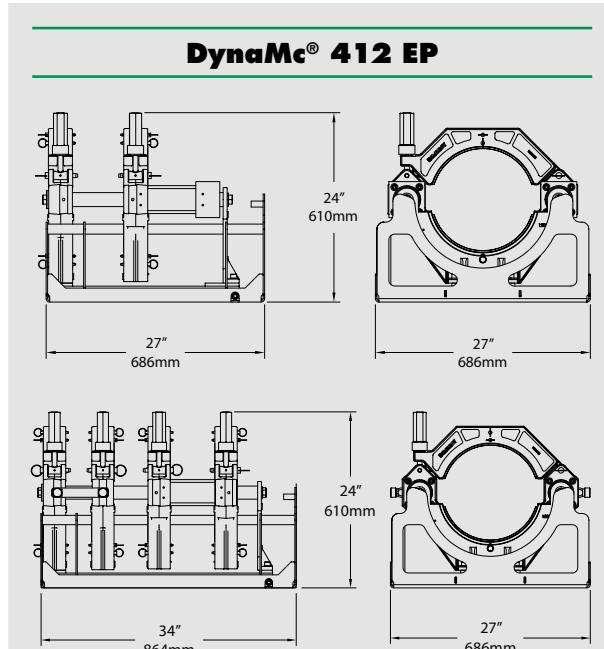
Facer Power: 1.6 HP, 10 Amp @ 120V / 5 Amp @ 240V

CHASSIS

Frame: Welded aluminum construction

WARRANTY

Term: 3 Years, see page 7 for details

**CAPACITY**

Fuses Pipe Sizes: 4" IPS – 12" DIPS (110mm - 340mm)

WEIGHT

2 Jaw Machine: 170 lbs (77Kg)

4 Jaw Machine: 263 lbs (120Kg)

Facer: 54 lbs (24.5Kg)

Heater: 24 lbs (10.9Kg)

POWER

Heater Power: 3000 Watt

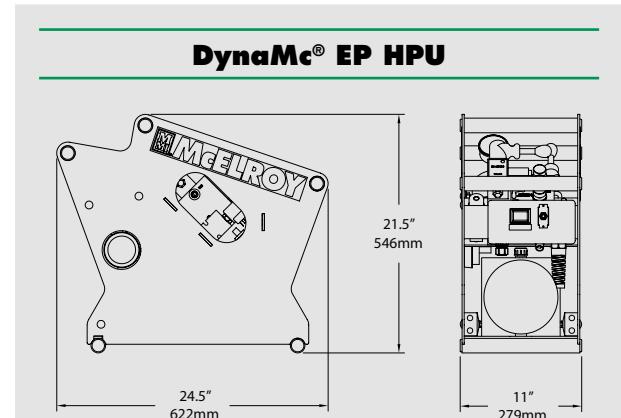
Facer Power: 1.6 HP, 10 Amp @ 120V / 5 Amp @ 240V

CHASSIS

Frame: Welded aluminum construction

WARRANTY

Term: 3 Years, see page 7 for details

**WEIGHT**

Machine: 115 lbs (52.1Kg)

HYDRAULICS

System Pressure: 1500PSI (103 BAR) Max.

POWER

Power: 2.2 HP, 14 Amp @ 120V / 7 Amp @ 240V

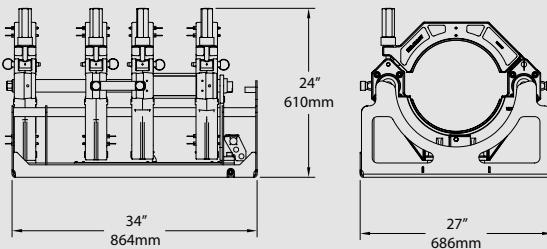
CHASSIS

Frame: Welded aluminum construction

WARRANTY

Term: 3 Years, see page 7 for details

DynaMc® 412 Auto



CAPACITY

Fuses Pipe Sizes: 110mm - 340mm (4" IPS – 12" DIPS)

WEIGHT

Carriage: 120Kg (263 lbs)

Minimum Carriage Transport Weight*: 70.5Kg (155 lbs)

Facer: 28.6Kg (62 lbs)

Heater: 27.2Kg (60 lbs)

POWER

Heater Power: 3000 Watt

Facer Power: Hydraulic

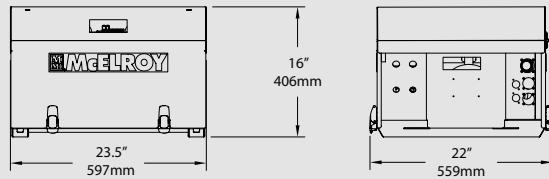
CHASSIS

Frame: Welded aluminum construction

WARRANTY

Term: 3 Years, see page 7 for details

DynaMc® Auto HPU



WEIGHT

Machine: 75.3Kg (166 lbs)

HYDRAULICS

System Pressure: 83 BAR (1200 PSI) Max.

POWER

Power: 4.0 HP, 28 Amp @ 110V / 14 Amp @ 220V

CHASSIS

Frame: Welded aluminum construction

WARRANTY

Term: 3 Years, see page 7 for details

618 Fusion Machines

Fusion Capability for 6" IPS – 18" OD pipe (180mm – 450mm)

Patent No's. 5,814,182 6,212,748 6,212,747 6,021,832 Japanese Patent No 4285806 European Patent No 0903215



618

McElroy's 618 line of fusion machines come in multiple model configurations to meet the demands of your pipeline project. They will butt fuse pipe sizes from **6" IPS to 18" OD (180mm to 450mm)**. One of our best sellers, the **Rolling 618** bridges the gap between small and large diameter pipe fusion.

The **TracStar® 618** offers a self-contained, self-propelled, track-mounted vehicle that can handle grades up to 30%. It is the number one choice on the job site for its ease of maneuverability and productivity gains. The **Pit Bull® 618** is used for special applications where the wheeled or tracked vehicle is not needed.

All units incorporate the interchangeable 618 4-jaw carriage, which can be easily removed for in-ditch fusion. For tight installations, the outer fixed jaw and skid can be removed from the carriage converting it to a 3-jaw carriage for an even more compact fusion unit. These

machines can fabricate segmented ells with optional mitered inserts and are DataLogger® compatible.

The TracStar 618 has an option that allows automated control and monitoring over the heat, soak, fuse and cool cycles. The **Automated TracStar 618** system guides the operator through a step-by-step procedure for fusing pipe. It has a built-in data logging feature that keeps a record of each fusion joint, which allows you to verify joint integrity.

AVAILABLE WITH AUTOMATED CONTROL

McElroy's automatic pendant accessory will help guide the user through the steps of the fusion process. The pendant even serves as a data logging device for verifying joint integrity.



Rolling 618

- Wheeled chassis for easy maneuvering on the job site
- Carriage can be easily removed for in-ditch use
- On-board generator for powering heater and other devices
- Gas-powered self-contained or electric models available
- Hydraulic pipe lift aids in loading and unloading pipe
- DataLogger® compatible
- Hydraulic Clamping available

TracStar® 618

- Self-contained, self-propelled, all-terrain
- Powered by a 20 HP liquid-cooled diesel engine
- Carriage can be easily removed for in-ditch use
- On-board generator for powering heater & other devices
- Dual hydraulic pipe lifts aid in handling pipe
- Fits in a standard long box truck bed for easy transport
- DataLogger® compatible
- Also available as an Automated fusion machine
- Hydraulic Clamping available

Pit Bull® 618

- Compact fusion for special applications
- Hydraulic Power Unit (HPU) sold separately
- DataLogger® compatible

GENERATOR

To size your generator see
Page 147

CYLINDER FORCE

For help selecting a cylinder force see
Page 133

DataLogger®

To learn more about the DataLogger see
Page 108

McElroy Technical Service:

Online or Off Whether you prefer online documentation, discussion forums, facebook, twitter, or a personal phone call, our technical services staff along with our worldwide distributor network are ready to assist with any technical issue on or off the jobsite.



Machine Type	Model No. *	Cylinder Force	Input Voltage Requirements	Minimum Power Requirements **	Plug Type (See pg 140)
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Rolling 618

Includes fusion machine, facer, 12" IPS – 18" OD heater, insulated heater stand and lifting assembly. ***



Rolling	A1869101	High	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A
Rolling	A1869102	Medium	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A
Rolling	A1869103	Low	N/A, On-Board Generator	N/A, Self-Contained Gasoline	N/A
Rolling Electric	A1869104	High	220V - 240V, 50/60Hz, 3Ph	8.0KVA/7.4KW	F
Rolling Electric	A1869105	Medium	220V - 240V, 50/60Hz, 3Ph	8.0KVA/7.4KW	F
Rolling Electric	A1869106	Low	220V - 240V, 50/60Hz, 3Ph	8.0KVA/7.4KW	F

* A Hydraulic Clamping kit is available for all rolling 618 models, to purchase a machine equipped with this add **HC** to the end of the part number. For more information, see page 106.

TracStar® 618

Includes fusion machine, facer, 12" IPS – 18" OD heater, insulated heater stand and lifting assembly. ***



Tracked	AT1807402	High	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
Tracked	AT1807401	Medium	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
Tracked	AT1807403	Low	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
Automated Tracked	AT1813202	High	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
Automated Tracked	AT1813201	Medium	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
Automated Tracked	AT1813203	Low	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A

* A Hydraulic Clamping kit is available for all TracStar 618 models, to purchase a machine equipped with this add **HC** to the end of the part number. For more information, see page 106.

Pit Bull® 618

Includes fusion carriage, facer, 12" IPS – 18" OD heater and insulated heater stand. HPU which includes extension hoses and lifting assembly sold separately. ***



In-ditch	AT1807502	High	220V - 240V, 50/60Hz, 1Ph,	3KW	C
In-ditch	AT1807501	Medium	220V - 240V, 50/60Hz, 1Ph,	3KW	C
In-ditch	AT1807503	Low	220V - 240V, 50/60Hz, 1Ph,	3KW	C
HPU	T1810901	N/A	240V, 60Hz, 1Ph	HPU 4.9KVA/4.8KW, Pit Bull + HPU 7.9KVA/7.8KW	G
HPU	T1810902	N/A	220V - 240V, 50/60Hz, 3Ph	HPU 5.2KVA/4.5KW, Pit Bull + HPU 8.2KVA/7.5KW	D

** This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 147.

*** 6" IPS - 12" DIPS heater sold separately.



The New McElroy Heater Caddy for TracStar® Machines

Let your heater tag along for the ride. Add the new Heater Caddy to your TracStar 28, 250, 412 or 618 fusion machine to enjoy this labor-saving device.

AT1818602 Heater Caddy for models built after 9/2010

AT1818601 Retrofit Kit for TracStars built before 9/2010

618 Accessories

SPARE HEATER LEGEND Heater for 618, Pit Bull & TracStar 618 Heater for Automated TracStar 618

Part No.	Description
Spare 4.63" Facer Blade Set - 6 blades, screws and wrench	
	Economical blade must be positioned for different pipe sizes.
T1208603	Standard blades.
T1208603C	Extended-life blades.
T1208603T	Carbide blades for abrasive materials.

Part No.	Description
Spare 9.12" Facer Blade Set - 6 blades, screws and wrench	
	Spans the entire facer range without repositioning.
T1812602	Standard blades.
T1812602C	Extended-life blades.

Part No.	Description
Spare Heater Plate Kit - Includes attaching screws and wrench	
	Plates have an anti-stick coating & are required for butt fusion.
A1242108	Set of two 6" IPS - 12" DIPS plates.
A1852013	Set of two 12" IPS - 18" OD plates.

Part No.	Description
	Adjustable pipe stand to properly support, position and align pipe to be fused.
1223201	

Part No.	Description
	PolyHorse® - To learn more, see page 96
1875502	PolyHorse with PowerAssist
1875501	Standard PolyHorse

Part No.	Description
Low Profile Rollers - To learn more, see page 101	
	Aids by reducing the drag on 4" to 18" pipe and protecting the pipe from damage. Case includes 40 complete roller assemblies.
A1867501	

Part No.	Description
Stub End Holder - To learn more, see page 116	
1879101	Self-centering stub end holder to hold stub end for butt fusion.

Part No.	Description
DataLogger® - To learn more, see page 108	
	Used to record and document fusion process parameters.
DL6303	Wireless DataLogger
DL6304	Wired DataLogger
DL13501	NEW! DataLogger 4 English Package*

* Other languages available. See page 108 for details.

Part No.	Description
	Spare 6" IPS - 12" DIPS Heater - 220-240V, 50/60Hz, 1Ph
S 1855502	Microprocessor-controlled with dial thermometer to monitor temperature. Includes heater plates insulated heater stand and stripper bars.
A T1813401	

Part No.	Description
	Spare 12" IPS - 18" OD Heater - 220-240V, 50/60Hz, 1Ph
S 1852019	Microprocessor-controlled with dial thermometer to monitor temperature. Includes heater plates insulated heater stand and stripper bars.
A T1813301	

Part No.	Description
	Pyrometer Kit
A218804	Accurately checks surface temperatures of heater.

Part No.	Description
	25' Hydraulic Extension Hoses
1219105	Set of four 25' hydraulic extension hoses required for in-ditch fusion. Extension hoses are included with Pit Bull HPU.

Part No.	Description
	25' Heater Extension Cord 240V, 1Ph, 15A
1219002	For use with non-automated machines when fusing in-ditch. Plug type C.

Part No.	Description
In-Ditch Facer Stand	
T1801101	Facer stand provides a convenient place to protect and store your facer out of the dirt and mud when fusing in-ditch.

Part No.	Description
NEW! Heater Caddy	
	Allows the heater and heater bag frame to attach to a TracStar.
AT1818602	
AT1818601	Retrofit Kit for TracStar 618 machines built before 9/2010.

Part No.	Description
	For fusing two materials with different melt rates. Shields the faster melt rate materials from over melting.
203009	

Part No.	Description
	For Rolling 618.
1816502	
T5009101	For TracStar 618.

Part No.	Description
	Automated In-Ditch Extension Kit
T5002003	Set of four 25' hydraulic extension hoses, extension cable and pendant strap. This kit is required for automated in-ditch fusion.

Part No.	Description
	Spare Automated Pendant
T5007109	Spare user interface for Automated TracStars 28, 250, 412 and 618.

Part No.	Description
	Spare Automated Control Box
T5001808	Spare control box for quick replacement. For use with Automated TracStars 28, 250, 412 and 618.

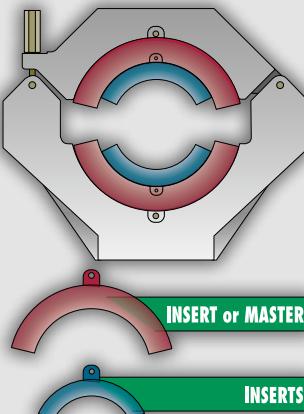
Part No.	Description
Spare Automated USB Thumb Drive & Adapter	
AT5040101	Used for downloading fusion records from the Automated Pendant to a USB thumb drive.

Butt Fusion Inserts

Our cast inserts have been surface-hardened for longer life. All inserts are serrated for maximum grip on the pipe. Inserts are made for one size pipe only. Not all inserts fit directly in the jaws. Some inserts nest inside other inserts, called master inserts.

NOTE: Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs.

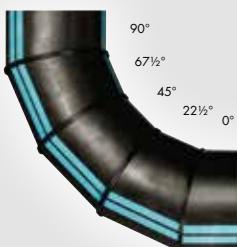
For JIS insert sizes, see page 127.



Mitered Inserts

Mitered inserts are used to fabricate segmented ell's. Our standard miter is 11 1/4°, other mitered angles are available upon request.

**Standard Ell Configuration
90° Ell 11 1/4° miter shown**



Butt Fusion Inserts Set = 8 Inserts

All inserts below fit in 18" OD (457mm) Jaws

Inserts	Pipe OD	Set No.
450mm	17.72 (450mm)	2418201
16" DIPS	17.40 (442mm)	2412117
16" OD	16.00 (406mm)	2412110
400mm	15.75 (400mm)	2412111
14" DIPS	15.30 (389mm)	2412215
14" OD	14.00 (355mm)	2412206
340mm	13.39 (340mm)	2411811
12" DIPS	13.20 (335mm)	2411826
12" IPS Master	12.75 (324mm)	2411810

11 1/4° Mitered Inserts Set = 4 Inserts & 1 Template

All inserts below fit in 18" OD (457mm) Jaws

Inserts	Pipe OD	Set No.
16" OD	16.00 (406mm)	2420619
400mm	15.75 (400mm)	2420618
14" DIPS	15.30 (389mm)	24206122
370mm	14.57 (370mm)	24206125
14" OD	14.00 (355mm)	2420617
12" DIPS	13.20 (335mm)	24206110
12" IPS	12.75 (324mm)	2420615
315mm	12.40 (315mm)	2420614
10" DIPS	11.10 (282mm)	24206116
12" IPS Master	12.75 (324mm)	2411810

All inserts below require 12" IPS Master inserts

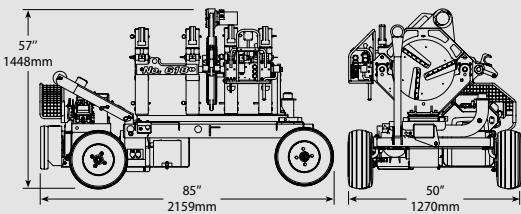
315mm	12.40 (315mm)	1211202
10" DIPS	11.10 (282mm)	1207221
280mm	11.02 (280mm)	1207205
10" IPS	10.75 (273mm)	1207204
250mm	9.84 (250mm)	1213503
8" DIPS	9.05 (230mm)	1207107
225mm	8.86 (225mm)	1207010
8" IPS	8.63 (219mm)	1207104
200mm	7.87 (200mm)	1207009
7.125"/180mm OD	7.13 (180mm)	1207008
6" DIPS	6.90 (175mm)	1207020
6" IPS Master	6.63 (168mm)	1207007
160mm	6.30 (160mm)	1207011

All inserts below require 12" IPS Master inserts

280mm	11.02 (280mm)	1214284
10" IPS	10.75 (273mm)	1214232
250mm	9.84 (250mm)	1214235
8" DIPS	9.05 (230mm)	1214269
225mm	8.86 (225mm)	1214281
8" IPS	8.63 (219mm)	1214230
200mm	7.87 (200mm)	1214234
180mm	7.09 (180mm)	1214290
6" DIPS	6.90 (175mm)	1214275
6" IPS	6.63 (168mm)	1214228

618 Specifications

Rolling 618 Gas Powered



CAPACITY

Fuses Pipe Sizes: 6" IPS – 18" OD pipe (180mm – 450mm)

WEIGHT

Machine: 1335 lbs (606Kg)
4 Jaw Carriage Configuration: 445 lbs (202Kg)
3 Jaw Carriage Configuration: 350 lbs (158Kg)
Facer: 91 lbs (41.3Kg)
6" IPS - 12" DIPS Heater: 28 lbs (13Kg)
12" IPS - 18" OD Heater: 34 lbs (15.4Kg)

HYDRAULICS

System Pressure: 1200 PSI (82.74 BAR) Max.
Hydraulic Reservoir Capacity: 6 Gallons (22.71 Liters)

ENGINE

Engine Type: 18 HP Air Cooled V-Twin
Fuel Type: Gasoline
Fuel Tank Capacity: 5 Gallons (18.92 Liters)
Operational Tank Capacity: 8 Hours
Starting System: Electric

ELECTRICAL

Input: None, self-contained
AC Output: 2 receptacles 240V each

POWER

Heater Power: 3000 Watt
Facer Power: Hydraulic

CHASSIS

Frame: Welded steel tube construction
Front Axle: Articulating
Brake: Mechanical

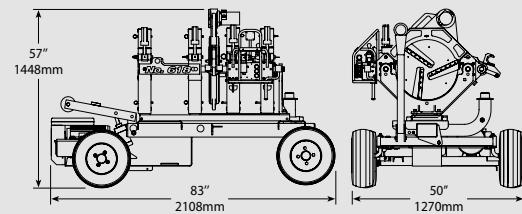
MOBILITY

Tires: High-flotation Inflatable Tires
Transportation: Pulled via towing ring
Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Rolling 618 Electric Powered



CAPACITY

Fuses Pipe Sizes: 6" IPS – 18" OD pipe (180mm – 450mm)

WEIGHT

Machine: 1100 lbs (498Kg)
4 Jaw Carriage Configuration: 445 lbs (202Kg)
3 Jaw Carriage Configuration: 350 lbs (158Kg)
Facer: 91 lbs (41.3Kg)
6" IPS - 12" DIPS Heater: 28 lbs (13Kg)
12" IPS - 18" OD Heater: 34 lbs (15.4Kg)

HYDRAULICS

System Pressure: 1200 PSI (82.74 BAR) Max.
Hydraulic Reservoir Capacity: 6 Gallons (22.71 Liters)

ELECTRICAL

Input: 6.2KVA/5.2KW @ 220V-240V, 50/60Hz, 3Ph

POWER

Heater Power: 3000 Watt
Facer Power: Hydraulic
Electric Motor: 5 HP

CHASSIS

Frame: Welded steel tube construction
Front Axle: Articulating
Brake: Mechanical

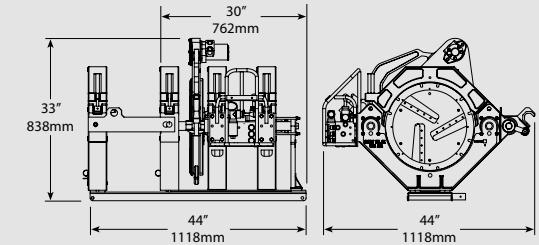
MOBILITY

Tires: High-flotation Inflatable Tires
Transportation: Pulled via towing ring
Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Pit Bull® 618



CAPACITY

Fuses Pipe Sizes: 6" IPS – 18" OD pipe (180mm – 450mm)

WEIGHT

4 Jaw Carriage Configuration: 445 lbs (202Kg)
3 Jaw Carriage Configuration: 350 lbs (158Kg)
Facer: 91 lbs (41.3Kg)
6" IPS - 12" DIPS Heater: 28 lbs (13Kg)
12" IPS - 18" OD Heater: 34 lbs (15.4Kg)

POWER

Heater Power: 3000 Watt
Facer Power: Hydraulic

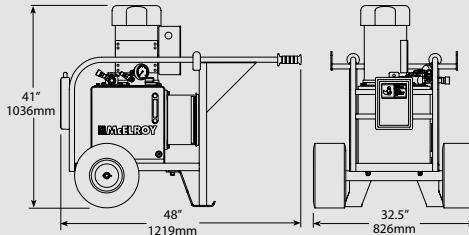
CHASSIS

Frame: Welded steel construction

WARRANTY

Term: 3 Years, see page 7 for details

Pit Bull® HPU (Hydraulic Power Unit)



WEIGHT

Machine: 390 lbs (176.9Kg)

HYDRAULICS

System Pressure: 1500 PSI (103.42 BAR) Max.
 Hydraulic Reservoir Capacity: 10 Gallons (37 Liters)
 Pump Flow Rate 60 Hz: 6.1 gpm (23.1 Lpm)
 Pump Flow Rate 50 Hz: 5.0 gpm (18.9 Lpm)
 Fluid: Exxon Univis N46 or equivalent
 Filtration: 10 micron absolute

POWER

Power Requirement: 5.2KVA/4.5KW @ 240V, 3Ph

MOTOR

Electric: 5 HP

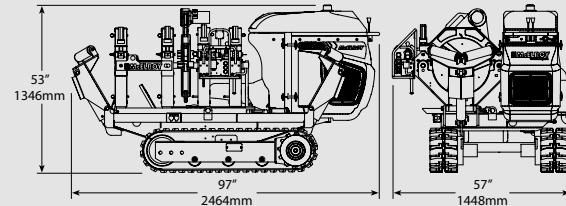
MOBILITY

Tires: High-flotation inflatable tires
 Transportation: Two wheel cart

WARRANTY

Term: 3 Years, see page 7 for details

TracStar® 618



CAPACITY

Fuses Pipe Sizes: 6" IPS – 18" OD pipe (180mm – 450mm)

WEIGHT

Machine: 2085 lbs (946Kg)
 4 Jaw Carriage Configuration: 445 lbs (202Kg)
 3 Jaw Carriage Configuration: 350 lbs (158Kg)
 Facer: 91 lbs (41.3Kg)
 6" IPS - 12" DIPS Heater: 28 lbs (13Kg)
 12" IPS - 18" OD Heater: 34 lbs (15.4Kg)

HYDRAULICS

System Pressure: 2000 PSI (137.90 BAR) Max.
 Hydraulic Reservoir Capacity: 8 Gallons (30.28 Liters)

ENGINE

Engine Type: 20 HP liquid cooled
 Fuel Type: Diesel
 Fuel Tank Capacity: 5 Gallons (18.92 Liters)
 Operational Tank Capacity: 8 Hours
 Starting System: Electric

ELECTRICAL

Input: None, self-contained
 AC Output: 120V & 240V, 60Hz, 15 Amp

POWER

Heater Power: 3000 Watt
 Facer Power: Hydraulic

CHASSIS

Frame: Welded steel construction
 Brake: Self-locking

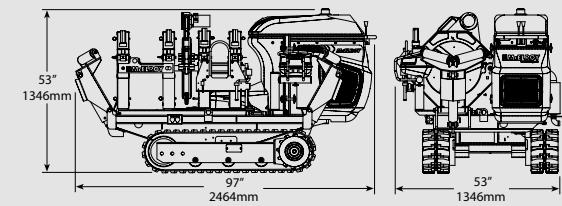
MOBILITY

Tracked: Rubber crawler tracks
 Transportation: Self-propelled
 Vehicle speed: 1.5 Mph Max.
 Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Automated TracStar® 618



CAPACITY

Fuses Pipe Sizes: 6" IPS – 18" OD pipe (180mm – 450mm)

WEIGHT

Machine: 2085 lbs (948Kg)
 4 Jaw Carriage Configuration: 445 lbs (202Kg)
 3 Jaw Carriage Configuration: 350 lbs (158Kg)
 Facer: 91 lbs (41.3Kg)
 6" IPS - 12" DIPS Heater: 28 lbs (13Kg)
 12" IPS - 18" OD Heater: 34 lbs (15.4Kg)

HYDRAULICS

System Pressure: 2000 PSI (137.90 BAR) Max.
 Hydraulic Reservoir Capacity: 8 Gallons (30.28 Liters)

ENGINE

Engine Type: 20 HP liquid cooled
 Fuel Type: Diesel
 Fuel Tank Capacity: 5 Gallons (18.92 Liters)
 Operational Tank Capacity: 8 Hours
 Starting System: Electric

ELECTRICAL

Input: None, self-contained

POWER

Heater Power: 3000 Watt
 Facer Power: Hydraulic

CHASSIS

Frame: Welded steel construction
 Brake: Self-locking

MOBILITY

Tracked: Rubber crawler tracks
 Transportation: Self-propelled
 Vehicle speed: 1.5 Mph Max.
 Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

500 Fusion Machines

Fusion Capability for 6" IPS – 20" OD pipe (180mm – 500mm)

Patent No's. 5,814,182 6,212,748 6,212,747 6,021,832 Japanese Patent No 4285806 European Patent No 0903215



TracStar® 500 Series 3

McElroy's **TracStar® 500** Series 3 will butt fuse pipe sizes from **6" IPS to 20" OD (180mm – 500mm)**. The Series 3 incorporates numerous productivity enhancement features usually found in the MegaMc machines.

Considered the flagship McElroy fusion machine, the success of the TracStar 500 spawned the entire TracStar line of fusion equipment.

The TracStar 500 Series 3 features a facer and heater that are indexer-mounted and powered by the machine. Hydraulic clamping is a standard feature, as well as an economy engine throttle setting that helps conserve fuel.

The **Automatic TracStar 500** is also available with automatic control and monitoring over the heat, soak, fuse and cool cycles. This automatic system guides the operator through a step-by-step procedure for fusing pipe. It has a built-in data logging feature that keeps a record of each fusion joint, which allows you to verify joint integrity.

AVAILABLE WITH AUTOMATIC CONTROL McElroy's automatic pendant accessory will help guide the user through the steps of the fusion process. The pendant even serves as a data logging device for verifying joint integrity.



TracStar® 500 Series 3

- Heater and facer mounted on hydraulic indexer
- Fuel saving auto-throttle
- Standard Hydraulic Clamping
- One heater covers entire range of pipe fusion sizes
- Patented Centerline Guidance System for equal distribution of force around the joint
- 11+ hours operational fuel tank capacity
- ISO-compliant industrial Teflon-coated plates
- Dual hydraulic pipe lifts
- DataLogger® compatible
- Dual speed tracks
- Also available as an Automatic

Pit Bull® 500 Series II

- Removable 3- or 4-jaw carriage for in-ditch use
- Compact fusion for special applications
- Hydraulic Power Unit (HPU) sold separately
- DataLogger® compatible

GENERATOR

To size your generator see
Page 147

DataLogger®

To learn more about the DataLogger see
Page 108

CYLINDER FORCE

For help selecting a cylinder force see
Page 134

IN-CLASS FUSION TRAINING

Operator Training and Qualification, or Troubleshooting and Rebuild courses are available.
www.mcelproy.com/university



ONLINE RESOURCES

Videos available on your desktop, or mobile device.
www.mcelproy.com/university

Machine Type	Model No.	Cylinder Force	Input Voltage Requirements	Minimum Power Requirements *	Plug Type (See pg 140)
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TracStar® 500 Series 3

Includes fusion machine, facer, 6" IPS to 20" OD heater, and lifting assembly.



Standard 20" Carriage	AT5000110	Medium	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
Standard 500mm Carriage	AT5000111	Medium	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A

Automatic 20" Carriage	AT5036105	Medium	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
Automatic 500mm Carriage	AT5036106	Medium	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A

Pit Bull® 500 Series II

Includes fusion carriage, facer, facer stand, 6" IPS to 20" OD heater. HPU which includes extension hoses and lifting assembly sold separately. **



In-ditch 20" Carriage	AT5034001	Medium	240V, 50/60Hz, 1Ph	4KW	C
In-ditch 500mm Carriage	AT5034002	Medium	240V, 50/60Hz, 1Ph	4KW	C
HPU	T1810901	N/A	240V, 60Hz, 1Ph	HPU 4.9KVA/4.8KW, Pit Bull + HPU 8.9KVA/8.8KW	G
HPU	T1810902	N/A	220V - 240V, 50/60Hz, 3Ph	HPU 5.2KVA/4.5KW, Pit Bull + HPU 9.2KVA/8.5KW	D

* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 147.

** 6" IPS - 12" DIPS heater sold separately.



150%
Production
Increase!

Enhance Productivity with Stick Pipe

The PolyHorse is a new pipe-handling system that consists of a series of adjustable racks to store and help install the pipe on the job site. For use with PE pipe sizes 3" through 20", the PolyHorse can reduce manpower expense, provide an efficient, less hazardous environment for handling pipe bundles and enhance productivity by 150%. See page 96

500 Accessories

Part No.	Description
Spare Facer Blade Kit - Includes six blades, screws and wrench	
T5005006	Standard blades.
T5005006C	Extended-life blades.
T5005008T	Carbide blades for abrasive materials.

	Spare Heater Plate Kit - Includes attaching screws and wrench Plates have an anti-stick coating & are required for butt fusion. AT5048011 Set of two 6" IPS - 20" OD plates.
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	Pipe Support Stand - See page 100 for more information 1223201 Adjustable pipe stand to properly support, position and align pipe to be fused.
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	PolyHorse® - To learn more, see page 96 1875502 PolyHorse with PowerAssist 1875501 Standard PolyHorse
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	Low Profile Rollers - To learn more, see page 101 A1867501 Aids by reducing the drag on 4" to 18" pipe and protecting the pipe from damage. Case includes 40 complete roller assemblies.
--	--

	NEW! MegaMc® Rollers - To learn more, see page 102 4842401 Aids by reducing the drag on the pipe and protecting the pipe from damage. Supports 12" IPS - 54" IPS pipe.
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Part No.	Description
DataLogger® - To learn more, see page 108	
	Used to record and document fusion process parameters.
DL6303	Wireless DataLogger
DL6304	Wired DataLogger
DL13501	NEW! DataLogger 4 English Package*

* Other languages available. See page 108 for details.

Part No.	Description
1879101	Self-centering stub end holder to hold stub end for butt fusion. Requires 18" OD butt fusion insert.

	Spare 6" IPS -20" OD Heater - 220-240V, 50/60Hz, 1Ph T5048001 Microprocessor-controlled with dial thermometer to monitor temperature. Includes heater plates insulated heater stand and stripper bars.
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	Pyrometer Kit A218804 Accurately checks surface temperatures of heater.
--	---

	In-Ditch Facer Stand T5004701 Facer stand provides a convenient place to protect and store your facer out of the dirt and mud when fusing in-ditch.
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	TracStar 500 Series 3 Hose & In-Ditch Extension Kit T5002006 25' facer extension hoses, carriage extension hoses, switch box and indexer extension cables.
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Part No.	Description
Shipping Container	
	T5009101 Shipping container for TracStar 500.

Part No.	Description
25' Heater Extension Cable for Pit Bull 500	
	1219002 Pit Bull heater extension cable for in-ditch applications.

Auto-Only Accessories

	TracStar 500 Series 3 Automatic Hose & In-Ditch Extension Kit T5002007 25' of extension hoses and cables and pendant strap required for automated in-ditch fusion.
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	Spare Automatic Pendant T5007111 Spare user interface for Automatic TracStar 500 Series 3.
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	Spare Automatic Control Box T5001811 Spare control box for quick replacement. For use with Automatic TracStar 500 Series 3.
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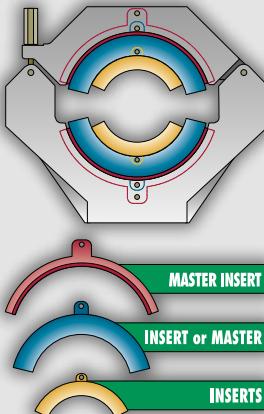
	Spare Automated USB Thumb Drive & Adapter AT5040101 Used for downloading fusion records from the Automated Pendant to a USB thumb drive.
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Butt Fusion Inserts

Our cast inserts have been surface-hardened for longer life. All inserts are serrated for maximum grip on the pipe. Inserts are made for one size pipe only. Not all inserts fit directly in the jaws. Some inserts nest inside other inserts, called master inserts.

NOTE: Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs.

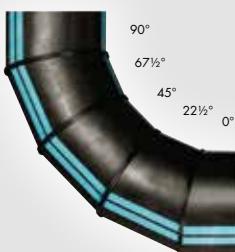
For JIS insert sizes, see page 127.



Mitered Inserts

Mitered inserts are used to fabricate segmented ellips. Our standard miter is 11 1/4°, other mitered angles are available upon request.

Standard Ell Configuration
90° Ell 11 1/4° miter shown



Butt Fusion Inserts Set = 8 Inserts

All inserts below fit in 20" OD (508mm) jaws

Inserts	Pipe OD	Set No.
500mm	19.69 (500mm)	T5029803
18" DIPS	19.50 (495mm)	T5029706
18"/20" OD Master	18.00 (457mm)	T5029703

All inserts below fit in 500mm jaws

500mm OD Jaw	19.69 (500mm)	N/A
18" DIPS	19.50 (495mm)	T5004303
18"/500mm OD Master	18.00 (457mm)	T5004206

All inserts below require 18" OD Master Inserts

450mm	17.72 (450mm)	2418201
16" DIPS	17.40 (442mm)	2412117
16" OD	16.00 (406mm)	2412110
400mm	15.75 (400mm)	2412111
14" DIPS	15.30 (389mm)	2412215
14" OD	14.00 (355mm)	2412206
340mm	13.39 (340mm)	2411811
12" DIPS	13.20 (335mm)	2411826
12" IPS Master	12.75 (324mm)	2411810

11 1/4° Mitered Inserts Set = 4 Inserts & 1 Template

All inserts below fit in 20" OD (508mm) jaws

Inserts	Pipe OD	Set No.
450mm	17.72 (450mm)	T5031103
18" OD	18.00 (457mm)	T5030803
18"/20" OD Master	18.00 (457mm)	T5029703

All inserts below fit in 500mm jaws

18" OD	18.00 (457mm)	T5004403
18"/500mm OD Master	18.00 (457mm)	T5004206

All inserts below require 18" OD Master Inserts

16" OD	16.00 (406mm)	2420619
400mm	15.75 (400mm)	2420618
14" DIPS	15.30 (389mm)	24206122
370mm	14.57 (370mm)	24206125
14" OD	14.00 (355mm)	2420617
12" DIPS	13.20 (335mm)	24206110
12" IPS	12.75 (324mm)	24206115
315mm	12.40 (315mm)	2420614
10" DIPS	11.10 (282mm)	24206116
12" IPS Master	12.75 (324mm)	2411810

All inserts below require 12" IPS & 18" OD Master

315mm	12.40 (315mm)	1211202
10" DIPS	11.10 (282mm)	1207221
280mm	11.02 (280mm)	1207205
10" IPS	10.75 (273mm)	1207204
250mm	9.84 (250mm)	1213503
8" DIPS	9.05 (230mm)	1207107
225mm	8.86 (225mm)	1207010
8" IPS	8.63 (219mm)	1207104
200mm	7.87 (200mm)	1207009
7.125"/180mm OD	7.13 (180mm)	1207008
6" DIPS	6.90 (175mm)	1207020
6" IPS Master	6.63 (168mm)	1207007
160mm	6.30 (160mm)	1207011

500 Specifications

TracStar® 500 Series 3

CAPACITY
Fuses Pipe Sizes: 6" IPS – 20" OD pipe (180mm – 500mm)

WEIGHT
Machine: 3123 lbs (1417Kg)
4 Jaw Carriage Configuration: 750 lbs (340.2Kg)
3 Jaw Carriage Configuration: 365 lbs (165.6Kg)
Automatic Machine: 3183 lbs (1444Kg)
Automatic 4 Jaw Carriage Configuration: 740 lbs (335.7Kg)
Automatic 3 Jaw Carriage Configuration: 355 lbs (161Kg)
Facer: 98 lbs (44.5Kg)
6" IPS - 20" OD Heater: 63 lbs (28.6Kg)

HYDRAULICS
System Pressure: 2300 PSI (157.6 BAR) Max.
Hydraulic Reservoir Capacity: 12 Gallons (45.4 Liters)

ENGINE
Engine Type: 23.5 HP, 1001cc, 3-cylinder liquid cooled
Fuel Type: Diesel
Fuel Tank Capacity: 11 Gallons (41.6 Liters)
Operational Tank Capacity: 11 Hours
Starting System: Electric

ELECTRICAL
Input: None, self-contained

POWER
Heater Power: 5000 Watt
Facer Power: Hydraulic

CHASSIS
Frame: Welded steel construction

MOBILITY
Tracked: Rubber crawler tracks
Transportation: Self-propelled
Vehicle speed: Low 1.18mph / High 2.1mph
Lifting Lift points and lifting assembly

WARRANTY
Term: 3 Years, see page 7 for details

Pit Bull® 500 Series II

CAPACITY
Fuses Pipe Sizes: 6" IPS – 20" OD pipe (180mm – 500mm)

WEIGHT
4 Jaw Carriage Configuration: 390 lbs (176.9Kg)
3 Jaw Carriage Configuration: 289 lbs (131.1Kg)
Facer: 84 lbs (38.1Kg)
6" IPS - 12" DIPS Heater: 28 lbs (13Kg)
12" IPS - 20" OD Heater: 39 lbs (17.7Kg)

POWER
Heater Power (12" IPS - 20" OD Heater): 4000 Watt
Facer Power: Hydraulic

CHASSIS
Frame: Welded steel construction

WARRANTY
Term: 3 Years, see page 7 for details

Pit Bull® HPU (Hydraulic Power Unit)

WEIGHT
Machine: 390 lbs (176.9Kg)

HYDRAULICS
System Pressure: 1500 PSI (103.4 BAR) Max.
Hydraulic Reservoir Capacity: 10 Gallons (37 Liters)
Pump Flow Rate 60 Hz: 6.1 gpm (23.1 Lpm)
Pump Flow Rate 50 Hz: 5.0 gpm (18.9 Lpm)
Filtration: 10 micron absolute

POWER
Power Requirement: 5.2KVA/4.5KW @ 240V, 3Ph

MOTOR
Electric: 5 HP

MOBILITY
Tires: High-flotation inflatable tires
Transportation: Two-wheel cart

WARRANTY
Term: 3 Years, see page 7 for details

Note: All carriage weights are without facer and heater. Specifications subject to change without notice. **Additional dimensions available on page 144.**

500

FUSION MACHINES



824/630 Fusion Machines

Fusion Capability for 8" IPS – 24" OD pipe (225mm – 630mm)

Patent Numbers: 5,814,182 6,212,748 6,212,747 6,021,832 Japanese Patent No 4285806 European Patent No 0903215



MegaMc® 824 & TracStar® 630

The **MegaMc® 824** and the **TracStar® 630** machines will butt fuse pipe sizes from **8" IPS to 24" OD (225mm to 630mm)**. Above ground or in the ditch, these revolutionary machines bring the flexibility of the smaller machines to MegaMc large-diameter fusion. It is the first fusion machine of this size specifically designed for in-ditch, close-quarter work with all the advantages of a track or rolling machine.

The carriage has 4 jaws with a removable 3-jaw carriage and is capable of top-loading the heater and facer to maximize functionality within limited space. The TracStar 630 is mounted on independently controlled, self-propelled tracks and features a wireless remote driving control.

Both models are hydraulically powered to assist all fusion functions including the operation of the jaws, pipe lifts, heater and facer. The machines allow for butt fusion of most fittings without special holders or removal of outer jaw. Mitered inserts are available for fabricating ell's.

The **Automatic TracStar 630** controls and monitors the heat, soak, fuse and cool cycles. It has a built-in data logging feature that keeps a record of each fusion joint, which allows you to verify joint integrity.

MegaMc® 824

- 4- or 3-jaw capable for improved in-ditch fusion
- Carriage can be easily removed for in-ditch use
- For confined spaces can be converted to top-loading heater and facer
- DataLogger® compatible
- Rugged outriggers for stability

TracStar® 630

- Track-mounted, self-contained, self-propelled, all-terrain
- On-board generator for powering heater
- Carriage can be easily removed for in-ditch use
- Also available as an Automatic fusion machine
- 4- or 3-jaw capable for improved in-ditch fusion
- For confined spaces can be converted to top-loading heater and facer
- Dual speed tracks



MACHINE PLUG TYPE

To find the right electrical plug type see
Page 140

GENERATOR

To size your generator see
Page 147

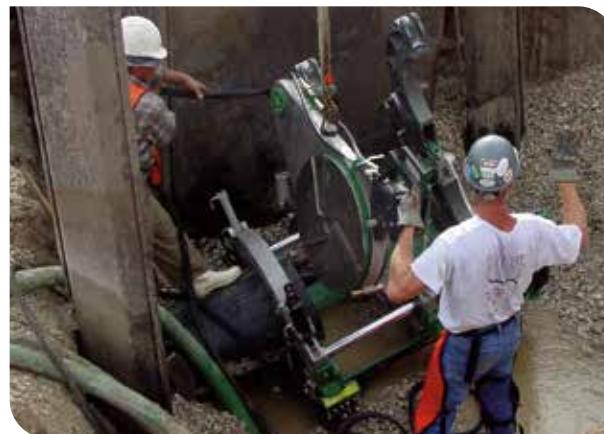
CYLINDER FORCE

For help selecting a cylinder force see
Page 135

McElroy's International Distribution Network

McElroy products are offered through an international network of sales and authorized service center locations providing our customers around the globe with the tools to succeed.





Machine Type	Model No.	Cylinder Force	Input Voltage Requirements	Minimum Power Requirements *	Plug Type (See pg 140)
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MegaMc® 824

Includes fusion machine, facer, heater, 24" OD butt fusion inserts and lifting assembly. Optional heater/facer stand sold separately.



Rolling	A2435501	High	220V - 240V, 50/60Hz, 3Ph	29.8KVA/28.1KW	I
Rolling	A2435502	Medium	220V - 240V, 50/60Hz, 3Ph	29.8KVA/28.1KW	I
Rolling	A2435503	Low	220V - 240V, 50/60Hz, 3Ph	29.8KVA/28.1KW	I

TracStar® 630

Includes fusion machine, facer, heater, 24" OD butt fusion inserts, remote control with batteries and 12V charger. Optional heater/facer stand sold separately.



Tracked	AT2400101	High	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
Tracked	AT2400102	Medium	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
Tracked	AT2400103	Low	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A

Automatic Tracked	AT2408101	High	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
Automatic Tracked	AT2408102	Medium	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A
Automatic Tracked	AT2408103	Low	N/A, On-Board Generator	N/A, Self-Contained Diesel	N/A

* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 147.

824/630 Accessories

Part No.	Description
Spare Facer Blade Kit - Six blades, screws and wrench	
	Economical blade must be positioned for different pipe sizes.
3615710	9" Standard blades.
3615710C	9" Extended-life blades.
3615703T	5" carbide blades for abrasive materials.

Part No.	Description
Spare 11" Facer Blade Kit - Six blades, screws and wrench	
	Spans the entire facer range without repositioning.
3615712	Standard blades.
3615712C	Extended-life blades.

Part No.	Description
	A2428506 Set of 2 plates with anti-stick coating required for butt fusion. Kit includes attaching screws and wrench.

Part No.	Description
2429101	824 stand for rolling unit.
T9017401	TracStar 630/900 pipe stand
4823901	Heavy-duty pipe stand

Part No.	Description
MegaMc® Pipe Stand To learn more, see page 99	
	Powered pipe stand with lateral and vertical movement for 8"- 36" (200mm - 900mm) pipe.
3645001	Gas-powered
3645002	Diesel-powered

Part No.	Description
Low Profile Rollers - To learn more, see page 101	
	Aids by reducing the drag on 4" to 18" pipe and protecting the pipe from damage. Case includes 40 complete roller assemblies.
A1867501	

Part No.	Description
NEW! MegaMc® Rollers - To learn more, see page 102	
	4842401 Aids by reducing the drag on the pipe and protecting the pipe from damage. Supports 12" IPS - 54" IPS pipe.

Part No.	Description
NEW! MegaMc® PolyHorse® - To learn more, see page 98	
	4834001 Pipe-handling system for 20" to 48" OD (500mm to 1,200mm) pipe.

Part No.	Description
	2419501 Holds stub end for butt fusion.

Part No.	Description
	Used to record and document fusion process parameters.
DL6303	Wireless DataLogger
DL6304	Wired DataLogger
DL13501	NEW! DataLogger 4 English Package*

* Other languages available. See page 108 for details.

Part No.	Description
	A218804 Accurately checks surface temperatures of heater.

Part No.	Description
	T2409101 Heater/Facer stand recommended for tight in-ditch installations where top loading of the heater and facer is necessary.

Part No.	Description
In-Ditch Extension Kit	
	T2408301 Set of 40' hydraulic extension hoses and cable. Required for use when doing in-ditch fusion.

Part No.	Description
In-Ditch Automatic Extension Kit	
	T9002005 Set of 40' hydraulic extension hoses, cable, facer stand and pendant strap. Required for use when doing automatic in-ditch fusion.

Part No.	Description
	T5007110 Spare user interface for Automatic TracStar 630 and 900.

Part No.	Description
	T5001809 Spare control box for quick replacement. For use with Automatic TracStars 630 and 900.

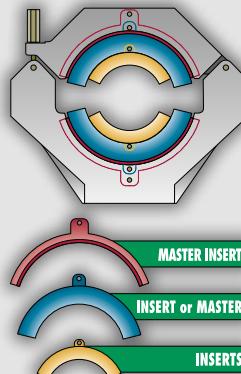
Part No.	Description
	AT5040101 Used for downloading fusion records from the Automated Pendant to a USB thumb drive.

Butt Fusion Inserts

Our cast inserts have been surface-hardened for longer life. Fabricated inserts are constructed out of precision laser-cut carbon steel and are normally lighter in weight than cast inserts.

All inserts are serrated for maximum grip on the pipe. Inserts are made for one size pipe only. Not all inserts fit directly in the jaws. Some inserts nest inside other inserts, called master inserts.

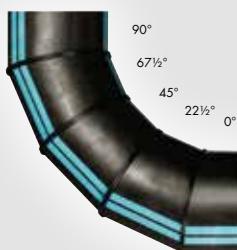
NOTE: Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs.



Mitered Inserts

Mitered inserts are used to fabricate segmented ellipses. Our standard miter is 11 1/4°, other mitered angles are available upon request.

Standard Ell Configuration 90° Ell 11 1/4° miter shown



Butt Fusion Inserts Set = 8 Inserts

All inserts below fit in 24.80" (630mm) jaws

Inserts	Pipe OD	Cast	Fabricated
24" OD	24.00 (610mm)	2411604	N/A
22" OD	22.00 (560mm)	2411919	N/A
20" DIPS	21.60 (549mm)	2411922	N/A
20" OD	20.00 (508mm)	2412010	N/A
500 mm	19.69 (500mm)	2412011	N/A
18" DIPS	19.50 (495mm)	2412023	N/A
18" Master	18.00 (457mm)	2411708	N/A

All inserts below require 18" OD Master Inserts

450 mm	17.72 (450mm)	N/A	2418201
16" DIPS	17.40 (442mm)	2412117	N/A
16" OD	16.00 (406mm)	2412110	N/A
400 mm	15.75 (400mm)	2412111	N/A
14" DIPS	15.30 (389mm)	2412215	N/A
14" OD	14.00 (355mm)	2412206	N/A
340 mm	13.39 (340mm)	2411811	N/A
12" DIPS	13.20 (335mm)	2411826	N/A
12" Master	12.75 (324mm)	2411810	N/A

All inserts below require 18" OD & 12" Master

315 mm	12.40 (315mm)	1211202	N/A
10" DIPS	11.10 (282mm)	1207221	N/A
280 mm	11.02 (280mm)	1207205	N/A
10" IPS	10.75 (273mm)	1207204	N/A
250 mm	9.84 (250mm)	1213503	N/A
8" DIPS	9.05 (230mm)	1207107	N/A
225 mm	8.86 (225mm)	1207010	N/A
8" IPS	8.63 (219mm)	1207104	N/A

11 1/4° Mitered Inserts Set = 4 Inserts & 1 Temp.

All inserts below fit in 24.80" (630mm) jaws

Inserts	Pipe OD	Set No.
22 OD/560mm	22.00 (560mm)	2421229
20" DIPS	21.60 (549mm)	2421257
20" OD	20.00 (508mm)	2421217
500mm	19.69 (500mm)	2412014
18" DIPS	19.50 (495mm)	2421251
450mm	17.72 (450mm)	2421214
18" OD	18.00 (457mm)	2421215
16" DIPS	17.40 (442mm)	2421245
420mm	16.53 (420mm)	2421266
18" Master	18.00 (457mm)	2411708

All inserts below require 18" OD Master Inserts

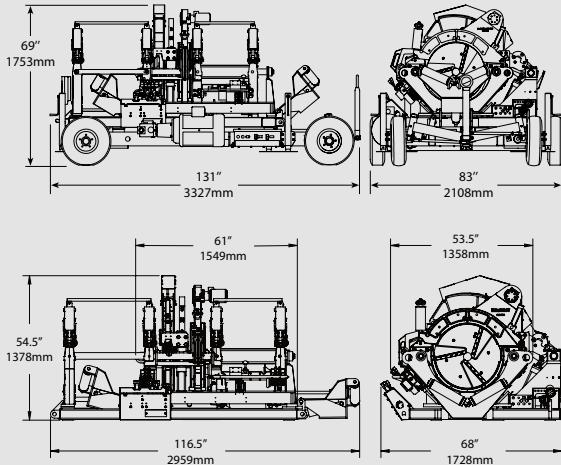
16" OD	16.00 (406mm)	2420619
400mm	15.75 (400mm)	2420618
14" DIPS	15.30 (389mm)	24206122
370mm	14.57 (370mm)	24206125
14" OD	14.00 (355mm)	2420617
12" DIPS	13.20 (335mm)	24206110
12" IPS	12.75 (324mm)	2420615
315mm	12.40 (315mm)	2420614
10" DIPS	11.10 (282mm)	24206116
12" Master	12.75 (324mm)	2411810

All inserts below require 18" OD & 12" Master

280mm	11.02 (280mm)	1214284
10" IPS	10.75 (273mm)	1214232
250mm	9.84 (250mm)	1214235
8" DIPS	9.05 (230mm)	1214269
225mm	8.86 (225mm)	1214281
8" IPS	8.63 (219mm)	1214230
200mm	7.87 (200mm)	1214234
180mm	7.09 (180mm)	1214290

824/630 Specifications

MegaMc® 824



CAPACITY

Fuses Pipe Sizes: 8" IPS – 24" OD pipe (225mm – 630mm)

WEIGHT

Machine: 5905 lbs (2678Kg)

4 Jaw Carriage Configuration: 3790 lbs (1719Kg)

3 Jaw Carriage Configuration: 1350 lbs (612Kg)

Facer: 390 lbs (177Kg)

Heater: 240 lbs (109Kg)

HYDRAULICS

System Pressure: 2300 PSI (158 BAR) Max.

Hydraulic Reservoir Capacity: 28 Gallons (106 Liters)

Motor: 20 HP, 3 Phase, 240V

POWER

Heater Power: 10,950 Watt

Facer Power: Hydraulic

CHASSIS

Frame: Welded steel tube construction

Front Axle: Articulating

Brake: Mechanical

MOBILITY

Tires: 6.90 - 9NHS, 75 PSI Max.

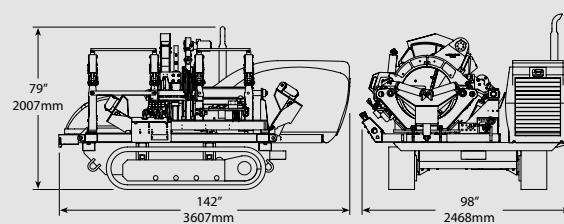
Transportation: Pulled via towing ring

Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

TracStar® 630



CAPACITY

Fuses Pipe Sizes: 8" IPS – 24" OD pipe (225mm – 630mm)

WEIGHT

Machine: 8600 lbs (3900Kg)

4 Jaw Carriage Configuration: 3790 lbs (1719Kg)

3 Jaw Carriage Configuration: 1350 lbs (612Kg)

Facer: 390 lbs (177Kg)

Heater: 240 lbs (109Kg)

HYDRAULICS

System Pressure: 2300 PSI (158 BAR) Max.

Hydraulic Reservoir Capacity: 12 Gallons (45 Liters)

ENGINE

Engine Type: 84.5 HP, 3600cc, 4-cylinder turbo

Fuel Type: Diesel

Fuel Tank Capacity: 23 Gallons (87 Liters)

Operational Tank Capacity: 17 Hours

Starting System: Electric

ELECTRICAL

Input: None, self-contained

POWER

Heater Power: 10,950 Watt

Facer Power: Hydraulic

CHASSIS

Frame: Welded steel construction

Brake: Self-locking

MOBILITY

Tracked: Rubber crawler tracks

Transportation: Self-propelled

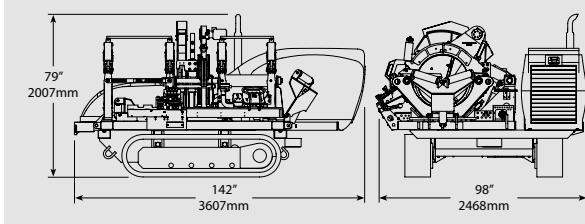
Vehicle speed: Low 1mph / High 1.7mph

Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Automatic TracStar® 630



CAPACITY

Fuses Pipe Sizes: 8" IPS – 24" OD pipe (225mm – 630mm)

WEIGHT

Machine: 8600 lbs (3900Kg)

4 Jaw Carriage Configuration: 3790 lbs (1719Kg)

3 Jaw Carriage Configuration: 1350 lbs (612Kg)

Facer: 390 lbs (177Kg)

Heater: 240 lbs (109Kg)

HYDRAULICS

System Pressure: 2300 PSI (158 BAR) Max.

Hydraulic Reservoir Capacity: 12 Gallons (45 Liters)

ENGINE

Engine Type: 84.5 HP, 3600cc, 4-cylinder turbo

Fuel Type: Diesel

Fuel Tank Capacity: 23 Gallons (87 Liters)

Operational Tank Capacity: 17 Hours

Starting System: Electric

ELECTRICAL

Input: None, self-contained

POWER

Heater Power: 10,950 Watt

Facer Power: Hydraulic

CHASSIS

Frame: Welded steel construction

Brake: Self-locking

MOBILITY

Tracked: Rubber crawler tracks

Transportation: Self-propelled

Vehicle speed: Low 1mph / High 1.7mph

Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Note: All carriage weights are without facer and heater. Specifications subject to change without notice. **Additional dimensions available on page 144.**

824 / 630

FUSION MACHINES

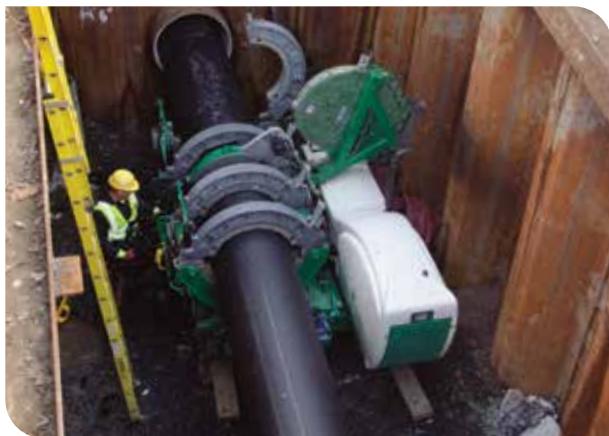


1236

Fusion Machines

Fusion Capability for 12" IPS – 36" OD pipe (340mm – 900mm)

Patent Numbers: 5,814,182 - 6,212,748 - 6,212,747 - 6,021,832 Japanese Patent No 4285806 European Patent No 0903215



MegaMc® 1236 & TracStar® 900

The **MegaMc® 1236** and **TracStar® 900** machines will butt fuse pipe sizes from **12" IPS to 36" OD (340mm to 900mm)**. Above ground or in the ditch, these machines bring the flexibility of the smaller machines to MegaMc large-diameter fusion. These fusion machines have all the advantages of their predecessors with additional features for in-ditch, close-quarter work.

The carriage has 4 jaws with a removable 3-jaw carriage and is capable of top-loading the heater and facer to maximize functionality within limited space. The TracStar 900 is mounted on independently controlled, self-propelled tracks and features a wireless remote driving control. Both models are hydraulically powered to assist all fusion

functions including the operation of the jaws, pipe lifts, heater and facer. The machines allow for butt fusion of most fittings without special holders or removal of outer jaw. Mitered inserts are available for fabricating ell's.

The **Automatic TracStar 900** controls and monitors the heat, soak, fuse and cool cycles. It has a built-in data logging feature that keeps a record of each fusion joint, which allows you to verify joint integrity.

MegaMc® 1236

- 4- or 3-jaw capable for improved in-ditch fusion
- Carriage can be easily removed for in-ditch use
- For confined spaces can be converted to top-loading heater and facer
- DataLogger® compatible
- Rugged outriggers for stability

TracStar® 900

- Track mounted, self-contained, self-propelled, all-terrain
- On-board generator for powering heater
- Carriage can be easily removed for in-ditch use
- Also available as an Automatic fusion machine
- 4- or 3-jaw capable for improved in-ditch fusion
- For confined spaces can be converted to top-loading heater and facer
- Dual speed tracks

GENERATOR

To size your generator see
Page 147

CYLINDER FORCE

For help selecting a cylinder force see
Page 136

DataLogger

To learn more about the DataLogger see
Page 108

McElroy Technical Service:

Online or Off Whether you prefer online documentation, discussion forums, facebook, twitter, or a personal phone call, our technical services staff along with our worldwide distributor network are ready to assist with any technical issue on or off the jobsite.

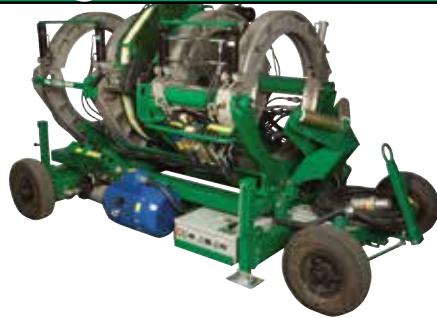




Machine Type	Model No.	Cylinder Force	Input Voltage Requirements	Minimum Power Requirements *	Plug Type (See pg 140)
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MegaMc® 1236

Includes fusion machine, facer, heater and lifting assembly. Optional heater/facer stand sold separately.



Rolling	A3639501	High	220V - 240V, 50/60Hz, 3Ph	39.4KVA/37.7KW	I
Rolling	A3639502	Medium	220V - 240V, 50/60Hz, 3Ph	39.4KVA/37.7KW	I
Rolling	A3639503	Low	220V - 240V, 50/60Hz, 3Ph	39.4KVA/37.7KW	I

TracStar® 900

Includes fusion machine, facer, heater, remote control with batteries and 12V charger and lifting assembly. Optional heater/facer stand sold separately.



Tracked	AT9028001	High	None, On-Board Generator	Self-Contained Diesel	N/A
Tracked	AT9028002	Medium	None, On-Board Generator	Self-Contained Diesel	N/A
Tracked	AT9028003	Low	None, On-Board Generator	Self-Contained Diesel	N/A

Automatic Tracked	AT9028101	High	None, On-Board Generator	Self-Contained Diesel	N/A
Automatic Tracked	AT9028102	Medium	None, On-Board Generator	Self-Contained Diesel	N/A
Automatic Tracked	AT9028103	Low	None, On-Board Generator	Self-Contained Diesel	N/A

* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 147.

1236/900 Accessories

Part No.	Description
Spare Facer Blade Kit - Six blades, screws and wrench	
3615707	15" Standard blades.
3615707C	15" Extended-life blades.
3615703T	5" carbide blades for abrasive materials. Must be positioned for different pipe sizes.

Part No.	Description
A3617201	Set of 2 plates with anti-stick coating required for butt fusion. Kit includes attaching screws and wrench.

Part No.	Description
T9017401	TracStar 630/900 pipe stand
4823901	Heavy-duty pipe stand

Part No.	Description
3606901	Holds stub end for butt fusion.

Part No.	Description
MegaMc® Pipe Stand - To learn more, see page 99	
3645001	Powered pipe stand with lateral and vertical movement.
3645002	Gas-powered stand for 8" - 36" pipe sizes
6513501	Diesel-powered stand for 8" - 36" pipe sizes
6513502	Gas-powered stand for 36" - 65" pipe sizes

Part No.	Description
NEW! MegaMc® Rollers - To learn more, see page 102	
4842401	Aids by reducing the drag on the pipe and protecting the pipe from damage. Supports 12" IPS - 54" IPS pipe.

Part No.	Description
4834001	Pipe-handling system for 20" to 48" OD (500mm to 1,200mm) pipe.

Part No.	Description
DL6303	Used to record and document fusion process parameters.
DL6304	Wireless DataLogger
DL13501	Wired DataLogger
DL13501	NEW! DataLogger 4 English Package*

* Other languages available. See page 108 for details.

Part No.	Description
A218804	Accurately checks surface temperatures of heater.

Part No.	Description
T9027301	In-Ditch Heater/Facer Stand recommended for tight in-ditch installations where top loading of the heater and facer is necessary.

Part No.	Description
In-Ditch Extension Kit	
T2408301	Set of 40' hydraulic extension hoses and cable. Required for use when doing in-ditch fusion.

Auto-Only Accessories

Part No.	Description
T9002005	Set of 40' hydraulic extension hoses, cable, facer stand and pendant strap. Required for use when doing automatic in-ditch fusion.

Part No.	Description
T5007110	Spare user interface for Automatic TracStar 630 and 900.

Part No.	Description
T5001809	Spare control box for quick replacement. For use with Automatic TracStars 630 and 900.

Part No.	Description
AT5040101	Used for downloading fusion records from the Automated Pendant to a USB thumb drive.



The MegaMc® PolyHorse®

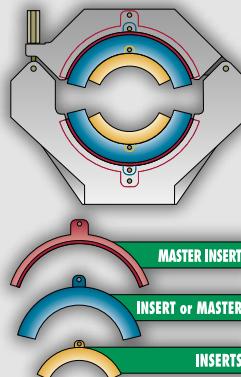
Boost productivity and promote safer working conditions on 20" to 48" OD (500mm to 1,200mm) polyethylene pipe jobsites. The MegaMc PolyHorse consists of a series of pipe racks and powered pipe stands that hold enough pipe for a day's worth of fusion work **See page 98 for more information**

Butt Fusion Inserts

Our cast inserts have been surface-hardened for longer life. Fabricated inserts are constructed out of precision laser-cut carbon steel and are normally lighter in weight than cast inserts.

All inserts are serrated for maximum grip on the pipe. Inserts are made for one size pipe only. Not all inserts fit directly in the jaws. Some inserts nest inside other inserts, called master inserts.

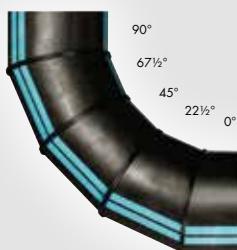
NOTE: Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs.



Mitered Inserts

Mitered inserts are used to fabricate segmented ellipses. Our standard miter is 11 1/4°, other mitered angles are available upon request.

Standard Ell Configuration 90° Ell 11 1/4° miter shown



Butt Fusion Inserts Set = 8 Inserts

All inserts below fit in 36" (914mm) jaws

Inserts	Pipe OD	Cast	Fabricated
900mm	35.43 (900mm)	N/A	3629401
34" OD	34.00 (864mm)	3603532	N/A
32" OD	32.00 (813mm)	3603512	3629501
800mm	31.50 (800mm)	3603509	3629601
30" OD	30.00 (762mm)	3603515	3629701
28" OD	28.00 (710mm)	3603418	3619705
26" OD	26.00 (660mm)	3606614	3629801
24" DIPS	25.80 (655mm)	3606617	3629901
630mm Master	24.80 (630mm)	3606604	N/A

All inserts below require 630mm Master inserts

24" OD	24.00 (610mm)	2411604	N/A
22" OD	22.00 (560mm)	2411919	N/A
20" DIPS	21.60 (549mm)	2411922	N/A
20" OD	20.00 (508mm)	2412010	N/A
500mm	19.69 (500mm)	2412011	N/A
18" DIPS	19.50 (495mm)	2412023	N/A
18" Master	18.00 (457mm)	2411708	N/A

All inserts below require 630mm & 18" OD Master

450mm	17.72 (450mm)	N/A	2418201
16" DIPS	17.40 (442mm)	2412117	N/A
16" OD	16.00 (406mm)	2412110	N/A
400 mm	15.75 (400mm)	2412111	N/A
14" DIPS	15.30 (389mm)	2412215	N/A
14" OD	14.00 (355mm)	2412206	N/A
340 mm	13.39 (340mm)	2411811	N/A
12" DIPS	13.20 (335mm)	2411826	N/A
12" Master	12.75 (324mm)	2411810	N/A

11 1/4° Mitered Inserts Set = 4 Inserts & 1 Temp.

All inserts below fit in 36" (914mm) jaws

Inserts	Pipe OD	Set No.
32" OD	32.00 (813mm)	3603526
800mm	31.50 (800mm)	3603523
30" OD	30.00 (762mm)	3603520
28" OD	28.00 (711mm)	3603529
26" OD	26.00 (660mm)	3606623
24" DIPS	25.80 (655mm)	3606620
630mm	24.80 (630mm)	3606610
24" OD	24.00 (610mm)	3606613
630mm Master	24.80 (630mm)	3606604

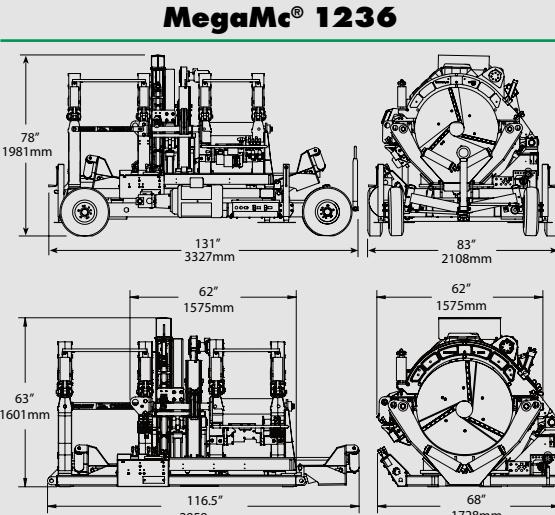
All inserts below require 630mm Master inserts

22 OD/560	22.00 (560mm)	2421229
20" DIPS	21.60 (549mm)	2421257
20" OD	20.00 (508mm)	2421217
500mm	19.68 (500mm)	2412014
18" DIPS	19.50 (495mm)	2421251
18" OD	18.00 (457mm)	2421215
450mm	17.72 (450mm)	2421214
16" DIPS	17.40 (442mm)	2421245
420mm	16.53 (420mm)	2421266
18" Master	18.00 (457mm)	2411708

All inserts below require 630mm & 18" Master inserts

16" OD	16.00 (406mm)	2420619
400mm	15.75 (400mm)	2420618
14" DIPS	15.30 (389mm)	24206122
370mm	14.57 (370mm)	24206125
14" OD	14.00 (355mm)	2420617
12" DIPS	13.20 (335mm)	24206110
12" IPS	12.75 (324mm)	2420615
315mm	12.40 (315mm)	2420614

1236/900 Specifications



CAPACITY

Fuses Pipe Sizes: 12" IPS – 36" OD pipe (340mm – 900mm)

WEIGHT

Machine: 6842 lbs (3103Kg)

4 Jaw Carriage Configuration: 3865 lbs (1753Kg)

3 Jaw Carriage Configuration: 1820 lbs (825Kg)

Facer: 480 lbs (218Kg)

Heater: 382 lbs (173Kg)

Spreader Bar: 200 lbs (90.7Kg)

HYDRAULICS

System Pressure: 2300 PSI (158 BAR) Max.

Hydraulic Reservoir Capacity: 28 Gallons (106 Liters)

Motor: 20HP, 3 Phase, 240V

POWER

Heater Power: 20,461 Watt

Facer Power: Hydraulic

CHASSIS

Frame: Welded steel tube construction

Front Axle: Articulating

Brake: Mechanical

MOBILITY

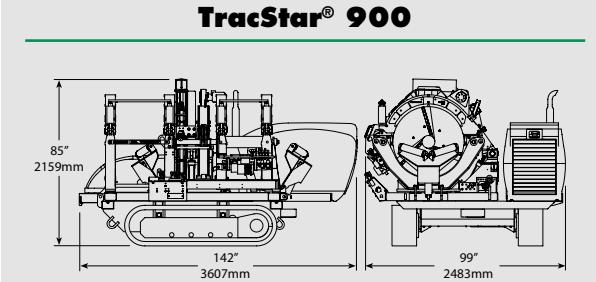
Tires: 6.90 - 9NHS, 75 PSI Max.

Transportation: Pulled via towing ring

Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details



CAPACITY

Fuses Pipe Sizes: 12" IPS – 36" OD pipe (340mm – 900mm)

WEIGHT

Machine: 9527 lbs (4321Kg)

4 Jaw Carriage Configuration: 3865 lbs (1753Kg)

3 Jaw Carriage Configuration: 1820 lbs (825Kg)

Facer: 480 lbs (218Kg)

Heater: 382 lbs (173Kg)

Spreader Bar: 200 lbs (90.7Kg)

HYDRAULICS

System Pressure: 2300 PSI (158 BAR) Max.

Hydraulic Reservoir Capacity: 12 Gallons (45 Liters)

ENGINE

Engine Type: 84.5 HP, 3600cc, 4-cylinder turbo

Fuel Type: Diesel

Fuel Tank Capacity: 23 Gallons (87 Liters)

Operational Tank Capacity: 17 Hours

Starting System: Electric

ELECTRICAL

Input: None, self-contained

POWER

Heater Power: 20,461 Watt

Facer Power: Hydraulic

CHASSIS

Frame: Welded steel construction

Brake: Self-locking

MOBILITY

Tracked: Rubber crawler tracks

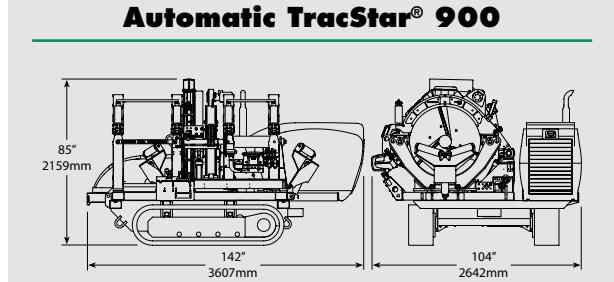
Transportation: Self-propelled

Vehicle speed: Low 1mph / High 1.7mph

Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details



CAPACITY

Fuses Pipe Sizes: 12" IPS – 36" OD pipe (340mm – 900mm)

WEIGHT

Machine: 9527 lbs (4321Kg)

4 Jaw Carriage Configuration: 3865 lbs (1753Kg)

3 Jaw Carriage Configuration: 1820 lbs (825Kg)

Facer: 480 lbs (218Kg)

Heater: 382 lbs (173Kg)

Spreader Bar: 200 lbs (90.7Kg)

HYDRAULICS

System Pressure: 2300 PSI (158 BAR) Max.

Hydraulic Reservoir Capacity: 12 Gallons (45 Liters)

ENGINE

Engine Type: 84.5 HP, 3600cc, 4-cylinder turbo

Fuel Type: Diesel

Fuel Tank Capacity: 23 Gallons (87 Liters)

Operational Tank Capacity: 17 Hours

Starting System: Electric

ELECTRICAL

Input: None, self-contained

POWER

Heater Power: 20,461 Watt

Facer Power: Hydraulic

CHASSIS

Frame: Welded steel construction

Brake: Self-locking

MOBILITY

Tracked: Rubber crawler tracks

Transportation: Self-propelled

Vehicle speed: Low 1mph / High 1.7mph

Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Note: All carriage weights are without facer and heater. Specifications subject to change without notice. **Additional dimensions available on page 144.**

1236 / 900

FUSION MACHINES





MegaMc® 1648

The **MegaMc® 1648** machine will butt fuse pipe sizes from **16" OD to 48" OD (450mm to 1200mm)**. The machine allows for butt fusion of most fittings without special holders or removal of the outer jaw. Mitered inserts are available for fabricating ells. McElroy's unique semi-automatic control system requires only one operator. Hydraulic power assists all fusion functions including the complete operation of the jaws, pipe lifts, heater and facer.

- 4-jaw construction
- Hydraulic clamping
- Hydraulic pivoting heater and facer
- DataLogger® compatible
- Dual hydraulic pipe lifts

Machine Type	Model No.	Cylinder Force	Heater Power	Minimum Power Requirements *	Plug Type (See pg 140)
--------------	-----------	----------------	--------------	------------------------------	---------------------------

MegaMc® 1648 Includes fusion machine, facer, heater and lifting assembly.

Rolling	A4800806	High	220V - 240V, 50/60Hz, 3Ph	45KVA/43.8KW	J
Rolling	A4800807	Medium	220V - 240V, 50/60Hz, 3Ph	45KVA/43.8KW	J

* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 147.

GENERATOR

To size your generator see
Page 147

CYLINDER FORCE

For help selecting a cylinder force see
Page 137

DataLogger

To learn more about the DataLogger see
Page 108

IN-CLASS FUSION TRAINING
Operator Training and Qualification, or Troubleshooting and Rebuild courses are available.
www.mcelroy.com/university

McELROY UNIVERSITY

ONLINE RESOURCES
Videos available on your desktop, or mobile device.
www.mcelroy.com/university

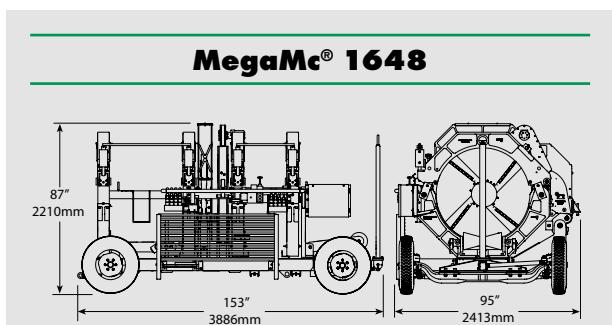
Part No.	Description
Spare Facer Blade Set - Includes 8 blades, screws and wrench	
3615708	Standard blades.
3615708C	Extended-life blades.
3615708T	5" carbide blades for abrasive materials. Must be positioned for different pipe sizes.
Spare Heater Plate Kit	
A6311805	Set of 2 plates with anti-stick coating required for butt fusion. Kit includes attaching screws and wrench.
Pipe Support Stand - See page 100 for more information	
4823901	Heavy-duty pipe stand.



Part No.	Description
NEW! MegaMc® Rollers - To learn more, see page 102	
4842401	Aids by reducing the drag on the pipe and protecting the pipe from damage. Supports 12" IPS - 54" IPS pipe.
NEW! MegaMc® PolyHorse® - To learn more, see page 98	
4834001	Pipe-handling system for 20" to 48" OD (500mm to 1,200mm) pipe.
MegaMc™ Pipe Stand - To learn more, see page 99	
Powered pipe stand with lateral and vertical movement for 36"- 65" (900mm - 1600mm) pipe.	
6513501	Gas-powered
6513502	Diesel-powered
Stub End Holder - To learn more, see page 117	
4812601	Holds stub end for butt fusion.
DataLogger® - To learn more, see page 108	
Used to record and document fusion process parameters.	
DL6303	Wireless DataLogger
DL6304	Wired DataLogger
DL13501	NEW! DataLogger 4 English Package*

* Other languages available. See page 108 for details.

Part No.	Description
A218804	Accurately checks surface temperatures of heater.



MegaMc® 1648

CAPACITY

Fuses Pipe Sizes: 16" OD – 48" OD pipe (450mm – 1200mm)

WEIGHT

Machine: 8800 lbs (3992Kg)

Facer: 775 lbs (351.5Kg)

Heater: 600 lbs (272.2Kg)

Spreader Bar: 275 lbs (124.7Kg)

HYDRAULICS

System Pressure: 1500 PSI (103 BAR) Max.

Hydraulic Reservoir Capacity: 33 Gallons (125 Liters)

Motor: 10 HP, 3 Phase, 240V

POWER

Heater Power: 35,000 Watt

Facer Power: Hydraulic

CHASSIS

Frame: Welded steel tube construction

Front Axle: Articulating

Brake: Mechanical

MOBILITY

Tires: 7.0 - 15, 60PSI Max.

Transportation: Pulled via towing ring

Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

Specifications subject to change without notice.
Additional dimensions available on page 144.

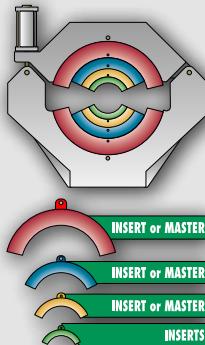
1648 Butt Fusion & Mitered Inserts

Butt Fusion Inserts

Our inserts are made from a high strength aluminum alloy and have been surface-hardened for longer life. Fabricated inserts are constructed out of precision laser-cut carbon steel and are normally lighter in weight than cast inserts.

All inserts are serrated for maximum grip on the pipe. Inserts are made for one size pipe only. Not all inserts fit directly in the jaws. Some inserts nest inside other inserts, called master inserts.

NOTE: Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs.



Mitered Inserts

Mitered inserts are used to fabricate segmented ellipses. All inserts are surface hardened for longer life and are serrated for maximum grip on the pipe.

**Standard Ell Configuration
90° Ell 11 1/4° miter shown**



Butt Fusion Inserts Set = 8 Inserts

All inserts below fit in 48" (1219mm) jaws

Inserts	Pipe OD	Cast	Fabricated
1200mm	47.25 (1200mm)	N/A	4819501
42" DIPS	44.50 (1130mm)	N/A	4821201
1100mm	43.30 (1100mm)	4813127	N/A
42" OD	42.00 (1067mm)	4813104	4827501
1000mm	39.37 (1000mm)	4813111	4819601
36" DIPS	38.30 (973mm)	N/A	4821101
36" OD Master	36.00 (914mm)	4813006	N/A

All inserts below require 36" OD Master

900mm	35.43 (900mm)	N/A	3629401
34" OD	34.00 (864mm)	3603532	N/A
32" OD	32.00 (813mm)	3603512	3629501
800mm	31.50 (800mm)	3603509	3629601
30" OD	30.00 (762mm)	3603515	3629701
28"/710mm OD	28.00 (710mm)	3603418	3619705
26" OD	26.00 (660mm)	3606614	3629801
24" DIPS	25.80 (655mm)	3606617	3629901
630mm Master	24.80 (630mm)	3606604	N/A

All inserts below require 36" OD & 630mm Master

24" OD	24.00 (610mm)	2411604	N/A
22" OD	22.00 (560mm)	2411919	N/A
20" DIPS	21.60 (549mm)	2411922	N/A
20" OD	20.00 (508mm)	2412010	N/A
500mm	19.69 (500mm)	2412011	N/A
18" DIPS	19.50 (495mm)	2412023	N/A
18" Master	18.00 (457mm)	2411708	N/A

All inserts below require 36" OD, 630mm & 18" OD Master

450mm	17.72 (450mm)	N/A	2418201
16" DIPS	17.40 (442mm)	2412117	N/A
16" OD	16.00 (406mm)	2412110	N/A

11 1/4° Mitered Inserts Set = 4 Inserts & 1 Template

All inserts below fit in 48" (1219mm) jaws

Inserts	Pipe OD	Cast
42" OD	42.00 (1067mm)	4813115
36" OD	36.00 (914mm)	4813010
36" Master	36.00 (914mm)	4813006

All inserts below require 36" OD Master

32" OD	32.00 (813mm)	3603526
800mm	31.50 (800mm)	3603523
30" OD	30.00 (762mm)	3603520
28" OD	28.00 (710mm)	3603529
26" OD	26.00 (660mm)	3606623
24" DIPS	25.80 (655mm)	3606620
630mm	24.80 (630mm)	3606610
24" OD	24.00 (610mm)	3606613
630mm Master	24.80 (630mm)	3606604

All inserts below require 36" OD & 630mm Master

20" DIPS	21.60 (549mm)	2421257
20" OD	20.00 (508mm)	2421217
18" DIPS	19.50 (495mm)	2421251
18" OD	18.00 (457mm)	2421215
16" DIPS	17.40 (442mm)	2421245



2065/1600 Fusion Machines

Fusion Capability for 20"OD – 65" OD pipe (500mm – 1600mm)



2065/1600

Designed for the largest of pipe applications, the **MegaMc® 2065** and new **1600** machines will butt fuse pipe sizes from **20" OD to 65" OD (500mm to 1600mm)**. The 2065 has been used around the world on large-diameter polyethylene projects in a variety of industries. The 2-jaw 2065 allows for butt fusion of most fittings without special holders. Mitered inserts are available for fabricating ell's. McElroy's unique semi-automatic control system requires only one operator.

McElroy developed the 4-jaw 1600 machine to tackle large pipe jobs, with 30,000 lbs. of clamping force per jaw for improved gripping and rerounding of pipe. With 88,000 lbs. of fusion force, operators will find they have extra force in reserve to overcome drag. The 1600 boasts a road-approved 102" width, extendable hydraulic outriggers/levelers for stabilization and an improved facer design that is 40% faster. Like the 2065, hydraulic power assists all fusion functions including complete operation of the jaws, pipe lifts, heater and facer.

MegaMc® 2065

- DataLogger® compatible
- Hydraulic clamping
- Hydraulic pipe lifts aid in loading and unloading pipe
- Serrated jaws and inserts keep pipe from slipping
- Hydraulic pivoting heater and facer

MegaMc® 1600

All the features of the 2065 plus:

- 4-jaw machine with 30,000 lbs. of clamping force per jaw help round pipe ends and offer better gripping
- 88,000 lbs. of available fusion force is more than twice the force of the 2065, allowing you to fuse thicker wall pipes and overcome heavier drag forces
- Stronger, more powerful facer is 40% faster, making it easier to face heavy-wall pipe
- Extendable hydraulic outriggers/levelers stabilize the machine on level or uneven job site locations
- Complete fourth jaw can be removed as a whole unit, for enhanced convenience in fusing prefabricated fittings onto the pipe
- Automatic hydraulic heater stripping improves open and close times
- 102" width suitable for most flatbed trailers and is road shippable without permit in most of the U.S.

High Pressure Clamping Kit

A6325001

Double the hydraulic clamping force of each jaw.

Retrofit a 2-jaw MegaMc 2065 with a High Pressure Clamping Kit for higher fusion pressures and greater clamping force.

GENERATOR

To size your generator see
Page 147

CYLINDER FORCE

For help selecting a cylinder force see
Page 138

DataLogger

To learn more about the DataLogger see
Page 108

McElroy's International Distribution Network

McElroy products are offered through an international network of sales and authorized service center locations providing our customers around the globe with the tools to succeed.



Fusion Machines & Accessories 2065/1600

Machine Type	Model No.	Cylinder Force	Input Voltage Requirements	Minimum Power Requirements *	Plug Type (See pg 140)
--------------	-----------	----------------	----------------------------	------------------------------	---------------------------

2065

Includes fusion machine, facer, 48" and 65" heaters and lifting assembly.



Rolling	A6300102	High	220V - 240V, 50/60Hz, 3Ph	50KVA/48.8KW	J
Rolling	A6300104	High	380V - 415V, 50Hz, 3Ph	49.6KVA/48.5KW	O

1600

Includes fusion machine, facer, 48" and 65" heaters and lifting assembly.



Rolling	A6500103	High	220V - 240V, 50/60Hz, 3Ph	65KVA/61KW	J
Rolling	A6500102	Medium	220V - 240V, 50/60Hz, 3Ph	65KVA/61KW	J
Rolling	A6500104	Medium	380V - 415V, 50Hz, 3Ph	65KVA/61KW	N/A
Rolling	A6500105	High	380V - 415V, 50Hz, 3Ph	65KVA/61KW	O

* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 147.

Part No.

Description

Spare Facer Blade Set - Includes 8 blades screws and wrench



3615708

Standard blades.

3615708C

Extended-life blades.

DataLogger® - To learn more, see page 108



Used to record and document fusion process parameters.

DL6303

Wireless DataLogger

DL6304

Wired DataLogger

DL13501

NEW! DataLogger 4 English Package*

* Other languages available. See page 108 for details.

Pyrometer Kit



A218804

Accurately checks surface temperatures of heater.

Part No.

Description

Spare Heater Plate Kit - Includes attaching screws and wrench



Plates have an anti-stick coating and are required for butt fusion.

A6314301

Set of 2 plates 48" to 65".

A6311805

Set of 2 plates 20" to 48".

Stub End Holder - To learn more, see page 117



6315501

Holds stub end for butt fusion.

NEW! MegaMc® Rollers - To learn more, see page 102



4842401

Aids by reducing the drag on the pipe and protecting the pipe from damage.
Supports 12" IPS - 54" IPS pipe.

Pipe Support Stand - See page 100 for more information



6314001

Heavy-duty stand. Height is adjustable to properly support pipe to be fused.

MegaMc™ Pipe Stand - To learn more, see page 99



Powered pipe stand with lateral and vertical movement for 36"- 65" (900mm - 1600mm) pipe.

6513501

Gas-powered

6513502

Diesel-powered

NEW! MegaMc® PolyHorse® - To learn more, see page 98



4834001

Pipe-handling system for 20" to 48" OD (500mm to 1,200mm) pipe.

2065/1600 Butt Fusion & Mitered Inserts

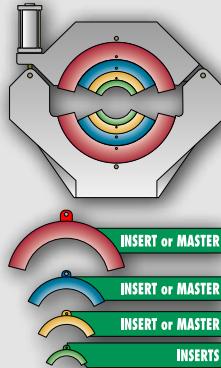
Butt Fusion Inserts

Our cast inserts have been surface-hardened for longer life. Fabricated inserts are constructed out of precision laser-cut carbon steel and are normally lighter in weight than cast inserts.

All inserts are serrated for maximum grip on the pipe. Inserts are made for one size pipe only. Not all inserts fit directly in the jaws. Some inserts nest inside other inserts, called master inserts.

NOTE: Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs.

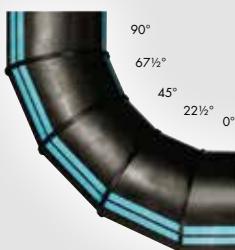
FAB = Fabricated Inserts



Mitered Inserts

Mitered inserts are used to fabricate segmented ellips. Our standard miter is 11 1/4°, other mitered angles are available upon request.

**Standard Ell Configuration
90° Ell 11 1/4° miter shown**



Butt Fusion Inserts Set = 8 Inserts

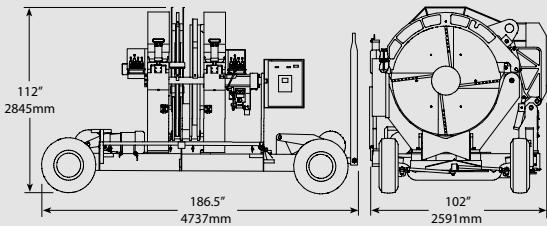
		2 Jaw Inserts		4 Jaw Inserts	
All Inserts below fit in 65.25 (1657mm) jaws					
Inserts	Pipe OD	Cast	FAB	Cast	FAB
65" OD	65.00 (1651mm)	N/A	6512011*	N/A	6512010
63" Master	63.51 (1613mm)	Inc w/pkg*	N/A	Inc w/pkg	N/A
63" OD	63.00 (1600mm)	N/A	6317301*	N/A	6512004
54" DIPS	57.10 (1450mm)	Call	6316401*	Call	6316402
1400mm	55.12 (1400mm)	Call	6317401*	Call	6317407
54" OD	54.00 (1372mm)	6308706*	6317201*	6308707	6317206
52" OD	52.00 (1321mm)	Call	6315401*	Call	6315406
48" DIPS	50.80 (1290mm)	Call	6316201*	Call	6316206
48" Master	48.00 (1219mm)	6304504*	N/A	6304506	N/A
All inserts below require 63.51" & 48" Master Inserts					
1200mm	47.25 (1200mm)	N/A	4819501	N/A	4819501
42" DIPS	44.50 (1130mm)	Call	4821201	Call	4821201
1100mm	43.31 (1100mm)	4813127	Call	4813127	Call
42" OD	42.00 (1067mm)	4813104	4827501	4813104	4827501
1000mm	39.38 (1000mm)	4813111	4819601	4813111	4819601
36" DIPS	38.30 (973mm)	Call	4821101	Call	4821101
36" Master	36.00 (914mm)	4813006	N/A	4813006	N/A
All inserts below require 63.51", 48", 36" Master Inserts					
900mm	35.43 (900mm)	N/A	3629401	N/A	3629401
34" OD	34.00 (864mm)	3603532	N/A	3603532	N/A
32" OD	32.00 (813mm)	3603512	3629501	3603512	3629501
800mm	31.50 (800mm)	3603509	3629601	3603509	3629601
30" OD	30.00 (762mm)	3603515	3629701	3603515	3629701
28" OD	28.00 (711mm)	3603418	3619705	3603418	3619705
26" OD	26.00 (660mm)	3606614	3629801	3606614	3629801
24" DIPS	25.80 (655mm)	3606617	3629901	3606617	3629901
630mm Master	24.80 (630mm)	3606604	N/A	3606604	N/A
All inserts below require 63.51", 48", 36" & 630mm Master Inserts					
24" OD	24.00 (610mm)	2411604	2402301	2411604	2402301
20" DIPS	21.60 (549mm)	2411922	N/A	2411922	N/A
20" OD	20.00 (508mm)	2412010	N/A	2412010	N/A

11 1/4° Mitered Inserts Set = 4 Inserts & 1 Template

2065/1600 Inserts			
All inserts below fit in 65.25 (1657mm) jaws			
Inserts	Pipe OD	Cast	FAB
63" Master	63.51 (1613mm)	Inc w/pkg	N/A
54" OD x 11.25	54.00 (1372mm)	Call	N/A
48" OD x 11.25	48.00 (1219mm)	Call	N/A
1200mm x 11.25	47.25 (1200mm)	Call	N/A
All inserts below require 63.51" OD Master Inserts			
48" Master	48.00 (1219mm)	6304504	N/A
All inserts below require 63.51", 48" OD Master Inserts			
42" OD x 11.25	42.00 (1067mm)	4813115	N/A
1000mm x 11.25	39.37 (1000mm)	Call	N/A
36" OD x 11.25	36.00 (914mm)	4813010	N/A
900mm x 11.25	35.43 (900mm)	4813016	N/A
34" OD x 11.25	34.00 (864mm)	Call	N/A
36" Master	36.00 (914mm)	4813006	N/A
All inserts below require 63.51", 48", 36" OD Master Inserts			
32" OD x 11.25	32.00 (813mm)	3603526	N/A
800mm x 11.25	31.50 (800mm)	3603523	N/A
30" OD x 11.25	30.00 (762mm)	3603520	N/A
28" OD x 11.25	28.00 (711mm)	3603529	N/A
26" OD x 11.25	26.00 (660mm)	3606623	N/A
24" DIPS x 11.25	25.80 (655mm)	3606620	N/A
630mm x 11.25	24.80 (630mm)	3606610	N/A
24" OD x 11.25	24.00 (610mm)	3606613	N/A

* Set = 4 Inserts

MegaMc® 2065



CAPACITY

Fuses Pipe Sizes: 20"OD – 65" OD pipe (500mm – 1600mm)

WEIGHT

Machine: 14,000 lbs (6350Kg)
Facer: 1200 lbs (544Kg)
20-48" Heater: 600 lbs (272.2Kg)
48-65" Heater: 713.5 lbs (323.6Kg)
Spreader Bar: 650 lbs (294.8Kg)

HYDRAULICS

System Pressure: 1500 PSI (103 BAR) Max.
Hydraulic Reservoir Capacity: 24 Gallons (90.85 liters)

POWER

20-48" Heater Power: 35,000 Watt
48-65" Heater Power: 38,437 Watt

Facer Power: Hydraulic

CHASSIS

Frame: Welded steel tube construction
Front Axle: Articulating
Brake: Mechanical

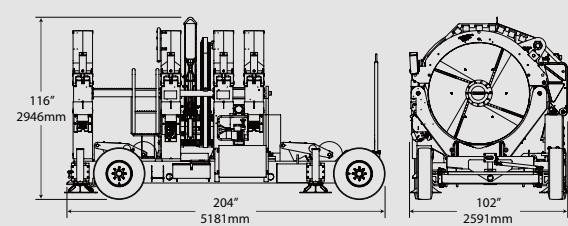
MOBILITY

Tires: 12 - 16.5LT, F-12
Transportation: Pulled via towing ring
Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

MegaMc® 1600



CAPACITY

Fuses Pipe Sizes: 20"OD – 65" OD pipe (500mm – 1600mm)

WEIGHT

Machine: 21,000 lbs (9525Kg)
Facer: 1200 lbs (544Kg)
20-48" Heater: 600 lbs (272.2Kg)
48-65" Heater: 713.5 lbs (323.6Kg)
Spreader Bar: 1000 lbs (453.6Kg)

HYDRAULICS

System Pressure: 3000 PSI (207 BAR) Max.
Hydraulic Reservoir Capacity: 35 Gallons (132 liters)

POWER

20-48" Heater Power: 35,000 Watt
48-65" Heater Power: 38,437 Watt

Facer Power: Hydraulic

CHASSIS

Frame: Welded steel tube construction
Front Axle: Articulating

MOBILITY

Tires: 8.25 - 15LT High Load Rating
Transportation: Pulled via towing ring
Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 7 for details

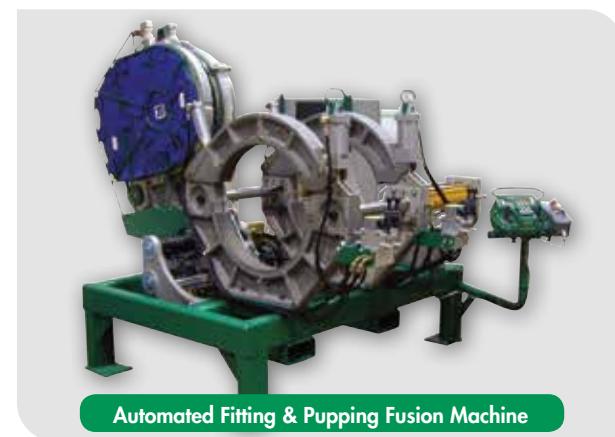
Custom Fusion Machines



Polyethylene Ball Valve Machine



Manual U-Bend Machine



Automated Fitting & Piping Fusion Machine

Custom Machines

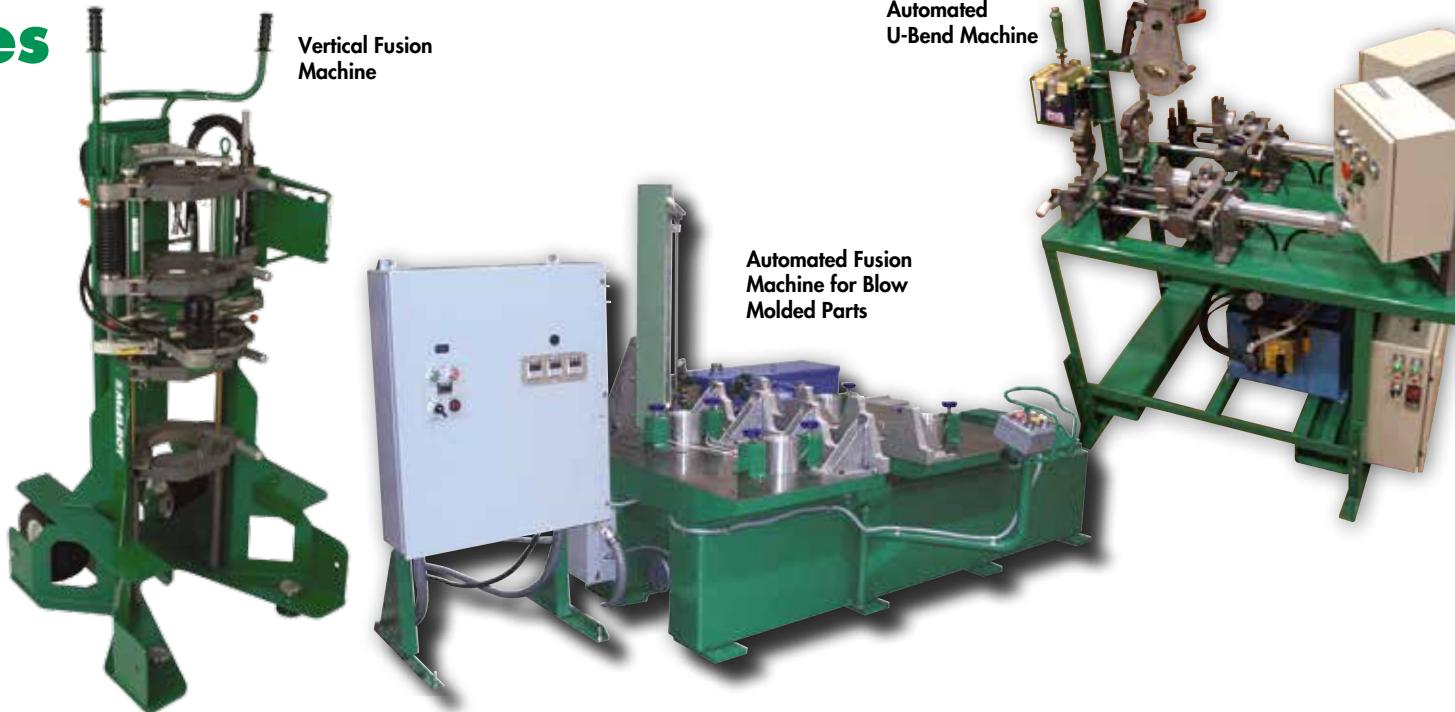
McElroy has an extensive background producing a broad variety of custom-designed special purpose machinery to fit your individual needs. We have an excellent engineering and design staff to research your needs and develop custom fusion equipment. Our manufacturing facilities have the capability of producing a broad variety of products efficiently and effectively with our state-of-the-art production equipment and skilled craftsmen. These machines can be designed for field or in-plant conditions and can have the capability for butt fusion, sidewall fusion or mitered joints for any size pipe desired. If you have special machine requirements and need help with the design and production, contact a McElroy representative. We will work on the solution with you.

Contact us at:

918-836-8611

Email us at:

engineering@mcelroy.com



DESIGNING ...



ANOTHER BREAKTHROUGH MOMENT

McElroy Design and Engineering services – let us find a solution for you.

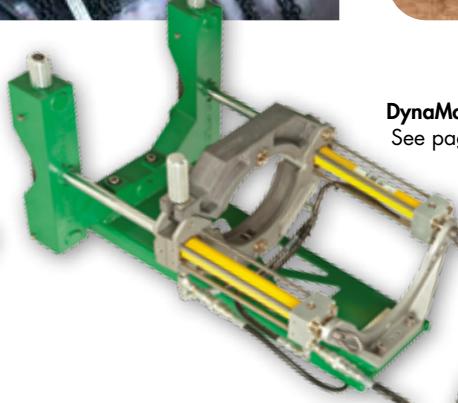
Large Diameter Sidewall Fusion Machines **Sidewall**

Sidewall Fusion

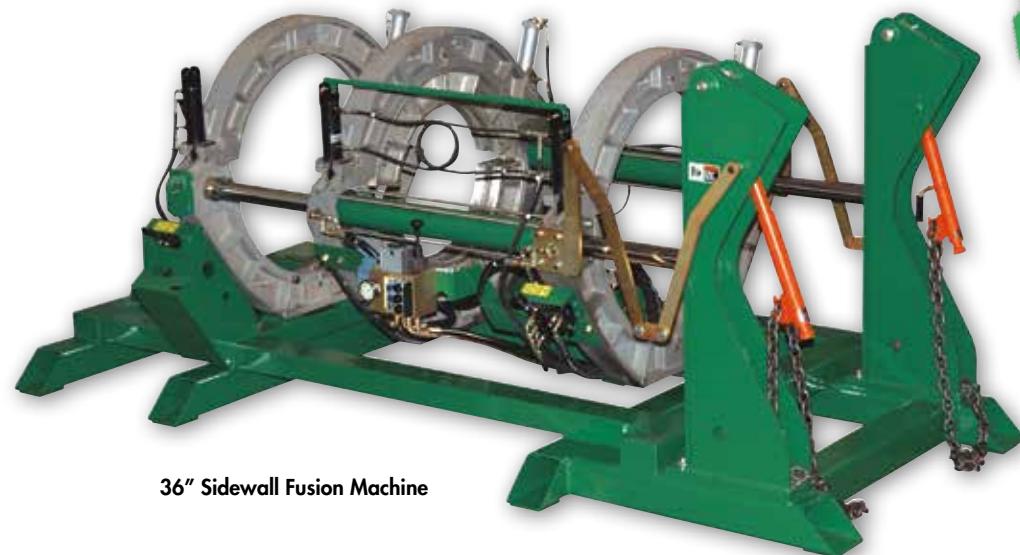
Large-diameter sidewall fusion machines are designed for fusing large branch fittings on any main size. This line of hydraulic machines provides precise alignment of heated parts, exact fusion pressure and shares many features found in all McElroy machines. The result is increased productivity, joint reliability, machine durability and long life with minimal maintenance. The heater surfaces use the same McElroy patented serrated design that has become the industry standard for sidewall fusion. The large diameter sidewall fusion machines are designed for use in the manufacturing environment or In Field applications.

Contact us at:
918-836-8611

Email us at:
engineering@mcelroy.com



DynaMc® 28 EP Sidewall Fusion Machine
See page 32 and 125 for more details.



36" Sidewall Fusion Machine



18" Sidewall Fusion Machine



Sign up now for our newsletter, **McElroy Connections**

Each issue is dedicated to keeping you up-to-date on the latest developments in polyethylene (PE) fusion equipment and polyethylene (PE) pipe applications through: Field proven, practical information you can use to improve productivity, and your bottom line. www.mcelroy.com/fusion/newsletter/subscribe.htm

M**M** **McELROY** CONNECTIONS

Productivity Typical Productive Job Site Setup Using McElroy Equipment

Each job site is a puzzle. McElroy makes productivity tools so you have the pieces to complete the puzzle in the shortest amount of time.

It's not just one or two tools either – it's a whole team of productivity tools that can be mixed and matched. With help from your local McElroy distributor, you can target the tools best suited to the job at hand. This can save you time and money.

Our team of productivity tools helps you excel before, during and after the pipe fusion process.

When time is money, McElroy products shine. We want you to have the best pipe-handling and productivity-boosting products available. Knowing how these products can work in your favor can make you even more profitable.

McElroy Productivity Tools. It's not cheating...It's working smarter.

The McElroy productivity team includes:

- **PolyHorse®** – a pipe-handling system for 3" IPS - 20" OD pipe (90mm – 500mm). The PolyHorse reduces manpower and machinery needed on the job site.
- **MegaMc® PolyHorse®** – a pipe-handling system designed to boost productivity and promote safer working conditions on 20" - 48" OD (500mm - 1,200mm) jobsites.
- **MegaMc® Pipe Stands** – adjustable, rugged, powered pipe stands can accommodate pipe from 8" to 65".
- **Pipe Stands** – for 2" IPS - 65" OD pipe (63mm - 1600mm). McElroy pipe stands are essential for reducing operator strain, speeding the job site setup and making fusion processes easier.
- **Low Profile Rollers** – pipe rollers for 4" - 20" pipe (100mm – 500mm). The Low Profile Rollers are perfect for pulling lengths of pipe considerable distances.
- **MegaMc® Rollers** – designed for 12" IPS - 54" IPS (340mm - 1370mm) pipe.
- **PolyPorter®** – pipe stand and dolly for 2" IPS - 8" DIPS pipe (63mm – 250mm). The PolyPorter allows a single operator to maneuver a stick of pipe into a fusion machine.
- **LineTamer®** – coiled pipe straightener and rerounder for 2" IPS - 6"IPS pipe (60mm – 180mm). The LineTamer is recognized as the premier tool for handling coiled pipe, conduit or duct efficiently.
- **Hydraulic Clamping** – hydraulically powered clamping for 412 and 618 fusion machines. Hydraulic Clamping saves time and operator fatigue when clamping jaws open and closed.

Productivity

A typical job site setup like this, requires 2 operators and 1 piece of equipment to load pipe in the PolyHorse and pull the pipe.



Hydraulic Clamping Kit



TracStar® Fusion Machine



Pipe Stand



PolyHorse® PowerAssist



PolyHorse®



PolyHorse® Pipe Handling System

Pipe handling capability for 3" IPS - 20" OD pipe (90mm - 500mm)

PolyHorse®

The PolyHorse is a pipe-handling system that consists of a series of adjustable racks to store and help install the pipe on the jobsite. For use with PE pipe sizes **3" to 20"**, the PolyHorse can reduce manpower expense, provide an efficient, less hazardous environment for handling pipe bundles and enhance productivity by 150%.

PE pipe is off-loaded from the delivery truck directly onto the PolyHorse, off the ground and out of the way, until needed. In use, the operator rolls the pipe down the rack and onto the integral pipe rollers where it is easily loaded into a McElroy fusion machine. This eliminates the costs for additional lifting equipment and manpower.

- Reduces manpower and additional equipment
- Handles pipe sizes 3" through 20"
- Enhance productivity by 150%
- Standard 3 truss setup has 36,000 lb. total capacity (add 12,000 lbs. capacity for each additional truss)
- Compact kit available with half-length trusses for tight job sites
- Modular Design
- Patents pending

The table below shows the predicted productivity in an 8-hour day. All joints based on 60 seconds per inch of pipe diameter cool time and 50-foot pipe lengths using 2 PolyHorse setups as shown on page 97.

Pipe Size IPS	No. of Joints	Fused Pipe ft.
4	142	7,100
6	102	5,100
8	82	4,100
10	68	3,400
12	58	2,900
18	40	2,000



Image shown with extension rack for additional pipe storage capacity.

Items used in this setup.

1 each: No.1875501 PolyHorse Kit

3 each: No.1875901 Screw Jack

3 each: No.1875601 Truss



150%
Production
Increase!

McElroy PolyHorse® Use the PolyHorse in conjunction with these machines to increase your production by up to 150%

Double Your Productivity

Utilize the downtime while the pipe is cooling

By using one operator, two McElroy fusion machines and two PolyHorse setups, you can double your productivity without adding additional operators.

Image shown with these items for increased productivity.

2 each: No. 1875501 PolyHorse Kit

3 each: No. 1876302 Stationary Rollers

2 each: McElroy Fusion Machines

2 each: McElroy Pipe Stands

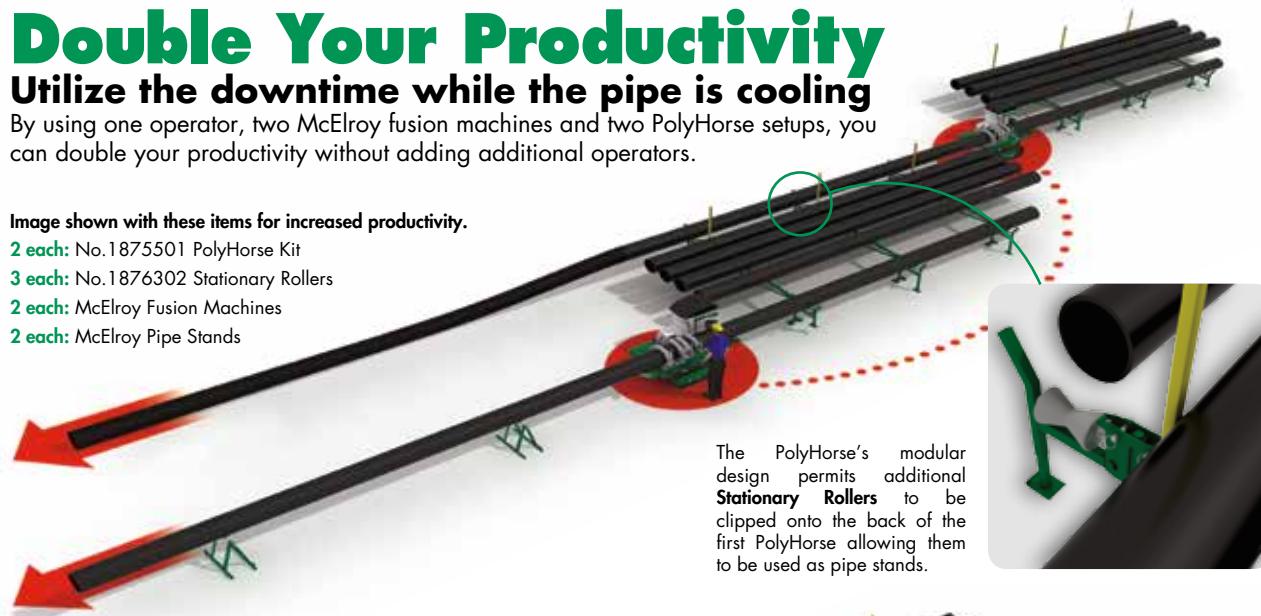
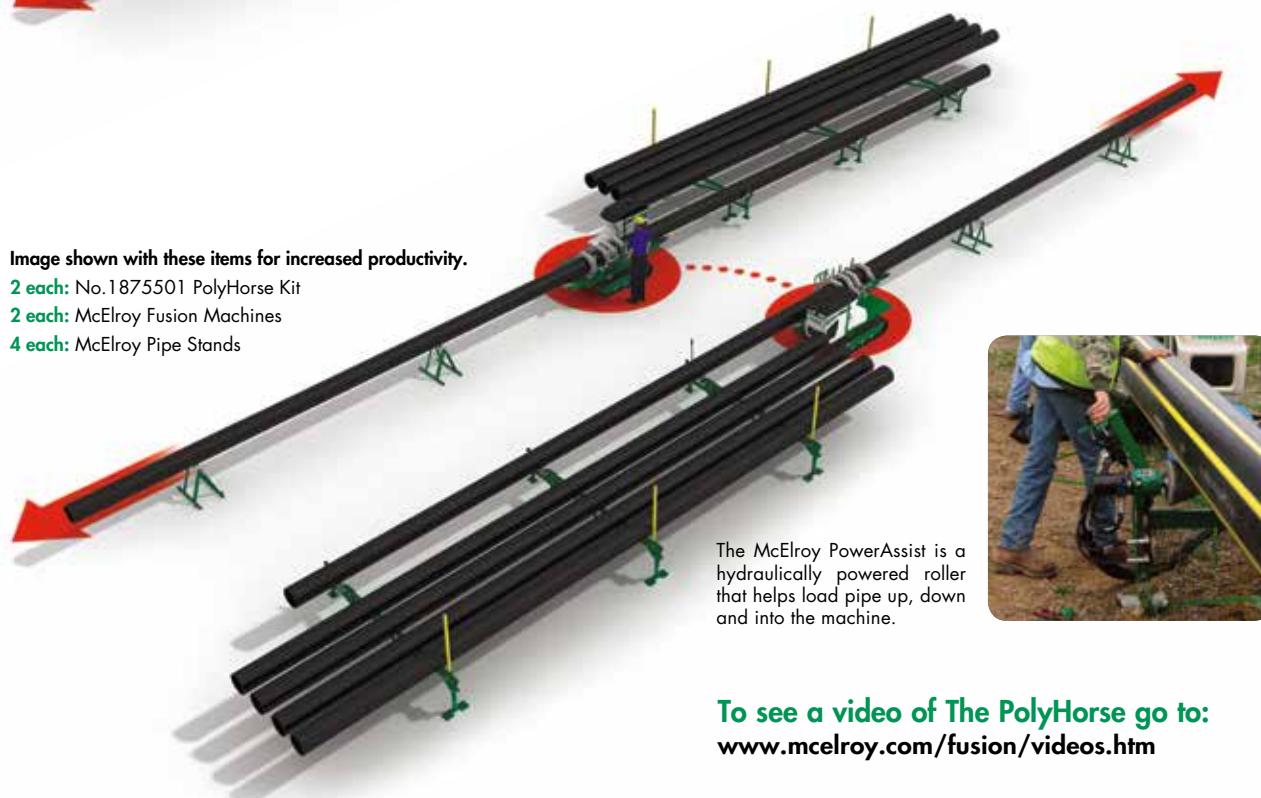


Image shown with these items for increased productivity.

2 each: No. 1875501 PolyHorse Kit

2 each: McElroy Fusion Machines

4 each: McElroy Pipe Stands



To see a video of The PolyHorse go to:
www.mcelroy.com/fusion/videos.htm

Part No.	Description
PolyHorse Kits	
1875502	Kit Includes 3 trusses, 3 stanchions, 6 screw jacks, 1 pivot roller support, 2 stationary rollers and wrench.
1875501	PolyHorse Kit w/manual roller
1875505	Compact PolyHorse Kit w/PowerAssist
1875504	Compact PolyHorse Kit w/manual roller
PowerAssist	
1874401	Attaches to the closest truss to the fusion operations and uses hydraulic power from the machine to effortlessly load pipe.
Stationary roller	
1876302	Attaches to the Screw Jack and supports the pipe for loading into the machine.
Pivot Roller Support	
1876301	Attaches to the closest truss to the fusion operations and lifts the end of the pipe above the height of the jaws to load pipe into the machine.
Screw Jack	
1875901	Used to level the trusses.
Truss	
1875601	Standard pipe support truss
1875602	Compact pipe support truss
Stantion	
1877101	Removable support to control pipe bundles.

MegaMc® PolyHorse® Pipe Handling System

For 20" - 48" OD pipe (500mm - 1200mm)

MegaMc® PolyHorse®

The MegaMc® PolyHorse® is a pipe-handling system designed to boost productivity and promote safer working conditions on 20" to 48" OD (500mm to 1,200mm) polyethylene pipe jobsites.

The productivity tool consists of a series of pipe racks and powered pipe stands that hold enough pipe for a day's worth of fusion work. With the pipe stored in a single location and ready for use, the MegaMc PolyHorse allows heavy machinery to work in other places on the jobsite. A single operator can dispense pipe onto the stands, maneuver the pipe into alignment, and insert pipe into the fusion machine with the use of a remote control.

Instead of dedicating a piece of heavy machinery to lift, align, load and hold a stick of pipe to be fused, the MegaMc PolyHorse does all the work. After setting up the MegaMc PolyHorse, sticks of pipe are loaded directly onto the pipe racks that are purposefully designed with an incline that allows gravity to feed the pipes to the dispenser. The dispenser is activated by the remote control, lowering a single stick of pipe into a tracked powered pipe stand and roller powered pipe stand attached to the end of the racks. The operator then controls the powered pipe stands to move and align the pipe stick up to 24 inches laterally and 34 inches vertically. Powered rubber tracks feed a stick of pipe into the fusion machine.



NEW! MegaMc PolyHorse Includes 2 rack sets, powered tracked pipe stand, roller pipe stand, lifting sling, 4 outrigger pads, 8 safety cones, remote control.

Part No.	Maximum Load Per Pipe Stick	Maximum Load	Input Voltage Requirements	Minimum Power Requirements
4834001	10,500 lbs. (4,763Kg)	70,000 lbs. (31,751Kg)	220V - 240V, 50/60Hz, 3Ph	5.1KVA/4.1KW
4834002	10,500 lbs. (4,763Kg)	70,000 lbs. (31,751Kg)	380V - 415V, 50Hz, 3Ph	4.9KVA/4.1KW



MegaMc 824



TracStar 630



MegaMc 1236



TracStar 900



MegaMc 1648



MegaMc 2065



MegaMc 1600

MegaMc® PolyHorse® Use the PolyHorse in conjunction with these machines to increase your production by up to 150%

Pipe Handling for 8" to 36" (225mm - 900mm) and 36" to 65" Pipe (900mm - 1600mm)

MegaMc® Pipe Stands



MegaMc® Pipe Stands

Most job sites require heavy machinery to lift and hold a length of pipe in place for large-diameter fusion projects. To free up some of the heavy machinery's time and save money, the new self-contained, powered MegaMc® Pipe Stands help align the pipe with the fusion machine, and then hold the pipe at the proper height.

Simply start the engine to adjust the pipe up to 24" laterally and 34" vertically, then turn the engine off and the height is locked in place. Since the unit is self-contained, there are no hydraulic hoses running across the site.

Rugged rollers with low-friction pillow block bearings allow the pipe to move easily through the rollers. Two models are available for use on most medium- and large-diameter job sites, with a smaller unit that works with 8" to 36" pipe. A larger unit handles pipe from 36" to 65".



Features

- Self-contained HPU
- Adjustable while fully loaded, up to 24" laterally and 34" vertically
- Height locks in place, even with HPU turned off
- Features rugged 6 5/8" diameter rollers with low-friction pillow block bearings
- Wide base for stability, stackable for easy storage
- Can be lifted by forklift or crane

Part No.	Description	Maximum Capacity	Fuel Type
MegaMc Pipe Stands			
3645001	8" to 36" (225mm to 900mm)	9,000 lbs. (4,082 Kg)	Gasoline
3645002	8" to 36" (225mm to 900mm)	9,000 lbs. (4,082 Kg)	Diesel
6513501	36" to 65" (900mm to 1600mm)	16,000 lbs. (7,257 Kg)	Gasoline
6513502	36" to 65" (900mm to 1600mm)	16,000 lbs. (7,257 Kg)	Diesel

Pipe Stands

Pipe stands save wear and tear on machinery, reduce strain on operators and makes the fusion process easier. Pipe stands are adjustable for uneven terrain so that the pipe is supported at the same height as the machine. By bringing the pipe in parallel to the machine it is much easier to adjust hi/low and achieve a square face-off. When building a pipeline, pipe stands can greatly increase productivity. Instead of moving the machine for each joint, you would pull the fused pipe through the machine and roll in a new stick to be fused. This allows you to stage all the pipe in one location, and keep the fusion machine stationary, minimizing down time between fusion joints.

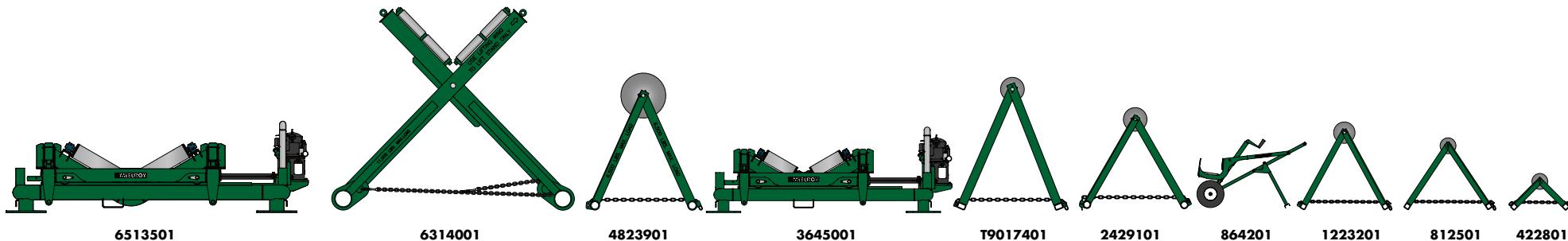


To see an animation go to:

www.mcelroy.com/fusion/animations.htm

14	26	28	250	412	618	500	824	630	1236	900	1648	2065	1600
Applicable Machines													

Description	Part No.	14	26	28	250	412	618	500	824	630	1236	900	1648	2065	1600	Maximum Load	Notes	Weight
14 Pipe Stand	422801	x														2500 lbs (1134Kg)	For use with the 14 Cart (434001) only	37 lbs (16.8Kg)
28 Pipe Stand	812501	x	x	x	x											2500 lbs (1134Kg)	When used with 14 and 26 use Manual Fusion machine Stand No.439001	64 lbs (29Kg)
2" - 8" PolyPorter®	864201	x	x	x	x											300 lbs (136Kg)		63 lbs (28.5Kg)
412/618 Pipe Stand	1223201					x	x	x								2750 lbs (1247Kg)	N/A	130 lbs (59Kg)
824 Pipe Stand	2429101							x								4500 lbs (2041Kg)	N/A	197 lbs (89Kg)
TracStar® 900 Pipe Stand	T9017401							x	x	x	x					4500 lbs (2041Kg)	N/A	155 lbs (70Kg)
Heavy-Duty Pipe Stand	4823901							x	x	x	x	x				6500 lbs (2948Kg)	N/A	595 lbs (270Kg)
2065 Pipe Stand	6314001										x	x				11,000 lbs (4989Kg)	N/A	1025 lbs (465Kg)
8" - 36" MegaMc® Pipe Stand	3645001							x	x	x	x					9000 lbs (4082Kg)	Gas-powered, self-contained, adjustable	2160 lbs (980Kg)
8" - 36" MegaMc® Pipe Stand	3645002							x	x	x	x					9000 lbs (4082Kg)	Diesel-powered, self-contained, adjustable	2160 lbs (980Kg)
36" - 65" MegaMc® Pipe Stand	6513501							x	x	x	x	x				16,000 lbs (7257Kg)	Gas-powered, self-contained, adjustable	3025 lbs (1372Kg)
36" - 65" MegaMc® Pipe Stand	6513502							x	x	x	x	x				16,000 lbs (7257Kg)	Diesel-powered, self-contained, adjustable	3025 lbs (1372Kg)





Low Profile Rollers

McElroy's Low Profile Rollers are a modular pipe roller designed to make pulling 4" - 18" IPS (100mm - 450mm) diameter thermoplastic pipe easier and to minimize drag on the pipe. Perfectly paired with other McElroy productivity-enhancing tools, such as the PolyHorse, the new rollers are tip-resistant, allow for curved pulls of pipe over considerable distances, and provide no resistance to external fusion joint beads moving across the roller. The Low Profile Rollers can be ordered from McElroy's worldwide network of distributors and are packaged in a "nested" crate that contains 40 complete roller assemblies.

Features

- Minimizes drag on the pipe
- Allows for curved pulls
- Rolls easily, increasing productivity
- Keeps pipe clean and off the ground
- Sealed ball-bearing construction
- Compact storage in reusable crate that fits in 3/4 ton pickup bed
- 2000 lb. capacity per pair of rollers
- Tip-resistant
- Minimizes pipe damage
- Modular design



Reusable crate for shipping and storage fits in 3/4 ton pick-up bed.

Part No.	Description
Low Profile Rollers	
A1867501	40 complete rollers per case (1875 lbs.)
1867501	Individual roller (2 required for assembly)

MegaMc® Rollers

Pipe handling for 12" IPS - 54" IPS pipe (340mm - 1400mm)

MegaMc® Rollers

McElroy's MegaMc® Roller is a productivity tool that keeps pipe off the ground as it is being fused and pulled along the right of way. The rollers are designed for 12" IPS through 54" IPS (340mm to 1400mm) pipe.

McElroy designed the MegaMc Rollers to be tip resistant while handling a capacity of 9,000 pounds per unit. The rollers can be paired with other productivity tools on a job site, including the MegaMc PolyHorse and MegaMc Pipe Stands in order to boost jobsite workflow.

The pipe and pipe joints roll through the rollers easily. By keeping the pipe off the ground, the pipe is protected from the damage of being pulled on the ground, as well as excessive pulling forces. The MegaMc Rollers are stackable, with the ability to transport 52 rollers on a flatbed semi trailer.



Features

- Minimizes drag on the pipe
- Keeps pipe clean and off the ground
- Sealed ball-bearing construction
- Tip-resistant
- Minimizes pipe damage
- Stackable to transport 52 rollers on semi trailer
- Easily lifted with chain, straps or forks

Part No.	Description
NEW! MegaMc Rollers	
4842401	54" roller assembly

Pipe Portability for 2" IPS - 8" DIPS pipe (63mm - 250mm)

Pipe Stand & Dolly PolyPorter®



PolyPorter®

The PolyPorter was created from the mind of a pipeline contractor. It is an innovative workhorse that tackles the job of handling pipe in the field. The PolyPorter combines the mechanical advantage of a dolly with the functionality of a pipe stand to create one of the most useful pipeline tools. One person can easily load a length of pipe without strain. The pipe can then be pushed easily through the roller-equipped hook arm into the fusion machine. The jack enables the operator to raise and lower the PolyPorter to level the pipe in uneven terrain to the height of the machine.

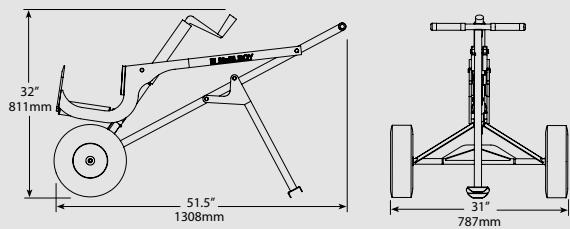
Features

- Can lift 2" IPS - 8" DIPS (63mm - 250mm) pipe
- Combines the advantage of a dolly and a pipe stand
- One person can easily load a length of pipe without strain
- Pipe easily slides through the roller into the fusion machine
- Jack enables PolyPorter to be raised to height of machine



To see a video of The PolyPorter go to:
www.mcelroy.com/fusion/videos.htm

Part No.	Description
PolyPorter	
864201	PolyPorter pipe stand and dolly.

PolyPorter®	
	
CAPACITY	
Lifts:	2" IPS - 8" DIPS pipe (63mm - 250mm)
Height Range:	20.5" - 38" (521mm - 965mm) at center of 8"DIPS pipe
Maximum Load:	300 lbs (136Kg)
WEIGHT	
PolyPorter:	63 lbs (28.6Kg)
MOBILITY	
Tires:	Inflatable tires
WARRANTY	
Term:	3 Years, see page 7 for details

LineTamer® Coiled Pipe Straightener & Re-round

Patent No. 5,676,009



LineTamer®

With the McElroy LineTamer®, you can quickly install coiled PE pipe, conduit and duct. You can install an entire coil of pipe with a minimum of two fusion joints. The LineTamer cost-effectively straightens and re-rounds coiled pipe to meet or exceed ASTM D2513 ovality requirements. It removes coil set for speedy installations on the job site. The **3" to 6" IPS LineTamer** comes equipped with 4" to 6" re-rounding rollers, an optional 3" to 4" re-rounding rollers are also available and the unit is powered by hydraulic controls for ease of operation.

The **2" IPS LineTamer** allows you to straighten and re-round 2" IPS PE pipe, conduit and duct quickly with minimal training. Ball thrust bearings make for easy roller adjustment to remove the coil set in the pipe for straightening.

Coiled Pipe Trailers

Proper handling of coiled pipe, conduit or duct requires the McElroy LineTamer to be mounted on a specially designed, heavy-duty, coil pipe trailer. McElroy has worked closely with several OEM trailer manufacturers to provide complete trailer packages featuring the LineTamer. Each trailer has been engineered to handle the coil and correctly align the pipe to optimize re-rounding and straightening. Custom configurations, such as coil self-loading, powered threading rollers and other customer-specific features are available. Contact your McElroy representative about a LineTamer trailer package to meet your pipe-handling needs.



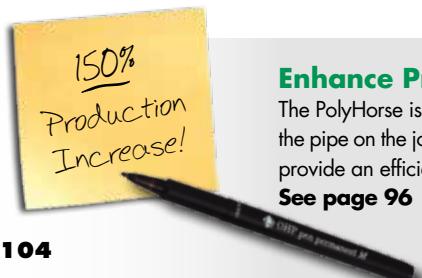
Example of Coiled Pipe Trailer

2" IPS LineTamer

- Straightens and re-rounds 2" IPS pipe
- Can install a full coil of pipe with only two fusion joints
- Removes coil set for speedy installations
- Ball thrust bearings for easy adjustment

3-6" IPS LineTamer

- Straightens and re-rounds 3" to 6" IPS pipe
- Can install a full coil of pipe with only two fusion joints
- Removes coil set for speedy installations
- Self-contained hydraulic power unit



Enhance Productivity with Stick Pipe

The PolyHorse is a new pipe-handling system that consists of a series of adjustable racks to store and help install the pipe on the job site. For use with PE pipe sizes 3" through 20", the PolyHorse can reduce manpower expense, provide an efficient, less hazardous environment for handling pipe bundles and enhance productivity by 150%.

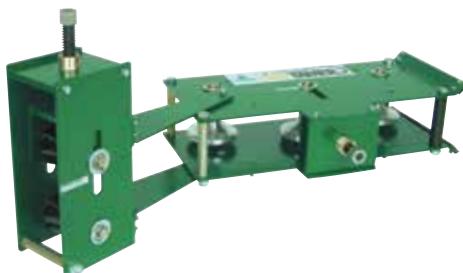
See page 96



Coiled Pipe Straightener & Re-rounding LineTamer®

2" IPS LineTamer

LineTamer (no trailer) with 2" IPS rollers installed.



Package	Model No.	Length	Width	Height	Weight
2" IPS LineTamer	LT0122	44.44" (1129mm)	19.75" (502mm)	20.38" (518mm)	119 lbs. (54 kg)

3-6" IPS LineTamer

LineTamer (no trailer) with 4"-6" IPS rollers installed.



Package	Model No.	Length	Width	Height	Weight
6" LineTamer & gasoline HPU	ALT0048	96" (2438mm)	46" (1168mm)	50" (1270mm)	1015 lbs. (460 kg)
6" LineTamer only	LT0048	96" (2438mm)	46" (1168mm)	50" (1270mm)	850 lbs. (386 kg)

Part No.

Description

Part No.

Description

Part No.

Description

Hydraulic Power Unit



LT0172

Gasoline HPU for 3" - 6" LineTamer

6517501

Diesel HPU for 3" - 6" LineTamer

3"- 4" Re-round Roller Kit



LT0037

Kit is required for re-rounding 3" - 4" IPS pipe. Includes 2 re-round rollers and stop plates.

Tandem Hydraulic Power Unit



LT0171

Tandem gasoline HPU for SweetWater Metal Products self-loading trailer.

Sign up now for our newsletter, McElroy Connections

Each issue is dedicated to keeping you up-to-date on the latest developments in polyethylene (PE) fusion equipment and polyethylene (PE) pipe applications through: Field proven, practical information you can use to improve productivity, and your bottom line. www.mcelroy.com/fusion/newsletter/subscribe.htm



McELROY CONNECTIONS

Hydraulic Clamping

Retrofit Kit for Rolling 412, TracStar® 412, Rolling 618, TracStar® 618, and TracStar® 500 II

Hydraulic Clamping

One of the more popular features of large-diameter MegaMc® fusion machines is the hydraulic clamping that tightens the jaw clamps. Now, users can retrofit their Rolling and TracStar 412s, as well as their Rolling and TracStar 618s and TracStar 500 Series IIs, with hydraulic clamping that replaces the standard manual crank clamp knobs.

The retrofit kit can be installed by your local McElroy distributor and includes a manifold block that is added to the carriage and controls the two fixed-jaw cylinders and two movable-jaw cylinders independently.



Features

- Increased productivity by eliminating manual cranking of clamp knobs
- Less time spent working with jaw operation and more time spent fusing pipe
- Quick disconnect hydraulic fittings are provided for fusing tees, ell and tie-ins
- Retrofit kit can be installed at your local McElroy distributor
- Can be purchased, factory-installed on new machines

Part No.	Description
Hydraulic Clamping kits	
A1262301	Retrofit Kit for Rolling and TracStar 412
A1870301	Retrofit Kit for Rolling and TracStar 618
AT5044801	Retrofit Kit for TracStar 500 Series II
AT5045201	Retrofit Kit for TracStar 500 Auto



Kits are compatible only with the 412 and 618 Rolling machines introduced in 2003 under the model number series 12481xx & 18691xx. Components for individual kits may vary.



DataLogger® 4

The DataLogger® 4 from McElroy offers the ability to record and document the parameters of the pipe fusion process. The latest generation of DataLogger is smaller in size, has a rechargeable internal battery, double the screen resolution of previous DataLoggers, and a pressure sensor with a 0 to 3,000 PSI pressure range. The DataLogger 4 has worldwide appeal, with multilingual support and recognition of many international fusion standards.

The FusionGuide™ feature gives a faster "go/no-go" interpretation of graphs generated by the DataLogger. Trained inspectors can look at the FusionGuide data to determine if a fusion joint was fused with correct pressures and times according to supported standards.



Screenshot from the DataLogger 4 FusionGuide™



DataLogger® 4 Packages

Includes Rugged Pocket PC with DataLogger software pre-installed, carrying case and one year of free software support.

Part No.	Description
DL13501	English Package
DL13502	Spanish Package
DL13503	Portuguese Package
DL13504	Russian Package
DL13505	Chinese Package

Pyrometer Kit



A218804

Accurately checks surface temperatures of heater.



Wired & Wireless DataLogger®



DataLogger® Packages

DataLogger packages include DataLogger, Rugged Pocket PC with software pre-installed, carrying case and one year of free software support. Specifications subject to change without notice.

Part No.	Description
DL6303	Wireless DataLogger for up to 2,000 PSI
DL6304	Wired DataLogger for up to 4,000 PSI

Features

- Rugged handheld device
- Provides familiar Microsoft® Windows® user interface
- Generates reports in imperial or metric units
- Joint report recorded in nonvolatile Flash memory
- Battery-operated for portability
- NIST-traceable calibration

Wired DataLogger

- Wired model available for job sites sensitive to wireless technologies and for fusion operations up to 4,000 psi
- Easily distinguished by "McElroy green" molded top

Wireless DataLogger

- For up to 2,000 psi job sites
- Wireless connection available via Bluetooth®
- Easily distinguished by yellow molded top

Spare Cables for Wired & Wireless DataLoggers

	MLE00070	Replacement hydraulic transducer cable for Wireless DataLogger.
	MLE00087	Data-collection cable for Wired DataLogger.
	MLE00089	Replacement hydraulic transducer cable for Wired DataLogger.
	MQG00069	Serial hand-held computer cable for Wired DataLogger.
	MQE00110	Multi-voltage AC adapter for handheld computer

DataLogger Adapter Kit for machines after 1994

Adapter kits are used with machines made after 1994. These machines have a port labeled TXA on the manifold. This series of fusion machines are plumbed with high pressure hydraulic hoses.

ADL6601	28 to 1648 (Included with DataLogger)
ADL6602	28 Combination Unit
ADL6603	Sidewinder®
ADL6612	2065

DataLogger Retrofit Kit

Retrofit Kits are for 1994 and older configuration machines without a port labeled TXA. This series of fusion machines were plumbed with hydraulic lines made of stainless steel tubing.

ADL6604	28, 412, 618
ADL6605	28 CU
ADL6606	824 Machine – Hose
ADL6607	824 Machine – Tubing
ADL6608	1236 Machine – Hose
ADL6609	1236 Machine – Tubing
ADL6610	1648 Machine
ADL6611	2065 Machine

DataLogger Connection Guide



1



2



3

Older machines without a port labeled TXA require a DataLogger Retrofit Kit shown in the table above.

If you have an older McElroy machine, the TXA port may be plugged as in illustration 1, or it may have an older style QD as in illustration 2. In either case you will need to install a new QD similar to the one shown in illustration 3 to work with the new DataLogger. Some machines require an additional kit which can be found in the DataLogger Adapter Kits in the table to the left.

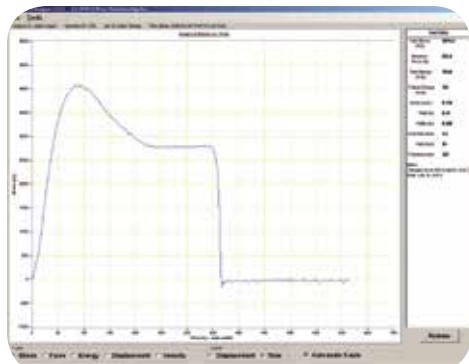
If the QD in the TXA port looks like the one in illustration 3 no further upgrades are necessary to use the new DataLogger.

McSnapper®

The McElroy McSnapper® is a tensile with impact testing machine designed specifically for polyolefin materials. It was developed to accurately test fusion joints. The McSnapper is designed to meet ASTM F2634 standard test method for laboratory testing of polyethylene (PE) butt fusion joints using tensile-impact testing.

The machine can be used in the development of new materials, qualify operators, quality assurance for existing materials or in fusion compatibility to determine lot uniformity, strength and fuseability of pipe and fittings.

The McSnapper requires the operator to provide the machine tool needed to prepare test coupons.



Example of McSnapper Data Analysis



Fusion joint
testing coupon



- Tensile with impact testing machine
- Testing adheres to ASTM F2634
- Provides accurate testing for fused joints
- Testing up to 2.6" wall thickness

Part No.	Description
McSnapper Package	
S00108	McSnapper fusion machine, butt fusion testing kit for wall thickness up to 2.6" and operator's manual.

Guided Side Bend Tester

McElroy's Guided Side Bend Tester performs a qualitative test of a fusion joint by destructively testing a coupon. The quality assurance device tests the ductility of polyethylene pipe fusion joints in a safe, quick manner. "Bend back" tests have been performed in the field for years. This testing method places the entire wall thickness into tension and gives assurance of the ductility of joints.

Now, operators can perform the test safely with the use of a hydraulically powered device that put three points of pressure on test coupons. If no gaps or breaks are present in the fusion joint after the test, the result is a passing grade. The Guided Side Bend Tester is lightweight, and requires the operator to supply a planer, calipers and saw to complete the testing procedure.

Features

- Qualitative testing of the ductility of a joint
- Faster, easier and safer than traditional bend tests
- Can test coupons up to 7-inch-thick pipe walls
- Rugged and lightweight
- Two-speed hydraulic hand-pump system powers coupon test



Part No.	Description
NEW! Guided Side Bend Tester	
S05501	Guided Side Bend Tester performs a qualitative test of a fusion joint by destructively testing a coupon.

In Field® Tensile Tester

Field Tester For 2" IPS & Larger Pipe

Patents pending

In Field® Tensile Tester

Tensile testing of fusion joints in the past required cutting a coupon out of the pipe, sending it off to a laboratory and waiting for the results to come back. Technicians often found it very difficult to perform alternate tests such as bend-back tests on thicker pipes in the field. McElroy's In Field Tensile Tester aims to improve on these tests by providing a quick and easy way to qualitatively test joints in the field. The dual reduced section coupon allows for a quick comparison of the integrity of the joint versus the parent pipe. A hand-pump system tests coupons from 2" IPS and larger pipes (up to 5" thick wall). To create the coupon, a template is attached to the pipe's outer wall, where a drill and reciprocating saw produce the coupon in minutes. The coupon is then inserted into the hand-pump tensile test unit for destructive testing.



- Qualitative testing of a joint in the field
- Faster and easier than a bend test
- Can produce coupons from up to 5-inch thick pipe wall
- Template accommodates 2" IPS and larger pipe
- Process takes minutes, not days or weeks
- Hand-pump system tests coupon

Part No.	Description
In Field Tensile Tester Package	
AS03501	Includes hand-pump testing unit, coupon template and drill bit.

Part No.	Description
Spare In Field Coupon Drill Fixture	
S04801	Coupon template for 2" OD and larger pipe.

Part No.	Description
Spare Drill Bit	
MJL00074	Specially designed drill bit for coupon drill fixture.

Test Caps

McElroy Test Caps are designed for quick and easy air pressure testing of polyethylene pipe. All of our test caps are reusable, provide a positive o-ring seal and have been pressure rated to 165 PSI to meet 49 CFR192.513. Installation and removal is quick and easy on pipe sizes from **1/2" CTS to 2" IPS**. Test pressure actually improves the cap's grip on the pipe. One test cap is required per pipe size. They are made of corrosion-resistant material and are durable in construction.

TP-300 Test Caps

- Quick and easy air pressure testing of polyethylene pipe
- Easily installed and removed for repeated use
- Test caps meet 49 CFR192.513
- Tests pipe sizes from **1/2" CTS to 2" IPS**
- Safety lanyard for added operator protection

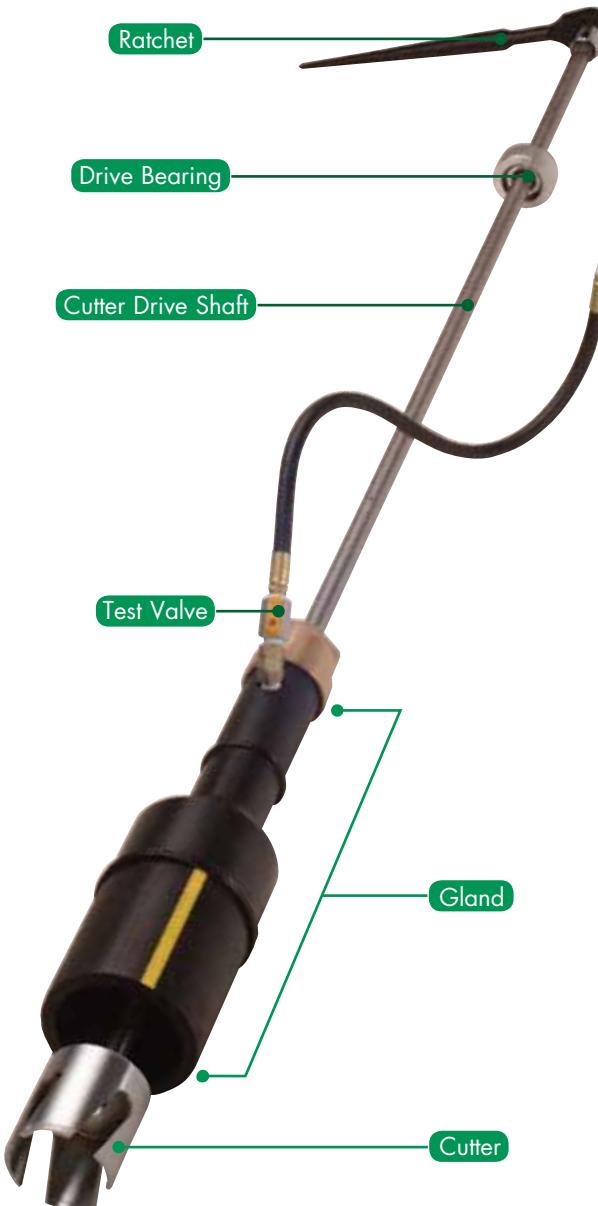


Part No.	Description
Service Line Test Caps	
TP-301	1/2" CTS Test Cap Assembly
TP-302	1/2" IPS Test Cap Assembly
TP-303	3/4" CTS Test Cap Assembly
TP-304	3/4" IPS Test Cap Assembly
TP-305	1" CTS Test Cap Assembly
TP-306	1" IPS Test Cap Assembly
TP-307	1-1/4" CTS Test Cap Assembly
TP-308	1-1/4" IPS Test Cap Assembly
TP-309	1-1/2" IPS Test Cap Assembly
TP-310	2" IPS Test Cap Assembly



Hot Tap Tool

Tapping Capability for 2" IPS – 6" IPS Branch Saddles



Hot Tap Tool

The McElroy Hot Tap Tool is the most precise and economical way to tap through **2", 3", 4" or 6" branch saddles**. This tool can be used with the 2LC, 2CU, Pit Bull® 14, Pit Bull® 26 or the 28CU fusion machines in combination with the Sidewinder®. The gland is customized to meet the user's material of choice, eliminating the need for material compatibility fusion in the field.

Main line contamination is eliminated by containing continuous chips in the cutter, ahead of the coupon, then retracting them out of the main. Tool components are butt fused together, eliminating the need for safety chains. The gland fitting of the tool includes a packing seal for safety, ensuring no leakage around the cutter drive shaft and a test valve. The McElroy Hot Tap Tool is long enough to meet or exceed ASTM standards for squeeze off dimensions or it can be used with a ball valve.

Part No.

Description

2" IPS Hot Tap Tool

Includes tool, ratchet wrench and storage case.	
220002	2" Hot Tap (Medium Density 2406)
220003	2" Hot Tap (High Density 3408)
221501	Spare Cutter 1.5" OD x 1.75" Long

3" IPS Hot Tap Tool

Includes tool, ratchet wrench and storage case.	
220106	3" Hot Tap (Medium Density 2406)
220107	3" Hot Tap (High Density 3408)
221601	Spare Cutter 2.25" OD x 2.25" Long

4" IPS Hot Tap Tool

Includes tool, ratchet wrench and storage case.	
220206	4" Hot Tap (Medium Density 2406)
220207	4" Hot Tap (High Density 3408)
221702	Spare Cutter 3" OD x 2.75" Long

6" IPS Hot Tap Tool

Includes tool, ratchet wrench and storage case.	
220302	6" Hot Tap (Medium Density 2406)
220303	6" Hot Tap (High Density 3408)
221902	Spare Cutter 4.44" OD x 3.25" Long

6" IPS Polyvalve Conversion Kit

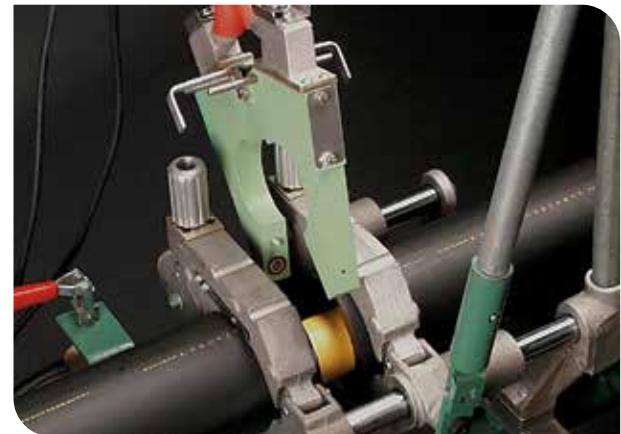
Converts a standard 6" Hot Tapping Tool to a 6" Polyvalve Hot Tap Tool. Kit includes 3" OD cutter.	
220305	6" Hot Tap Conversion Kit

NOTE Other materials available upon request.
Contact your McElroy representative.

Split Heaters

McElroy split heaters are used for fusing the outer pipe of a dual-containment system. Split heaters open enough to go around the inner pipe so that an outer pipe can be heated and fused. All heaters have durable anti-stick coatings.

Note: The first character of the heater name (i.e. 2 x 8) represents the maximum IPS size of the inner pipe for the heater application. The second character represents the maximum IPS size of the outer pipe. Outer pipe wall thickness is limited to a maximum of DR 11.



Heater	Model No.	Machine	Heater ID	Heater OD	Fuseable Sizes	Input	Output	Weight
Split Heaters								
	2 x 4	425601	14	3.188"	5.375"	(1 x 4), (2 x 4)	120V	800Watt
	2 x 8	829801	28	3.875"	8.625"	(2 x 5), (2 x 6)	120V	1574Watt
	3 x 8	829501	28	5.00"	10.25"	(2 x 6), (3 x 6), (2 x 7), (3 x 7), (2 x 8), (3 x 8)	120V	1754Watt
	4 x 8	829901	28/412 *	6.00"	10.25"	(2 x 8), (3 x 8), (4 x 8)	120V	1754Watt
	6 x 10	1238801	412/618 *	7.75"	12.5"	(4 x 10), (5 x 10), (6 x 10)	240V	2200Watt
	8 x 14	1239201	618	9.937"	14.75"	(6x12), (7x12), (6x14), (7x14), (8x12), (8x14)	240V	2800Watt

* Guide-rod bracket kits required for adaptation to this size machine. (4 x 8 Split Heater requires separate power supply if used in 412 fusion machine)

Part No.	Description
Guide Rod Bracket Adapter Kits	
A1239301	4 x 8 Split Heater to 412 Fusion Machine.
A1839301	6 x 10 Split Heater to 618 Fusion Machine.

Part No.	Description
Insulated Heater Sling	
SW08601	2 x 4 Heater Sling

Part No.	Description
Insulated Heater Stands	
821802	2 x 8, 3 x 8 and 4 x 8 Heater Stand
1234202	6 x 10 Heater Stand
1835102	8 x 14 Heater Stand

Stub End Holders

Stub End Holding Capability for 1-1/2" (38mm) to 21-1/8" (536mm) Flanges



Self-Centering Stub End Holders

McElroy's new Stub End Holders address a critical aspect of the fusion process – holding a stub end firmly in place while fusing it to a length of pipe. Now, McElroy has a stub end holder for 8", 12" and 18" jaws or inserts that allows you to tighten all four serrated jaws of the holder from a single adjustment point. During the tightening, the stub end holder self-centers automatically, creating a very efficient process that lets you fuse more and worry less.

Features

- Serrated jaws securely hold a stub end throughout the fusion process
- Improved gripping ability
- A single adjustment point adjusts all four stub end holder jaws simultaneously
- Automatically self-centers during tightening to hold the stub end concentric to the pipe

Self-Centering Stub End Holder Specifications

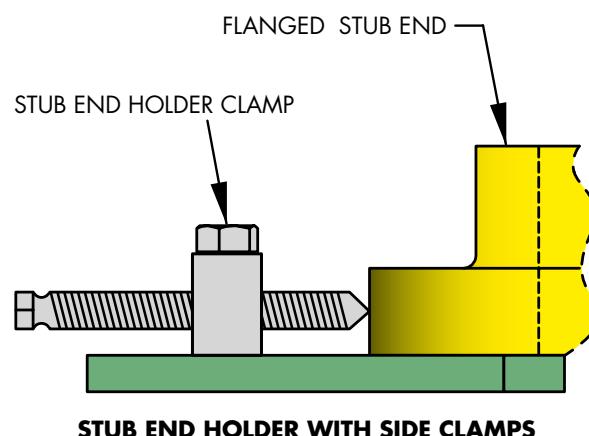
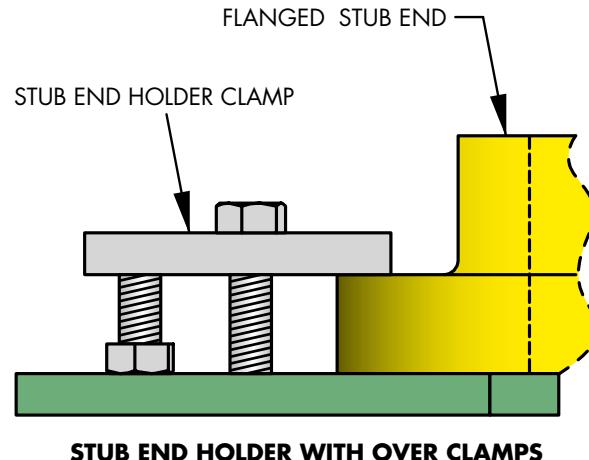
Part Number	Machine Size	Required Jaw Size	Range of Operation				Weight
			Minimum OD	Maximum OD	Minimum ID*	Maximum ID*	
885001	28/250	8" IPS	2.37" (60mm)	10.88" (276mm)	N/A	N/A	14.6 lbs. (6.6 kg)
1270101	412	12" IPS	4.50" (114mm)	16.02" (407mm)	10.78" (274mm)	17.21" (437mm)	20.4 lbs. (9.3 kg)
1879101	618/500	18" IPS	6.63" (148mm)	21.27" (540mm)	13.36" (339mm)	22.46" (570mm)	29.1 lbs. (13.2 kg)

* 12" and 18" Stub End Holders are capable of clamping on the inner diameter of the stub end to accommodate larger sizes



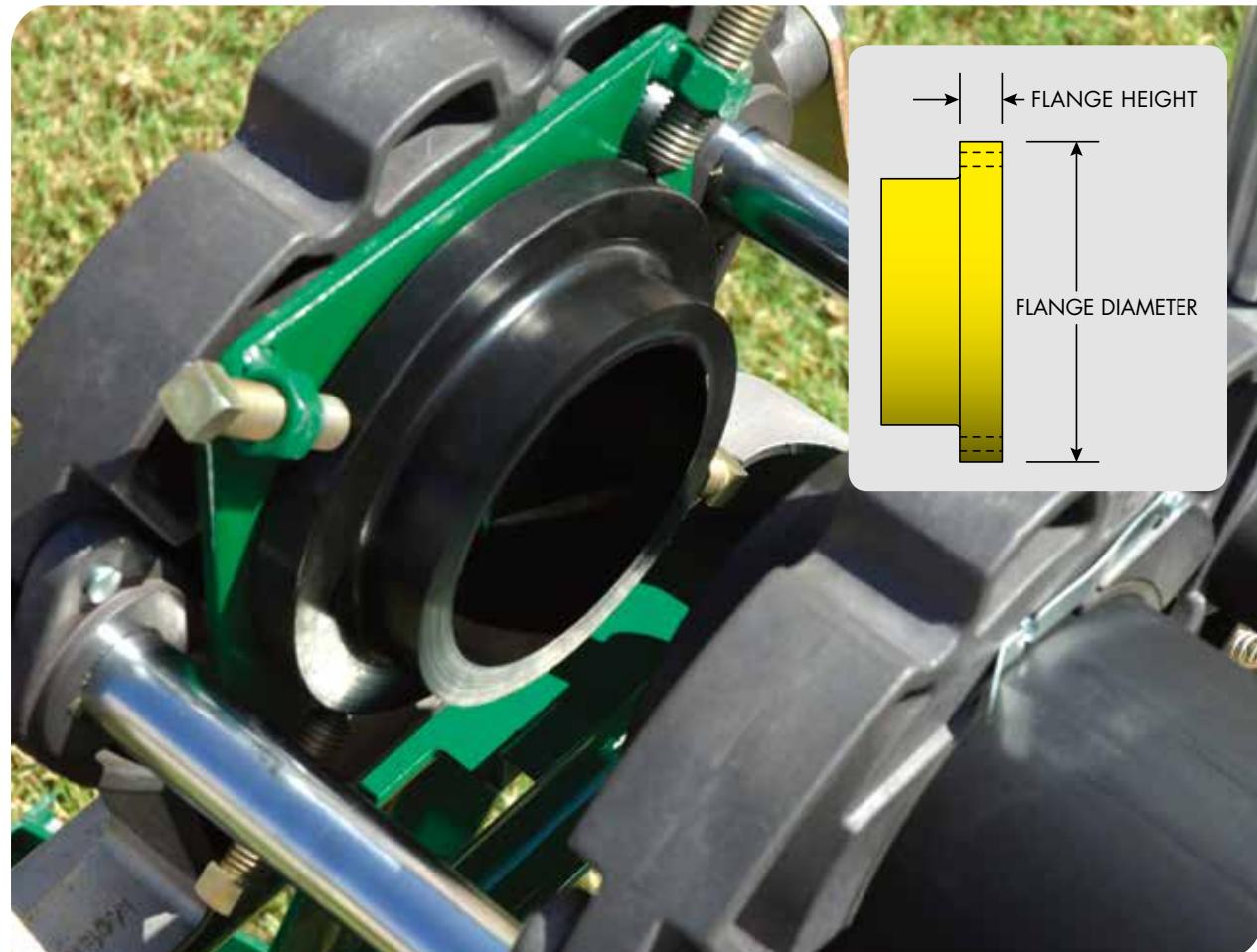
Manual Clamp Stub End Holders

Stub end holders are designed to hold various sizes of stub end fittings for fusion to the end of a pipe. To determine which stub end holder will be required for your stub end, use the chart shown. The chart lists the flange OD range and flange thickness ranges that are required. Your stub end dimensions must be within the ranges shown.



Manual Clamp Stub End Holder Specifications

Part Number	Machine Size	Min. Flange DIA.	Max Flange DIA	Min. Flange Height	Max. Flange Height
410601	14	1-1/2" (38mm)	7-19/32" (193mm)	no over clamps	no over clamps
2419501	824	7" (178mm)	26-1/4" (667mm)	1/4" (6.35mm)	3-3/8" (86mm)
3606901	1236	13-5/8" (346mm)	36-3/4" (933mm)	1/4" (6.35mm)	3-3/8" (86mm)
4812601	1648	16-5/8" (422mm)	49-1/4" (1251mm)	1/4" (6.35mm)	3-3/8" (86mm)
6315501	2065	21-1/8" (536mm)	68-7/8" (1749mm)	1-3/8" (35mm)	4-3/8" (111mm)



Accessories 2CU Sidewall Fusion Accessories

Main Size	Fitting Insert	Sidewall Insert	Line Pipe Bolster	Concave Heater Adptr	Convex Heater Adptr	Heater

CENTRAL, PERFORMANCE PIPE, JM EAGLE 2" IPS Outlet Branch Saddle (2-5/8" Dia Round Base, 2-3/8" Dia Outlet)

PERFORMANCE PIPE Butt Outlet Tapping Tee (2-5/8" Dia Large Round Base, 2-3/8" Dia Cap)

	2" IPS	Not Required ①	410213	413301	S210237288	S200237300	215505
	3" IPS	Not Required ①	410305	413302	S210350288	S200350300	215505
	4" IPS	Not Required ①	410405	413303	S210450288	S200450300	215505
	6" IPS	Not Required ①	821403	413306	S210662288	S200662300	215505
	8" IPS	Not Required ①	Not Required	Not Required	S210862288	S200862300	215505
	10" IPS ②	Not Required ①	Not Required	Not Required	S211075288	S201075300	215505
	12" IPS ②	Not Required ①	Not Required	Not Required	S211275288	S201275300	215505
	4" DIPS	Not Required ①	410411	413315	S210480288	S200480300	215505
	6" DIPS	Not Required ①	821405	413316	S210690288	S200690300	215505
	8" DIPS ②	Not Required ①	Not Required	Not Required	S210905288	S200905300	215505
	10" DIPS ②	Not Required ①	Not Required	Not Required	S211110288	S201110300	215505
	12" DIPS ②	Not Required ①	Not Required	Not Required	S211320288	S201320300	215505

CENTRAL, PERFORMANCE PIPE Socket Outlet Tapping Tee (2.5"x1.9" Rectangular Base, 2-1/2" Dia Cap)

JM EAGLE Socket Outlet Tapping Tee (Type1=2.5"x2.0" Rec Base, 2.03" Dia Cap, Type2=2.5"x1.9" Rec Base, 2.40" Dia Cap)

	1 1/4" IPS	*	410211	413304	S230166287	S200166300	215505
	1 1/2" IPS	*	410212	413305	S230190287	S200190300	215505
	2" IPS	*	410213	413301	S230237287	S200237300	215505
	3" IPS	*	410305	413302	S230350287	S200350300	215505
	4" IPS	*	410405	413303	S230450287	S200450300	215505
	6" IPS	*	821403	413306	S230662287	S200662300	215505
	8" IPS	*	Not Required	Not Required	S230862287	S200862300	215505
	10" IPS ②	*	Not Required	Not Required	S231075287	S201075300	215505
	12" IPS ②	*	Not Required	Not Required	S231275287	S201275300	215505
	4" DIPS	*	410411	413315	S230480287	S200480300	215505
	6" DIPS	*	821405	413316	S230690287	S200690300	215505
	8" DIPS ②	*	Not Required	Not Required	S230905287	S200905300	215505
	10" DIPS ②	*	Not Required	Not Required	S231110287	S201110300	215505
	12" DIPS ②	*	Not Required	Not Required	S231320287	S201320300	215505

* CENTRAL fittings with a stem dia. of 1.61" require 227402 — CENTRAL & Performance Pipe fittings with a stem dia. of 1.88" require 212302 — Performance Pipe fittings with a stem dia. of 1.68" require 212304

JM Eagle Type 2 fittings require 212306 Insert set to clamp on stem dia of 1.75" — JM Eagle Type 1 fittings require 213902 Insert set to clamp on cap dia of 2.03"

2CU Sidewall Fusion Accessories **Accessories**

Main Size	Fitting Insert	Sidewall Insert	Line Pipe Bolster	Concave Heater Adptr	Convex Heater Adptr	Heater
						

PERFORMANCE PIPE 1" Butt Outlet Tapping Tee (2" Dia Small Round Base, 2-3/8" Dia Cap)



1 1/4" IPS	Not Required	410211	413304	S210166237	S200166300	215505
1 1/2" IPS	Not Required	410212	413305	S210190237	S200190300	215505
2" IPS	Not Required	410213	413301	S210237237	S200237300	215505
3" IPS	Not Required	410305	413302	S210350237	S200350300	215505
4" IPS	Not Required	410405	413303	S210450237	S200450300	215505
6" IPS	Not Required	821403	413306	S210662237	S200662300	215505
8" IPS	Not Required		Not Required	S210862237	S200862300	215505
10" IPS ②	Not Required	Not Required	Not Required	S211075237	S201075300	215505
12" IPS ②	Not Required	Not Required	Not Required	S211275237	S201275300	215505

CENTRAL, PERFORMANCE PIPE, JM EAGLE Butt Outlet Service Saddles (2.5" x 1.9" Rectangular Base)



1 1/4" IPS	*	410211	413304	S230166287	S200166300	215505
1 1/2" IPS	*	410212	413305	S230190287	S200190300	215505
2" IPS	*	410213	413301	S230237287	S200237300	215505
3" IPS	*	410305	413302	S230350287	S200350300	215505
4" IPS	*	410405	413303	S230450287	S200450300	215505

* Use 207902 for 1/2" CTS Outlet — Use 208002 for 3/4" IPS Outlet — Use 208102 for 1" IPS Outlet — Use 207537 for 1-1/4" IPS Outlet

PERFORMANCE PIPE Butt Outlet Service Saddles (1.7" Dia Round Base)

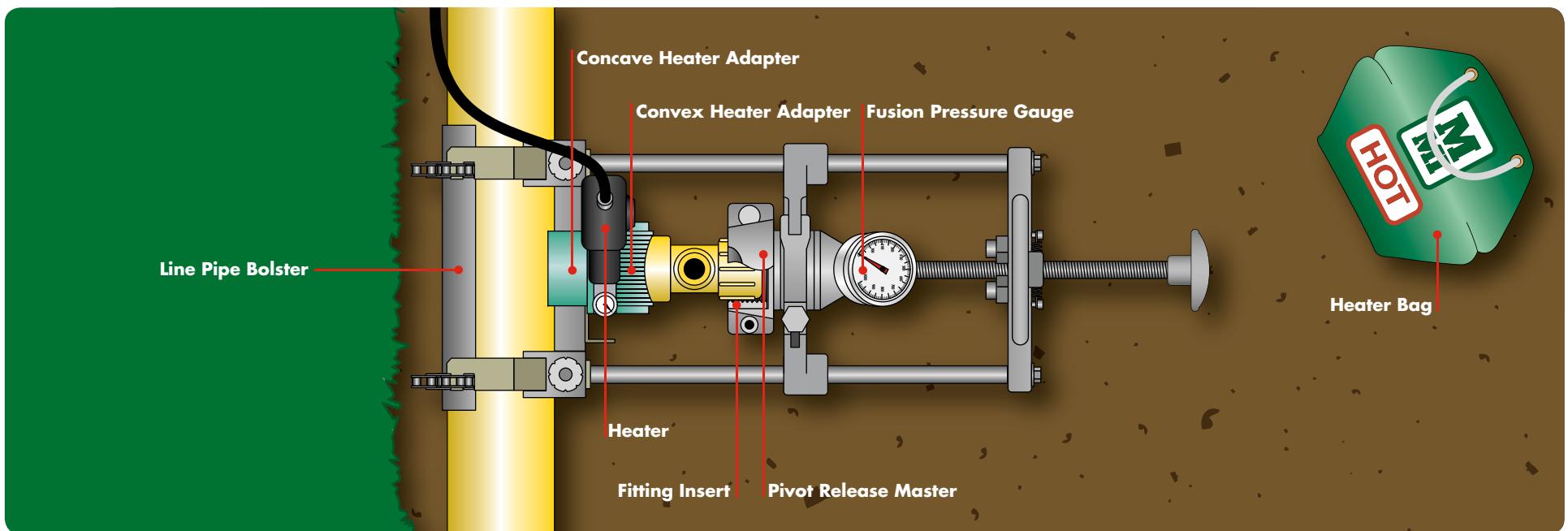


1 1/4" IPS	*	410211	413304	S210166212	S200166300	215505
1 1/2" IPS	*	410212	413305	S210190212	S200190300	215505
2" IPS	*	410213	413301	S210237212	S200237300	215505
3" IPS	*	410305	413302	S210350212	S200350300	215505
4" IPS	*	410405	413303	S210450212	S200450300	215505

* Use 208302 for 3/4" CTS Outlet — Use 208002 for 3/4" IPS Outlet — Use 208402 for 1" CTS Outlet — Use 208102 for 1" IPS Outlet

LEGEND: ① The 208102 Fitting Insert set may be used to clamp on stem of tapping tee instead of cap ② Requires (2) A213601 Tailstock Chain Assemblies.

Accessories Sidewinder® Sidewall Fusion Accessories



ACCESSORIES

Main Size	Jaw Clamp Only	Chain Clamp Only		Accessories for Jaw and Chain Clamp Machines			
	Line Pipe Insert	Sidewall Insert	Line Pipe Bolster	Fitting Insert	Concave Heater Adptr	Convex Heater Adptr	Heater
1 1/4" IPS							
1 1/2" IPS							
2" IPS							
3" IPS							
4" IPS	Not Required						
4" DIPS	N/A						
6" DIPS	N/A						
8" DIPS	N/A	Not Required	Not Required				
10" DIPS	N/A	Not Required	Not Required				

PERFORMANCE PIPE Butt Outlet Service Saddles (1.7" Dia Round Base)



1 1/4" IPS	SW09802 ③	410211	413304	* ①	S210166212	S200166300	214905
1 1/2" IPS	SW09902 ③	410212	413305	* ①	S210190212	S200190300	214905
2" IPS	SW10003	410213	413301	* ①	S210237212	S200237300	214905
3" IPS	SW10102	410305	413302	* ①	S210350212	S200350300	214905
4" IPS	Not Required	410405	413303	* ①	S210450212	S200450300	214905
4" DIPS	N/A	410411	413315	* ①	S210480212	S200480300	214905
6" DIPS	N/A	821405	413316	* ①	S210690212	S200690300	214905
8" DIPS	N/A	Not Required	Not Required	* ①	S210905212	S200905300	214905
10" DIPS	N/A	Not Required	Not Required	* ①	S211110212	S201110300	214905

* All require SW04901 (2" IPS Master Insert). — Use 208302 for 3/4" CTS Outlet — Use 208002 for 3/4" IPS Outlet — Use 208402 for 1" CTS Outlet — Use 208102 for 1" IPS Outlet

LEGEND: ① Also Requires SW04701 (3" IPS Pivot Release Master) included with Sidewinder package ② Chain Clamp Models Require (2) A213601 Tailstock Chain Assemblies

③ Requires SW10003 (2" IPS Master Insert).

Sidewinder® Sidewall Fusion Accessories Accessories

Main Size	Jaw Clamp Only	Chain Clamp Only	Accessories for Jaw and Chain Clamp Machines				
	Line Pipe Insert	Sidewall Insert	Line Pipe Bolster	Fitting Insert	Concave Heater Adptr	Convex Heater Adptr	Heater

CENTRAL, PERFORMANCE PIPE, JM EAGLE 2" IPS Outlet Branch Saddle (2-5/8" Dia Round Base, 2-3/8" Dia Outlet)

PERFORMANCE PIPE Butt Outlet Tapping Tee (2-5/8" Dia Large Round Base, 2-3/8" Dia Cap) & 1 1/4" IPS Butt Outlet Tapping Tee (2-5/8" Dia Large Round Base, 3-1/16" Dia Cap)

	2" IPS	SW10003	410213	413301	SW04901 * ①	S210237288	S200237300	214905
	3" IPS	SW10102	410305	413302	SW04901 * ①	S210350288	S200350300	214905
	4" IPS	Not Required	410405	413303	SW04901 * ①	S210450288	S200450300	214905
	6" IPS	N/A	821403	413306	SW04901 * ①	S210662288	S200662300	214905
	8" IPS	N/A	Not Required	Not Required	SW04901 * ①	S210862288	S200862300	214905
	10" IPS ②	N/A	Not Required	Not Required	SW04901 * ①	S211075288	S201075300	214905
	12" IPS ②	N/A	Not Required	Not Required	SW04901 * ①	S211275288	S201275300	214905
	4" DIPS	N/A	410411	413315	SW04901 * ①	S210480288	S200480300	214905
	6" DIPS	N/A	821405	413316	SW04901 * ①	S210690288	S200690300	214905
	8" DIPS ②	N/A	Not Required	Not Required	SW04901 * ①	S210905288	S200905300	214905
	10" DIPS ②	N/A	Not Required	Not Required	SW04901 * ①	S211110288	S201110300	214905
	12" DIPS ②	N/A	Not Required	Not Required	SW04901 * ①	S211320288	S201320300	214905

* Performance Pipe 1 1/4" IPS Butt Outlet Tapping Tee (Large Round Base) Requires SW04803 insert set instead of SW04901 insert set.

PERFORMANCE PIPE 1" Butt Outlet Tapping Tee (2" Dia Small Round Base, 2-3/8" Dia Cap)

	1 1/4" IPS	SW09802 ③	410211	413304	SW04901 ①	S210166237	S200166300	214905
	1 1/2" IPS	SW09902 ③	410212	413305	SW04901 ①	S210190237	S200190300	214905
	2" IPS	SW10003	410213	413301	SW04901 ①	S210237237	S200237300	214905
	3" IPS	SW10102	410305	413302	SW04901 ①	S210350237	S200350300	214905
	4" IPS	Not Required	410405	413303	SW04901 ①	S210450237	S200450300	214905
	6" IPS	N/A	821403	413306	SW04901 ①	S210662237	S200662300	214905
	8" IPS	N/A	Not Required	Not Required	SW04901 ①	S210862237	S200862300	214905
	10" IPS ②	N/A	Not Required	Not Required	SW04901 ①	S211075237	S201075300	214905
	12" IPS ②	N/A	Not Required	Not Required	SW04901 ①	S211275237	S201275300	214905

* All require SW04901 (2" IPS Master Insert).

LEGEND: ① Also Requires SW04701 (3" IPS Pivot Release Master) included with Sidewinder package ② Chain Clamp Models Require (2) A213601 Tailstock Chain Assemblies
 ③ Requires SW10003 (2" IPS Master Insert).

Accessories Sidewinder® Sidewall Fusion Accessories

Main Size	Jaw Clamp Only	Chain Clamp Only	Accessories for Jaw and Chain Clamp Machines				
Main Size	Line Pipe Insert	Sidewall Insert	Line Pipe Bolster	Fitting Insert	Concave Heater Adptr	Convex Heater Adptr	Heater

PERFORMANCE PIPE 2" IPS Butt Outlet Tapping Tee (2-7/8" Dia Round Base, 3-1/2" Dia Cap)



2" IPS	SW10003	410213	413301	①	S450237312	S420237500	424315
3" IPS	SW10102	410305	413302	①	S450350312	S420350500	424315
4" IPS	Not Required	410405	413303	①	S450450312	S420450500	424315
6" IPS	N/A	821403	413306	①	S450662312	S420662500	424315
8" IPS	N/A	Not Required	Not Required	①	S450862312	S420862500	424315
10" IPS ②	N/A	Not Required	Not Required	①	S451075312	S421075500	424315
12" IPS ②	N/A	Not Required	Not Required	①	S451275312	S421275500	424315
4" DIPS	N/A	410411	413315	①	S450480312	S420480500	424315
6" DIPS	N/A	821405	413316	①	S450690312	S420690500	424315
8" DIPS ②	N/A	Not Required	Not Required	①	S450905312	S420905500	424315
10" DIPS ②	N/A	Not Required	Not Required	①	S451110312	S421110500	424315
12" DIPS ②	N/A	Not Required	Not Required	①	S451320312	S421320500	424315

PERFORMANCE PIPE 2" IPS Butt Outlet Tapping Tee (3-3/4" Dia Large Round Base, 3-1/2" Dia Cap)



2" IPS	SW10003	410213	413301	①	S450237426	S420237500	424315
3" IPS	SW10102	410305	413302	①	S450350426	S420350500	424315
4" IPS	Not Required	410405	413303	①	S450450426	S420450500	424315
6" IPS	N/A	821403	413306	①	S450662426	S420662500	424315
8" IPS	N/A	Not Required	Not Required	①	S450862426	S420862500	424315
10" IPS ②	N/A	Not Required	Not Required	①	S451075426	S421075500	424315
12" IPS ②	N/A	Not Required	Not Required	①	S451275426	S421275500	424315
4" DIPS	N/A	410411	413315	①	S450480426	S420480500	424315
6" DIPS	N/A	821405	413316	①	S450690426	S420690500	424315
8" DIPS ②	N/A	Not Required	Not Required	①	S450905426	S420905500	424315
10" DIPS ②	N/A	Not Required	Not Required	①	S451110426	S421110500	424315
12" DIPS ②	N/A	Not Required	Not Required	①	S451320426	S421320500	424315

NOTE: Some adapters may extend past the heater body. Does not affect operation.

LEGEND: ① No additional inserts needed. Requires SW04701 [3" IPS Pivot Release Master] included with Sidewinder package ② Chain Clamp Models Require (2) A213601 Tailstock Chain Assemblies
 ③ Requires SW10003 [2" IPS Master Insert].

Sidewinder® Sidewall Fusion Accessories Accessories

Main Size	Jaw Clamp Only	Chain Clamp Only	Accessories for Jaw and Chain Clamp Machines				
Main Size	Line Pipe Insert	Sidewall Insert	Line Pipe Bolster	Fitting Insert	Concave Heater Adptr	Convex Heater Adptr	Heater

CENTRAL, PERFORMANCE PIPE, JM EAGLE 3" IPS Outlet Branch Saddle (3-7/8" Dia Round Base, 3-1/2" Dia Outlet)



4" IPS	Not Required	410405	413303	①	S450450426	S420450500	424315
6" IPS	N/A	821403	413306	①	S450662426	S420662500	424315
8" IPS	N/A	Not Required	Not Required	①	S450862426	S420862500	424315
10" IPS ②	N/A	Not Required	Not Required	①	S451075426	S421075500	424315
12" IPS ②	N/A	Not Required	Not Required	①	S451275426	S421275500	424315
4" DIPS	N/A	410411	413315	①	S450480426	S420480500	424315
6" DIPS	N/A	821405	413316	①	S450690426	S420690500	424315
8" DIPS ②	N/A	Not Required	Not Required	①	S450905426	S420905500	424315
10" DIPS ②	N/A	Not Required	Not Required	①	S451110426	S421110500	424315
12" DIPS ②	N/A	Not Required	Not Required	①	S451320426	S421320500	424315

PERFORMANCE PIPE 3" IPS Outlet Branch Saddle (4-1/2" Dia Round Base, 3-1/2" Dia Outlet)



4" IPS	Not Required	410405	413303	①	S450450550	S440450550	424315
6" IPS	N/A	821403	413306	①	S450662550	S440662550	424315
8" IPS	N/A	Not Required	Not Required	①	S450862550	S440862550	424315
10" IPS ②	N/A	Not Required	Not Required	①	S451075550	S441075550	424315
12" IPS ②	N/A	Not Required	Not Required	①	S451275550	S441275550	424315

CENTRAL, PERFORMANCE PIPE, JM EAGLE 4" IPS Outlet Branch Saddle (4-3/4" Dia Round Base, 4-1/2" Dia Outlet)



6" IPS	N/A	821403	413306	SW07301	S450662550	S440662550	424315
8" IPS	N/A	Not Required	Not Required	SW07301	S450862550	S440862550	424315
10" IPS ②	N/A	Not Required	Not Required	SW07301	S451075550	S441075550	424315
12" IPS ②	N/A	Not Required	Not Required	SW07301	S451275550	S441275550	424315

CENTRAL, PERFORMANCE PIPE, JM EAGLE Butt Outlet Service Saddles (2.5" x 1.9" Rectangular Base)



1 1/4" IPS	SW09802 ③	410211	413304	* ①	S230166287	S200166300	214905
1 1/2" IPS	SW09902 ③	410212	413305	* ①	S230190287	S200190300	214905
2" IPS	SW10003	410213	413301	* ①	S230237287	S200237300	214905
3" IPS	SW10102	410305	413302	* ①	S230350287	S200350300	214905
4" IPS	Not Required	410405	413303	* ①	S230450287	S200450300	214905

* All require SW04901 (2" IPS Master Insert). — Use 207537 for 1-1/4" IPS Outlet — Use 208002 for 3/4" IPS Outlet — Use 208102 for 1" IPS Outlet — Use 207902 for 1/2" CTS Outlet

LEGEND: ① No additional inserts needed. Requires SW04701 (3" IPS Pivot Release Master) included with Sidewinder package ② Chain Clamp Models Require (2) A213601 Tailstock Chain Assemblies ③ Requires SW10003 (2" IPS Master Insert).

Accessories Sidewinder® Sidewall Fusion Accessories

Main Size	Jaw Clamp Only	Chain Clamp Only	Accessories for Jaw and Chain Clamp Machines				
Main Size	Line Pipe Insert	Sidewall Insert	Line Pipe Bolster	Fitting Insert	Concave Heater Adptr	Convex Heater Adptr	Heater

CENTRAL, PERFORMANCE PIPE Socket Outlet Tapping Tee (2.5"x1.9" Rectangular Base, 2-1/2" Dia Cap)

JM EAGLE Socket Outlet Tapping Tee (Type1=2.5"x2.0" Rec Base, 2.03" Dia Cap, Type2=2.5"x1.9" Rec Base, 2.40" Dia Cap)

	1 1/4" IPS	SW09802 ③	410211	413304	SW06101 * ①	S230166287	S200166300	214905
	1 1/2" IPS	SW09902 ③	410212	413305	SW06101 * ①	S230190287	S200190300	214905
	2" IPS	SW10003	410213	413301	SW06101 * ①	S230237287	S200237300	214905
	3" IPS	SW10102	410305	413302	SW06101 * ①	S230350287	S200350300	214905
	4" IPS	Not Required	410405	413303	SW06101 * ①	S230450287	S200450300	214905
	6" IPS	N/A	821403	413306	SW06101 * ①	S230662287	S200662300	214905
	8" IPS	N/A	Not Required	Not Required	SW06101 * ①	S230862287	S200862300	214905
	10" IPS ②	N/A	Not Required	Not Required	SW06101 * ①	S231075287	S201075300	214905
	12" IPS ②	N/A	Not Required	Not Required	SW06101 * ①	S231275287	S201275300	214905
	4" DIPS	N/A	410411	413315	SW06101 * ①	S230480287	S200480300	214905
	6" DIPS	N/A	821405	413316	SW06101 * ①	S230690287	S200690300	214905
	8" DIPS ②	N/A	Not Required	Not Required	SW06101 * ①	S230905287	S200905300	214905
	10" DIPS ②	N/A	Not Required	Not Required	SW06101 * ①	S231110287	S201110300	214905
	12" DIPS ②	N/A	Not Required	Not Required	SW06101 * ①	S231320287	S201320300	214905

* JM Eagle Type 1 requires SW06001 insert set instead of SW06101 insert set.

PERFORMANCE PIPE, JM EAGLE 2" IPS Butt Outlet Tapping Tee (4.20" x 4.34" Rectangular Base, 3-1/2" Dia Cap)

PERFORMANCE PIPE, JM EAGLE 2" IPS Butt Outlet Branch Saddle (4.20" x 4.34" Rectangular Base, 2-3/8" Dia Outlet)

	2" IPS	SW10003	410213	413301	* ①	S430237462	S420237500	424315
	3" IPS	SW10102	410305	413302	* ①	S430350462S	S420350500	424315
	4" IPS	Not Required	410405	413303	* ①	S430450462S	S420450500	424315
	6" IPS	N/A	821403	413306	* ①	S430662462	S420662500	424315
	8" IPS	N/A	Not Required	Not Required	* ①	S430862462	S420862500	424315
	10" IPS ②	N/A	Not Required	Not Required	* ①	S431075462	S421075500	424315
	12" IPS ②	N/A	Not Required	Not Required	* ①	S431275462	S421275500	424315
	4" DIPS	N/A	410411	413315	* ①	S430480462	S420480500	424315
	6" DIPS	N/A	821405	413316	* ①	S430690462	S420690500	424315
	8" DIPS ②	N/A	Not Required	Not Required	* ①	S430905462	S420905500	424315
	10" DIPS ②	N/A	Not Required	Not Required	* ①	S431110462	S421110500	424315
	12" DIPS ②	N/A	Not Required	Not Required	* ①	S431320462	S421320500	424315

* 2" IPS Butt Outlet Branch Saddles Require SW04901 (2" IPS Master Insert). — Performance Pipe recommends Bolster 411002 for their 2" IPS rectangular base, branch saddles.

LEGEND: ① Also Requires SW04701 (3" IPS Pivot Release Master) included with Sidewinder package ② Chain Clamp Models Require (2) A213601 Tailstock Chain Assemblies
 ③ Requires SW10003 (2" IPS Master Insert).

28 & 250 Sidewall Fusion Accessories

Sidewall Fusion Accessories

Part No.	Description
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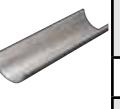
Saddle Fusion Heater

	826803	Adjustable thermoswitch to control temperature. Does not include heater blanket.
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Sidewall Heater Blanket

	826903	Protects and helps maintain a constant heater temperature.
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Line Pipe Bolster

	Supports and re-rounds main for saddle fusion. Required for 6" IPS - 8" IPS mains.
413306	6" IPS
413316	6" DIPS
827801	8" IPS

Sidewall Clamping Insert Sets

	Helps re-round 18" OD mains and smaller.
821403	6" IPS
821405	6" DIPS
835812	8" IPS
835813	10" IPS
835814	12" IPS
835815	14" OD
835816	16" OD
835817	18" OD

Sidewall Fusion Heater Adapters

Main Size	Concave Adapter	Convex Adapter
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PERFORMANCE PIPE, INDEPENDENT PIPE

4" DIPS Butt Outlet Branch Saddles (6-5/8" Round Base, 4.80" Dia Outlet)

6" DIPS	S710690700	S700690700
8" DIPS ①	S710905700	S700905700
10" DIPS ①	S711110700	S701110700
12" DIPS ①	S711320700	S701320700
16" DIPS ①	S711740700	S701740700
18" DIPS ①	S711950700	S701950700
20" DIPS ②	S712160700	S702160700
24" DIPS ②	S712580700	S702580700

PERFORMANCE PIPE, INDEPENDENT PIPE

6" DIPS Butt Outlet Branch Saddles (8-5/8" Round Base, 6.90" Dia Outlet)

12" DIPS ①	S8113200900	S8013200900
16" DIPS ①	S8117400900	S8017400900
18" DIPS ①	S8119500900	S8019500900
20" DIPS ②	S8121600900	S8021600900
24" DIPS ②	S8125800900	S8025800900

CENTRAL, PERFORMANCE PIPE, INDEPENDENT PIPE

8" IPS Butt Outlet Branch Saddles (9.41" Round Base, 8-5/8" Dia Outlet)

10" IPS ①	S8110750975	S8010750975
12" IPS ①	S8112750975	S8012750975
14" OD ①	S8114000975	S8014000975
16" OD ①	S8116000975	S8016000975
18" OD ①	S8118000975	S8018000975
20" OD ①	S8120000975	S8020000975
24" OD ②	S8124000975	S8024000975
36" OD ③	S8136000975	S8036000975
42" OD ④	S8142000975	S8042000975

Sidewall Fusion Heater Adapters

Main Size	Fitting Insert	Sidewall Insert
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PERFORMANCE PIPE, INDEPENDENT PIPE

6" IPS Butt Outlet Branch Saddles (7" Round Base, 6-5/8" Dia. Outlet)

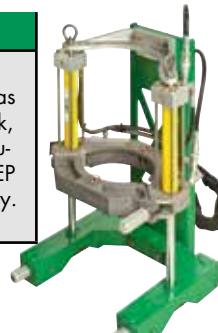
8" IPS	S710862775	S700862775
10" IPS ①	S711075775	S701075775
12" IPS ①	S711275775	S701275775
14" OD ①	S711400775	S701400775
16" OD ①	S711600775	S701600775
18" OD ①	S711800775	S701800775
20" OD ①	S712000775	S702000775
22" OD ②	S712200775	S702200775
24" OD ②	S712400775	S702400775
26" OD ②	S712600775	S702600775
28" OD ②	S712800775	S702800775
30" OD ②	S713000775	S703000775
32" OD ③	S713200775	S703200775
36" OD ③	S713600775	S703600775
42" OD ④	S714200775	S704200775
48" OD ④	S714800775	S704800775

DynaMc® 28 Sidewall Fusion Machine

Model No.

898101	The same saddle fusion sizes as 28CU with 1 jaw and tailstock, but offers a lighter weight solution. Heater, heater adapter, EP HPU and inserts sold separately.
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See page 32 for more information.



LEGEND: ① Requires (2) A213601 Tailstock Chain Assemblies. ② Requires (4) A213601 Tailstock Chain Assemblies. ③ Requires (6) A213601 Tailstock Chain Assemblies.
 ④ Requires (8) A213601 Tailstock Chain Assemblies.

Accessories 28 & 250 Sidewall Fusion Accessories

Metric Sidewall Fusion Heater Adapters

Main Size	Concave Adapter	Convex Adapter	Maximum Fitting OD	Minimum Fitting ID
				
280mm	S451102550	S441102550	5"	1.41"
450mm	S451771550	S441771550		
200mm	S710787600	S700787600		
225mm	S710886600	S700886600		
250mm	S710984600	S700984600		
280mm	S711102600	S701102600		
315mm	S711240600	S701240600		
355mm	S711398600	S701398600		
400mm	S711575600	S701575600		
450mm	S711772600	S701772600		
560mm	S712205600	S702205600		
630mm	S712480600	S702480600		
710mm	S712795600	S702795600		
800mm	S713150600	S703150600		
1000mm	S713937600	S703937600		
1200mm	S714724775	S704724775	7.34"	4"
355mm	S8113980975-350	S8013980975-350	9.25"	4"
450mm	S8117720975-350	S8017720975-350		
225mm	S8108860850	S8008860850		
280mm	S8111020850	S8011020850		
315mm	S8112400850	S8012400850		
355mm	S8113980850	S8013980850		
400mm	S8115750850	S8015750850		
450mm	S8117720850	S8017720850		
500mm	S8119690850	S8019690850		
560mm	S8122050850	S8022050850		
630mm	S8124800850	S8024800850		
710mm	S8127950850	S8027950850		
800mm	S8131500850	S8031500850		
1000m	S8139370850	S8039370850		
315mm	S8112400900	S8012400900	8.62"	4.5"
500mm	S8119690975	S8019690975	9.25"	6.25"

JIS Insert Sizes Accessories

2LC & 2CU Fusion Capability for 25mm - 50mm JIS

All inserts below fit in 2" Jaw

JIS Inserts	Pipe OD	Set No.
40 mm	48 mm (1.89")	207548
30 mm	42 mm (1.65")	207549
25 mm	34 mm (1.34")	207550

Pit Bull® 14 Fusion Capability for 25mm - 100mm JIS

All inserts below fit in 4" Master

JIS Inserts	Pipe OD	Set No.
100 mm (4") Master	114 mm (4.49")	Inc. w/pkg
75 mm	89 mm (3.50")	410112
50 mm (2") Master	60 mm (2.36")	410034

All inserts below require 2" Master

40 mm	48 mm (1.89")	207548
30 mm	42 mm (1.65")	207549
25 mm	34 mm (1.34")	207550

Pit Bull® 26 Fusion Capability for 50mm - 150mm JIS

All inserts below require 6" Master

150 mm	165 mm (6.50")	809426
125 mm	140 mm (5.51")	809431
100 mm	114 mm (4.49")	809408
75 mm	89 mm (3.50")	809321
50 mm	60 mm (2.36")	809214

250 Fusion Capability for 50mm - 200mm JIS

All inserts below fit in 8" Master

JIS Inserts	Pipe OD	Set No.
8" IPS	219 mm (8.63")	T2503504
200 mm	216 mm (8.50")	801528
175 mm	190 mm (7.48")	801546
6" Master	168 mm (6.63")	801510

All inserts below require 6" Master

150 mm	165 mm (6.50")	809426
125 mm	140 mm (5.51")	809431
100 mm	114 mm (4.49")	809408
75 mm	89 mm (3.50")	809321
50 mm	60 mm (2.36")	809214

412 Fusion Capability for 100mm - 250mm JIS

All inserts below fit in 12" Master

JIS Inserts	Pipe OD	Set No.
12" Master	324 mm (12.75")	Inc. w/pkg
250 mm	267 mm (10.51")	1207228
200 mm	216 mm (8.50")	1207226
175 mm	190 mm (7.48")	1207040
6" Master	168 mm (6.63")	1207007

All inserts below require 6" Master

150 mm	165 mm (6.50")	809426
125 mm	140 mm (5.51")	809431
100 mm	114 mm (4.49")	809408

618 Fusion Capability for 175mm - 400mm JIS

All inserts below fit in 618 Jaws

JIS Inserts	Pipe OD	Set No.
400 mm	420 mm (16.54")	2412120
350 mm	370 mm (14.57")	2412224
12" Master	324 mm (12.75")	2411810
300 mm	318 mm (12.52")	2411829

All inserts below require 12" Master

250 mm	267 mm (10.51")	1207228
200 mm	216 mm (8.50")	1207226
175 mm	190 mm (7.48")	1207040

TracStar® 500 Fusion Capability for 175mm - 400mm JIS

All inserts below fit in 18" Master

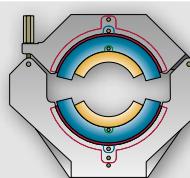
JIS Inserts	Pipe OD	Set No.
18" Master	457 mm (18.00")	Inc. w/pkg
400 mm	420 mm (16.54")	2412120
350 mm	370 mm (14.57")	2412224
12" Master	324 mm (12.75")	2411810
300 mm	318 mm (12.52")	2411829

All inserts below require 12" Master

250 mm	267 mm (10.51")	1207228
200 mm	216 mm (8.50")	1207226
175 mm	190 mm (7.48")	1207040

Fusion Inserts

All inserts are surface-hardened for longer life and are serrated for maximum grip on the pipe. Not all inserts fit directly in the jaws. Some inserts nest inside other inserts, called master inserts. See graphic on the right for an example.



NOTE: Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs.

Accessories For McElroy Fusion Equipment

Shears for Plastic Pipe



Part No.	Description
----------	-------------

MMD00009	1.7" OD Capacity
MMD00008	2.4" OD Capacity

Replacement Blades for Shears

MMD00015	Replacement Blades for MMD00009
MMD00017	Replacement Blades for MMD00008

Guillotine Cutter for Plastic Pipe



Part No.	Description
----------	-------------

MMD00051	For 2" to 4" IPS (63mm - 125mm)
MMD00036	For 3" to 8" IPS (90mm - 225mm)

Replacement Blades

MMD00052	Replacement Blades for MMD00051
MMD00037	Replacement Blades for MMD00036

Tube Cutter for Plastic Pipe



MMD00001	For 1/4" to 2-5/8 OD Capacity
MMD00002	For 1-7/8" to 4-1/2" OD Capacity
MMD00040	For 4" to 6-5/8 OD Capacity
MMD00092	For 2" IPS to 4" DIPS Capacity

Replacement Blades for Shears

MMD00005	Replacement Wheel for MMD00001
MMD00006	Replacement Wheel for MMD00002
MMD00039	Replacement Wheel for MMD00040
MMD00093	Replacement Wheel for MMD00092

McElroy Spreader Bars



Ideal for handling 40' bundles or a single joint of pipe. Nylon lifting straps fasten securely to spreader bar to prevent bundle breakage and damage to the pipe.	
8261000-0101	3,000 lbs Maximum
8261000-0201	6,000 lbs Maximum

External Bead Remover



1221101	For 1 1/4" to 6" IPS Pipe
1810102	For 4" IPS to 18" OD Pipe

Replacement Blades

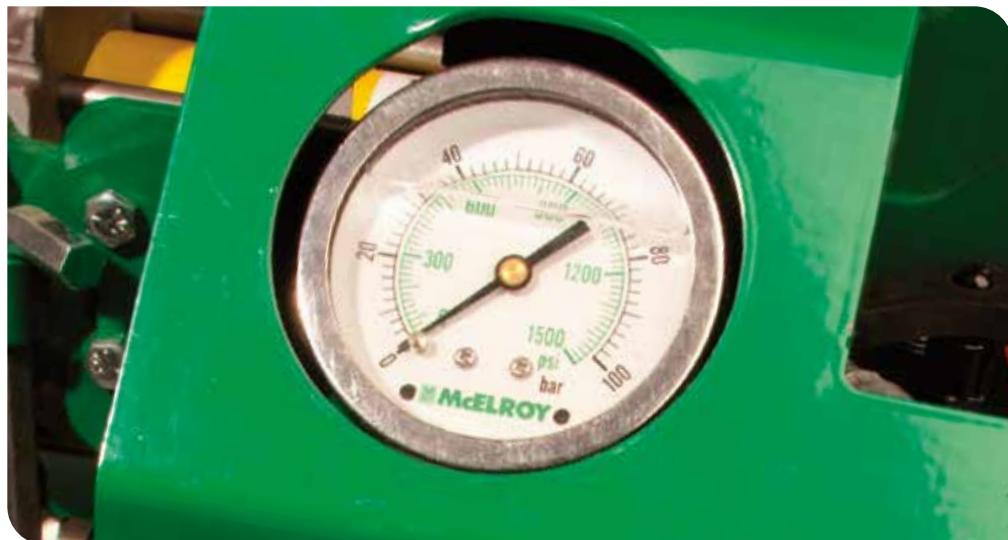
1221601	Replacement Blades for 1221101
1221603	Replacement Blades for 1810102

Pyrometer



A218804	Measures surface temperature of heater.
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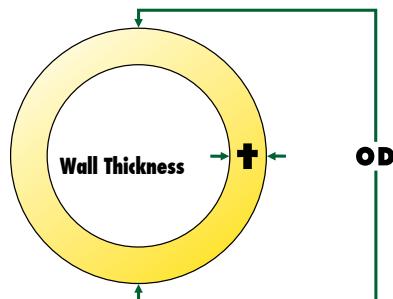
Determining Fusion Gauge Pressure Reference



Formula: Wall Thickness

$$t = \text{Formula} \frac{OD}{DR} =$$

$$t = \text{Example} \frac{8.625''}{11} = .784$$



Gauge Pressure

$$\text{Formula} \quad \frac{(OD - t) \times t \times 3.1416 \times IFP}{TEPA \text{ (chosen from table)}} + \text{Drag} = \text{Gauge Pressure}$$

$$\text{Example} \quad \frac{(8.625 - .784) \times .784 \times 3.1416 \times 75}{4.710} + 30 \text{ PSI} = 338 \text{ PSI}$$

Total Effective Piston Area of Machines (TEPA) in Square Inches (in²)

MACHINE	High Force	Medium Force	Low Force
28	4.71	3.24	1.66
250	4.71	3.24	1.66
412	11.78	6.01	3.14
618	11.78	6.01	3.14
500	N/A	6.01	3.14
824/TracStar® 630	29.44	15.32	9.45
1236/TracStar® 900	29.44	15.32	9.45
1648	31.42	14.14	N/A
2065	31.42	N/A	N/A
1600	31.42	14.14	N/A

Variable Definitions:

OD	Outside Diameter (inches)
t	Wall Thickness (inches)
π	3.1416
DR	Dimensional Ratio
IFP	Manufacturers Recommended Interfacial Pressure (PSI)
TEPA	Total Effective Piston Area - chosen from table (in ²)
Drag	Pressure Required To Move Pipe (PSI)

Example:

For this example we will use a 28 Fusion Machine

Pipe Size	8" IPS
OD of Pipe	8.625
DR of Pipe	DR 11
Recommended Interfacial Pressure	75 PSI
Measured Drag	30 PSI

Reference Fusion Pressure Calculators

McCalc® Fusion Pressure Calculator

for iOS and Android devices

The McCalc® Fusion Pressure Calculator is designed to help you quickly find the correct fusion pressure for your job.



To properly heat-fuse polyethylene pipe, the fusion pressure must be adjusted so the pipe manufacturer's recommended interfacial pressure is achieved.

McCalc takes the guesswork out of pipe fusion. By selecting your McElroy fusion machine and entering your pipe size and pressure requirements, the recommended theoretical gauge pressure is calculated.

Features

- Easy selection of any of McElroy's hydraulic fusion machines.
- Selection from multiple international standards for pipe fusion.
- Pipe size entry in IPS, DIPS, O.D., ISO, or JIS units.
- Wall thickness entry using the pipe's dimensional ratio or actual wall thickness.
- Interfacial pressure and drag pressure entry in units of psi, bar, kg/cm², or MPa.
- Multiple-language support including English, Spanish, and Portuguese.

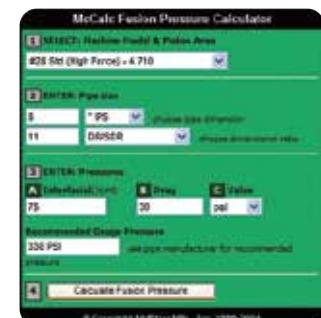
To download go to:
www.mcelroy.com/fusion/calculate.htm

The screenshot shows the McCalc Fusion Pressure Calculator app interface. At the top, it says "Carrier" and has a Wi-Fi signal icon. Below that is the title "McCalc Fusion Calculator". There are five main input fields with arrows to expand them: "Machine" (TracStar No.412 HF), "Piston Area" (11.780), "Specification" (ASTM F2620-11), "Pipe Size" (12 inch IPS), and "Wall Thickness" (11 DR/SDR). Below these is a section for "Interfacial Pressure" (75 psi) and "Drag Pressure" (50 psi). At the bottom is a "Calculate" button, followed by a summary of results: Bead-up: 319psi, Heat Soak: 50psi 0:05:12, Min. Bead: 1/4", Fuse/Cool: 319psi 0:12:44, Open/Close: 0:00:15, and Heater: 400-450°F. The footer says "© 2012 McElroy Manufacturing, Inc."

McCalc Fusion Pressure Calculator Online

If you have access to the web then check out the McCalc. It is an online fusion calculator that will automatically determine the proper fusion gauge pressure based on pipe size, dimensional ratio, machine type and pipe manufacturers' recommended interfacial pressure.

To use the Web version of McCalc go to:
www.mcelroy.com/fusion/calculate.htm



Fusion Pressure Calculator

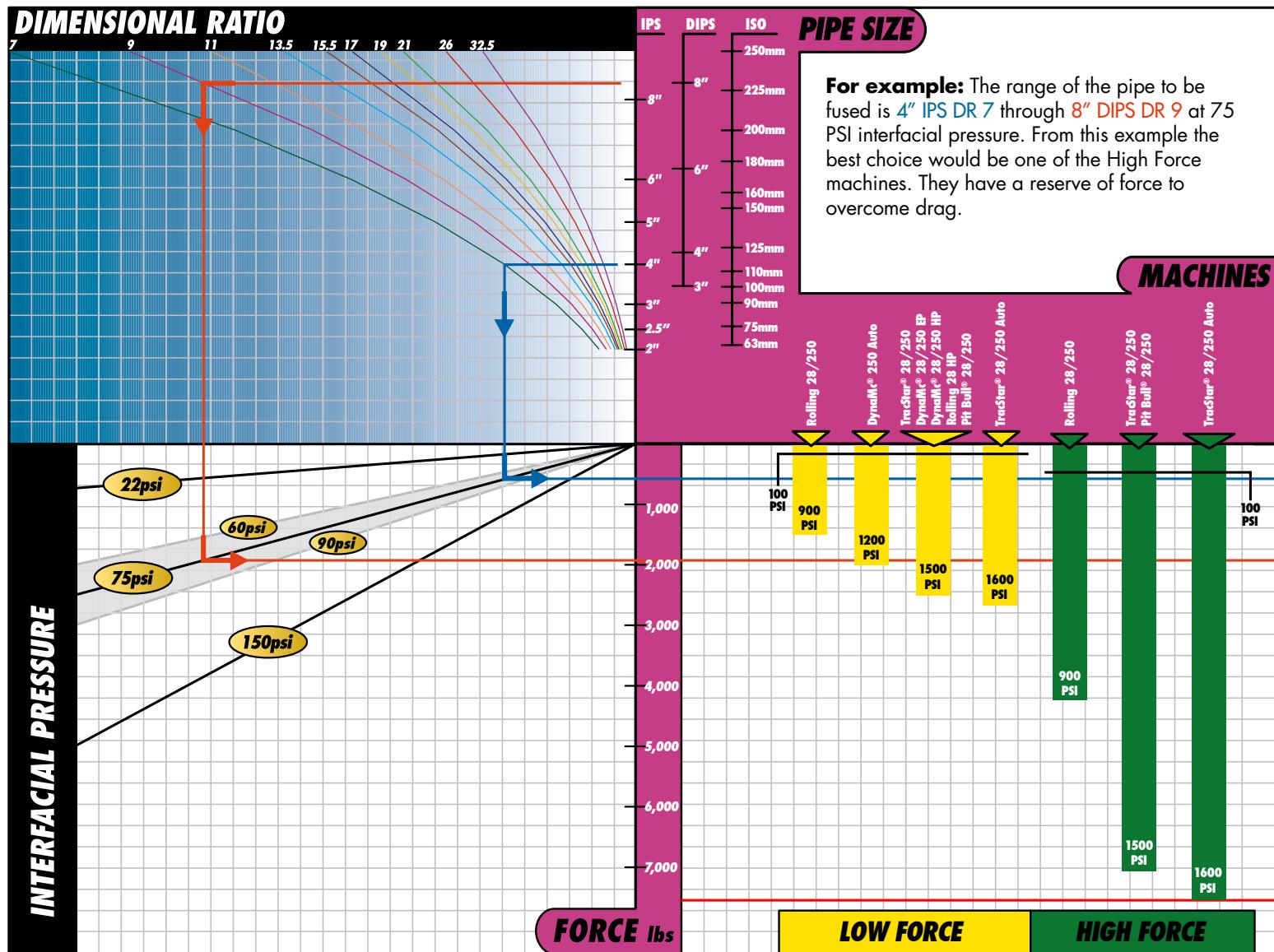
With the aid of McElroy's fusion pressure calculator, determining the proper fusion gauge pressure is easy without any math or complicated equations. To properly fuse pipe, the fusion pressure must be adjusted so that the pipe manufacturer's recommended interfacial pressure is achieved. Using the fusion pressure calculator, this process is as easy as matching the pipe size to its corresponding dimensional ratio, and matching your fusion machine to the pipe manufacturer's recommended interfacial pressure. It's that easy!

To request a sliding fusion pressure calculator, visit: www.mcelroy.com/fusion/fusecalc.htm

28/250 Cylinder Force Reference

This graph will aid in the selection of the correct fusion machine cylinder force option. First, select the range of pipe and DR to be fused in the machine (largest pipe – smallest DR and smallest pipe – highest DR). Second, select the type of pipe to be fused. The pipe type will determine the correct interfacial pressure to use. Your pipe manufacturer can help you with this number. Third, use the graph to determine which machine is best suited for the task. You can derive from the graph, that when using high interfacial pressures, the best choice is a High Force machine. When fusing at low interfacial

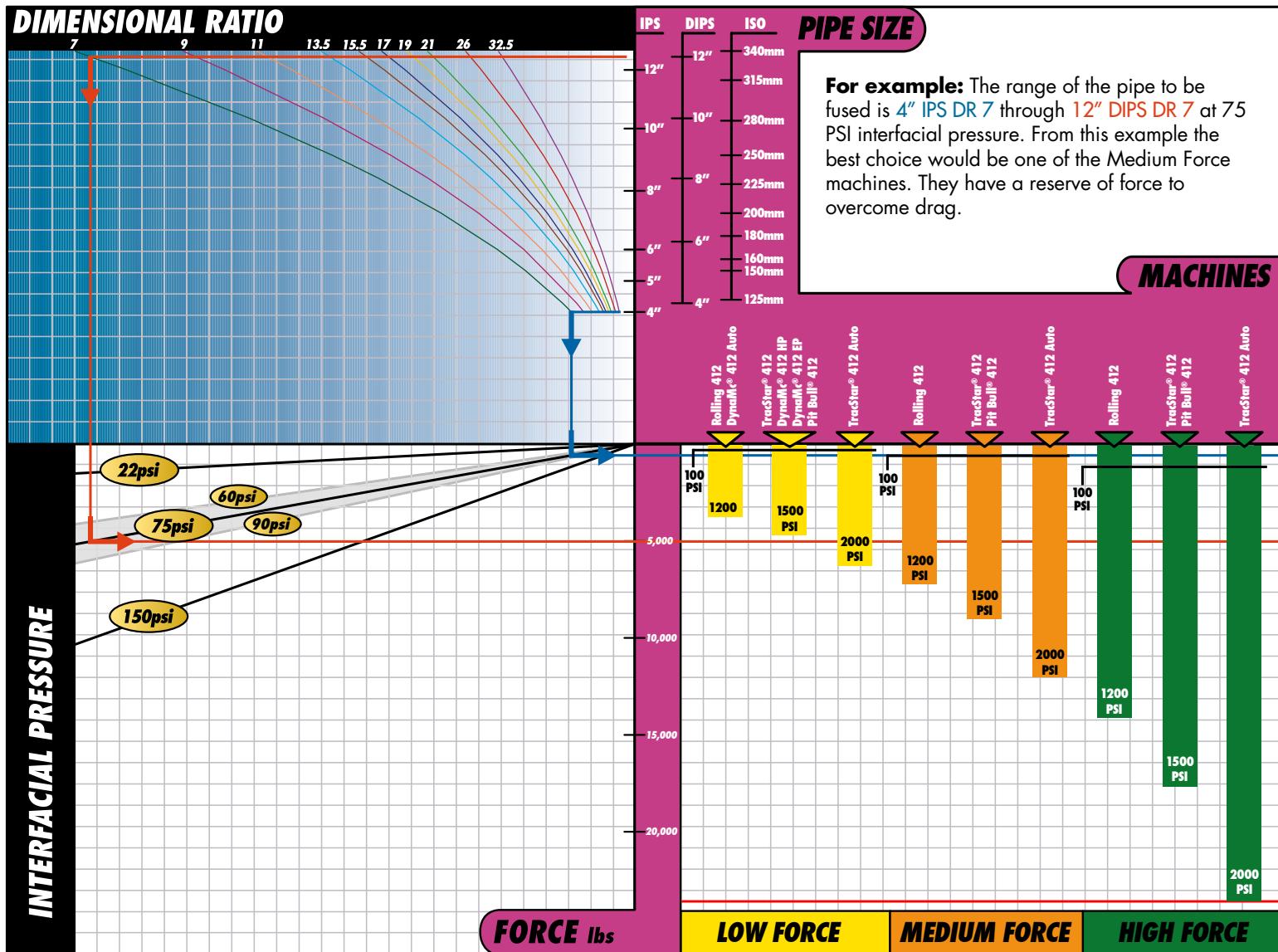
pressures, such as 22 PSI, the best choice is a Low Force machine. It is important to note that if the pipe sizes chosen results in a low gauge pressure (less than 100 PSI), the speed of the hydraulic jaws will be greatly reduced and a smaller fusion machine would be a better choice. A Low Force machine has a higher hydraulic jaw speed than a High Force machine. The graph shown does not include drag force. Drag force is the force required to move the pipe once clamped in the machine. In some circumstances, drag can be high, such as a tie-in of two long lengths of pipe.



Reference 412 Cylinder Force

This graph will aid in the selection of the correct fusion machine cylinder force option. First, select the range of pipe and DR to be fused in the machine (largest pipe – smallest DR and smallest pipe – highest DR). Second, select the type of pipe to be fused. The pipe type will determine the correct interfacial pressure to use. Your pipe manufacturer can help you with this number. Third, use the graph to determine which machine is best suited for the task. You can derive from the graph, that when using high interfacial pressures, the best choice is a High Force machine. When fusing at low interfacial

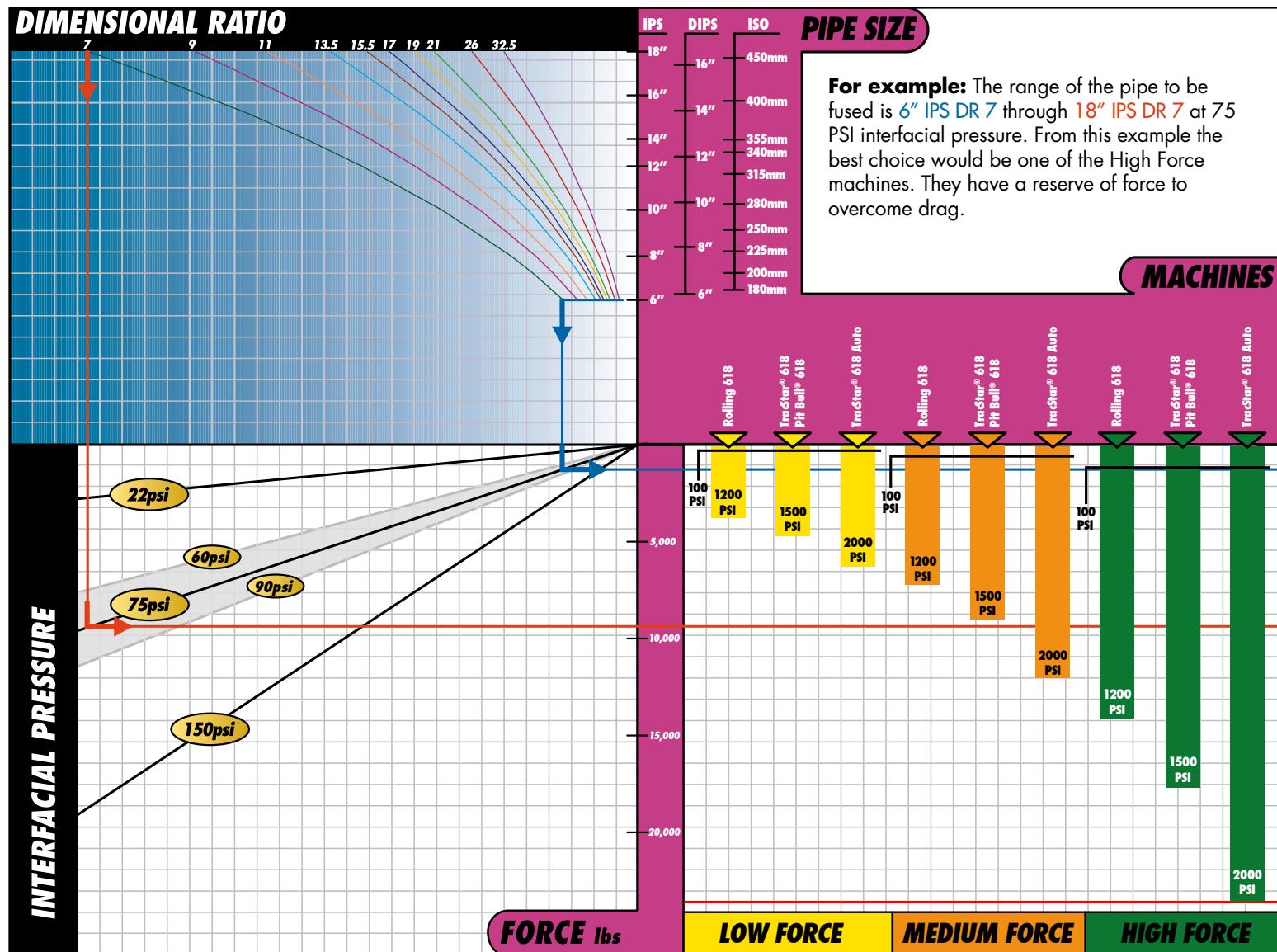
pressures, such as 22 PSI, the best choice is a Low Force machine. It is important to note that if the pipe sizes chosen results in a low gauge pressure (less than 100 PSI), the speed of the hydraulic jaws will be greatly reduced and a smaller fusion machine would be a better choice. A Low Force machine has a higher hydraulic jaw speed than a High Force machine. The graph shown does not include drag force. Drag force is the force required to move the pipe once clamped in the machine. In some circumstances drag can be high, such as a tie-in of two long lengths of pipe.



618 Cylinder Force Reference

This graph will aid in the selection of the correct fusion machine cylinder force option. First, select the range of pipe and DR to be fused in the machine (largest pipe – smallest DR and smallest pipe – highest DR). Second, select the type of pipe to be fused. The pipe type will determine the correct interfacial pressure to use. Your pipe manufacturer can help you with this number. Third, use the graph to determine which machine is best suited for the task. You can derive from the graph, that when using high interfacial pressures, the best choice is a High Force machine. When fusing at low interfacial

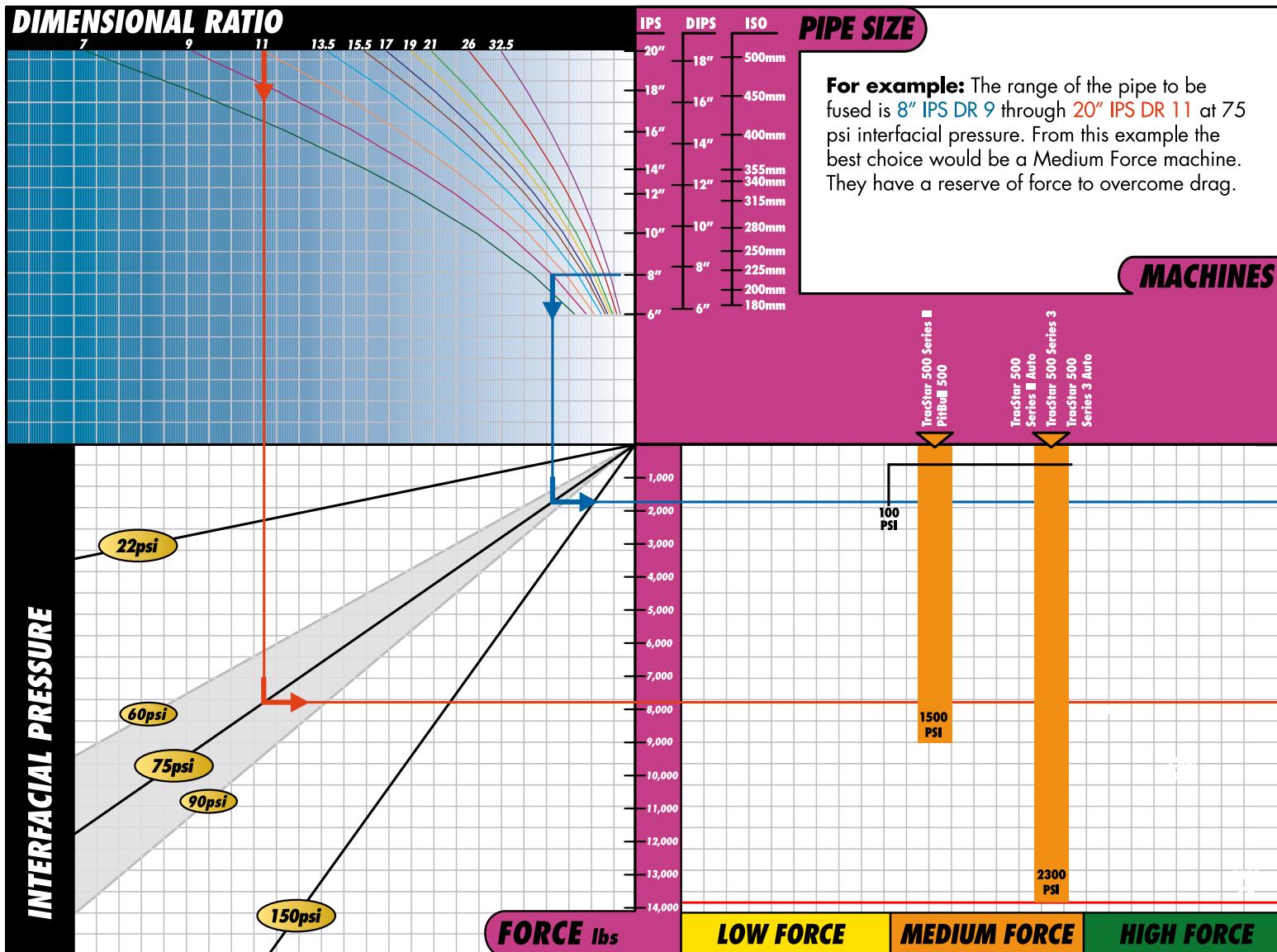
pressures, such as 22 PSI, the best choice is a Low Force machine. It is important to note that if the pipe sizes chosen results in a low gauge pressure (less than 100 PSI), the speed of the hydraulic jaws will be greatly reduced and a smaller fusion machine would be a better choice. A Low Force machine has a higher hydraulic jaw speed than a High Force machine. The graph shown does not include drag force. Drag force is the force required to move the pipe once clamped in the machine. In some circumstances drag can be high, such as a tie-in of two long lengths of pipe.



Reference 500 Cylinder Force

This graph will aid in the selection of the correct fusion machine cylinder force option. First, select the range of pipe and DR to be fused in the machine (largest pipe – smallest DR and smallest pipe – highest DR). Second, select the type of pipe to be fused. The pipe type will determine the correct interfacial pressure to use. Your pipe manufacturer can help you with this number. Third, use the graph to determine which machine is best suited for the task. You can derive from the graph, that when using high interfacial pressures, the best choice is a High Force machine. When fusing at low interfacial

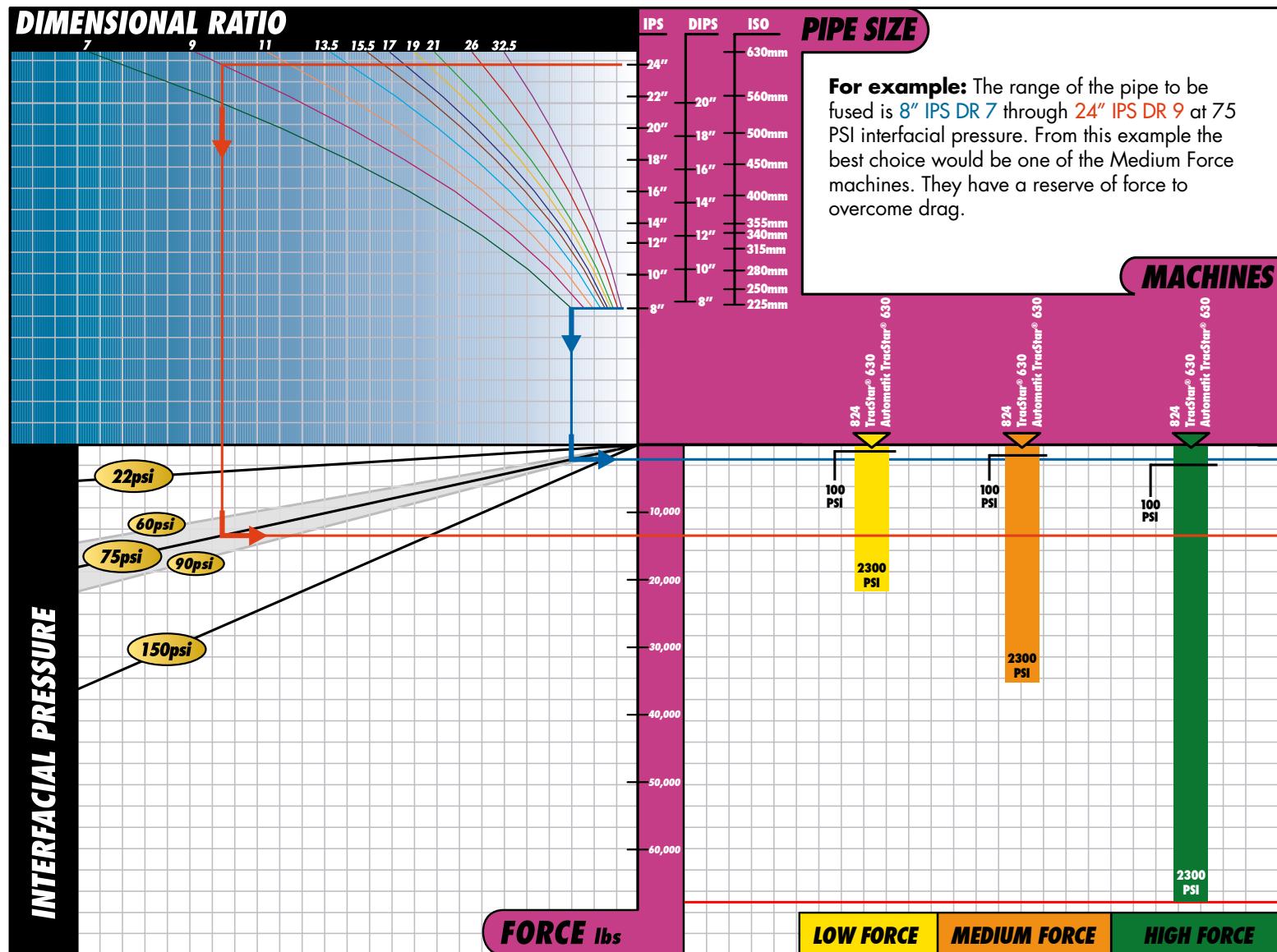
pressures, such as 22 PSI, the best choice is a Low Force machine. It is important to note that if the pipe sizes chosen results in a low gauge pressure (less than 100 PSI), the speed of the hydraulic jaws will be greatly reduced and a smaller fusion machine would be a better choice. A Low Force machine has a higher hydraulic jaw speed than a High Force machine. The graph shown does not include drag force. Drag force is the force required to move the pipe once clamped in the machine. In some circumstances drag can be high, such as a tie-in of two long lengths of pipe.



824/TracStar® 630 Cylinder Force Reference

This graph will aid in the selection of the correct fusion machine cylinder force option. First, select the range of pipe and DR to be fused in the machine (largest pipe – smallest DR and smallest pipe – highest DR). Second, select the type of pipe to be fused. The pipe type will determine the correct interfacial pressure to use. Your pipe manufacturer can help you with this number. Third, use the graph to determine which machine is best suited for the task. You can derive from the graph, that when using high interfacial pressures, the best choice is a High Force machine. When fusing at low interfacial

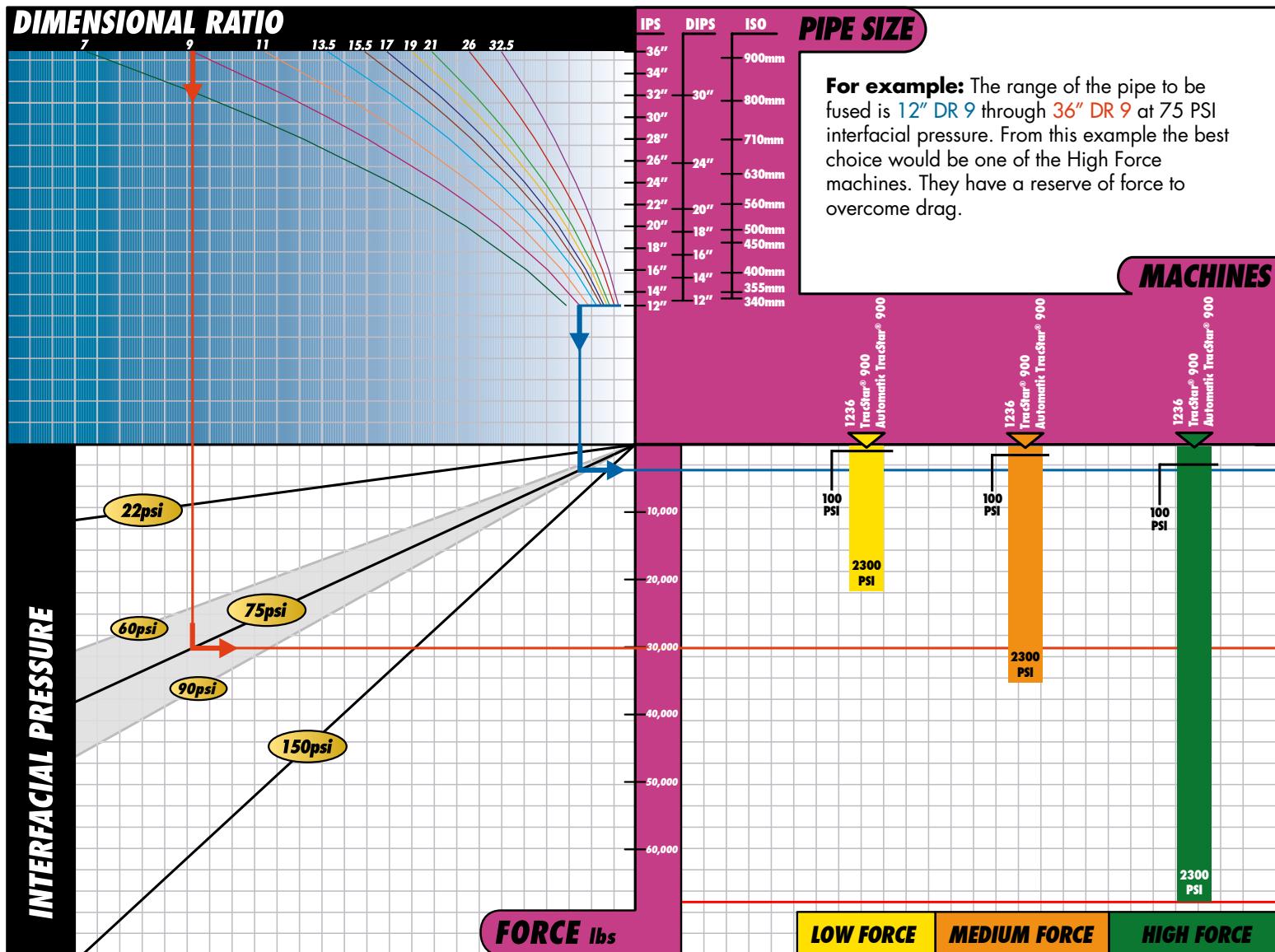
pressures, such as 22 PSI, the best choice is a Low Force machine. It is important to note that if the pipe sizes chosen results in a low gauge pressure (less than 100 PSI), the speed of the hydraulic jaws will be greatly reduced and a smaller fusion machine would be a better choice. A Low Force machine has a higher hydraulic jaw speed than a High Force machine. The graph shown does not include drag force. Drag force is the force required to move the pipe once clamped in the machine. In some circumstances drag can be high, such as a tie-in of two long lengths of pipe.



Reference 1236/TracStar® 900 Cylinder Force

This graph will aid in the selection of the correct fusion machine cylinder force option. First, select the range of pipe and DR to be fused in the machine (largest pipe – smallest DR and smallest pipe – highest DR). Second, select the type of pipe to be fused. The pipe type will determine the correct interfacial pressure to use. Your pipe manufacturer can help you with this number. Third, use the graph to determine which machine is best suited for the task. You can derive from the graph, that when using high interfacial pressures, the best choice is a High Force machine. When fusing at low interfacial

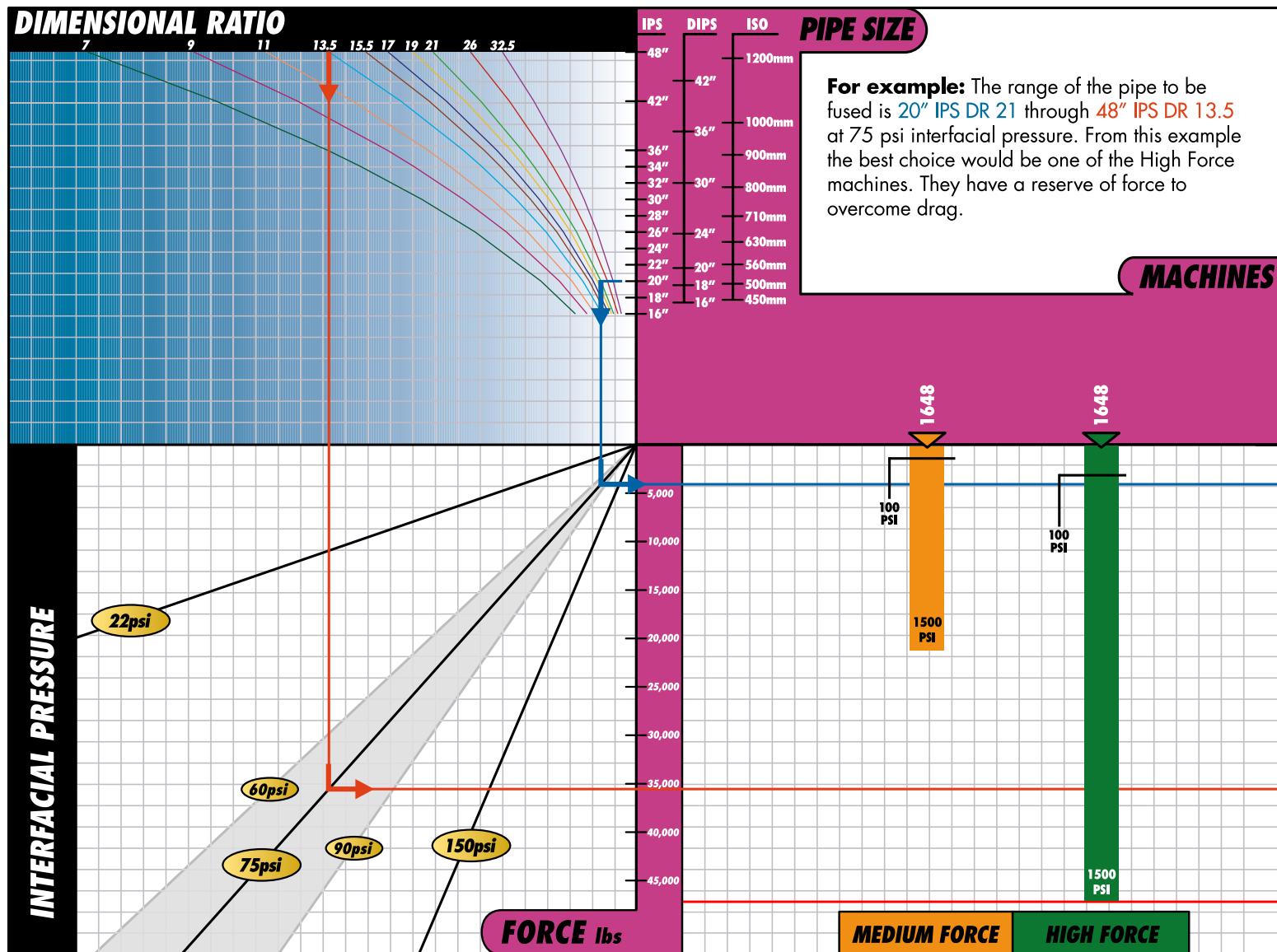
pressures, such as 22 PSI, the best choice is a Low Force machine. It is important to note that if the pipe sizes chosen results in a low gauge pressure (less than 100 PSI), the speed of the hydraulic jaws will be greatly reduced and a smaller fusion machine would be a better choice. A Low Force machine has a higher hydraulic jaw speed than a High Force machine. The graph shown does not include drag force. Drag force is the force required to move the pipe once clamped in the machine. In some circumstances drag can be high, such as a tie-in of two long lengths of pipe.



1648 Cylinder Force Reference

This graph will aid in the selection of the correct fusion machine cylinder force option. First, select the range of pipe and DR to be fused in the machine (largest pipe – smallest DR and smallest pipe – highest DR). Second, select the type of pipe to be fused. The pipe type will determine the correct interfacial pressure to use. Your pipe manufacturer can help you with this number. Third, use the graph to determine which machine is best suited for the task. You can derive from the graph, that when using high interfacial pressures, the best choice is a High Force machine. When fusing at low interfacial

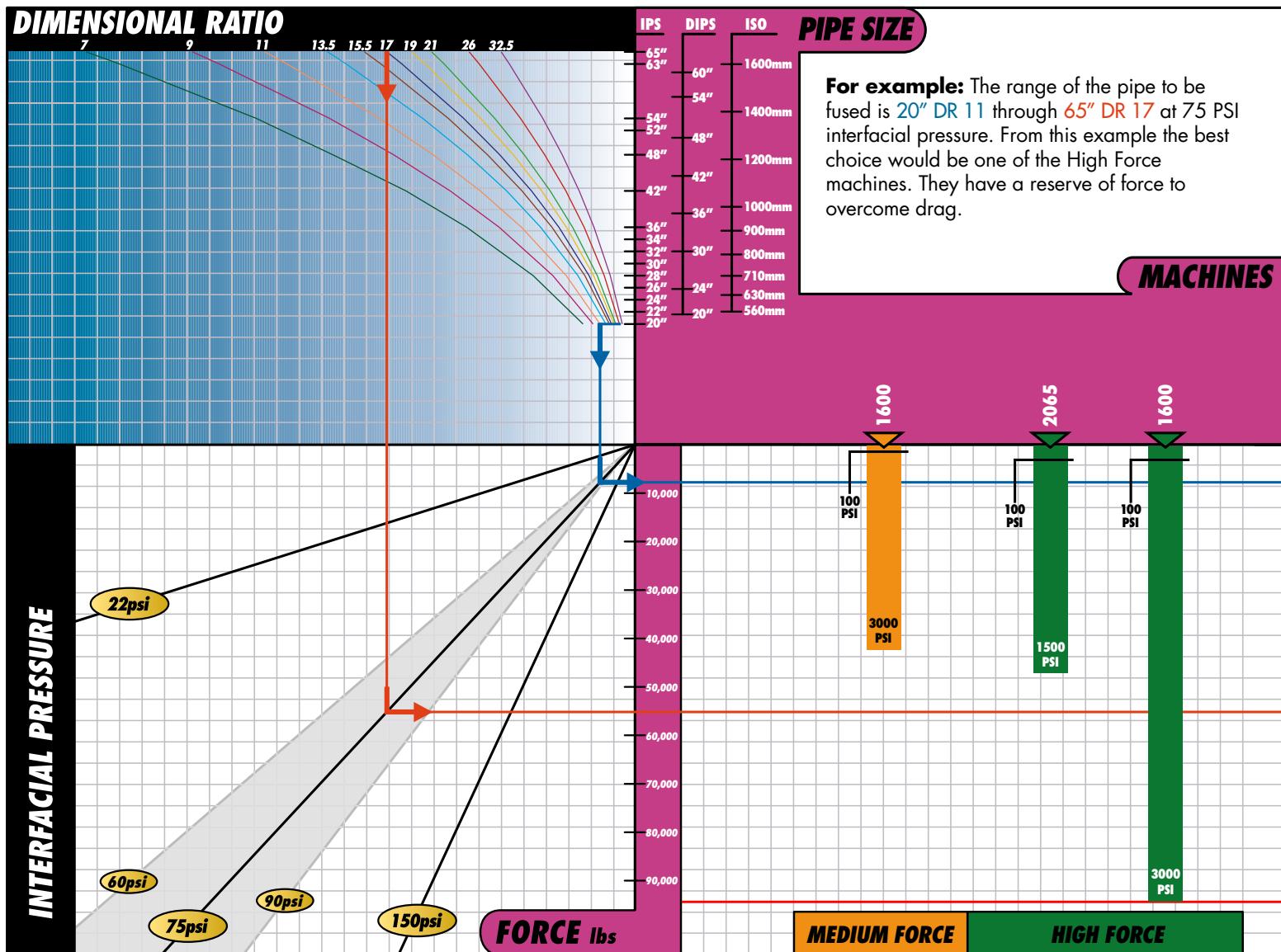
pressures, such as 22 PSI, the best choice is a Low Force machine. It is important to note that if the pipe sizes chosen results in a low gauge pressure (less than 100 PSI), the speed of the hydraulic jaws will be greatly reduced and a smaller fusion machine would be a better choice. A Low Force machine has a higher hydraulic jaw speed than a High Force machine. The graph shown does not include drag force. Drag force is the force required to move the pipe once clamped in the machine. In some circumstances drag can be high, such as a tie-in of two long lengths of pipe.



Reference 2065/1600 Cylinder Force

This graph will aid in the selection of the correct fusion machine cylinder force. First, select the range of pipe and DR to be fused in the machine (largest pipe – smallest DR and smallest pipe – highest DR). Second, select the type of pipe to be fused. The pipe type will determine the correct interfacial pressure to use. Your pipe manufacturer can help you with this number. Third, use the graph to determine which machine is best suited for the task. It is important to note that if the pipe sizes chosen results in a low gauge pressure (less than 100 PSI), the speed of the hydraulic jaws will be greatly reduced and a

smaller fusion machine would be a better choice. The graph shown does not include drag force. Drag force is the force required to move the pipe once clamped in the machine. In some circumstances drag can be high, such as a tie-in of two long lengths of pipe.



Facer Blade Chart For Older Equipment Reference

Machine Name	Applicable Model No	Model Manufacture Date	Blade Set Part No	Blade Quantity	Blade Sizes
2CU	200101	Before 9/88	204802	4 Blades	1 3/8" x 15/32"
2 Butt	213101	Before 9/88	204802	4 Blades	1 3/8" x 15/32"
14	420001	Before 9/00	413702	4 Blades	2 1/4" x 31/32"
4CU	400101	Before 8/81	406902	4 Blades	2 1/4" x 15/32"
4CU	400101	After 8/81	413702	4 Blades	2 1/4" x 31/32"
28	800200	Before 3/88	803302	4 Blades	3 3/4" x 15/32"
	850100	3/88 -8/03	3615702, 3615702C		5" x 1 7/32"
28 Pit Bull®	A850400	Before 4/04	846702	4 Blades	5" x 31/32"
412	1200200	Before 1/88	1208002	6 Blades	5" x 15/32"
412 (IPS)	1200200	Before 5/97	3615702, 3615702C	4 Blades	5" x 1 7/32"
412 (DIPS)	1245000	Before 10/03	3615714, 3615714C	6 Blades	5 3/8" x 1 7/32"
TracStar® 412	T1200100	Before 1/05	T1208610, T1208610C	6 Blades	6 1/8" x 31/32"
18	1800900	Before 5/90	1804802	6 Blades	6 3/4" x 15/32"
618	1855600	Before 10/03	3615710, 3615710C	6 Blades	9" x 1 7/32"
			3615703, 3615703C		5" x 1 7/32"
TracStar® 618	T1800100	Before 1/05	T1812603, T1812603C	6 Blades	4 5/8" x 31/32"
TracStar® 500	T5000101	Before 1/02	T5005002, T5005002C	6 Blades	9 7/8" x 31/32"
TracStar® 500 Series II	T5000102,3,6,7		T5005006, T5005006C	6 Blades	10 1/4" x 31/32"
TracStar® 500 Series II (mm)	T5000104,5,8,9		T5005006, T5005006C	6 Blades	10 1/4" x 31/32"
Pit Bull® 500	AT5034000		T5005006, T5005006C	6 Blades	10 1/4" x 31/32"
24	2400100	Before 1/88	3603698	6 Blades	9 3/8" x 15/32"
824	2400700	Before 10/03	3615710, 3615710C	6 Blades	9" x 1 7/32"
		After 10/03	3615712		11" x 1 7/32"
1236	3600100	Before 1/89	3603699	6 - 9.38" Blades & 6 - 5" Blades	5" x 15/32"
TracStar® 900	T9000100		3615707, 3615707C	6 Blades	15" x 1 7/32"

Note: Part numbers ending in "C" = extended life blades

Reference Plug Type Reference

Plug Type	Description
Plug Letter Designations	
A	15A, 2 Pole, 3 Wire, NEMA 5-15P, Straight Blade
B	20A, 2 Pole, 3 Wire, NEMA 5-20P, Straight Blade
C	15A, 2 Pole, 3 Wire, NEMA 6-15P, Straight Blade
D	20A, 3 Pole, 4 Wire, NEMA L15-20P, Locking
E	30A, 2 Pole, 3 Wire, NEMA L6-30P, Locking
F	30A, 3 Pole, 4 Wire, NEMA L15-30P, Locking
G	50A, 2 Pole, 3 Wire, Locking
H	60A, 3 Pole, 4 Wire, Pin and Sleeve
I	100A, 3 Pole, 4 Wire, Pin and Sleeve
J	200A, 4 Pole, 4 Wire, Pin and Sleeve
K	32A, 4 Pole, 5 Wire, IEC 60309 Pin and Sleeve
L	63A, 4 Pole, 5 Wire, IEC 60309 Pin and Sleeve
M	16A, 2 Pole, 3 Wire, DIN 49441, "Schuko"
N	30A, 2 Pole, 3 Wire, IEC 60309 Pin and Sleeve
O	125A, 4 Pole, 5 Wire, IEC60309 Pin and Sleeve



Conversions & Formulas Reference

Millimeter to Inch Conversion

mm	Inch	mm	Inch	mm	Inch	mm	Inch
1	0.039	26	1.024	51	2.008	76	2.992
2	0.079	27	1.063	52	2.047	77	3.032
3	0.118	28	1.102	53	2.087	78	3.071
4	0.158	29	1.142	54	2.126	79	3.110
5	0.197	30	1.181	55	2.165	80	3.150
6	0.236	31	1.221	56	2.205	81	3.189
7	0.276	32	1.260	57	2.244	82	3.228
8	0.315	33	1.299	58	2.284	83	3.268
9	0.354	34	1.339	59	2.323	84	3.307
10	0.394	35	1.378	60	2.362	85	3.347
11	0.433	36	1.417	61	2.402	86	3.386
12	0.472	37	1.457	62	2.441	87	3.425
13	0.512	38	1.496	63	2.480	88	3.465
14	0.551	39	1.535	64	2.520	89	3.504
15	0.591	40	1.575	65	2.559	90	3.543
16	0.630	41	1.614	66	2.598	91	3.583
17	0.669	42	1.654	67	2.638	92	3.622
18	0.709	43	1.693	68	2.677	93	3.661
19	0.748	44	1.732	69	2.717	94	3.701
20	0.787	45	1.772	70	2.756	95	3.740
21	0.827	46	1.811	71	2.795	96	3.780
22	0.866	47	1.850	72	2.835	97	3.819
23	0.906	48	1.890	73	2.874	98	3.858
24	0.945	49	1.929	74	2.913	99	3.898
25	0.984	50	1.969	75	2.953	100	3.937

Conversion Formulas

Inches \times 25.4 = Millimeters	Liters \times 1.057 = Quarts
Millimeters \times 0.03937 = Inches	Gallons \times 3.785 = Liters
Feet \times 304.8 = Millimeters	Liters \times 0.2642 = Gallons
Millimeters \times 0.00328 = Feet	Pounds \times 0.4536 = Kilograms
SQ. Inches \times 645.16 = SQ. mm	Kilograms \times 2.205 = Pounds
SQ. mm \times 0.00155 = SQ. Inches	Bar \times 14.503 = psi
Ounces \times 0.02957 = Liters	mPa \times 145.03 = psi
Quarts \times 0.9463 = Liters	Kg/cm ² \times 14.223 = psi

Fraction to Decimal Conversion

Fractions	Dec.	mm	Fractions	Dec.	mm
1/64	.0156	0.3969	33/64	.5156	13.0969
1/32	.0313	0.7938	17/32	.5313	13.4938
3/64	.0469	1.1906	35/64	.5469	13.8906
1/16	.0625	1.5875	9/16	.5625	14.2875
5/64	.0781	1.9844	37/64	.5781	14.6844
3/32	.0938	2.3813	19/32	.5938	15.0813
7/64	.1094	2.7781	39/64	.6094	15.4781
1/8	.1250	3.1750	5/8	.6250	15.8750
9/64	.1406	3.5719	41/64	.6406	16.2719
5/32	.1563	3.9688	21/32	.6563	16.6688
11/64	.1719	4.3656	43/64	.6719	17.0656
3/16	.1875	4.7625	11/16	.6875	17.4625
13/64	.2031	5.1594	45/64	.7031	17.8594
7/32	.2188	5.5563	23/32	.7188	18.2563
15/64	.2344	5.9531	47/64	.7344	18.6531
1/4	.2500	6.3500	3/4	.7500	19.050
17/64	.2656	6.7469	49/64	.7656	19.4469
9/32	.2813	7.1438	25/32	.7813	19.8438
19/64	.2969	7.5406	51/64	.7969	20.2406
5/16	.3125	7.9375	13/16	.8125	20.6375
21/64	.3281	8.3344	53/64	.8281	21.0344
11/32	.3438	8.7313	27/32	.8438	21.4313
23/64	.3594	9.1281	55/64	.8594	21.8281
3/8	.3750	9.5250	7/8	.8750	22.2250
25/64	.3906	9.9219	57/64	.8906	22.6219
13/32	.4063	10.3188	29/32	.9063	23.0188
27/64	.4219	10.7156	59/64	.9219	23.4156
7/16	.4375	11.1125	15/16	.9375	23.8125
29/64	.4531	11.5094	61/64	.9531	24.2094
15/32	.4688	11.9063	31/32	.9688	24.6063
31/64	.4844	12.3031	63/64	.9844	25.0031
1/2	.5000	12.7000	1	1.0000	25.4000

Reference Pipe Size Reference Charts

IPS Pipe Sizes		
Pipe	OD	Cir.
1/2"	0.84"	2.64"
3/4"	1.05"	3.30"
1"	1.32"	4.13"
1 1/4"	1.66"	5.22"
1 1/2"	1.90"	5.97"
2"	2.37"	7.46"
2 1/2"	2.87"	9.03"
3"	3.50"	11.00"
4"	4.50"	14.14"
5"	5.56"	17.47"
6"	6.63"	20.81"
8"	8.63"	27.10"
10"	10.75"	33.77"
12"	12.75"	40.06"
14"	14.00"	43.98"
16"	16.00"	50.27"
18"	18.00"	56.55"
20"	20.00"	62.83"
22"	22.00"	69.12"
24"	24.00"	75.40"
26"	26.00"	81.68"
28"	28.00"	87.96"
30"	30.00"	94.25"
32"	32.00"	100.53"
34"	34.00"	106.81"
36"	36.00"	113.10"
42"	42.00"	131.95"
48"	48.00"	150.80"
52"	52.00"	163.36"
54"	54.00"	169.65"
63"	63.00"	197.92"
65"	65.00"	204.20"

DIPS Pipe Sizes		
Pipe	OD	Cir.
3"	3.96"	12.44"
4"	4.80"	15.08"
6"	6.90"	21.68"
8"	9.05"	28.43"
10"	11.10"	34.87"
12"	13.20"	41.47"
14"	15.30"	48.07"
16"	17.40"	54.66"
18"	19.50"	61.26"
20"	21.60"	67.86"
24"	25.80"	81.05"
30"	32.00"	100.53"
36"	38.30"	120.32"
42"	44.50"	139.80"
48"	50.80"	159.59"
54"	57.10"	179.38"
60"	61.61"	193.55"

CTS Pipe Sizes		
Pipe	OD	Cir.
1/2"	0.63"	1.98"
3/4"	0.88"	2.75"
1"	1.13"	3.53"
1 1/4"	1.38"	4.32"
1 1/2"	1.63"	5.11"
2"	2.13"	6.68"

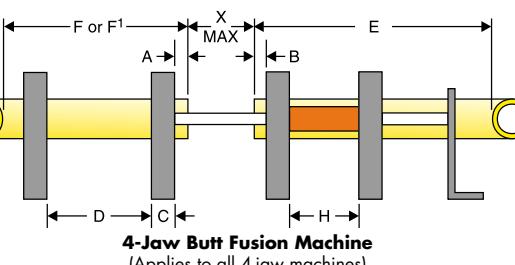
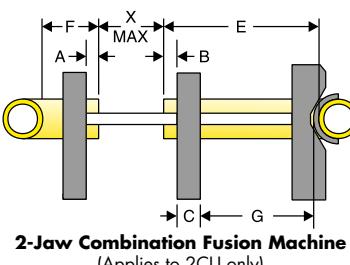
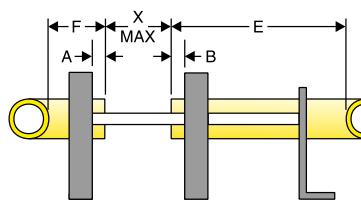
Metric JIS-1,1U, 2, 3 Pipe Sizes		
Pipe	OD	Cir.
20mm	1.06"	3.34"
25mm	1.34"	4.21"
30mm	1.65"	5.19"
40mm	1.89"	5.94"
50mm	2.36"	7.41"
75mm	3.50"	11.00"
100mm	4.49"	14.10"
125mm	5.51"	17.31"
150mm	6.49"	20.39"
175mm	7.48"	23.50"
200mm	8.50"	26.70"
250mm	10.51"	33.02"
300mm	12.52"	39.33"
350mm	14.57"	45.77"
400mm	16.54"	51.96"

PP-R Pipe Sizes		
Pipe	Nominal OD	
20mm	.5"	
25mm	.75"	
32mm	1"	
40mm	1.25"	
50mm	1.5"	
63mm	2"	
75mm	2.5"	
90mm	3"	
110mm	3.5"	
125mm	4"	
160mm	6"	
200mm	8"	
250mm	10"	
315mm	12"	
355mm	14"	
400mm	16"	
450mm	18"	
500mm	20"	
560mm	22"	
630mm	24"	
710mm	27.95"	87.82"
800mm	31.50"	98.95"
900mm	35.43"	111.32"
1000mm	39.37"	123.68"
1200mm	47.24"	148.42"
1400mm	55.12"	173.16"
1600mm	62.99"	197.90"

Metric ISO Pipe Sizes		
Pipe	OD	Cir.
16mm	0.63"	1.98"
20mm	0.78"	2.47"
25mm	0.98"	3.09"
32mm	1.26"	3.96"
40mm	1.57"	4.98"
50mm	1.97"	6.18"
63mm	2.48"	7.79"
75mm	2.95"	9.28"
90mm	3.54"	11.13"
100mm	3.94"	12.37"
110mm	4.33"	13.61"
125mm	4.92"	15.46"
150mm	5.91"	18.55"
160mm	6.30"	19.79"
180mm	7.09"	22.26"
200mm	7.87"	24.74"
225mm	8.86"	27.83"
250mm	9.84"	30.92"
280mm	11.02"	34.63"
315mm	12.40"	38.96"
340mm	13.39"	42.05"
355mm	13.98"	43.91
400mm	15.75"	49.47"
450mm	17.72"	55.66"
500mm	19.69"	61.84"
560mm	22.05"	69.26"
630mm	24.80"	77.92"
710mm	27.95"	87.82"
800mm	31.50"	98.95"
900mm	35.43"	111.32"
1000mm	39.37"	123.68"
1200mm	47.24"	148.42"
1400mm	55.12"	173.16"
1600mm	62.99"	197.90"

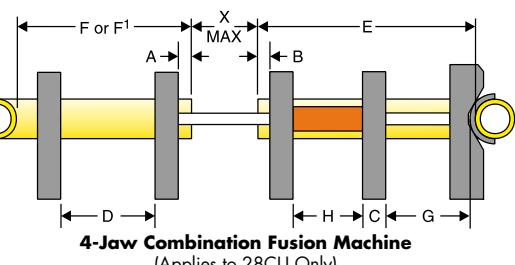
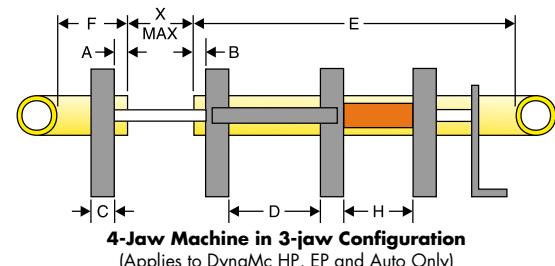
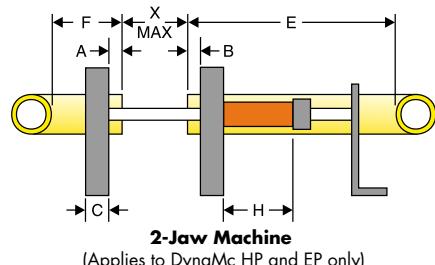
Pipe & Fitting Installation Dimensions Reference

MACHINE (All dims. in inches)	A	B	C	D	E	F	F1	G MAX.	G MIN.	H	X MAX.
2CU	0.37	0.33	1	—	9.5	2.5	—	7.17	1.17	—	5.55
2LC	0.37	0.33	1	—	10	2.5	—	—	—	—	3.3
Pit Bull® 14	0.50	0.50	1.75	—	11.63	5.25	—	—	—	—	4
26	0.69	0.69	2	—	10.58	3.05	—	—	—	—	—
28 Rolling	0.50	0.50	2	17.5	28	23	3	11.25	2.5	9.5	8.5
TracStar® 28 & Pit Bull® 28	0.50	0.50	2	12	63	15	3	11.25	2.5	9.5	8.5
250 Wheeled	0.76	0.76	2	17.5	28	23	3	11.25	2.5	9.5	8.5
TracStar® 250 & Pit Bull® 250	0.76	0.76	2	12	63	15	3	11.25	2.5	9.5	8.5
412 Rolling	1	1	3	11.62	21	47	4.5	—	—	—	8.5
TracStar® 412	1	1	3	11.62	63	16	4.5	—	—	—	8.5
Pit Bull® 412	1	1	3	11.62	63	16	4.5	—	—	—	8.5
618 Rolling	1	1	3.75	11.59	21	48	5.75	—	—	6.25	7.25
TracStar® 618	1	1	3.75	11.59	58	20	5.75	—	—	6.25	6.25
Pit Bull® 618	1	1	3.75	11.59	17	18	5.75	—	—	6.25	6.25
TracStar® 500 Series 3	1	1	3.75	6	64.25	22	—	—	—	7	6.50
Pit Bull® 500	1	1	3.75	6	17.50	17	6	—	—	7	6.50
824	1	1.37	3.75	26.25	51	36	6.12	—	—	17	18.50
TracStar® 630	1	1.37	3.75	26.25	66	32.50	8	—	—	17	18.50
1236	1	1.37	5	25	51	37.50	**	—	—	18	20
TracStar® 900	1	1.37	5	25	66	37.50	7.50	—	—	18	20
1648	2.25	2.25	6	37.69	83	52	***	—	—	22	14.50
2065	2.10	2.10	12.50	—	62.75	31	—	—	—	—	16
1600	2.10	2.10	12.50	43.88	62.75	71.50	15	—	—	6.50	16
DynaMc® 28 HP 4 Jaw	.5	.5	2	6.8	18	12.86	4	—	—	7	5.44
DynaMc® 28 HP 3 Jaw Config.	.5	.5	2	6.8	26.8	4.06	—	—	—	6.99	5.45
DynaMc® 28 HP 2 Jaw	.5	.5	2	—	18.5	4.06	4.06	—	—	—	5.24
DynaMc® 250 HP 4 Jaw	.76	.76	2	6.8	18.26	13.12	4.375	—	—	—	5.24
DynaMc® 250 HP 3 Jaw Config.	.76	.76	2	6.8	27.06	4.32	—	—	—	6.99	4.93
DynaMc® 250 HP 2 Jaw	.76	.76	2	—	18.76	4.33	—	—	—	6.99	4.724
DynaMc® 250 AUTO 4 Jaw	.76	.76	2	6.8	18.27	13.13	3.566	—	—	7.01	4.92
DynaMc® 250 AUTO 3 Jaw Config.	.76	.76	2	6.8	27.07	4.33	—	—	—	7.01	4.92
DynaMc® 412 HP 4 Jaw	1	1	3	3.5	19.61	12.23	6.06	—	—	6	4.89
DynaMc® 412 HP 3 Jaw Config.	1	1	3	3.5	26.11	5.73	—	—	—	6	4.89
DynaMc® 412 HP 2 Jaw	1	1	3	—	19.61	5.7	—	—	—	6	4.42
DynaMc® 412 AUTO 4 Jaw	1	1	3	3.5	19.55	12.56	6.06	—	—	6	4.95
DynaMc® 412 AUTO 3 Jaw Config.	1	1	3	3.5	26.05	6.07	—	—	—	6	4.94



NOTES: **A** and **B** dimensions are after face-off, **F** and **F1** dimensions allow for 1" of face-off material, **F1** dimension shows unit removed from chassis or outer jaw removed, **X MAX.** dimension is jaws shown in full open position.

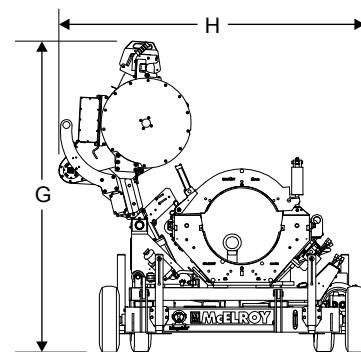
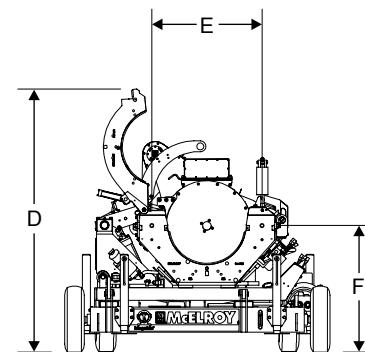
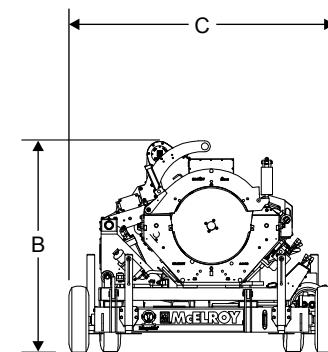
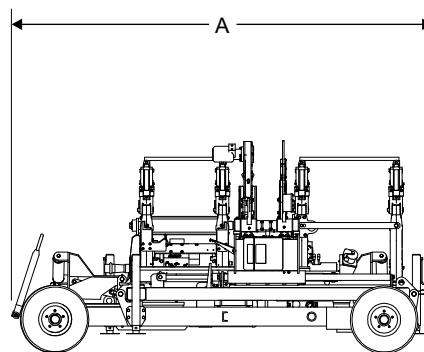
** 12.38 (Lower parking brake) or 36.00 (High parking brake)
*** 23.50 (W/O parking brake) or 46.00 (With parking brake)



Reference Machine Dimensions

MACHINE	A Machine Shipping Length	B Machine Shipping Height	C Machine Shipping Width	D Machine Height Jaws Open	E Between Center Line of Guide Rods	F Ground to Guide Rod Center Line	G Machine Height Heater Out	H Machine Width Facer Out	Guide Rod Diameter
2CU	20	17	12	—	6.375	6.125	—	—	0.75
2LC	14	14	14	—	6.375	5.75	—	—	0.75
Pit Bull® 14	16	16	17	—	8.625	8.5	—	—	1
26	16	18	20	—	12	9	—	—	—
28/250 Rolling	66	39	38	42	15	24.375	48	45	1
28/250 HP Rolling	66	39	38	42	15	24.375	48	45	1
TracStar® 28/250	95	51	44	51	15	28.125	52	44	1
412 Rolling	86	46	51	52	19	32	62	51	1.75
TracStar® 412	98	53	55	53	19	31.25	61	55	1.75
618 Rolling	86	57	51	64	24	34	68	58	1.75
TracStar® 618	98	53	57	63	24	33.875	67	58	1.75
TracStar® 500 Series II	95	53	65	67	25.25	30.75	67	65	1.75
TracStar® 500 Series 3	95	51	68	61.78	25.25	32.32	71.28	64.58	1.75
824	134	68	85	84	35	40	99	98	2.5
TracStar® 630	142	77	99	90	35	47.5	105	99	2.5
1236	134	80	85	103	46	46.25	101	121	2.5
TracStar® 900	142	86	98	109	46	52.375	107	114	2.5
1648	153	87	95	126	60	50.5	114	163	4
2065	186	106	108	156	78	64.25	152	192	4
1600	205	117	102	160	78	68	152	189	4

Note: All dimensions are in inches.

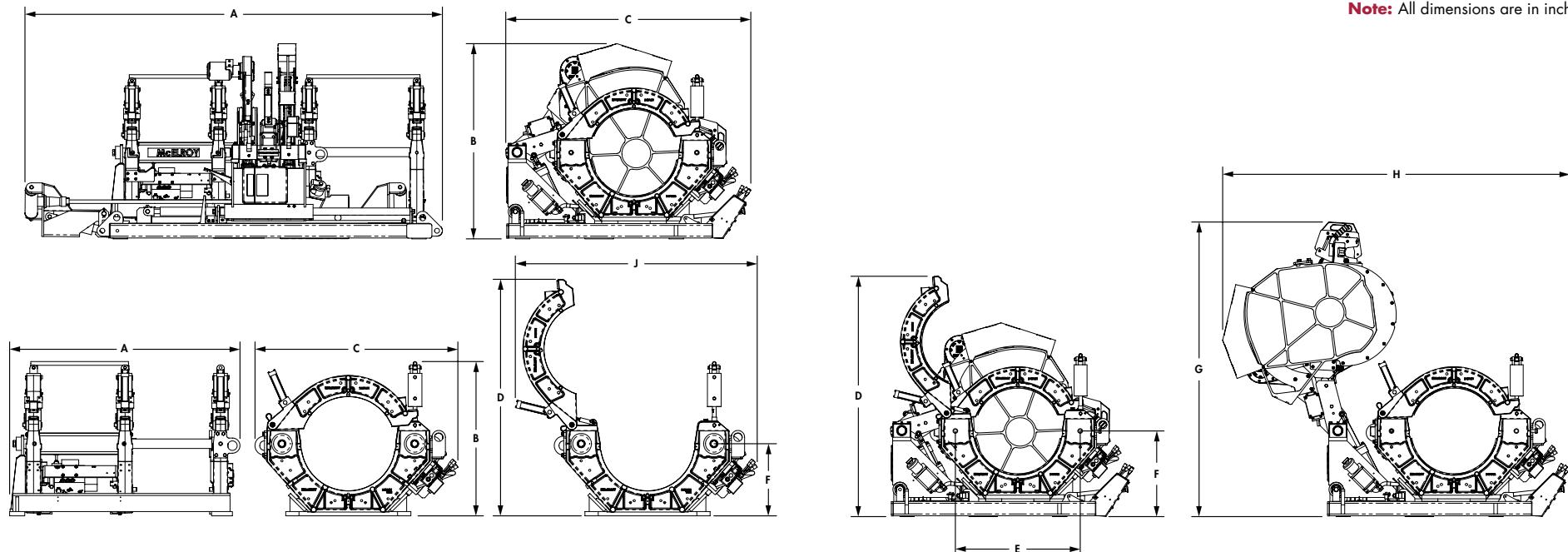


Carriage Dimensions Reference

A B C D E F G H J

MACHINE	Carriage Shipping Length	Carriage Shipping Height	Carriage Shipping Width	Carriage Height Jaws Open	Between Center Line of Guide Rods	Ground to Guide Rod Center Line	Carriage Height Facer/Heater Out	Carriage Width Facer/Heater Out	Carriage Width Jaws Open	Guide Rod Diameter
Pit Bull 28/250 (3 Jaw)	28.9	21.2	29.2	24	15	7.7	31	38.5	32.9	1
Pit Bull 28/250 (4 Jaw)	43.8	23.1	29.2	26	15	9.5	33	38.5	32.9	1
Pit Bull 412 (3 Jaw)	28.5	25.1	38.2	30	19	10.7	39.6	48	40.9	1.8
Pit Bull 412 (4 Jaw)	43.8	27	38.2	32	19	12.6	41.5	48	40.9	1.8
Pit Bull 618 (3 Jaw)	28.9	31.3	43.3	41.5	24	13.3	46	57.8	44.3	1.8
Pit Bull 618 (4 Jaw)	44.3	33.1	43.3	43.5	24	15.2	47.9	57.8	44.3	1.8
500 Series 3 (3 Jaw)	35.6	33	38.1	44	25.3	14.5	-	-	45.7	1.8
500 Series 3 (4 Jaw)	47.7	34	43.5	45	25.3	15.5	54.5	64.6	45.7	1.8
Pit Bull 500 Series II (3 Jaw)	29.4	27.3	38.1	43.2	25.3	14.3	-	-	45.7	1.8
Pit Bull 500 Series II (4 Jaw)	39.5	27.6	38.1	43.5	25.3	14.5	-	-	45.7	1.8
Pit Bull 630/824 (3 Jaw)	60.7	40.7	53.5	62.4	35	19	-	-	63.8	2.5
Pit Bull 630/824 (4 Jaw)	116.2	54.3	68.3	67.4	35	24	82.6	90	68.3	2.5
Pit Bull 900/1236 (3 Jaw)	61	49.1	61.3	81.1	46	25	-	-	77.7	2.5
Pit Bull 900/1236 (4 Jaw)	116.2	63.1	68.4	86.1	46	30	84.3	113.8	77.7	2.5
DynaMc 28 HP 4 Jaw	35	24	26	26	15	9.8	-	-	32	1
DynaMc 28 HP 2 Jaw	26	24	26	26	15	9.8	-	-	32	1
DynaMc 250 HP 4 Jaw	35	24	26	27	15	9.8	-	-	32	1
DynaMc 250 HP 2 Jaw	26	24	26	27	15	9.8	-	-	32	1
DynaMc 250 Auto	35	20	21	27	15	9.8	-	-	28	1
DynaMc 412 HP 4 Jaw	35	27	32	33	19	12.8	-	-	40	1.8
DynaMc 412 HP 2 Jaw	28	27	32	33	19	12.8	-	-	40	1.8
DynaMc 412 Auto 4 Jaw	35	24	27	33	19	12.8	-	-	35	1.8

Note: All dimensions are in inches.



Reference Hydraulic Fluid Characteristics

The use of proper hydraulic oil is mandatory to achieve maximum performance and machine life. Use a clean, high-quality, anti-wear hydraulic oil with a viscosity index (VI) of 135 minimum. It should have a maximum viscosity of 500 cSt (2000 SSU) at startup (ambient temperature) and a minimum viscosity of 13 cSt (65 SSU) at the maximum oil temperature (generally 80°F above ambient). Using hydraulic oils that do not meet these criteria may cause poor operation and/or damage to the hydraulic components. The following table specifies the oil temperature at various viscosities. Temperature rise of the

hydraulic oil can vary from 30° F to about 80° F over the ambient temperature depending on the pressure setting, age of the pump, wind, etc. Mobil Univis N46 hydraulic oil is installed at our factory. The advantage of this oil is a wider temperature range; however, this oil should not be used for continuous operation below 24° F. For use in extremely cold ambient temperatures, we suggest Mobil DTE 10 Excel 15, which can be used to -16° F. This oil should not be used for continuous operation above 113° F (oil temperature).

NOTE: The Mobil DTE 10 Excel series replaced the DTE 10M series. The Exxon Univis N series are now Mobil Univis N.

Fluid	cST 100F	cST 210F	V.I.	-30°F -34°C	-15°F -26°C	0°F -18°C	15°F -9°C	30°F -1°C	45°F 7°C	60°F 15°C	75°F 24°C	90°F 32°C	105°F 40°C	120°F 49°C	135°F 57°C	150°F 65°C	165°F 74°C	180°F 82°C	195°F 90°C	Range	
Mobil																					
DTE 10 Excel 15	15.8	4.1	168																		-16°F to 113°F -27°C to 45°C
DTE 10 Excel 32	32.7	6.6	164																		12°F to 154°F -11°C to 68°C
DTE 10 Excel 46	45.6	8.5	164																		23°F to 173°F -5°C to 78°C
DTE 10 Excel 68	68.4	11.2	156																		37°F to 196°F 3°C to 91°C
Univis N32	34.9	6.9	164																		12°F to 150°F -11°C to 66°C
Univis N46	46	8.5	163																		24°F to 166°F -4°C to 74°C
Univis N68	73.8	12.1	160																		39°F to 193°F 4°C to 89°C

NOTE: This chart is based on pump manufacturer recommendations of 13 to 500 cST. Temperatures shown are fluid temperatures not ambient temperatures.

Generator Sizing Form Reference

Complete this form and provide a copy to your generator supplier. This information will enable your generator supplier to correctly size a generator for your application.

1. Horsepower of Motor: _____ HP

2. Motor Voltage: _____ Volts

3. Motor Phases: 1 Phase or 3 Phase

4. Motor Frequency: 50Hz or 60Hz

5. Heater Wattage Rating: _____ Watts

6. Heater Voltage: _____ Volts

7. Operational Altitude Range: Minimum _____ Maximum _____

8. Ambient Temperature Range: Minimum _____ Maximum _____

9. Duty Cycle: Standby (Not continuous 24 hours a day)

10. Allowable Voltage Dip: 20%

11. Allowable Frequency Dip: 5%

12. Starting Load Application: Simultaneous turn-on of both motor and heater.

13. Running Load: Motor continuous, heater cycling on and off at approximately 5 minute intervals.

14. Generator Fuel Preference: Gasoline Diesel

15. Special Requirements for Customer Application: _____

Reference Notes

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412

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