

MI McELROY

FUSION CATALOG & REFERENCE GUIDE

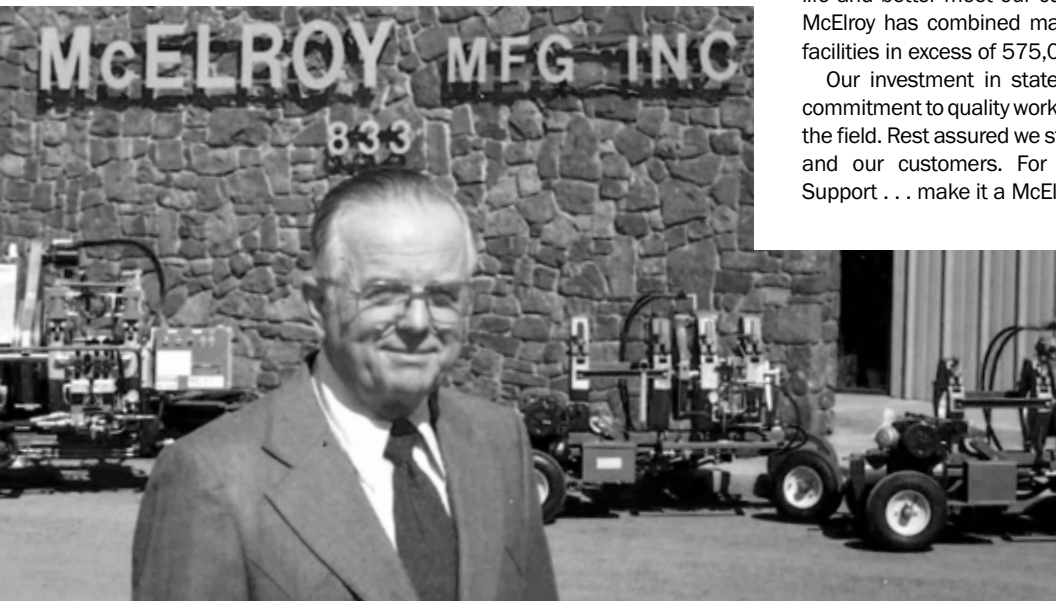


THE LEADER IN THERMOPLASTIC PIPE FUSION

McElroy began 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 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 - to 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.



HOW TO USE THIS CATALOG

Fusion equipment in this catalog is organized by product line. Technical specifications and part numbers for that machine range can be found at the end of each section.

- DISCOVER THE RIGHT MACHINE**
Product models are compared at the end of each section to help you find the right machine for your jobsite needs.
- EXPLORE PRODUCT SPECIFICATIONS**
Look for dimensions, power requirements and other information on each model at the end of each product section.
- FIND ACCESSORIES & REPLACEMENT PARTS**
Turn towards the back of the catalog to research accessories for all fusion equipment.
- REVIEW REFERENCE MATERIALS**
Evaluate cylinder force options, calculate fusion pressure, find in-depth machine and carriage dimensions and more.

FUSION MACHINES

Find fusion machine features, benefits, specifications and part numbers for pipe sizes from 1/2" CTS to 78" OD (16mm to 2000mm).

PRODUCTIVITY ACCESSORIES

Add productivity-enhancing tools to your fusion operations including the PolyHorse®, QuickCamp™, PolyPorter® and Pipe Rollers.

QUALITY ASSURANCE TOOLS

Add peace of mind to your pipeline with the DataLogger®, Guided Side Bend Tester and In Field® Tensile Tester.

REPLACEMENT PARTS & ACCESSORIES

Look for heater plates, facer stands and more.

REFERENCE

Review conversions, fusion pressure calculations, cylinder force options and detailed dimensions.

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.



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.



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.



A HISTORY OF BEING FIRST

McElroy has a long history of being first. We create products that have become standards of the industry - due to their innovative designs and features.

Here are some of our industry firsts:

- Incorporated our patented Centerline Guidance System
- Manufactured self-contained fusion machines
- Designed a manifold block semi-automatic pressure control system
- Developed highly productive tracked fusion machines



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 1970s are still operating today. They are designed to be used anywhere in the world and at interfacial pressures from 15 PSI to 150 PSI (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.

WORLDWIDE 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. 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





CERTIFIED MCELROY RENTAL

FUSION EQUIPMENT RENTALS AS DEPENDABLE AS YOUR PIPELINE

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.



WHY ARE CERTIFIED MCELROY RENTAL EQUIPMENT FLEETS A STEP ABOVE OTHER RENTAL OPTIONS?

-  **COMPREHENSIVE CHECKLIST**
Your McElroy distributor adheres to a comprehensive checklist for every rental machine in their fleet.
-  **FACTORY-TRAINED**
Factory-trained inspectors and mechanics are on-hand to perform inspection and repairs with genuine McElroy parts.
-  **CONSTANTLY MAINTAINED**
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.
-  **MEETS THE HIGHEST EXPECTATIONS**
Certified McElroy Rental distributors are audited to ensure that each fleet meets the high expectations of the program.



ENJOY PEACE OF MIND

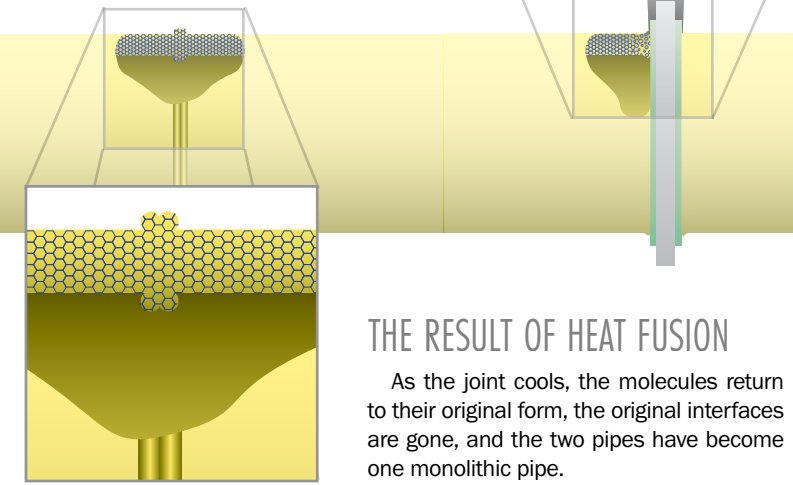
McElroy has a long tradition of standing behind its products. To protect your McElroy rental, the Certified McElroy Rental program works daily to maintain rental fleets around the globe. The combination of genuine parts, a factory-trained team that adheres to a strict set of maintenance requirements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

THE THEORY OF HEAT FUSION

The pipe fusion process associated with McElroy fusion machines is a widely accepted process that joins two pieces of thermoplastic pipe together with heat and pressure. While commonly associated with high-density polyethylene pipe (HDPE), our machines are capable of fusing (or welding) a variety of different types and sizes of pipe including medium-density polyethylene (MDPE), polypropylene and polypropylene-random (PP-R), polyamide nylon pipe (PA11 & PA12), Fusible-PVC® and more.

PRINCIPLES OF HEAT FUSION

Heating two surfaces to a designated temperature and then fusing them together by application of force. This process develops pressure, causing flow of the melted materials, which causes mixing and fusion. When the thermoplastic 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 RESULT OF HEAT FUSION

As the joint cools, the molecules return to their original form, the original interfaces are gone, and the two pipes have become one monolithic pipe.

WHY USE FUSED PIPE?

HEAT-FUSED THERMOPLASTIC PIPE HAS NUMEROUS BENEFITS OVER TRADITIONAL PIPING SYSTEMS



SEAMLESS

Fused thermoplastic pipes create a monolithic pipeline with less mechanical transitions, meaning less opportunities for leaks.



LONGER LIFESPAN

Thermoplastic pipes, like HDPE, are expected to last up to 100 years – saving replacement costs.



COST EFFECTIVE

Heat-fused pipelines create leak-free systems, reduce maintenance or repair needs, and conserve resources.



CORROSION RESISTANT

Thermoplastic pipes don't rust or corrode and are resistant to chemical abrasion.



TOUGH

Thermoplastic pipes can withstand common damages, vibrations and pressure surges.

THE FUSION PROCESS



1 CLAMPING THE PIPE

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



2 FACING THE PIPE

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



3 HEATING THE PIPE

A melt pattern, that penetrates into the pipe, must be formed around both pipe ends.



4 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.

SELECTING THE RIGHT McELROY MACHINE

The fusing of thermoplastic pipe results in a leak-free and corrosion-resistant system that is becoming the preferred choice for replacing conventional piping systems in infrastructures across the country. A crucial part of any new installation is choosing the right equipment for the job. McElroy machines are available in multiple cylinder force configurations to fit your pipe size and fusion standard requirements. They are available with vehicle options, flexible power sources and more to cater to your jobsite's specific needs. And McElroy offers solutions for fusion of pipe from 1/2" CTS to 78" OD (16mm to 2000mm).

1

WHAT PIPE MATERIAL ARE YOU FUSING?

While commonly associated with high-density polyethylene pipe (HDPE), McElroy machines are capable of fusing (or welding) a variety of different types and sizes of pipe including medium-density polyethylene (MDPE), polypropylene and polypropylene-random (PP-R), polyamide nylon pipe (PA11 & PA12), Fusible-PVC® and more.



UNDERSTANDING CYLINDER FORCE

Most McElroy hydraulic machines have the option of multiple carriage cylinders: high force (HF), medium force (MF) and low force (LF). These cylinder selections are identified by the cylinder color: green, orange and yellow respectively. Machine selection depends on the standard, the size range and dimensional ratio (DR) of the pipe and the total effective piston area (TEPA) required to fuse your pipe size.

See Reference section for more details.

- HIGH FORCE
- MEDIUM FORCE
- LOW FORCE

2

WHAT STANDARD ARE YOU FUSING TO?

Standards are the backbone of the fusion process. They contain parameters and procedures that have been developed, established and tested extensively, within the requirements of the industry publishing the standard. It's important to know this critical step before you begin fusing to ensure you follow the pipe manufacturer's recommended procedures.

McElroy equipment meets most generally-accepted fusion standards around the globe including ASTM F2620, ISO 21307, PPI TR-33 and more.



3

WHAT PIPE SIZE ARE YOU USING?

What size of pipe and wall thickness will you be working with? This determines which size carriage and/or combination of carriages you may need. McElroy fusion machines are available for pipe as small as 1/2" CTS (16mm) and as large as 78" (2000mm) OD.

See Reference section for more details.

WHAT TYPE OF FUSION ARE YOU DOING?

McElroy tools are available to perform several types of fusion.

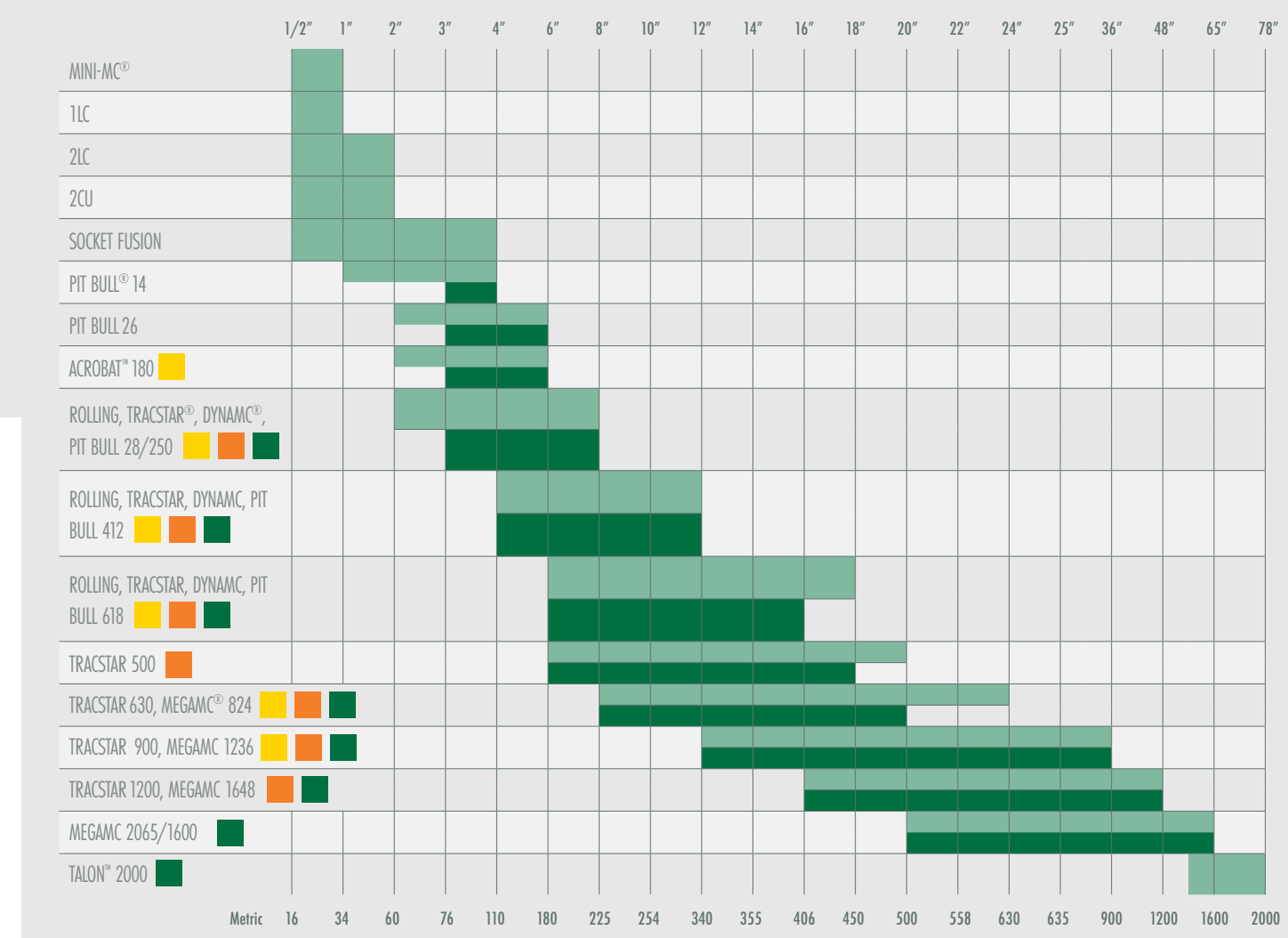
SOCKET FUSION kits are perfect for installing fittings for pipe diameters from 1/2" CTS to 4" IPS (16mm to 125mm).

BUTT FUSION machines are available from 1/2" CTS to 78" OD (16mm to 2000mm) in several configurations to meet jobsite demands.

SIDEWALL FUSION can be completed with the 28/250 range of machines. Pit Bulls, Rolling and TracStars are available as combination units that can accomplish both butt and saddle fusion.

CHOOSING PRODUCTIVITY & QUALITY ASSURANCE ACCESSORIES

Time is of the essence on most jobsites. Taking advantage of productivity tools such as the PolyHorse® and Pipe Stands can expedite your fusion process to help you turn out long runs of fused pipe each day – saving time and money. And don't leave your pipeline to chance. Make sure your fusion joints meet the highest standards, with a complete record to back them up, with industry-leading quality assurance tools including the DataLogger® and Guided Side Bend Tester.



4

WHAT ARE YOUR MACHINE REQUIREMENTS?

Once the pipe size and material have been determined, there are other considerations to make when it comes to choosing a machine that will make your job go more smoothly.

MACHINE OPERATIONS Depending on your pipe size, the fusion functions on McElroy machines utilize either hydraulic power or are manually powered by hand.

- Manually Operated**
Mini-Mc, 1LC, 2LC, 2CU, Socket, Pit Bull 14/26, Sidewinder®, DynaMc
- Hydraulically Operated**
Acrobat, DynaMc, Pit Bull, Rolling, TracStar, MegaMc, Talon

POWER REQUIREMENTS On-site power is an important factor in selecting a machine. McElroy offers solutions to work with on-site generators or completely self-contained machines to meet jobsite preferences.

- Electric-powered**
Mini-Mc, 1LC, 2LC, 2CU, Socket, Pit Bull 14, Pit Bull 26, Acrobat 180, Rolling, DynaMc, Pit Bull, MegaMc
- Diesel/Gas-powered**
Rolling 412 and 618, TracStar, Talon

VEHICLE TYPE Consider the portability of your fusion machine and the need to move around the jobsite. Machines are offered in three basic types: on wheels, on tracks or without a vehicle.

- Wheeled**
Rolling, MegaMc
- Tracked**
TracStar, Talon
- No Vehicle**
Mini-Mc, 1LC, 2LC, 2CU, Socket, Acrobat 180, DynaMc, Pit Bull

OTHER CONSIDERATIONS More features can increase productivity, provide quality assurance and increase flexibility on the job.

- DataLogger® Compatible**
Acrobat, DynaMc, Pit Bull, Rolling, TracStar, MegaMc
- Hydraulic Clamping**
Options available on Rolling, TracStar and MegaMc 412-2065
- Removable Carriage**
Acrobat, DynaMc, Rolling, TracStar, MegaMc



SET UP YOUR FUSION JOB FOR SUCCESS

We believe there is a winning formula in making qualified fusion joints for the most reliable thermoplastic piping systems in the world. Commit yourself to these five important elements and rise to the top of your game in the fusion industry.



For more than 35 years, McElroy has been the only pipe fusion machine manufacturer to continuously offer advanced training. Course offerings are meant to enhance your efficiency, productivity and safety in the proper use of McElroy machines. McElroy University classes are structured so that the skills learned and the machines used in each class closely match the machines found on pipelining jobsites. Our uniquely qualified McElroy University course instructors offer years of industry experience.

WHAT DOES MCELROY UNIVERSITY QUALIFICATION DO FOR YOU?

GET QUALIFIED BY THE INDUSTRY LEADER

Learn proper machine operations and procedures directly from McElroy, the leader in thermoplastic pipe fusion.

GAIN HANDS-ON EXPERIENCE

Students learn on the same type of equipment used on the jobsite, giving them the confidence to excel at their jobs and work more efficiently.

PERSONAL QUALIFICATION

Successful McElroy University qualifications are valid for two years and are associated with the student — not the organization you work for.

INCREASE YOUR VALUE ON THE JOB

McElroy University students stand out from the competition by having an understanding of common industry standards, proper machine procedures and more.

SHOW YOU'VE PASSED A THOROUGH TESTING PROCESS

Students must pass both a written and hands-on test, administered by McElroy-trained instructors, demonstrating their understanding of all course content.

LEARN TO WORK MORE SAFELY & PRODUCTIVELY

Students will demonstrate the ability to use proper operating procedures on all equipment covered and gain a better understanding of efficient machine operation and jobsite setup.

Visit mcelroy.com/university for current course offerings and locations.

FUSION MACHINES

McElroy is the leader in the design and manufacture of the industry's most complete line of pipe fusion equipment for joining thermoplastic pipe. Fusion machines are available for pipe as small as 1/2" CTS to as large as 2000mm OD. They can be hand-held, manually operated machines for small diameter pipe or hydraulically powered machines for medium and large diameter pipe. Whether it's a Pit Bull®, a TracStar® or one of our original wheeled units, we have a pipe fusion machine for every application.

In a hectic world, McElroy tools and thermoplastic pipe work together to make the world a better place through better infrastructure one project at a time.

Manually-operated fusion machines

provide all the power you need to perform accurate fusions all day long on the toughest of jobsites. Rugged and reliable, these compact fusion machines are lightweight and require only one operator. Precision engineering provides joint integrity with minimal maintenance.

SINGLE-OPERATOR FUSION MADE EASY

MANUAL

Pit Bull® 14

THE PERFECT SOCKET FUSION

Socket Tooling offers the perfect method for the installation of fittings with the ability to socket fuse ½" CTS to 4" IPS (16mm to 125mm) pipe. These socket tools are designed to meet ASTM F1056, ISO 8085-1 and ISO 4437 standards. Kits come in a range of sizes to fit your specific needs and include all of the necessary tooling.



CONSISTENT JOINT QUALITY

CENTERLINE GUIDANCE PROVIDES EQUAL DISTRIBUTION OF FORCE

Centerline Guidance is a balanced force system that is unique to all McElroy machines. This patented feature places the centerline of the pipe clamping jaws on the same plane as the pipe's centerline. The force applied during the fusion passes through the center of the pipe, producing an equal distribution of force around the diameter of the pipe which results in an even, continuous bead formation and quality joint.



1LC

Mini-Mc®

HAND-POWERED OPERATIONS

DESIGNED FOR PRECISION & EASE OF USE

With a small footprint and compact design, the manual machines perform anywhere you need them to – on the ground or in the ditch. The machines are made primarily of surface-hardened aluminum, making them light and easy to carry yet rugged enough to withstand even the toughest of conditions. A narrow clamp design helps align pipe precisely at the fusion joint, bringing simplicity and ease of use to hand-operated small fusion.



Sidewinder®

SIDEWALL & SADDLE FUSION

There are two manual machine options for sidewall fusion: the 2CU (Combination Unit) and the Sidewinder®. The 2CU's chain clamping feature allows the unit to be attached in alignment with the center of the pipe main for sidewall fusion of ½" to 2" service saddles, round base branch saddles and small tapping tees. It also has butt fusion capability. The Sidewinder fusion machines saddle fuse 4" IPS and smaller branch saddles, tapping tees and service saddle fittings onto 1 ¼" to 4" IPS and larger main sizes. The Sidewinder is offered in two configurations: jaw clamping for saddle fusion onto 1 ¼" to 4" IPS mains and chain clamping for saddle fusion onto main sizes larger than 4" IPS.



2LC

COMPACT & LIGHTWEIGHT

A compact and lightweight design simplifies small-diameter butt fusion projects with only one operator required. A small footprint makes McElroy manual machines the ideal tools for fusing pipe in tight spaces with fusion force easily applied by hand.

TOUGH CONSTRUCTION

HARD-ANODIZED ALUMINUM SURFACES FOR CORROSION RESISTANCE

McElroy equipment is built to withstand the tough environments our industry encounters. Hard-anodized aluminum surfaces resist corrosion, and ISO-compliant industrial Teflon-coated heater plates ensure durability and long life.



Pit Bull® 14



Socket Tooling

Mini-Mc®

1LC

MULTIPLE MACHINE CHOICES

McElroy's manual machines offer a compact and lightweight solution for butt fusing pipe sizes from ½" CTS to 6" DIPS (16mm to 180mm). Individual machines cover a range of pipe diameters giving you the flexibility to fuse multiple pipe sizes with one machine.

FIND THE RIGHT MACHINE FOR YOUR JOBSITE

STANDARD FEATURES

	Mini-Mc	1LC	2LC	2CU	Socket Fusion Kit	Pit Bull® 14	Pit Bull 26	Sidewinder®
Hand-operated	●	●	●	●	●	●	●	●
Thermostatically-controlled heater to provide constant fusion temperature	●	●	●	●	●	●	●	●
ISO-compliant industrial Teflon-coated heater plates	●	●	●	●	●	●	●	●
Compact and durable	●	●	●	●	●	●	●	●
ADDITIONAL FEATURES								
Patented Centerline Guidance System for equal distribution of force around the joint	●	●	●	●		●	●	
Hard-anodized aluminum surfaces for corrosion resistance	●	●	●	●		●	●	
Thrust-bearing-equipped clamp knobs to minimize force required to clamp and round pipe	●	●	●	●		●	●	●
Serrated jaws and inserts keep pipe from slipping during fusion	●	●	●	●		●	●	●
Locking mechanism to maintain force during the cooling cycle		●	●			●	●	●
Electric facer design						●	●	
Sidewall capabilities for fusion of branch saddles and tapping tees				●				●
DataLogger® compatible								●



INDUSTRY LEADING WARRANTY

McElroy leads the industry by standing by our products. We warrant all products manufactured, sold and repaired to be free from defects in materials and workmanship for 5 years. **See inside back cover for details.**

FEATURED ACCESSORIES See Replacement Parts & Accessories section for more information.



MANUAL MACHINE STAND
Expands to a comfortable operator height, folds for easy storage and has wheels for easy transporting.



HEAT SHIELD
For fusing two materials with different melt rates.



HOT TAP TOOL
Branch saddle tapping tool for polyethylene pipe.

See **Productivity Tools** section for more information.



MINI-MC FACER SET
Facer insert sets must be selected for each pipe size. Compatible with either facer.

FIND SIDEWALL ACCESSORIES

See **Replacement Parts & Accessories** section for inserts, heaters, heater adapters and more for Sidewinder and 2LC sidewall fusion machines.



FIND INSERTS

See **Replacement Parts & Accessories** section for butt fusion inserts for all manual machines.



	MINI-MC® ½" CTS - 1" IPS (16mm - 34mm)		1LC ½" CTS - 1" IPS (16mm - 34mm)				2LC ½" CTS - 2" IPS (16mm - 60mm)		2CU ½" CTS - 2" IPS (16mm - 60mm)	
MODELS	1" IPS Machine	32mm Machine	1" IPS Machine		32mm Machine					
Input Voltage	N/A	N/A	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph
Part Number	CTS07901	CTS08001	ACTS23301	ACTS23302	ACTS23303	ACTS23304	A217201	A217202	A200101	A200102
WEIGHT	3.5 lbs (1.6 Kg)		3.6 lbs (1.63 Kg)				23 lbs (10.4 Kg)		28 lbs (12.7 Kg)	
Facer	Sold separately		1.8 lbs (0.82 Kg)				7.9 lbs (3.54 Kg)		7.9 lbs (3.54 Kg)	
Heater	Sold separately		2.5 lbs (1.13 Kg)				7.24 lbs (3.28 Kg)		7.24 lbs (3.28 Kg)	
POWER			100 Watt				800 Watt		800 Watt	
Heater			Hand-operated with ¾" square drive				Hand-operated		Hand-operated	
Facer	Sold separately									
Plug Type ①			A	C	A	C	A	C	A	C
DIMENSIONS ②			DIMENSIONS ②				DIMENSIONS ②		DIMENSIONS ②	
Length	7.75" (197mm)		5.25" (133mm)				13" (330mm)		11" (279mm)	
Width	3.75" (95mm)		4.25" (108mm)				14" (357mm)		20" (508mm)	
Height	11.5" (292mm)		7.5" (191mm)				15" (381mm)		16" (406mm)	
INCLUDES	Fusion machine and screw/driver kit		Fusion machine, heater, facer, insulated heater sling, ratchet wrench, screw/driver kit and case				Fusion machine, heater, facer, insulated heater/facer stand and screw/driver kit		Fusion machine, heater, facer, insulated heater/facer stand and screw/driver kit	

SOCKET TOOLING KITS

½" CTS - 4" IPS (16mm - 125mm)

MODELS	ASW19101	ASW19102	ASW19201	ASW19202	ASW19301	ASW19302	ASW19401	ASW19402	ASW19501	ASW19502	ASW19601	ASW19602
Pipe Size Range	¾" - 2" IPS		½" CTS - 2" IPS		3" & 4" IPS		¾" & 1 ¼" IPS		16mm - 63mm		75mm - 125mm	

HEATER													
Heater Size	2"		2"		4"		2"		2"		4"		
Voltage Requirements	100-120V, 50/60Hz, 800 Watt, 1Ph	200-240V, 50/60Hz, 800 Watt, 1Ph	100-120V, 50/60Hz, 800 Watt, 1Ph	200-240V, 50/60Hz, 800 Watt, 1Ph	100-120V, 50/60Hz, 1,200 Watt, 1Ph	200-240V, 50/60Hz, 1,200 Watt, 1Ph	100-120V, 50/60Hz, 800 Watt, 1Ph	200-240V, 50/60Hz, 800 Watt, 1Ph	100-120V, 50/60Hz, 800 Watt, 1Ph	200-240V, 50/60Hz, 800 Watt, 1Ph	100-120V, 50/60Hz, 800 Watt, 1Ph	200-240V, 50/60Hz, 800 Watt, 1Ph	
Plug Type ①	A	C	A	C	A	C	A	C	A	C	A	C	

ADAPTERS & CUTTERS												
Socket Fitting Holder(s)	2" IPS		2" IPS		3" and 4" IPS		N/A	2" IPS		3" and 4" IPS		
Shears/Cutters	1.7" & 2.4" OD capacity						4" Plastic pipe cutter		1.7" & 2.4" OD capacity		4" Plastic pipe cutter	
Heater Adapters Included	¾" IPS, 1" IPS, 1 ¼" IPS, 1 ½" IPS, 2" IPS		½" CTS, ½" IPS, ¾" CTS, ¾" IPS, 1" CTS, 1" IPS, 1 ¼" CTS, 1 ¼" IPS, 1 ½" IPS, 2" IPS		3" IPS, 4" IPS		¾" IPS, 1 ¼" IPS		16mm, 20mm, 25mm, 32mm, 40mm, 50mm, 65mm		75mm, 90mm, 110mm, 125mm	

INCLUDES
Tool box, heater, heater adapters, tubing shears/cutters, chamfer tools/depth gauges, screw/driver kit and cold ring tools

① See **Reference** section for plug types

② See **Reference** section for more detailed dimensions

	PIT BULL® 14 1" IPS - 4" DIPS (32mm - 110mm)		PIT BULL 26 2" IPS - 6" DIPS (63mm - 180mm)		
MODELS	6" DIPS Machine		180mm Machine		
Input Voltage	100-120V, 50/60Hz, 1Ph	200-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	200-240V, 50/60Hz, 1Ph	200-240V, 50/60Hz, 1Ph
Part Number	A430101	A430102	A708502	A708505	A708504
WEIGHT	35 lbs (15.9 Kg)		50 lbs (22.7 Kg)		
Facer	21.56 lbs (9.78 Kg)		32 lbs (14.5 Kg)		
Heater	10 lbs (4.53 Kg)		14 lbs (6.4 Kg)		
POWER			POWER		
Minimum Power Req.	3 kVA, 2.5 kW		3 kVA, 2.5 kW		
Heater	1,200 Watt		1,200 Watt		
Facer	0.5 HP, 7 Amp	0.5 HP, 3.5 Amp	0.5 HP, 7 Amp	1.6 HP, 5 Amp	
Plug Type ①	A	C	A	C / M	C / M
DIMENSIONS ②			DIMENSIONS ②		
Length	15.5" (394mm)		15.4" (391mm)		
Width	16.5" (419mm)		19.7" (500mm)		
Height	31.8" (808mm)		30.4" (773mm)		
INCLUDES	Fusion machine, heater, facer, insulated heater stand and screw/driver kit		Fusion machine, heater, facer, insulated heater stand, facer stand, 6" IPS/180mm insert set and screw/driver kit		

① See **Reference** section for plug types

② See **Reference** section for more detailed dimensions

INCREASE PRODUCTIVITY ON THE JOB

Pair a manual machine stand and two PolyPorters® with either a Pit Bull 14 or 26 to save time and money. Combine these labor-saving tools in one convenient package.

14 PACKAGE		26 PACKAGE (6" DIPS)		26 PACKAGE (180mm)	
120V	240V	120V	240V	240V	
A441501	A441502	A708402	A708405	A708404	

	SIDEWINDER® Saddle Fuse 4" IPS and Smaller Branch Saddles			
MODELS	Chain Clamp	Compact Chain Clamp	Jaw Clamp	Compact Jaw Clamp
1500 PSI	ASW00110	ASW00120	ASW00130	ASW00140
1000 PSI	ASW00111	ASW00121	ASW00131	ASW00141
600 PSI	ASW00112	ASW00122	ASW00132	ASW00142
300 PSI	ASW00113	ASW00123	ASW00133	ASW00143
WEIGHT	28 lbs (13 Kg)			
Machine	27 lbs (12 Kg)	26 lbs (11.7 Kg)	25 lbs (11 Kg)	
DIMENSIONS				
Length	12.5" (318mm)	12.5" (318mm)	7.75" (203mm)	7.75" (203mm)
Width	12.5" (318mm)	12.5" (318mm)	10.5" (267mm)	10.5" (267mm)
Height	26.5" (673mm)	21.4" (546mm)	28" (711mm)	23" (584mm)
INCLUDES	Fusion machine, 3" pivot master and screw/driver kit			

The Acrobat™ is a versatile fusion machine capable of butt fusing 63mm to 180mm (2" IPS to 6" DIPS) pipe and fittings in adherence to both high and low interfacial pressure standards. With its small footprint and light weight, it can be carried from joint-to-joint yet has the same rugged durability and long-lasting performance expected of any McElroy butt fusion machine.

COMPACT, RELIABLE
BUTT FUSION

ACROBAT



SMALL FOOTPRINT

VERSATILE FOR ANY JOBSITE SITUATION

The Acrobat™ was designed with a small footprint and optimal weight. Modular HPU options, along with a portable heater and facer, make it simple to move from joint-to-joint.



PRESET PRESSURES

SMARTER DESIGN PRODUCES MORE EFFICIENT OPERATIONS

The intelligent design of both the Acrobat™ and DynaMc® HPUs allow the operator to preset the facing, heating and fusing pressures individually. This streamlines the fusion process, negating the need to make adjustments between operations.

HYDRAULIC POWER CHOICES

LIGHTWEIGHT & ROBUST OPTIONS

The Acrobat is compatible with two impressive hydraulic power units designed to meet the maximum system pressure desired on your jobsite. Choose either the lightweight Acrobat HPU that has a maximum gauge pressure up to 800 PSI or the more powerful DynaMc HPU that can reach pressures up to 1,500 PSI.



NO TOOLS REQUIRED

Acrobat carriages are thoughtfully designed to quickly adapt to meet jobsite demands. They can be configured from a 4-jaw to a 3-jaw machine by removing the base - all without the use of tools. In more confining spaces, the top jaws can be removed completely with the pull of a pin, for easier manipulation around pipe and fittings. A convenient insert design allows an operator to effortlessly change sizes to fit pipe dimensions with a snap. The heater and facer can be loaded from either the top or the bottom of the carriage (in the 3-jaw configuration) giving the operator better access and flexibility regardless of the joining challenge.

SMART HPU DESIGN

ADDED CONVENIENCE ON THE JOBSITE

The Acrobat HPU's smart design incorporates outlets for both the heater and facer. This allows the entire machine to draw power from a single source for easy jobsite setup.



DATALOGGER® COMPATIBLE

RECORD & ANALYZE JOINT DATA

Acrobat machines are compatible with the McElroy DataLogger, an Android-powered tablet that records and documents the key parameters of the fusion process. These joint records are used to verify that proper fusion procedures have been followed prior to installation, which is a growing jobsite requirement. Joint records from the DataLogger can be securely stored and analyzed online in the DataLogger Vault™. This allows quick and easy sorting, tagging and sharing of joint records by machine, joint, operator, device or job.



ACROBAT 180

63mm - 180mm (2" IPS - 6" DIPS)

MODELS	120V	240V
Fusion machine with Acrobat HPU	A714801	A714802
Fusion machine with DynaMc HPU	A714803	A714804

WEIGHT

4-Jaw Carriage	18.1 Kg (40 lbs)
3-Jaw Carriage	13.2 Kg (29 lbs)
Facer	15.9 Kg (35 lbs)
Heater	6.4 Kg (14 lbs)
Acrobat HPU	25.4 Kg (56 lbs)
DynaMc HPU	52.1 Kg (115 lbs)

HYDRAULICS

Acrobat HPU Max. Gauge Pressure	55.2 BAR (800 PSI)
DynaMc HPU Max. Gauge Pressure	103.4 BAR (1,500 PSI)

POWER

Total Power Requirement	0.78 kVA, 0.66 kW	1.08 kVA, 0.92kW
Heater Power	1,200 Watts	
Facer Power	0.9 kVA, 0.7 kW	1.2 kVA, 1 kW
Plug Type ¹	A	M
Acrobat HPU	0.3 HP, 6.5 AMP	0.3 HP, 4.5 AMP
DynaMc HPU	2.2 HP, 14 AMP	2.2 HP, 7 AMP

CHASSIS

Frame	Welded aluminum construction
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DIMENSIONS ²

Machine	Length	597mm (23.5")
	Width	381mm (15")
	Height	356mm (14")
Acrobat HPU	Length	562mm (22.1")
	Width	355mm (13.2")
	Height	482.5mm (19")
DynaMc HPU	Length	622mm (25")
	Width	279mm (11")
	Height	546mm (21.5")

INCLUDES

Fusion machine, facer, heater, insulated heater stand, facer stand, HPU and shipping container

¹ See **Reference** section for plug types

² See **Reference** section for more detailed dimensions

ACROBAT™ FEATURES & HPU COMPARISONS

STANDARD FEATURES

	Acrobat 180	Acrobat HPU	DynaMc® HPU
Small footprint, lightweight	●		
Toolless conversion from 4-jaw to 3-jaw carriage for tight work spaces	●		
Narrow jaws and inserts allow fusions for flanges to outlet branch of tees and most fittings	●		
Hard-anodized aluminum wear surfaces for corrosion resistance	●		
Single insert design	●		
Quick, toolless removal of upper jaws	●		
Easy, quick connections to HPU without tools	●		
Cylinder force options (H =High force, M =Medium force, L =Low force)			L

HPU COMPARISONS

Low-power consumption		●	●
Preset facing, heating and fusion pressures		●	●
1,500 PSI maximum system pressure			●
800 PSI maximum system pressure		●	
Heater and facer outlets on HPU		●	
DataLogger compatible		●	●



INDUSTRY LEADING WARRANTY

McElroy leads the industry by standing by our products. We warrant all products manufactured, sold and repaired to be free from defects in materials and workmanship for 5 years. **See inside back cover for details.**

Perfect for in-ditch and close-quarter butt fusion,

the DynaMc® line of machines pack a lot of power into a small package. They combine the robust, patented features of standard McElroy equipment into smaller units for use in tight working environments. They are available in 2- and 4-jaw units that easily detach from the cradle to further reduce the footprint of the machine. The DynaMc is a great choice on challenging jobsites when only a few fusions need to be made. It is offered in three pipe size ranges, from as small as 2" (63mm) up to 12" (340mm).

**BIG POWER,
SMALL PACKAGE**

DYNAMC



MULTIPLE MACHINE OPTIONS

HAND PUMP (HP), ELECTRIC PUMP (EP) & AUTOMATIC MODELS AVAILABLE

There are three different DynaMc options to meet customer demands. DynaMc HP machines butt fuse pipe with hand-powered pumps while the DynaMc EP is powered by a common hydraulic power unit (HPU). This same HPU can be used with many other DynaMc machines. The DynaMc Autos offer a powerful mix of features and operate within many specifications including PL2-3 and 4-32-08 for the gas and water industries respectively.



CONSISTENT JOINT QUALITY

DynaMc machines are designed to deliver consistent joint quality every time. The patented Centerline Guidance feature is a balanced force system that insures that the pipe centerline is on the same plane as the clamping jaws to provide equal distribution of force around the diameter of the pipe. Rigid aluminum carriage construction and hard-anodized jaws assist in re-rounding the pipe and maintaining alignment. Electric-powered hydraulic units utilize a semi-automatic control that maintains steady pressure throughout the fusion process – helping to produce quality joints.



MODULAR & COMPACT DESIGN

ADAPTS FOR CLOSE-QUARTER FUSION

The DynaMc® consists of a carriage, facer, facer stand, heater and insulated heater stand. The modular design provides for flexibility in confined working environments. Each of the components have a compact design with space limitations in mind. The DynaMc is available in 2- and 4-jaw configurations. On 4-jaw units, the full-length guide rod and unique movable third jaw allow work in close proximity to ells and tees without the removal of the outer jaw.



DATALOGGER® COMPATIBLE

RECORD & ANALYZE JOINT DATA

DynaMc EP and HP machines are compatible with the McElroy DataLogger, an Android-powered tablet that records and documents the key parameters of the fusion process. These joint records are used to verify that proper fusion procedures have been followed prior to installation, which is a growing jobsite requirement. Joint records from the DataLogger can be securely stored and analyzed online in the DataLogger Vault™. This allows quick and easy sorting, tagging and sharing of joint records by machine, joint, operator, device or job.

AUTO MODELS AVAILABLE

AUTOMATIC FUSION PARAMETER CALCULATIONS

The DynaMc® Auto machines offer a completely automatic solution for the fusion process with a powerful mix of features designed with input from industry experts.

The modular design of the DynaMc Auto features a common electric control unit and HPU to operate the carriage, heater and facer. The self-retracting heater minimizes open and close times, while the electronic control unit offers a USB port for downloading fusion reports and uploading firmware updates.

FIND THE RIGHT DYNAMC FOR YOUR JOBSITE

STANDARD FEATURES

	DynaMc HP	DynaMc EP & HPU	DynaMc Auto
Patented Centerline Guidance System for equal distribution of force around the joint	●	●	●
Serrated jaws and inserts keep pipe from slipping during fusion	●	●	●
On 4-jaw units, the full-length guide rod and unique movable third jaw allow work in close proximity to ells and tees without the removal of the outer jaw	●	●	●
Detachable easy-lift cradle for improved maneuverability to and from worksite	●	●	●
Powerful electric facer that can be loaded from either side of the carriage	●	●	●
Cylinder force options (H=High force, M=Medium force, L=Low force)	L	L	L

ADDITIONAL FEATURES

Utilizes a hydraulic accumulator to maintain fusion pressure and reduce power consumption		●	●
2-jaw machine available	●	●	
Double-action hand pump and high-velocity cylinders create fast carriage speeds during fusion processes	●		
DataLogger® compatible	●	●	
Features a common Electric Pump that powers a variety of fusion machines		●	
USB port for downloading fusion reports and uploading firmware			●
Weather-resistant enclosure for control unit			●

5 YEAR WARRANTY INDUSTRY LEADING WARRANTY

McElroy leads the industry by standing by our products. We warrant all products manufactured, sold and repaired to be free from defects in materials and workmanship for 5 years. **See inside back cover for details.**

FEATURED ACCESSORIES See Replacement Parts & Accessories section for more information.



HYDRAULIC POWER UNIT (HPU)

A hydraulic accumulator maintains fusion pressure and reduces power consumption.



HEAT SHIELD

For fusing two materials with different melt rates.



STUB END HOLDER

Holds various sizes of stub end fittings for fusion to the end of a pipe.



INSERT SETS

Surface hardened for longer life and are serrated for maximum grip.



DYNAMIC® 28 HP (HAND PUMP)
2" IPS - 8" DIPS (63mm - 225mm)



DYNAMIC 28 EP (ELECTRIC PUMP)
2" IPS - 8" DIPS (63mm - 225mm)

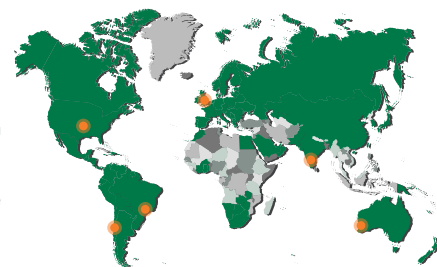


DYNAMIC 28 SIDEWALL
Max. Fitting Base Diameter 9.63" (245mm)

MODELS		2-Jaw		4-Jaw		2-Jaw		4-Jaw		1-Jaw/Tailstock							
Input Voltage		100-120V	220-240V	100-120V	220-240V	See separate heater and facer voltage requirements below											
Low Force		A881701	A881702	A881401	A881402	A900201	A900203	A900202	A900204	A900101	A900103	A900102	A900104	898101			
WEIGHT		WEIGHT		WEIGHT		WEIGHT		WEIGHT		WEIGHT		WEIGHT		WEIGHT			
Machine		108 lbs (49 Kg)		155 lbs (70 Kg)		78 lbs (36 Kg)		125 lbs (57 Kg)		88 lbs (40 Kg)		88 lbs (40 Kg)		88 lbs (40 Kg)			
Facer		39 lbs (17.7 Kg)				39 lbs (17.7 Kg)				Sold separately							
Heater		21 lbs (9.5 Kg)				21 lbs (9.5 Kg)				Sold separately							
HYDRAULICS		HYDRAULICS		HYDRAULICS		HYDRAULICS		HYDRAULICS		HYDRAULICS		HYDRAULICS		HYDRAULICS			
Max. System Pressure		1,500 PSI (103 BAR)		See HPU section for details		See HPU section for details		See HPU section for details		See HPU section for details		See HPU section for details		See HPU section for details			
POWER		POWER		POWER		POWER		POWER		POWER		POWER		POWER			
Minimum Power Req.		3 kVA, 2.9 kW		3 kVA, 2.9 kW (Add HPU power for total power required)		3 kVA, 2.9 kW (Add HPU power for total power required)		3 kVA, 2.9 kW (Add HPU power for total power required)		3 kVA, 2.9 kW (Add HPU power for total power required)		3 kVA, 2.9 kW (Add HPU power for total power required)		3 kVA, 2.9 kW (Add HPU power for total power required)			
Heater Power		1,750 Watt				1,750 Watt				1,750 Watt				1,750 Watt			
Heater Voltage Req.		100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph		
Facer Power		1.6 HP, 10 AMP	1.6 HP, 5 AMP	1.6 HP, 10 AMP	1.6 HP, 5 AMP	1.6 HP, 10 AMP	1.6 HP, 5 AMP	1.6 HP, 10 AMP	1.6 HP, 5 AMP	1.6 HP, 10 AMP	1.6 HP, 5 AMP	1.6 HP, 10 AMP	1.6 HP, 5 AMP	1.6 HP, 10 AMP	1.6 HP, 5 AMP		
Facer Voltage Req.		100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	220-240V, 50/60Hz, 1Ph		
Plug Type (Facer/Heater)		A/A	M/C	A/A	M/C	A/A	M/A	A/C	M/C	A/A	M/A	A/C	M/C	A/A	M/C		
DIMENSIONS (MACHINE CARRIAGE)		DIMENSIONS		DIMENSIONS		DIMENSIONS		DIMENSIONS		DIMENSIONS		DIMENSIONS		DIMENSIONS			
Length		25.8" (656mm)		34.3" (872mm)		26" (660mm)		34" (864mm)		30" (760mm)		30" (760mm)		30" (760mm)			
Width		25.9" (658mm)		25.9" (658mm)		21" (533mm)		21" (533mm)		18.5" (470mm)		18.5" (470mm)		18.5" (470mm)			
Height		23.4" (595mm)		23.4" (595mm)		19" (483mm)		19" (483mm)		20" (508mm)		20" (508mm)		20" (508mm)			
INCLUDES		INCLUDES		INCLUDES		INCLUDES		INCLUDES		INCLUDES		INCLUDES		INCLUDES			
		Fusion carriage, facer, facer stand, heater and insulated heater stand		Fusion carriage, facer, facer stand, heater and insulated heater stand.		EP Hydraulic Power Unit (HPU) sold separately		Fusion carriage, facer, facer stand, heater and insulated heater stand.		EP Hydraulic Power Unit (HPU) sold separately		Fusion carriage, facer, facer stand, heater and insulated heater stand.		EP Hydraulic Power Unit (HPU) sold separately			

① See **Reference** section for plug types
② See **Reference** section for more detailed dimensions

WORLDWIDE SALES, SERVICE & SUPPORT
FIND A DISTRIBUTOR NEAR YOU!
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.



① See **Reference** section for plug types
② See **Reference** section for more detailed dimensions



DYNAMIC® 28 EP COMPACT VERTICAL
2" IPS - 8" DIPS (63mm - 225mm)



DYNAMIC 250 HP (HAND PUMP)
63mm - 250mm (2" IPS - 8" DIPS)



DYNAMIC 250 EP (ELECTRIC PUMP)
63mm - 250mm (2" IPS - 8" DIPS)

MODELS		3-Jaw		2-Jaw		4-Jaw		2-Jaw		4-Jaw	
Input Voltage		100-120V		See separate heater and facer voltage requirements below		See separate heater and facer voltage requirements below		See separate heater and facer voltage requirements below		See separate heater and facer voltage requirements below	
Low Force		A893001		A882701	A882702	A882601	A882602	A900401	A900402	A900301	A900302
WEIGHT		WEIGHT		WEIGHT		WEIGHT		WEIGHT		WEIGHT	
Machine		240 lbs (108.9 Kg)		49 Kg (108 lbs)		70 Kg (155 lbs)		36 Kg (78 lbs)		57 Kg (125 lbs)	
Facer		39 lbs (17.7 Kg)		17.7 Kg (39 lbs)		17.7 Kg (39 lbs)		17.7 Kg (39 lbs)		17.7 Kg (39 lbs)	
Heater		21 lbs (9.5 Kg)		9.5 Kg (21 lbs)		9.5 Kg (21 lbs)		9.5 Kg (21 lbs)		9.5 Kg (21 lbs)	
HYDRAULICS		HYDRAULICS		HYDRAULICS		HYDRAULICS		HYDRAULICS		HYDRAULICS	
Max. System Pressure		See HPU section for details		103 BAR (1,500 PSI)		See HPU section for details		See HPU section for details		See HPU section for details	
POWER		POWER		POWER		POWER		POWER		POWER	
Minimum Power Req.		3 kVA, 2.9 kW (Add HPU power for total power required)		4.2 kVA, 4.2 kW (Add HPU power for total power required)		4.2 kVA, 4.2 kW (Add HPU power for total power required)		4.2 kVA, 4.2 kW (Add HPU power for total power required)		4.2 kVA, 4.2 kW (Add HPU power for total power required)	
Heater Power		1,750 Watt		1,750 Watt	3,000 Watt	1,750 Watt	3,000 Watt	1,750 Watt	3,000 Watt	1,750 Watt	3,000 Watt
Heater Voltage Req.		100-120V, 50/60Hz, 1Ph		220-240V, 50/60Hz, 1Ph		220-240V, 50/60Hz, 1Ph		220-240V, 50/60Hz, 1Ph		220-240V, 50/60Hz, 1Ph	
Facer Power		1.6 HP, 10 Amp @ 120V		1.6 HP, 10 AMP	1.6 HP, 5 AMP	1.6 HP, 10 AMP	1.6 HP, 5 AMP	1.6 HP, 10 AMP	1.6 HP, 5 AMP	1.6 HP, 10 AMP	1.6 HP, 5 AMP
Facer Voltage Req.		100-120V, 50/60Hz, 1Ph		100-120V, 50/60Hz, 1Ph	200-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	200-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	200-240V, 50/60Hz, 1Ph	100-120V, 50/60Hz, 1Ph	200-240V, 50/60Hz, 1Ph
Plug Type (Facer/Heater)		N	C	A/C	M/C	A/C	M/C	A/C	M/C	A/C	M/C
DIMENSIONS (MACHINE CARRIAGE)		DIMENSIONS		DIMENSIONS		DIMENSIONS		DIMENSIONS		DIMENSIONS	
Length		29" (736.6mm)		660mm (26")		864mm (34")		660mm (26")		864mm (34")	
Width		31" (787.4mm)		660mm (26")		660mm (26")		533mm (21")		533mm (21")	
Height		40" (1,016mm)		597mm (23.5")		597mm (23.5")		483mm (19")		483mm (19")	
INCLUDES		INCLUDES		INCLUDES		INCLUDES		INCLUDES		INCLUDES	
		Fusion carriage, facer, facer stand, heater and insulated heater stand. Electric Pump HPU is sold separately		Fusion carriage, facer, facer stand, heater and insulated heater stand		Fusion carriage, facer, facer stand, heater and insulated heater stand		Fusion carriage, facer, facer stand, heater and insulated heater stand.		EP Hydraulic Power Unit (HPU) sold separately	

ACCESSORIES
See **Replacement Parts & Accessories** section for replacement parts and accessories for DynaMc fusion machines.

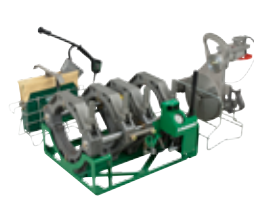


FIND INSERTS
See **Replacement Parts & Accessories** section for butt fusion and mitered inserts for DynaMc machines.





DYNAMIC® 250 AUTO
63mm - 250mm (2" IPS - 8" DIPS)



DYNAMIC 412 HP (HAND PUMP)
4" IPS - 12" DIPS (110mm - 340mm)



DYNAMIC 412 EP (ELECTRIC PUMP)
4" IPS - 12" DIPS (110mm - 340mm)



DYNAMIC 412® AUTO
4" IPS - 12" DIPS (110mm - 340mm)



DYNAMIC EP HPU (HYDRAULIC POWER UNIT)



DYNAMIC AUTO HPU

MODELS	4-Jaw				2-Jaw		4-Jaw		2-Jaw				4-Jaw											
Input Voltage	110-120V				220-240V		See separate heater & facer voltage requirements below				See separate heater & facer voltage requirements below													
Low Force	A887001				A887002		A1263601		A1263602		A1262901		A1262902		A1274901		A1274902		A1274801		A1274802			
WEIGHT							WEIGHT						WEIGHT											
Machine	54 Kg (119 lbs)				200 lbs (90 Kg)		293 lbs (132 Kg)		170 lbs (77 Kg)				263 lbs (120 Kg)											
Facer	21.3 Kg (47 lbs)				54 lbs (24.5 Kg)		24 lbs (10.9 Kg)		54 lbs (24.5 Kg)				24 lbs (10.9 Kg)											
Heater	19.5 Kg (43 lbs)				24 lbs (10.9 Kg)				24 lbs (10.9 Kg)															
HYDRAULICS							WEIGHT						WEIGHT											
Max. System Pressure	83 BAR (1,200 PSI)				1,500 PSI (103 BAR)		See HPU section for details		See HPU section for details															
POWER							WEIGHT						WEIGHT											
Minimum Power Req.	3 kVA, 3kW (Add Auto HPU power for total power required)				4.2 kVA, 4.2 kW		4.2 kVA, 4.2 kW (Add HPU power for total power required)		4.2 kVA, 4.2 kW (Add HPU power for total power required)															
Heater Power	3,000 Watt				3,000 Watt		3,000 Watt		3,000 Watt															
Heater Voltage Req.	110-120V, 50/60Hz, 1Ph		220-240V, 50/60Hz, 1Ph		220-240V, 50/60Hz, 1Ph		220-240V, 50/60Hz, 1Ph		220-240V, 50/60Hz, 1Ph															
Facer Power	Hydraulic				1.6 HP, 10 AMP		1.6 HP, 5 AMP		1.6 HP, 10 AMP		1.6 HP, 5 AMP		1.6 HP, 10 AMP				1.6 HP, 5 AMP							
Facer Voltage Req.	N/A				100-120V, 50/60Hz, 1Ph		220-240V, 50/60Hz, 1Ph		100-120V, 50/60Hz, 1Ph		220-240V, 50/60Hz, 1Ph		100-120V, 50/60Hz, 1Ph				220-240V, 50/60Hz, 1Ph							
Plug Type (Facer/Heater)	N				A/M		M/M		A/M		M/M		A/M				M/M							
DIMENSIONS (MACHINE CARRIAGE)							WEIGHT						WEIGHT											
Length	864mm (34")				27" (686mm)		34" (864mm)		27" (686mm)				34" (864mm)											
Width	533mm (21")				32" (813mm)		27" (686mm)		27" (686mm)															
Height	483mm (19")				26.5" (673mm)		24" (610mm)		24" (610mm)															
INCLUDES	Auto hydraulic power unit, control unit, carriage, facer, facer stand and heater assembly				Fusion carriage, facer, facer stand, heater and insulated heater stand		Fusion carriage, facer, facer stand, heater and insulated heater stand.		EP Hydraulic Power Unit (HPU) sold separately															

1 See **Reference** section for plug types
2 See **Reference** section for more detailed dimensions

5 YEAR WARRANTY
INDUSTRY LEADING WARRANTY
McElroy leads the industry by standing by our products. We warrant all products manufactured, sold and repaired to be free from defects in materials and workmanship for 5 years. **See inside back cover for details.**



BETTER TRACEABILITY FOR YOUR FUSION OPERATIONS IS HERE!
THE NEW DATALOGGER® 6
The best way to track pipe fusion. The DataLogger 6 features a ruggedized, touchscreen Android tablet that is water and dust resistant. An intuitive interface and on-screen guidance allow for monitoring the fusion process with real-time analysis. See **Quality Assurance Tools** section or visit mcelroy.com/datalogger for details.



FIND COURSES ONLINE & REGISTER TODAY
Fusion training for small-, medium- and large-diameter pipe. McElroy University Courses are offered year-round, with new classes added frequently. Troubleshooting, Rebuild and Inspector courses are also available. www.mcelroy.com/university



CUSTOMER/TECH SUPPORT
Whether you prefer email, discussion forums 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.
☎ (918) 831-9236 ✉ businesssupport@mcelroy.com

The Pit Bull® is the workhorse of the McElroy machine line with a marked level of endurance. The carriage alone provides all the muscle you need to fuse small- and medium-diameter pipe when wheeled- and track-mounted vehicles are not necessary. The carriage, heater, insulated heater stand and Hydraulic Power Unit (HPU) are separate components that can be situated in various arrangements to allow flexibility in confined environments.

BUILT FOR THE DITCH

PIT BULL





SMALL FOOTPRINT

DESIGNED FOR TIGHT SPACES

Compact and portable, the Pit Bull® carriage is built specifically for pipe fusion in the trenches. On tight installations, or to fuse tees, ells, adapters and fittings, the machines can be converted from a 4-jaw to a 3-jaw carriage for an even more compact fusion unit.



FIND THE RIGHT PIT BULL FOR YOUR JOBSITE

STANDARD FEATURES

	28	250	412	618
Patented Centerline Guidance System for equal distribution of force around the joint	●	●	●	●
Hard-anodized aluminum wear surfaces for corrosion resistance	●	●	●	●
Serrated jaws and inserts keep pipe from slipping during fusion	●	●	●	●
Thrust-bearing-equipped clamp knobs to minimize force required to clamp and round pipe	●	●	●	●
3- or 4-jaw carriage for close quarter use	●	●	●	●
DataLogger compatible	●	●	●	●
Powerful hydraulic facer for facing the toughest pipe	●	●	●	●
Industry standard semi-automatic hydraulic control system	●	●	●	●
Cylinder force options (H=High force, M=Medium force, L=Low force)	HL	HL	HML	HML

ADDITIONAL FEATURES

Hydraulic clamping available			●	●
Available in Combination Unit (CU) for sidewall fusion	●	●		

CONSISTENT JOINT QUALITY

Pit Bull machines are designed to deliver consistent joint quality every time. The patented Centerline Guidance feature is a balanced force system that insures that the pipe centerline is on the same plane as the clamping jaws to provide equal distribution of force around the diameter of the pipe. Rigid aluminum carriage construction and hard-anodized jaws assist in re-rounding the pipe and maintaining alignment. Electric-powered hydraulic units utilize a semi-automatic control that maintains steady pressure throughout the fusion process – helping to produce quality joints.



PIT BULL HPU

PORTABLE POWER

The Pit Bull is powered by a common Hydraulic Power Unit (HPU). The HPU is wheeled for easy mobility on the jobsite and comes separate from the fusion machine so that the carriage can be placed directly in the trench for in-ditch fusion.

DATALOGGER® COMPATIBLE

RECORD & ANALYZE FUSION JOINT DATA

All of the Pit Bull® machines are compatible with the McElroy DataLogger, an Android-powered tablet that records and documents the key parameters of the fusion process. These joint records are used to verify that proper fusion procedures have been followed prior to installation, which is a growing jobsite requirement. Joint records from the DataLogger can be securely stored and analyzed online in the DataLogger Vault™. This allows quick and easy sorting, tagging and sharing of joint records by machine, joint, operator, device or job.

RUGGED & RELIABLE

READY FOR THE TOUGHEST JOBS

The Pit Bulls are capable of fusing pipe all day long with consistent, high-quality results. They offer the same power as rolling or tracked fusion machines of the same size, and most will conveniently fit on any of McElroy's wheeled or tracked vehicles. All of the McElroy Pit Bulls feature serrated jaws and inserts to keep the pipe from slipping during fusion. When jobs are down and dirty, the Pit Bull is your go-to machine.



FEATURED ACCESSORIES

See *Replacement Parts & Accessories* section for more information.

HYDRAULIC POWER UNIT
Includes extension hoses and lifting assembly.

HEAT SHIELD
For fusing two materials with different melt rates.

STUB END HOLDER
Holds various sizes of stub end fittings for fusion to the end of a pipe.

SIDEWALL HEATER
For sidewall fusion with Pit Bull 28 and 250 Combination Unit machines.



PIT BULL® 28
2" IPS - 8" DIPS (63mm - 225mm)

MODELS	Standard		Combination Unit ⓘ	
Input Voltage	120V	240V	120V	240V
High Force	AT805505	AT805501	AT805506	AT805502
Medium Force	N/A		N/A	
Low Force	AT805507	AT805503	AT805508	AT805504

WEIGHT ⓘ

4-Jaw Carriage	265 lbs (120.2 Kg)	311 lbs (141.1 Kg)
3-Jaw Carriage	142 lbs (64.4 Kg)	188 lbs (85.3 Kg)
Facer	37 lbs (16.8 Kg)	19.9 Kg (44 lbs)
Butt Fusion Heater	21 lbs (9.5 Kg)	12.2 Kg (27 lbs)
Spreader Bar/Lifting Sling	N/A	N/A

POWER

Plug Type ⓘ	A	C	A	C
Butt Fusion Heater	1,750 Watt		3,000 Watt	
Facer	Hydraulic		Hydraulic	
HPU	See HPU section for details			

DIMENSIONS ⓘ

Length	44" (1,118mm)
Width	30" (762mm)
Height	23" (584mm)

INCLUDES

Fusion carriage, 8" IPS inserts, butt fusion heater, facer and insulated heater stand. HPU sold separately
--



PIT BULL 250
63mm - 250mm (2" IPS - 8" DIPS)

MODELS	Standard	Combination Unit ⓘ
Input Voltage	240V	
High Force	AT2505501	AT2505502
Medium Force	N/A	
Low Force	AT2505503	AT2505504

WEIGHT ⓘ

4-Jaw Carriage	112 Kg (247 lbs)	133 Kg (293 lbs)
3-Jaw Carriage	56.2 Kg (124 lbs)	77.1 Kg (170 lbs)
Facer	19.9 Kg (44 lbs)	
Butt Fusion Heater	12.2 Kg (27 lbs)	
Spreader Bar/Lifting Sling	N/A	

POWER

Plug Type ⓘ	C
Butt Fusion Heater	3,000 Watt
Facer	Hydraulic
HPU	See HPU section for details

DIMENSIONS ⓘ

Length	1,118mm (44")
Width	762mm (30")
Height	584mm (23")

INCLUDES

Fusion carriage, butt fusion heater, facer and insulated heater stand. HPU sold separately
--



PIT BULL® 412 ⓘ
4" IPS - 12" DIPS (110mm - 340mm)

MODELS	240V
Input Voltage	240V
High Force	AT1213002
Medium Force	AT1213001
Low Force	AT1213003

WEIGHT ⓘ

4-Jaw Carriage	442 lbs (200.5 Kg)
3-Jaw Carriage	282 lbs (128 Kg)
Facer	62 lbs (28.1 Kg)
Butt Fusion Heater	24 lbs (10.9 Kg)
Spreader Bar/Lifting Sling	N/A

POWER

Plug Type ⓘ	C
Butt Fusion Heater	3,000 Watt
Facer	Hydraulic
HPU	See HPU section for details

DIMENSIONS ⓘ

Length	44" (1,118mm)
Width	38" (965mm)
Height	28" (711mm)

INCLUDES

Fusion carriage, heater, facer, insulated heater stand, and 12" IPS butt fusion inserts. HPU sold separately
--



PIT BULL 618 ⓘ
6" IPS - 18" OD (160mm - 450mm)

MODELS	240V
Input Voltage	240V
High Force	AT1807502
Medium Force	AT1807501
Low Force	AT1807503

WEIGHT

4-Jaw Carriage	605 lbs (274.4 Kg)
3-Jaw Carriage	416 lbs (188.7 Kg)
Facer	91 lbs (41.3 Kg)
Butt Fusion Heater	6" IPS - 12" DIPS: 28 lbs (13 Kg) 12" IPS - 18" OD: 34 lbs (15.4 Kg)
Spreader Bar/Lifting Sling	6.2 lbs (2.8 Kg)

POWER

Plug Type ⓘ	C
Butt Fusion Heater	3,000 Watt
Facer	Hydraulic
HPU	See HPU section for details

DIMENSIONS ⓘ

Length	44" (1,118mm)
Width	44" (1,118mm)
Height	33" (838mm)

INCLUDES

Fusion carriage, facer, 12" IPS - 18" OD heater and insulated heater stand. HPU sold separately



PIT BULL HYDRAULIC POWER UNIT (HPU)

MODELS

Input Voltage	220-240V, 60Hz, 1Ph	220-240V, 50/60Hz, 3Ph
Part Number	T1810901	T1810902

WEIGHT

Machine	390 lbs (176.9 Kg)
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HYDRAULICS

Max. System Pressure	1,500 PSI (103 BAR)
Hyd. Reservoir Capacity	10 Gallons (37 Liters)
Pump Flow Rate 60Hz	6.1 GPM (23 LPM)
Pump Flow Rate 50Hz	5.0 GPM (18.9 LPM)
Filtration	10 micron absolute

POWER

Power Requirement	7.9 kVA / 7.8 kW	8.2 kVA / 7.5 kW
Electric	5 HP, 21.5 Amp	5 HP, 13.4 Amp
Plug Type ⓘ	G	D

MOBILITY

Tires	High-floatation inflatable tires
Transportation	Two-wheel cart

DIMENSIONS

Length	48" (1,219 mm)
Width	32.5" (826 mm)
Height	41" (1,036 mm)

INCLUDES

Pit Bull hydraulic power unit (HPU), extension hoses and lifting assembly

ⓘ See **Replacement Parts & Accessories** section for Sidewall heaters and accessories | ⓘ Machine weight includes vehicle, 4-jaw carriage, facer and heater. 4-Jaw Carriage weight includes carriage, facer and heater | ⓘ See **Reference** section for plug types | ⓘ See **Reference** section for more detailed dimensions

ⓘ A Hydraulic Clamping Kit is available for the Pit Bull 412 and 618 machines. Add **HC** to the end of the part number listed in the chart | ⓘ Machine weight includes vehicle, 4-jaw carriage, facer and heater. 4-Jaw Carriage weight includes carriage, facer and heater | ⓘ See **Reference** section for plug types | ⓘ See **Reference** section for more detailed dimensions

5 YEAR WARRANTY
INDUSTRY LEADING WARRANTY
 McElroy leads the industry by standing by our products. We warrant all products manufactured, sold and repaired to be free from defects in materials and workmanship for 5 years. **See inside back cover for details.**



CUSTOMER/TECH SUPPORT
 Whether you prefer email, discussion forums 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.

☎ (918) 831-9236 | ✉ businesssupport@mcelroy.com

+ CYLINDER FORCE LEGEND
 Most McElroy hydraulic machines have the option of multiple carriage cylinders: high force (HF), medium force (MF) and low force (LF). These cylinder selections are identified by the cylinder color, green, orange, yellow respectively. Machine selection depends on the standard you are fusing to and the total effective piston area (TEPA) required to fuse your pipe size. **See Reference section for more.**

High Force Medium Force Low Force

ACCESSORIES
 See **Replacement Parts & Accessories** section for replacement parts and accessories for Pit Bull fusion machines.

FIND INSERTS
 See **Replacement Parts & Accessories** section for butt fusion and mitered inserts for all Pit Bull machines.

McElroy Rolling machines have staked a claim as the industry standard since 1975. Their ease of use and rugged quality construction opened the door for the most extensive line of fusion machines on the market. Wheeled for easy maneuvering on the jobsite, the carriage on many of the machines is easily removable for in-ditch use. Rolling and MegaMc® models are designed to fuse pipe as small as 2" IPS (63mm) all the way up to 65" OD (1600mm) with as much as 88,000 pounds of fusion force. Whether fusing pipe large or small, the Rolling and MegaMc machines will tackle any job.

THE STANDARD SINCE 1975

ROLLING & MEGAMC

NO LIFTING REQUIRED

WHEELED CHASSIS PROVIDES EASY
JOBSITE MANEUVERING

Fusion machine portability brings convenience to jobsites with longer pipelines utilizing medium- and large-diameter pipe. The Rolling machines are easily towed to each fusion area and remain stationary as sticks of pipe are fused and pulled through.



SEE THE MEGAMC® IN ACTION

Visit our YouTube channel
to find out more about the
MegaMc 1648 Series 2.

POWERFUL HYDRAULICS

HYDRAULIC POWER ASSISTS FUSION FUNCTIONS

All fusion functions on the Rolling and MegaMc® machines are powered smoothly by hydraulics, including a powerful hydraulic facer for facing the toughest pipe with ease. The clamping and unclamping of the jaws is hydraulically powered on all of the MegaMcs and is available with the Rolling 412 and 618. The facer and heater on all MegaMcs hydraulically index left to right and pivot in and out of the fusion machine.



EASILY SUPPORT & ALIGN PIPE

PIPE LIFTS ENHANCE PRODUCTIVITY

Dual hydraulic pipe lifts are featured on the MegaMc machines and the Rolling 412 and 618 models. These heavy-duty lifts with deep-vee rollers allow pipe to be easily pulled into and out of the fusion carriage.



FLEXIBLE POWER OPTIONS

MODELS AVAILABLE IN GAS OR ELECTRIC

Two of our most popular Rolling machines, the 412 and 618, come in electric or gas models to power the heater, facer and hydraulic pump. These options allow the choice of preferred power source to meet the specific requirements of each jobsite. The gas models offer a self-contained unit with an on-board generator and 120V and 240V receptacles. Electric models require a power source from either a separate generator or grid power and are a good option when fusing indoors because they don't produce fumes.

Gas-powered machines are available for the Rolling 412 and 618.

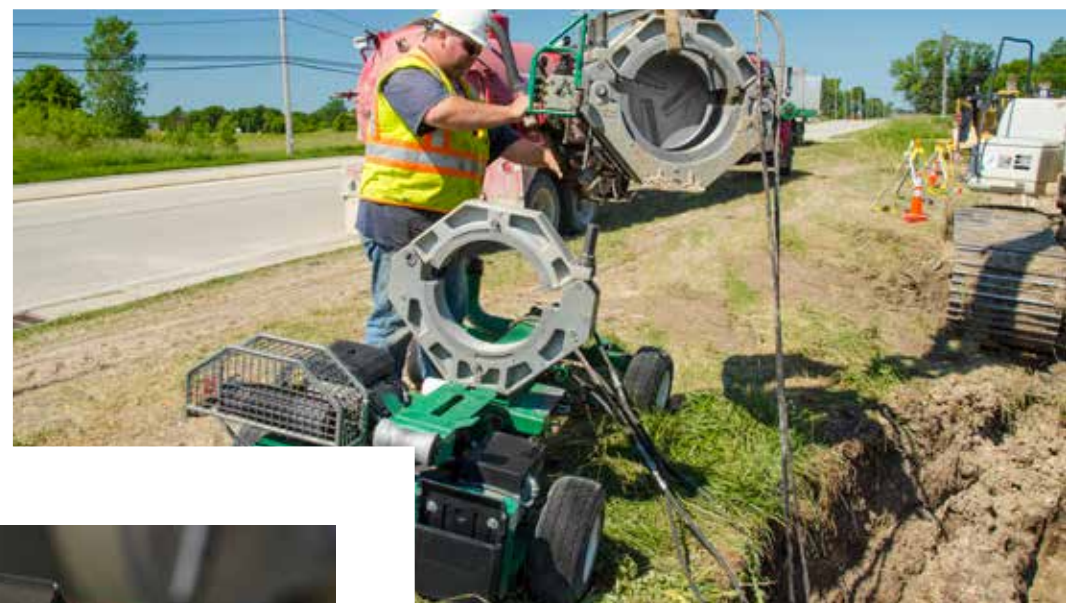




COMBINATION UNIT AVAILABLE

ALLOWS FUSION OF BRANCH SADDLES

Rolling 28 and 250 machines are available as a Combination Unit (CU) which allows fusion of branch saddles with a sidewall heater onto any size main. Inserts are placed into the movable jaws and tailstock chains and clamp knobs allow the carriage assembly to be attached to the centerline of the pipe main for an accurate fusion.



INCREASE JOBSITE EFFICIENCY WITH THE POLYHORSE® PIPE HANDLING SYSTEM

The PolyHorse is a more productive way to store and handle pipe on the job - helping to reduce manpower while promoting a safer working environment. It's a series of adjustable racks available in two size ranges: 3" IPS to 20" OD (90mm to 500mm) or 20" OD to 48" OD (500mm to 1,200mm). They are designed to hold enough pipe for a day's worth of work and allow a single operator to load and align pipe without the use of extra machinery. See **Productivity Tools** section for more details.

DATALOGGER® COMPATIBLE

RECORD & ANALYZE FUSION JOINT DATA

All Rolling and MegaMc® machines are compatible with the McElroy DataLogger, an Android-powered tablet that records and documents the key parameters of the fusion process. These joint records are used to verify that proper fusion procedures have been followed prior to installation, which is a growing jobsite requirement. Joint records from the DataLogger can be securely stored and analyzed online in the DataLogger Vault™. This allows quick and easy sorting, tagging and sharing of joint records by machine, joint, operator, device or job.



DITCH READY

REMOVABLE CARRIAGE FOR CONFINED SPACES

Many of the Rolling and MegaMc machines incorporate a 4-jaw carriage that can easily be removed for in-ditch fusion. The outer fixed jaw and skid can also be removed, converting it to a 3-jaw carriage for an even more compact fusion unit.



MULTIPLE CYLINDER OPTIONS

MEET JOBSITE DEMANDS

Pipe type, job requirements and pipe fusion standards are all important aspects of planning a fusion job. The Rolling and MegaMc® machines are available in a variety of different cylinder forces to meet your jobsite requirements.

FIND THE RIGHT MACHINE FOR YOUR JOBSITE

STANDARD FEATURES

	28	250	412	618	824	1236	1648	1600	2065
Patented Centerline Guidance System for equal distribution of force around the joint	●	●	●	●	●	●	●	●	●
Industry standard semi-automatic hydraulic control system	●	●	●	●	●	●	●	●	●
Serrated jaws and inserts keep pipe from slipping during fusion	●	●	●	●	●	●	●	●	●
DataLogger® compatible	●	●	●	●	●	●	●	●	●
Powerful hydraulic facer for facing the toughest pipe with ease	●	●	●	●	●	●	●	●	●
Hard-anodized aluminum wear surfaces for corrosion resistance	●	●	●	●	●	●	●	●	●
Cylinder force options (H=High force, M=Medium force, L=Low force)	HL	HL	HML	HML	HML	HML	HM	HM	H

ADDITIONAL FEATURES

Removable 3- or 4-jaw carriage for close quarter use	●	●	●	●	●	●	●		
Hydraulic pipe lifts			●	●	●	●	●	●	●
Hydraulic clamping available (standard on all MegaMc machines)			●	●	●	●	●	●	●
Thrust-bearing-equipped clamp knobs to minimize force required to clamp and round pipe	●	●	●	●					
Large capacity 2-stage hydraulic pump for cool oil at max operating pressure	●	●							
Available in Combination Unit (CU) for sidewall fusion	●	●							
Self-contained, gas-powered model with on-board generator			●	●					
Heater and facer can be easily converted to top-loading for confined spaces					●	●	●	●	
Rugged outriggers for added stability					●	●	●	●	●
Hydraulic pivoting heater and facer					●	●	●	●	●

+ CYLINDER FORCE LEGEND

Most McElroy hydraulic machines have the option of multiple carriage cylinders: high force (HF), medium force (MF) and low force (LF). These cylinder selections are identified by the cylinder color, green, orange, yellow respectively. Machine selection depends on the standard you are fusing to and the total effective piston area (TEPA) required to fuse your pipe size. See **Reference section for more.**

High Force Medium Force Low Force

FEATURED ACCESSORIES

See **Replacement Parts & Accessories** section for more information.



PIPE SUPPORT STAND

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



HEAT SHIELD

For fusing two materials with different melt rates.



STUB END HOLDER

Holds various sizes of stub end fittings for fusion to the end of a pipe.



INSERT SETS

Surface hardened for longer life and are serrated for maximum grip.

ROLLING 28

2" IPS - 8" DIPS (63mm - 225mm)

MODELS	Standard		Combination Unit ⓘ		Standard		Combination Unit ⓘ			
Input Voltage	120V, 60Hz, 1Ph	240V, 60Hz, 1Ph	120V, 60Hz, 1Ph	240V, 60Hz, 1Ph	120V, 60Hz, 1Ph	240V, 50Hz	240V, 60Hz	120V, 50Hz	240V, 60Hz	
High Force	A860805	A860806	A860801	A860808	A866007	A866001	A866009	A866008	A866002	A866010
Medium Force	N/A				N/A				N/A	
Low Force	A860810	N/A	N/A		A866005	A866003	N/A	A866006	A866004	N/A

WEIGHT ⓘ

Machine	575 lbs (260.8 Kg)		260.8 Kg (575 lbs)	
4-Jaw Carriage	265 lbs (120.2 Kg)	311 lbs (141.1 Kg)		112 Kg (247 lbs)
3-Jaw Carriage	142 lbs (64.4 Kg)	188 lbs (85.3 Kg)		56.2 Kg (124 lbs)
Facer	37 lbs (16.8 Kg)		20 Kg (44 lbs)	
Heater	21 lbs (9.5 Kg)		12.2 Kg (27 lbs)	
Spreader Bar/Lifting Sling	N/A		N/A	

HYDRAULICS

Maximum System Pressure	1,200 PSI (82.7 BAR)	82.7 BAR (1,200 PSI)
Hydraulic Reservoir Cap.	5 Gallons (18.92 Liters)	18.92 Liters (5 Gallons)

POWER

Min. Power Req.	3.4 kVA , 3.2 kW @ 120V / 3.5 kVA , 3.2 kW @ 240V				3.4 kVA , 3.2 kW @ 120V / 3.5 kVA , 3.2 kW @ 240V					
Plug Type ⓘ	A	C	A	C	A	M	C	A	M	C
Heater	1,750 Watt				3,000 Watt					
Facer	Hydraulic				Hydraulic					
Electric Motor	1.5 HP				1.5 HP					

ENGINE

Engine Type	N/A				N/A			
Fuel Type	N/A				N/A			
Fuel Tank Capacity	N/A				N/A			
Operational Tank Cap.	N/A				N/A			
Starting System	N/A				N/A			

CHASSIS & MOBILITY

Front Axle	Articulating		Articulating	
Brake	Mechanical		Mechanical	
Tires	High-floatation inflatable tires		High-floatation inflatable tires	
Transportation	Pulled via towing ring		Pulled via towing ring	
Lifting	N/A		N/A	

DIMENSIONS ⓘ

Length	65.5" (1,664mm)	1,664mm (65.5")
Width	38" (965mm)	965mm (38")
Height	49.5" (1,257mm)	1,257mm (49.5")

INCLUDES

	Fusion machine, 8" IPS inserts, facer, butt fusion heater and insulated heater stand	Fusion machine, facer, butt fusion heater and insulated heater stand
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ⓘ See **Replacement Parts & Accessories** section for Sidewall heaters and accessories

Ⓜ Machine weight includes vehicle, 4-jaw carriage, facer and heater. 4-Jaw Carriage weight includes carriage, facer and heater

Ⓧ See **Reference** section for plug types

Ⓨ Dimensions include fusion carriage on vehicle. See **Reference** section for more detailed dimensions



ROLLING 412 ⓘ

4" IPS - 12" DIPS (110mm - 340mm)

MODELS	Gas-powered	Electric-powered	Gas-powered	Electric-powered
Input Voltage	N/A	220-240V, 50/60Hz, 3Ph	N/A	220-240V, 50/60Hz, 3Ph
High Force	A1248101	A1248104	A1869101	A1869104
Medium Force	A1248102	A1248105	A1869102	A1869105
Low Force	A1248103	A1248106	A1869103	A1869106

WEIGHT ⓘ

Machine	1,225 lbs (556 Kg)	915 lbs (415 Kg)	1,335 lbs (606 Kg)	1,100 lbs (498 Kg)
4-Jaw Carriage	442 lbs (200.5 Kg)		605 lbs (274.4 Kg)	
3-Jaw Carriage	282 lbs (128 Kg)		548 lbs (248.6 Kg)	
Facer	62 lbs (28.1 Kg)		91 lbs (41.3 Kg)	
Heater	24 lbs (10.9 Kg)		34 lbs (15.4 Kg)	
Spreader Bar/Lifting Sling	6.2 lbs (2.8 Kg)		6.2 lbs (2.8 Kg)	

HYDRAULICS

Maximum System Pressure	1,200 PSI (82.74 BAR)	1,200 PSI (82.74 BAR)
Hydraulic Reservoir Cap.	6 Gallons (22.71 Liters)	6 Gallons (22.71 Liters)

POWER

Minimum Power Req.	N/A, Self-Contained Gasoline	6.2 kVA , 5.8 kW	N/A, Self-Contained Gasoline	8.0 kVA , 7.4 kW
Plug Type ⓘ	N/A	F	N/A	F
Heater	3,000 Watt		3,000 Watt	
Facer	Hydraulic		Hydraulic	
Electric Motor	N/A	3HP	N/A	5HP

ENGINE

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

ELECTRICAL

AC Output	2 receptacles, 1 @ 120V, 1 @ 240V	1 receptacle @ 240V	2 receptacles, 1 @ 120V, 1 @ 240V	1 receptacle @ 240V
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CHASSIS & MOBILITY

Front Axle	Articulating		Articulating	
Brake	Mechanical		Mechanical	
Tires	High-floatation inflatable tires		High-floatation inflatable tires	
Transportation	Pulled via towing ring		Pulled via towing ring	
Lifting	Lift points and lifting assembly		Lift points and lifting assembly	

DIMENSIONS ⓘ

Length	85" (2,159mm)	85" (2,159mm)	83" (2,108mm)
Width	49" (1,245mm)	50" (1,270mm)	
Height	46 (1,168mm)	57" (1,448mm)	

INCLUDES

	Fusion machine, facer, heater, insulated heater stand, 12" IPS butt fusion inserts and lifting assembly	Fusion machine, facer, 12" IPS - 18" OD heater, insulated heater stand and lifting assembly
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Ⓜ A Hydraulic Clamping Kit is available for the Rolling 412 and 618 machines. Add **HC** to the end of the part number listed in the chart

Ⓜ Machine weight includes vehicle, 4-jaw carriage, facer and heater. 4-Jaw Carriage weight includes carriage, facer and heater

Ⓧ See **Reference** section for plug types

Ⓨ Dimensions include fusion carriage on vehicle. See **Reference** section for more detailed dimensions



MODELS	MEGAMC® 824 8" IPS - 24" OD (225mm - 630mm)	MEGAMC 1236 12" IPS - 36" OD (340mm - 900mm)	MEGAMC 1648 SERIES 2 16" OD - 48" OD (450mm - 1200mm)	MEGAMC 2065 20" OD - 65" OD (500mm - 1600mm)	MEGAMC 1600 20" OD - 65" OD (500mm - 1600mm)			
Input Voltage	220V-240V, 50/60Hz, 3Ph	220V-240V, 50/60Hz, 3Ph	220 - 240V, 50/60Hz, 3Ph	380 - 415V, 50Hz, 3Ph	220 - 240V, 50/60Hz, 3Ph	380 - 415V, 50Hz, 3Ph		
High Force	A2435501	A3639501	A4861701	A4861703	A6300102	A6300104	A6500103	A6500105
Medium Force	A2435502	A3639502	A4861702	A4861704	N/A	N/A	A6500102	A6500104
Low Force	A2435503	A3639503	N/A	N/A	N/A	N/A	N/A	N/A
WEIGHT ③		WEIGHT ③	WEIGHT ③	WEIGHT ③	WEIGHT ③	WEIGHT ③	WEIGHT ③	WEIGHT ③
Machine	5,905 lbs (2,678 Kg)	6,842 lbs (3,103 Kg)	11,787 lbs (5,346 Kg)	14,000 lbs (6,350 Kg)	21,000 lbs (9,525 Kg)			
4-Jaw Carriage	3,790 lbs (1,719 Kg)	3,865 lbs (1,753 Kg)	7,450 lbs (3,379.3 Kg)	N/A	N/A			
3-Jaw Carriage	1,350 lbs (612 Kg)	1,820 lbs (825 Kg)	3,680 lbs (1,669 Kg)	N/A	N/A			
Facer	390 lbs (177 Kg)	480 lbs (218 Kg)	775 lbs (351.5 Kg)	1,200 lbs (544 Kg)	1,200 lbs (544 Kg)			
Heater	240 lbs (109 Kg)	382 lbs (173 Kg)	600 lbs (272.2 Kg)	20 - 48" Heater: 600 lbs (272.2 Kg) 48 - 65" Heater: 713.5 lbs (323.6 Kg)	20 - 48" Heater: 600 lbs (272.2 Kg) 48 - 65" Heater: 713.5 lbs (323.6 Kg)			
Spreader Bar/Lifting Sling	175 lbs (79 Kg)	200 lbs (90.7 Kg)	500 lbs (226.8 Kg)	650 lbs (294.8 Kg)	1,000 lbs (453.6 Kg)			
HYDRAULICS		HYDRAULICS	HYDRAULICS	HYDRAULICS	HYDRAULICS			
Max. System Pressure	2,300 PSI (158 BAR)	2,300 PSI (158 BAR)	3,000 PSI (207 BAR)	1,500 PSI (103 BAR)	3,000 PSI (207 BAR)			
Hydraulic Reservoir Cap.	28 Gallons (106 Liters)	28 Gallons (106 Liters)	23 Gallons (87 Liters)	24 Gallons (90.85 Liters)	35 Gallons (132 Liters)			
POWER		POWER	POWER	POWER	POWER			
Min. Power Req.	29.8 kVA / 28.1 kW	39.4 kVA / 37.7 kW	62.3 kVA / 55.2 kW	50 kVA / 48.8 kW	49.6 kVA / 48.5 kW	65 kVA / 61 kW		
Plug Type ④	I	I	J	O	J	N/A	J	O
Heater	10,950 Watt	20,461 Watt	35,000 Watt	20 - 48" Heater: 35,000 Watt 48 - 65" Heater: 38,437 Watt	20 - 48" Heater: 35,000 Watt 48 - 65" Heater: 38,437 Watt			
Facer	Hydraulic	Hydraulic	Hydraulic	Hydraulic	Hydraulic			
Motor	20 HP	20 HP	25 HP	20 HP	10 HP	10 HP	25 HP	20 HP
CHASSIS & MOBILITY		CHASSIS & MOBILITY	CHASSIS & MOBILITY	CHASSIS & MOBILITY	CHASSIS & MOBILITY			
Front Axle	Articulating	Articulating	Articulating	Articulating	Articulating			
Brake	Mechanical	Mechanical	Mechanical	Mechanical	Mechanical			
Tires	6.90 - 9NHS, 75 PSI Max.	6.90 - 9NHS, 75 PSI Max.	ST 235 80R16 10 ply, 3,520 lbs. (1,596 Kg) cap.	12 – 16.5 LTF, F-12	8.25 - 15LT High Load Rating			
Transportation	Pulled via towing ring	Pulled via towing ring	Pulled via towing ring	Pulled via towing ring	Pulled via towing ring			
Lifting	Lift points and lifting assembly	Lift points and lifting assembly	Lift points and lifting assembly	Lift points and lifting assembly	Lift points and lifting assembly			
DIMENSIONS ⑤		DIMENSIONS ⑤	DIMENSIONS ⑤	DIMENSIONS ⑤	DIMENSIONS ⑤			
Length	131" (3,327mm)	131" (3,327mm)	193" (4,902mm)	186.5" (4,737mm)	204" (5,181mm)			
Width	83" (2,108mm)	83" (2,108mm)	89.5" (2,273mm)	102" (2,591mm)	102" (2,591mm)			
Height	69" (1,753mm)	78" (1,981mm)	99" (2,515mm)	112" (2,845mm)	116" (2,946mm)			
INCLUDES		INCLUDES	INCLUDES	INCLUDES	INCLUDES			
	Fusion machine, facer, heater, 24" OD butt fusion inserts and lifting assembly	Fusion machine, facer, heater and lifting assembly	Fusion machine, facer, heater and lifting assembly	Fusion machine, 63" OD inserts facer, 48" and 65" heaters and lifting assembly	Fusion machine, 63" OD inserts, facer, 48" and 65" heaters and lifting assembly			

③ Machine weight includes vehicle, 4-jaw carriage, facer and heater. 4-Jaw Carriage weight includes carriage, facer and heater

④ See **Reference** section for plug types

⑤ Dimensions include fusion carriage on vehicle. See **Reference** section for more detailed dimensions



54-INCH POLYETHYLENE PIPE OFFERS THREE-WAY SOLUTION

WHYCHUS CREEK HAS PROVIDED IRRIGATION WATER TO FARMERS IN THREE SISTERS IRRIGATION DISTRICT (TSID) IN CENTRAL OREGON SINCE 1888, BUT THROUGH INEFFICIENT CANAL SYSTEMS THAT LOSE UP TO 50 PERCENT OF THE WATER BEFORE IT REACHES THE FARMS.

To remedy the problem, the TSID chose to eliminate seepage losses by piping their main canal with twin 54-inch high-density polyethylene (HDPE) pipes.

The water that was typically lost in the canal that flows through the Deschutes National Forest is now being conserved through HDPE piping. The resulting water conservation will boost various fish species' populations, including steelhead trout, which are listed as 'threatened' by the United States Fish and Wildlife Service.

The rehabilitated canal now offers six cubic feet per second more water. With the

increased water flow, Whychus Creek could be rescued from the Oregon Section 303 (d) listing for not meeting proper water temperature expectations for beneficial use of fish spawning and migration.

The water is also used to generate green energy through a hydroelectricity plant at the end of the pipeline. Farmers in the region could also use the water for irrigation in dry years.

The 3.77-mile pipeline begins at a diversion dam and terminates at the 80-acre Watson Reservoir. At the reservoir, two Francis turbines generate 1.5 megawatts of

energy for the Central Electric Cooperative and the city of Sisters.

PE AND THE PROCESS

HDPE was chosen for the project because of the inherent characteristics of the pipe material. The pipe is flexible, can curve and snake with terrain, can weather the ground movements in areas of seismic activity, and resists corrosion and cracking. Fifty-foot sticks of pipe were delivered to the staging site, where they were butt fused to a length of pipe one at a time, creating a long, continuous pipeline.

McElroy's MegaMc® 1600, was used to fuse the lengths of pipe together. Capable of fusing pipes sized up to 65 inches in diameter, the MegaMc 1600 is one of McElroy's largest fusion machines. One advantage to choosing the MegaMc 1600 was the machine's clearance. While some fusion machines on the market typically require a crane to lift the heater and facer into the jaw carriage of the machine, the 1600 has a hydraulic pivoting heater and facer.

Aside from not needing additional equipment, the 1600 can be tented to protect the fusion joint and operators from adverse working environments. Since the canal is dry during the winter months, before the glacier and snow melt, workers fuse the pipe during the winter months and routinely fuse through freezing temperatures and

winter precipitation without a hitch. The lengths of pipe are then pulled into position in the empty canal.

To better move the heavy pipe, TSID employed McElroy productivity tools. As the length of pipe was pulled out of the machine, a pipe roller was used approximately 30 feet from the fusion machine. The pipe roller keeps the pipe at a fixed height to make matching the pipe ends to each other much easier. On the other side of the MegaMc 1600, TSID incorporated a MegaMc Pipe Stand, a gasoline-powered pipe stand with rollers that allows the operator to move the pipe horizontally and vertically in order to achieve optimal alignment. Pipe stands save wear and tear on fusion machines and make the fusion process much easier. Operators believed the powered pipe stand saved up to 30 minutes on some fusion joints. By using the MegaMc 1600 and Pipe Stand, the team of TSID workers averaged six fusion joints per day.

Opposed or not, soon central Oregon will see an increase in fish populations and a new green energy resource, all from a pipeline that could last longer than the initial man-made irrigation canal.

To read the full story, go to mcelroy.com/en/articles/sistersoregon.htm



TracStar® fusion machines are the number one choice on jobsites fusing long pipelines with their ease of maneuverability and freedom of movement. Self-propelled via rubber crawler tracks, these vehicles can traverse rough terrain and grades up to 30%. All of the TracStars are self-contained with all of the necessary electrical equipment on board. The carriage is mounted on the track-driven chassis for easy pipe loading and movement along the pipe. The carriage is also removable so that pipe can be fused directly in the ditch. With fusion capabilities of 2" IPS to 48" OD pipe, there's a TracStar for most any size job.

REVOLUTIONIZING THE INDUSTRY

TRACSTAR



ALL-TERRAIN TRACK-MOUNTED VEHICLE

TACKLES THE TOUGHEST JOBSITES

The TracStar®'s rugged, dual rubber tracks bring the best in all-terrain mobility to jobsites. They can travel easily across mud, loose soil, snow and grades of up to 30%. The track system features a zero-degree turning radius while evenly dispersing the weight which keeps it from sinking in the soft soil.

The tracks minimize damage to concrete and asphalt surfaces, which is a plus on public and private properties. Cranes are eliminated because the TracStars can be driven directly to and from the jobsite from the ramps of a trailer.



SEE THE TRACSTAR IN ACTION

Watch pipe fusion demonstrations and learn more about the versatility and capabilities of the TracStar machine line on our YouTube channel.



HYDRAULIC PIPE LIFTS

ENHANCES PRODUCTIVITY WITH EASY PIPE TRANSFER THROUGH MACHINE

Dual hydraulic pipe lifts are featured on every TracStar Series 2 machine. These heavy-duty lifts with deep-vee rollers allow pipe to be easily pulled into and out of the fusion carriage.



SELF-CONTAINED DIESEL ENGINE

ENHANCES JOBSITE PRODUCTIVITY

All TracStar® fusion machines are powered by a liquid-cooled or turbo diesel engine that provide power to the hydraulic pump and generator – creating a self-contained fusion solution. Each machine has the fuel tank and operational capacity to perform a full day's work, bringing fuel efficiency to the jobsite. Larger TracStar models, the 630, 900 and 1200, are equipped with an advanced emission control engine that meets the EPA's latest Tier 4 standards, eliminating the need for diesel exhaust fluid (DEF).

High sulfur diesel models available. Consult your sales representative.



ON-BOARD GENERATOR

ELIMINATES THE NEED FOR AN EXTERNAL POWER SOURCE

By incorporating an on-board generator, the TracStar has everything it needs with the ability to generate its own electricity – eliminating the need for additional power. This brings convenience to the operator since they don't have to transport a separate generator.

REMOVABLE CARRIAGE

FOR ACCESS IN TIGHT SPACES

TracStar® machines incorporate an interchangeable 4-jaw carriage, which can be easily removed for close-quarter or 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.



DATALOGGER® COMPATIBLE

RECORD & ANALYZE FUSION JOINT DATA

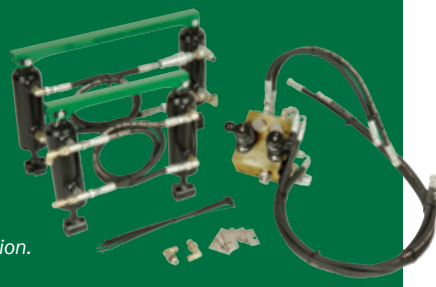
All of the TracStar machines are compatible with the McElroy DataLogger, an Android-powered tablet that records and documents the key parameters of the fusion process. These joint records are used to verify that proper fusion procedures have been followed prior to installation, which is a growing jobsite requirement. Joint records from the DataLogger can be securely stored and analyzed online in the DataLogger Vault™. This allows quick and easy sorting, tagging and sharing of joint records by machine, joint, operator, device or job.

INCREASE PRODUCTIVITY ON THE JOBSITE

WITH A HYDRAULIC CLAMPING RETROFIT KIT

One of the more popular features of large-diameter MegaMc® fusion machines is the hydraulic clamping that tightens the jaws. Now users can retrofit their Rolling and TracStar 412, 618 and 500 machines with hydraulic clamping – replacing the manual crank clamp knobs.

See **Productivity Tools** section for more information.



AUTO MODELS AVAILABLE

MEETS THE DEMAND FOR AUTOMATIC FUSION PROCESSES

An auto option is available on TracStar units with fusion capability for 2" IPS up to 36" OD (63mm to 900mm) pipe. This is designed for those jurisdictions that require automatic control and monitoring over the heat, soak, fuse and cool cycles. The system guides the operator through a step-by-step procedure for fusing pipe.



FIND THE RIGHT TRACSTAR® FOR YOUR JOBSITE

STANDARD FEATURES

	28	250	412	618	500	630	900	1200
Self-contained, self-propelled, all-terrain	●	●	●	●	●	●	●	●
Removable 3- or 4-jaw carriage for close quarter use	●	●	●	●	●	●	●	●
Patented Centerline Guidance System for equal distribution of force around the joint	●	●	●	●	●	●	●	●
Serrated jaws and inserts keep pipe from slipping during fusion	●	●	●	●	●	●	●	●
Powerful hydraulic facer for facing the toughest pipe with ease	●	●	●	●	●	●	●	●
Industry standard semi-automatic hydraulic control system	●	●	●	●	●	●	●	●
Self-locking brakes	●	●	●	●	●	●	●	●
DataLogger® compatible	●	●	●	●	●	●	●	●
On-board generator for powering heater	●	●	●	●	●	●	●	●
Dual hydraulic pipe lifts	●	●	●	●	●	●	●	●
Operational fuel tank capacity (hours)	8+	8+	8+	8+	11+	12+	12+	12+
Cylinder force options (H=High force, M=Medium force, L=Low force)	HL	HL	HML	HML	M	HML	HML	HM

ADDITIONAL FEATURES

Dual speed tracks					●	●	●	●
Hydraulic clamping available (standard on 500-1200)			●	●	●	●	●	●
Battery disconnect for easy lockout	●	●	●	●		●	●	●
Thrust-bearing-equipped clamp knobs to minimize force required to clamp and round pipe	●	●	●	●	●			
Auto machine option	●	●	●	●	●	●	●	
Combination unit (CU) available for sidewall fusion	●	●						
Indexer-mounted, hydraulic pivoting heater and facer					●	●	●	●
Fuel-saving auto throttle					●			
Heater and facer can be easily converted to top loading for confined spaces						●	●	●
Wireless Remote Control ensures safe and precise machine placement						●	●	●
Ergonomic operator platform								●
Removable cowling design allows easy access for machine maintenance	●	●	●	●		●	●	●
Remote engine stop/start						●	●	●
Outriggers for machine stability and leveling								●

FEATURED ACCESSORIES

See **Replacement Parts & Accessories** section for more information.



25' HYDRAULIC EXTENSION HOSES
Set of four 25' Hydraulic extension hoses required for in-ditch fusion.



HEAT SHIELD
For fusing two materials with different melt rates.



STUB END HOLDER
Holds various sizes of stub end fittings for fusion to the end of a pipe.



INSERT SETS
Surface hardened for longer life and are serrated for maximum grip.



NEW PIPELINE BRINGS NATURAL GAS TO RURAL RESIDENTS OF MAINE

IT COSTS LESS, BURNS CLEANER AND IS READILY PRODUCED IN NORTH AMERICA, BUT THE INFRASTRUCTURE IS SIMPLY NOT IN PLACE TO BRING NATURAL GAS HEAT TO MANY RURAL RESIDENTS OF MAINE.

Summit Natural Gas of Maine is out to change that. They have already installed more than 130 miles of pipeline in central Maine, but that's just the start. Over the next five years, they plan to invest \$460 million into the construction of transmission and distribution lines that will serve more than 52,000 customers in the Ken-

nebec Valley and beyond.

Their most recent project is a 66-mile natural gas pipeline and compression station that will serve approximately 8,000 residential, commercial and industrial customers in the under-served towns of Cumberland, Falmouth and Yarmouth (CFY). These bedroom communities just north

of Portland rely primarily on fuel oil or propane with some electric and wood-burning sources.

Summit estimates that switching to natural gas from heating oil will save residents in heating costs. Experts predict higher heating oil prices in the next few years as many of the northeastern states, including

Maine, follow New York's lead in adopting specifications for ultra-low sulfur diesel, which is more expensive to produce.

While there are initial costs to residents associated with converting to natural gas, it offers lower prices over time. In addition, Summit is offering several rebate incentives to make conversions more feasible and affordable.

The CFY project started the second week of May and is 75 percent complete for the 2014 installation plan. So far more than 1,200 customers have signed contracts, and Summit said that number is growing every day. Over the next five years, Summit expects to have about 8,000 residential, commercial and industrial customers, and paired with the project in central Maine, Summit will have a total of more than 50,000 new customers.

Summit touts the convenience of having natural gas piped directly into the home versus an on-site tank that has to be serviced by fuel trucks. So material selection for the pipeline was one of the most important decisions that was made in order to support Mainers with natural gas for generations to come.

Summit selected high-density polyethylene (HDPE) for the pipeline — which is joined through heat fusion — over a steel distribution system because of its lower cost and maintenance. Pipe sizes in the application are 12", 8", 4" and 2" along with 1" and ½" service lines.

The CFY project is unique in that it is the closest pipeline project to the Maine shore. Laying pipeline in Maine's coastal communities comes with its own set of challenges — namely boring through an abundance of

ledge and rock.

Crews so far have used jack and bore techniques to install pipe under the Amtrak Downeaster railroad tracks and have used HDD at various locations under the Royal River, railroad tracks, Interstate 295 and the scenic U.S. Route 1. Pipe was fused and buried using open-trench techniques alongside narrow, two-lane roads that remained open to traffic throughout the project.

HDD was also in play under private driveways in an effort to avoid having to cut then repair them.

Laying the groundwork for natural gas service in Maine brings a lifestyle to the area that simply wasn't possible before. Heavy reliance on heating oil is truly a New England experience with more than 7 in 10 Maine households using fuel oil as their

primary energy source for home heating. That's a higher share than any other state, according to the U.S. Energy Information Administration.

Two McElroy Rolling 412 fusion machines were used on the job as well as a TracStar® 412 and TracStar 618. The crews completed four or five fusions a day when they started, but their skills progressed to the point that they were doing up to 17 fu-

sions a day of 12" DR11 polyethylene pipe. The self-propelled TracStar moved easily on long sections of pipeline while the Rolling machines were better for shorter, straight-forward sections of pipeline.

Summit had two of its own inspectors on site using McElroy's DataLogger® 5 which records the heating and cooling times and other parameters of the fusion process to ensure that the joints were properly fused

"IT'S AN EMERGING MARKET WE'RE GETTING INTO. PLASTIC, ESPECIALLY THIS SIZE, IS NEW TO US, BUT IT'S EASY TO WORK WITH." GENE COTE



before the pipe was buried.

Cianbro had three fusion teams on site working closely with Shaw Bros. which dug the trenches and buried the pipe at a rate of about 500 to 700 feet a day.

The new pipeline will be supplied by the Maritimes & Northeast pipeline that stretches from Goldboro, Nova Scotia, through Maine and New Hampshire to the pipeline grid in Dracut, MA. The 684-mile transmission pipeline system was built to transport natural gas from developments offshore Nova Scotia to markets in Atlantic Canada and the northeastern United States.

A compressor station was built near the Cumberland Fairgrounds to reduce the pressure from 1440 PSI to 90 PSI for a safe transfer from the 30" steel line to the 12" HDPE line.

To read the full article, go to mcelroy.com/en/articles/naturalgastomaine.htm

McElroy's biggest machine to date — the Talon™ brings a revolutionary new way to fuse large-diameter pipe that is in growing demand to replace aging infrastructures and increase capacity for a variety of today's applications. The machine features a self-propelled vehicle with the unique ability to safely lift pipe from the ground, position it to be fused and move from joint-to-joint down the pipeline – greatly reducing the need for supporting equipment. It features a quick-action facer and an electric-powered indexer to accurately and safely position the heater and facer into the fusion machine.

A REVOLUTION IN LARGE-DIAMETER FUSION

TALON

INNOVATIVE JAW DESIGN

SELF LOADS PIPE FROM THE GROUND

The Talon™ 2000 rethinks the way large-diameter pipe jobsites function. Its unique design and innovative jaw capability allow the machine to pick up pipe sticks from the ground and align them in the machine without the use of added heavy equipment — greatly increasing efficiency on the job and promoting a safer working environment when handling large-diameter pipe.



SEE THE TALON IN ACTION

Get a quick introduction to the features and benefits of this revolutionary machine on our YouTube channel.

ONLY ONE MACHINE OPERATOR REQUIRED

Typical large-diameter jobsites require multiple operators and personnel. With large-diameter pipe, even moving the pipe into position can require a coordinated team to get everything just right. The Talon™ can be operated by a single person who can maneuver, face and fuse the pipe using familiar controls and a touchscreen interface.



LIVE TECH SUPPORT

HELP IS ALWAYS AVAILABLE

The Talon's advanced design includes remote assistance if you ever need help. This allows a technician to remotely diagnose any problems you may be having and get your jobsite back up and running as soon as possible.



¹ Requires a data-enabled SIM card

SELF-CONTAINED & SELF-PROPELLED

DESIGNED FOR PIPELINING

Made to be driven from joint-to-joint down the pipeline, the Talon is completely self-contained with a diesel engine and on-board generator — eliminating the need for added power on site. The machine is self-propelled by a set of rugged steel tracks. A wireless remote control ensures safe, efficient operations and precise machine placement. It also features roll and pitch control to better align pipe on uneven ground.



EFFICIENT FACING

INNOVATIVE FACER DESIGN

The Talon features a quick-action facer and an electric-powered indexer to accurately and safely position the heater and facer into the fusion machine. It can remove up to 1" pipe per side in less than eight minutes.



RECORD FUSION JOINT DATA

DATALOGGER® VAULT™ COMPATIBLE

The Talon™ includes a built-in data logging feature that records all fusion joint data to ensure proper fusion procedures have been followed prior to installation. Records are accessible in the DataLogger Vault which allows quick and easy sorting, tagging, sharing and storage of joint records by machine, joint, operator, device or job.



TALON 2000
54" OD - 78" OD (1,400mm OD - 2,000mm OD)



MODELS	
Talon 2000	A7800101
WEIGHT	
Machine	56,000 lbs (25,401 Kg)
Vehicle	46,000 lbs (20,865 Kg)
Indexer (includes heater and facer)	10,000 lbs (4,536 Kg)
Quarter Jaw (2000mm)	145 lbs (66 Kg) ea.
HYDRAULICS	
Max. System Pressure	3,000 PSI (207 BAR)
Hydraulic Reservoir Cap.	60 Gallons (227 Liters)
ENGINE	
Engine Type	173.5HP (129.4kW), 4.4L (268.5in ³) displacement, 4 cylinders, twin turbo, US EPA Tier 4i/EU Stage IIIB
Fuel Type	ULS Diesel (15 PPM)
Fuel Tank Capacity	100 Gallons (378 Liters)
Operational Tank Capacity	12 Hours
Starting System	Electric

POWER	
Heater	70,500 Watt
Facer	Electric

CHASSIS	
Frame	Welded steel construction
Brake	Self-locking

MOBILITY	
Tracked	Steel crawler tracks
Transportation	Self-propelled
Vehicle Speed	.5 MPH
Lifting	Lift points and lifting slings

DIMENSIONS	
Length	148.5" (3,772 mm)
Width	257.5" (6,540.5 mm)
Height	193" (4,902 mm)
Maximum Height	256.1" (6,504.9 mm)
Minimum Hook Height (Required for Indexer installation)	290.2" (7,371.1 mm)

INCLUDES
Fusion machine, facer, heater, remote control with batteries, lifting slings and indexer shipping skid

WIRELESS CONTROL

PRECISE MACHINE PLACEMENT

Wireless remote control of the Talon™ increases visibility and ensures a safe, efficient working environment.



TOUCH-SCREEN INTERFACE

FAMILIAR CONTROLS MAKE OPERATIONS SIMPLE

The Talon's fusion operations are controlled at a touchscreen operator station, which has been designed to mimic the controls of other McElroy hydraulic machines — creating a familiar, easy-to-follow interface.

STANDARD TALON FEATURES

Self-loads pipe from the ground	●
Self-contained, self-propelled	●
Track-mounted for maneuverability	●
Roll and pitch control to better align with pipe	●
Top-loading heater and facer, no cranes necessary	●
Electric-powered indexer accurately positions heater and facer	●
Patented Centerline Guidance System for equal distribution of force around the joint	●
Carriage converts to 1 fixed jaw with 3 movable jaws for easy tie-in and fitting fusions	●
Efficient facer design removes up to 1" of pipe per side in under 8 minutes	●
Wireless remote control ensures safe, efficient working environment and precise machine placement	●
Built-in data logging feature records fusion joint data and syncs with the DataLogger Vault for storage and analysis	●
Remote-access, real-time troubleshooting (Requires a data-enabled SIM card)	●

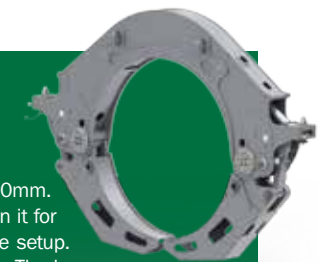
2000

INNOVATIVE JAW DESIGN

QUARTER-JAW INSERTS THAT SELF-LOAD PIPE FROM THE GROUND

The Talon 2000 is available with quarter-jaw inserts to fit your required pipe size from 54" to 2000mm. This unique design allows the lower jaws of the machine to lift pipe from the ground and position it for proper alignment and fusion. They are easily installed by two people as part of a quick, jobsite setup. Simply place each upper insert into the jaw, rotate and lock into place with a spring-loaded pin. The lower quarter jaws are inserted into the jaw pivot, then rotated and locked into place with two included bolts.

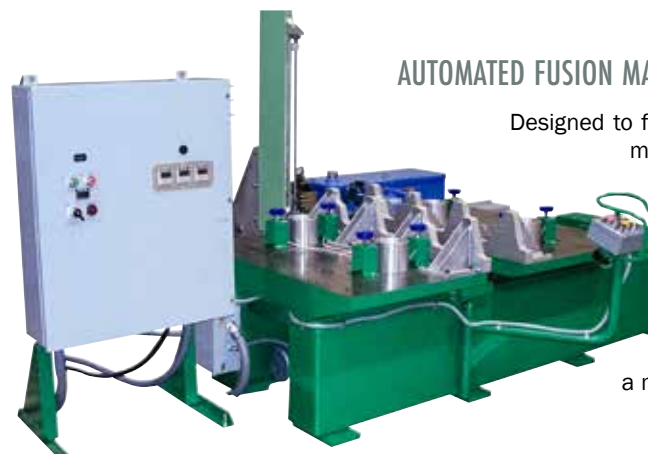
See **Replacement Parts & Accessories** section for available inserts.



CUSTOM FUSION MACHINES

LET OUR DESIGN & ENGINEERING SERVICES FIND A SOLUTION FOR YOU

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 indoor or outdoor conditions and have the capability for butt, socket or sidewall fusions and fabricating segmented ells 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.

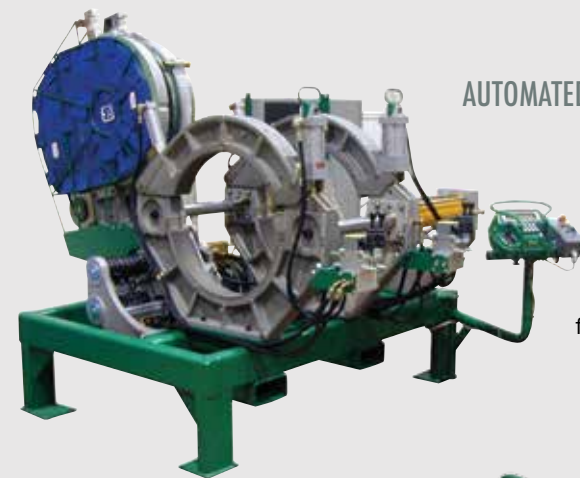


AUTOMATED FUSION MACHINE FOR BLOW MOLDED PARTS

Designed to fuse together two of the same blow molded parts, this machine gives you the ability to offer multiple sizes for your finished product using your modular design. The fixturing and vacuum system on the machine allows for quick part loading and unloading, reducing the fusion cycle time to a minimum.

POLYETHYLENE BALL VALVE MACHINE

McElroy has worked with multiple polyethylene ball valve manufacturers to supply in-plant equipment for the assembly and fusion of their injection-molded valve components. Multiple sets of custom interchangeable tooling allows for different valve sizes in a single machine or for machines sized for a specific high-volume valve size.



AUTOMATED FITTING & PUPPING FUSION MACHINE

This butt fusion machine is designed for in-plant fabrication of mitered elbows or pupping more complex fittings.



MANUAL U-BEND MACHINE

This was created as a more affordable option for customers with a lower output requirement than the automated dual-station, U-bend machines. Special inserts hold the U-bend fittings for fusion to the double coils. These machines use the jaws and fusion mechanism from our standard 14 fusion machines. It is available with adjustable or rigid inner-fixed jaws and uses specially-designed facers with two small facer blade holders that provide burr-free facing for side-by-side fusions. These machines can also be designed to provide solutions for many special geothermal loop fusion applications.

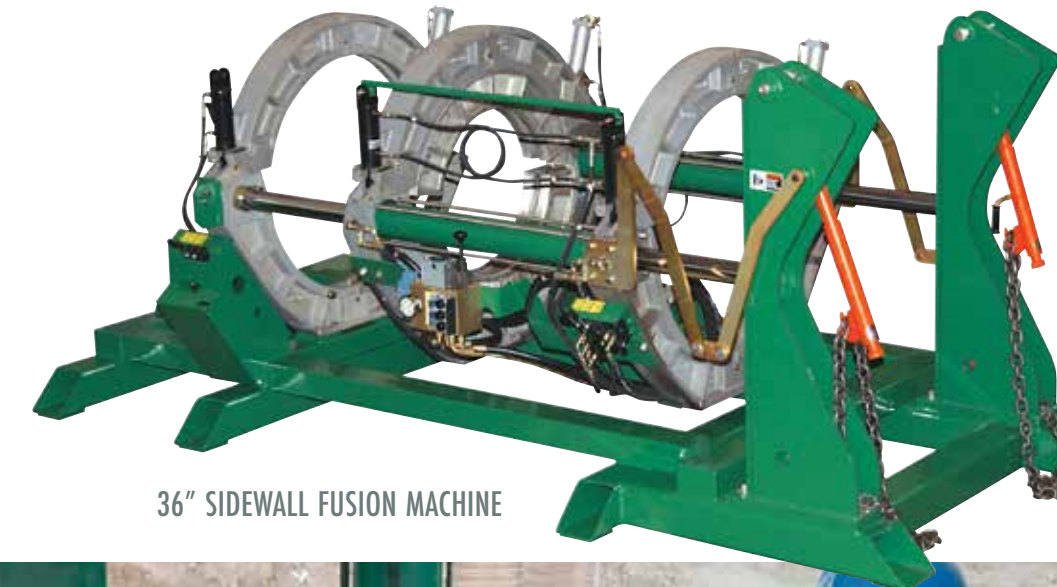


VERTICAL FUSION MACHINE

A pipe manufacturer investigating fusible plastic casings for oil wells led to the design of this machine which allows for proper fusions in a vertical configuration. It has a counterbalanced heater for an even melt-top and bottom. The stand was designed with leveling feet and the ability to support a fusible well casing weighing up to 3,500 lbs. This machine can be tipped back on its wheels and used as a standard horizontal fusion machine.

LARGE-DIAMETER SIDEWALL FUSION MACHINES

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 of the quality features found in all McElroy machines. This results in 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.



36" SIDEWALL FUSION MACHINE



FOR MORE INFORMATION ON **CUSTOM**
OR **SIDEWALL FUSION MACHINES**,
PLEASE CONTACT US AT:

(918) 831-9350

applicationsengineering@mcelroy.com



BIG, OPERATOR-FRIENDLY TALON™ 2000 BRINGS INNOVATIVE PIPELINING METHOD TO LARGE- DIAMETER FUSION

Fusing large-diameter pipe for long distances can be accomplished efficiently and professionally with the revolutionary, new capabilities of the Talon 2000. Self-propelled on rugged steel tracks, the Talon 2000 has introduced the pipelining method to the pipe fusion industry with its

ability to move from joint to joint — from one end of a job to the other.

Contractors found the Talon 2000's innovative approach suited their needs exquisitely when constructing a 13,000-foot irrigation pipeline to a drought-stricken agricultural area. High-density polyethylene

pipe (HDPE) was selected to replace a 17-year-old steel pipe that was already corroding and leaking. A rust-free, longer-lasting, leak-free system was sought.

The staging of the job called for 54-inch DR 17 pipe sticks to be laid out in a straight line for two and a half miles. Moving pre-

cisely to each fusion location via wireless remote control, the Talon 2000 picked up each stick of pipe from the ground with its powerful jaws, aligned it within the machine, fused it and drove over the top of the pipeline to the next joint.

Operators appreciated the self-loading feature which made it easier and safer to handle pipe since it stays close to the ground. They didn't need a crane to lift pipe overhead into the top of the machine. They also didn't need a crane to lift the heater and facer. The Talon 2000's electric-powered indexer accurately and safely positioned the heater and quick-action facer into place.

Another advantage was that they didn't have to do tie in fusions — which takes more time, equipment and manpower. Since the Talon can move on its own from fusion to fusion, they didn't need heavy equipment to pull large pipe strings together. Only an off-road fork lift was used.

Though big and somewhat intimidating at first, fusion operators found that the Talon 2000 made it easier to do their jobs effectively. A feature that sequences the heater removal process and completes the fusion with a single input from the operator was found to work exceptionally well. The touch-screen interface was a great help since it is similar to McElroy's other hydraulic machines they had worked with before.

The Talon 2000 offered them a lot within one machine. It is completely self-contained with a diesel engine and on-board generator — which eliminated the need for added power on site. It has a built-in data logging feature to record joint fusion data to ensure proper fusion procedures were followed. These records can be uploaded to the DataLogger® Vault™, a secure server on the internet for quick and easy sorting, tagging, sharing and storage of joint records.

Contractors were pleased with the results and found the Talon 2000 to be a great asset on the job. They exceeded their expectations by performing six fusions a day per 10-hour shift with quality results and an HDPE pipeline that will bring a reliable water source to the area for decades to come.

INCREASE JOBSITE EFFICIENCY PRODUCTIVITY TOOLS

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 line 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.

WEATHER TIGHT SEAL

KEEPS THE ELEMENTS OUT

The QuickCamp allows for continuous pipe fusion in conditions that may otherwise shut down a jobsite. It's made for 24/7 operations so your crew can keep working. The QuickCamp's unique pipe seals keep the elements out to maintain fusion joint integrity and make a more comfortable working environment inside the shelter. The pipe is fed via remote control from the MegaMc PolyHorse through the pipe seals into the QuickCamp and requires little operator interaction.



The McElroy QuickCamp™ System is a lighted, insulated and climate-controlled enclosure that allows operators to fuse pipe day or night under all weather conditions. The QuickCamp System includes the QuickCamp Shelter, which houses a 630 or 900 fusion carriage and comes with a MegaMc® PolyHorse® and MegaMc Rollers for greater productivity.

SEE HOW EASY IT IS TO SET UP THE QUICKCAMP

Watch the rapid deployment of the QuickCamp on the jobsite on our YouTube channel.

OUTSMART THE ELEMENTS QUICKCAMP

FAST & EASY SETUP

QUICK-DEPLOYING SHELTER GETS YOU BACK TO WORK

The QuickCamp™ Shelter is a specially-modified ISO shipping container that, when time to deploy, two people can unfold and be ready to work quickly. A 630 or 900 fusion machine carriage is included in the package and ships installed inside the QuickCamp. Leveling jacks help to correctly position the unit and window air-conditioning units quickly slide into place.



ONLY ONE OPERATOR

PRODUCTIVITY-ENHANCING ACCESSORIES SAVE TIME & MONEY

While the QuickCamp works to keep the elements out — saving downtime on the jobsite — it also provides the tools to allow operators to work more efficiently. Thanks to the included MegaMc® PolyHorse®, technicians can work an entire shift independently. The hydraulically-powered racks hold a day's worth of pipe and allow one operator to load, align and fuse pipe via remote control from inside the QuickCamp Shelter — eliminating the wait for heavy equipment to load pipe for each fusion joint.

COMFORTABLE ENVIRONMENT

KEEP WORKING NO MATTER THE CONDITIONS

The QuickCamp is well lit, both inside and out. Its 2.5" thick, R15-rated insulated walls help to regulate the inside temperature, while two heating and air units allow operators to create a comfortable work environment. Multiple electrical outlets can be found inside for powering personal equipment. And there is plenty of room inside for office space, a breakroom or storage.



STANDARD QUICKCAMP FEATURES

	QuickCamp 630	QuickCamp 900
Pipe size range from 8" IPS to 24" OD (225mm to 630mm)	●	
Pipe size range from 12" IPS to 36" OD (340mm to 900mm)		●
Shelter folds into standard ISO, 20' cargo container for shipping	●	●
Folded shelter contains fusion machine carriage	●	●
Carriage slides out of shelter for in-ditch use or fusing stub ends and fittings	●	●
Ample space for an office, breakroom or storage	●	●
Electrical outlets to power personal equipment	●	●
Hydraulic Power Unit powers fusion carriage with customer-furnished generator	●	●
One-size-fits-all pipe seals	●	●
Included heating and air-conditioning units fit into fold-out shelves	●	●

The PolyHorse® is a more productive way to store and handle pipe on the job. It helps reduce manpower and expenses while promoting a safer working environment. The PolyHorse pipe-handling system is a series of adjustable racks available in two size ranges: the standard PolyHorse for 3" IPS to 20" OD (90mm to 500mm) or the MegaMc® PolyHorse for larger size pipe from 20" OD to 48" OD (500mm to 1,200mm). They are designed to hold enough pipe for a day's worth of fusion work and allow a single operator to load and align pipe without the use of extra machinery.



INCREASE JOBSITE EFFICIENCY, NO MATTER THE PIPE SIZE POLYHORSE



SEE THE POLYHORSE IN ACTION

Visit the McElroy YouTube channel for setup and feature demonstrations.



PolyHorse

POWER THE PIPE

INCREASE PRODUCTIVITY WITH POWER-ASSISTED ROLLERS

Both the standard PolyHorse® and MegaMc® PolyHorse offer solutions to decrease operator and machine strain while increasing productivity. The PolyHorse can be purchased in a manual model or with hydraulic PowerAssist which helps to maneuver the pipe up, down and into the fusion carriage. The MegaMc PolyHorse features a powered, tracked pipe stand operated by remote control. It offers up to 24 inches of lateral and 34 inches of vertical movement to align out-of-round or curved pipe.



MegaMc PolyHorse

SAVE TIME & MANPOWER

HANDLE PIPE ONCE, AND ONLY ONCE

When the delivery truck shows up on the jobsite, pipe can be loaded directly on to the racks of the PolyHorse. The system will take care of the pipe from delivery onward — eliminating the need for a piece of heavy equipment to constantly tend to the next length of pipe. One operator can efficiently load and align each stick of pipe in the fusion machine. The MegaMc PolyHorse can be remotely controlled allowing the operator to stay at the fusion machine or move to the end of the pipe to help sight in alignment.

FIND THE RIGHT POLYHORSE FOR YOUR JOBSITE

	PolyHorse	MegaMc PolyHorse
Pipe size range from 3" IPS to 20" OD (90mm to 500mm)	●	
Pipe size range from 20" OD to 48" OD (500mm to 1,200mm)		●
Modular design	●	●
Enhances productivity by up to 150%	●	●
Reduces job cost	●	●
Reduces manpower and additional equipment	●	●
Quick setup	●	●
Racks are configurable depending on your jobsite	●	●
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	●	●
Pipe stays cleaner off the ground	●	●
Adjustable height legs set rack incline and adapt to uneven terrain	●	●
24" of lateral and 34" of vertical range of motion to align curved pipe with jaws of fusion machine		●

McElroy pipe rollers save time and reduce the need for heavy equipment to pull pipe while limiting damage to the pipe. Pipe rollers are available for a wide range of pipe, from 1" IPS up to 78" OD. They can handle the heaviest pipe loads with a maximum capacity of 16,000 pounds. Mix and match to create the best jobsite workflow — making pipe handling run more smoothly, increasing productivity and profitability.

WORK SMARTER, NOT HARDER, PIPE ROLLERS

PROTECT THE PIPE

KEEP PIPE OFF THE GROUND & REDUCE DAMAGE

Pipe rollers can be placed in intervals from the fusion machine on down the pipeline, creating a track that allows fused pipe to slide across the rollers. This is especially useful in industries that require contractors to keep the pipe clean and off the ground. Low Profile Rollers and MegaMc® Rollers allow for curved pulls over considerable distances. All McElroy pipe rollers are tip resistant and minimize drag on the pipe.

REDUCE STRAIN & USE LESS EQUIPMENT

McElroy pipe rollers take the hard work out of manipulating pipe. Products like the PolyPorter® combine the mechanical advantage of a dolly with the functionality of a pipe stand. This allows one operator to pick up, position and align pipe up to 8" DIPS. Many pipe stands are hydraulically adjustable, helping to quickly align pipe in the fusion machine. They are capable of supporting pipe from 3" up to 65", which eliminates the need for added lifting equipment. All pipe rollers and MegaMc® pipe stands have a sealed ball-bearing construction to ensure that pipe rolls smoothly.



PolyPorter



MIX & MATCH

CREATE THE SETUP THAT'S RIGHT FOR YOUR JOBSITE

Pipe Stands work in conjunction with one another to create the most efficient jobsite setup. Pipe rollers can be paired with both fusion machines and accessories, including the PolyHorse® or QuickCamp™ to increase productivity. Many pipe stands are adjustable for uneven terrain. This ensures the pipe is supported at the same height as the fusion machine, making alignment and face-off easier. Pipe stands and rollers allow long lengths of pipe to be pulled through the machine rather than moving the equipment from joint to joint — minimizing downtime between fusions.

FIND THE RIGHT PIPE ROLLER FOR YOUR JOBSITE

STANDARD FEATURES

	PolyPorter	Low Profile Rollers	MegaMc Rollers	Pipe Stands	MegaMc Pipe Stands
Keeps pipe clean and off the ground	●	●	●	●	●
Tip resistant	●	●	●	●	●
Minimizes drag on the pipe	●	●	●	●	●
Sealed ball-bearing construction	●	●	●	●	●
Minimizes pipe damage	●	●	●	●	●

ADDITIONAL FEATURES

Combines the advantages of a dolly and a pipe stand	●				
One person can easily load a length of pipe without strain	●				
Raises pipe to level of fusion machine	●			●	●
Allows for curved pulls		●	●		
Stackable for more compact storage		●	●		●
Hydraulic power available					●
Lateral adjustment for pipe alignment					●



With the **McElroy LineTamer®**, you can quickly install coiled pipe, conduit and duct by eliminating the need for multiple 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 jobsite. The 3" to 6" IPS LineTamer comes equipped with 4" to 6" re-rounding rollers. 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 pipe, conduit and duct quickly with minimal training. Ball-thrust bearings make for easy roller adjustment to remove the coil set in the pipe.

COILED PIPE STRAIGHTENER AND RE-ROUNDER LINE TAMER

STANDARD LINETAMER® FEATURES

	2" IPS	3-6" IPS
Straightens and re-rounds 2" IPS pipe	●	
Straightens and re-rounds 3" to 6" IPS pipe		●
Can install a full coil of pipe	●	●
Removes coil set for speedy installations	●	●
Ball-thrust bearings for easy adjustment	●	●
Self-contained hydraulic power unit	●	●



2" IPS LINETAMER

MODELS	
	LT0122
WEIGHT	
Machine	119 lbs (54 Kg)
DIMENSIONS	
Length	44.4" (1,129mm)
Width	19.8" (502mm)
Height	20.4" (518mm)
INCLUDES	
LineTamer and 2" IPS rollers. Trailer not included	



3-6" IPS LINETAMER

MODELS	
6" LineTamer & Gasoline HPU	ALT0048
6" LineTamer only	LT0048
WEIGHT	
Machine	730 lbs (331 Kg)
HPU	165 lbs (75 Kg)
DIMENSIONS	
Length	96" (2,438.4mm)
Width	46" (1,168.4mm)
Height	50" (1,270mm)
INCLUDES	
LineTamer and 4" - 6" IPS rollers. Trailer not included	

FEATURED ACCESSORIES



HYDRAULIC POWER UNIT FOR 3" - 6" IPS LINETAMER

Part numbers:
LT0172 - Gas HPU
6517501 - Diesel HPU
LT0185 - Electric HPU



3" - 4" RE-ROUND ROLLER KIT
 Required for 3" - 4" IPS pipe. Includes 2 re-round rollers and stop plates.

Part number:
LT0037



TANDEM HYDRAULIC POWER UNIT
 HPU for SweetWater Metal Products self-loading trailer.

Part number:
LT0171



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 for 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.

HANDLE PIPE TRANSITIONS EASILY, FUSE IN TIGHT SPACES

STUB END HOLDER

SELF-CENTERING STUB END HOLDERS

McElroy's Stub End Holders address a critical aspect of the fusion process by offering easy connectivity when transitioning to a different pipe material or fusing in extremely tight spaces. The stub ends hold a stub end fitting firmly in place as it is fused to the pipe end. Designed for 8", 12" and 18" machine jaws or inserts, they work by allowing you to tighten all four serrated jaws of the holder from a single adjustment point. During tightening, the stub end holder self-centers automatically, creating a very efficient fusion process in unique situations.



STANDARD SELF-CENTERING STUB END HOLDER FEATURES

- Serrated jaws securely hold a stub end throughout the fusion process ●
- Improved gripping ability ●
- A single 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 HOLDERS

MODELS	For 28/250 Machines	For 412 Machines	For 618/500 Machines	For 630/824 Machines
Part Number	885001	1270101	1879101	3655501

RANGE OF OPERATION

	For 28/250 Machines	For 412 Machines	For 618/500 Machines	For 630/824 Machines
Minimum OD	2.37" (60mm)	4.5" (114mm)	6.63" (148mm)	14.5" (368.3mm)
Maximum OD	10.88" (276mm)	16.02" (407mm)	21.27" (540mm)	41" (1,041.4mm)
Minimum ID ⓘ	N/A	10.78" (274mm)	13.36" (339mm)	N/A
Maximum ID ⓘ	N/A	17.21" (437mm)	22.46" (570mm)	N/A

REQUIRED JAW SIZE

	8" IPS	12" IPS	18" IPS	36" OD
Weight	14.6 lbs (6.6 Kg)	20.4 lbs (9.3 Kg)	29.1 lbs (13.2 Kg)	205 lbs (93 Kg)

WEIGHT

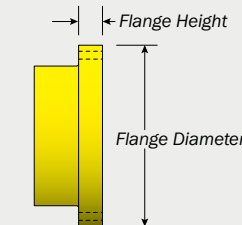
Weight	14.6 lbs (6.6 Kg)	20.4 lbs (9.3 Kg)	29.1 lbs (13.2 Kg)	205 lbs (93 Kg)
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ⓘ 12" and 18" Stub End Holders are capable of clamping on the inner diameter of the stub end to accommodate larger sizes.



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.

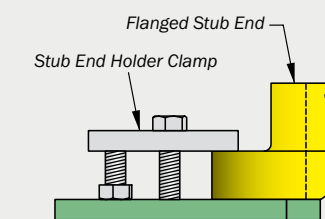


MANUAL CLAMP STUB END HOLDERS

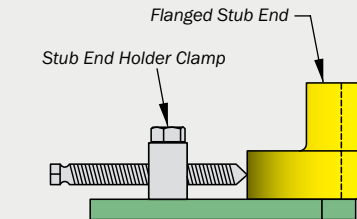
MODELS	For 14 Machines	For 824 Machines	For 1236 Machines	For 1648 Machines	For 2065 Machines
Part Number	410601	2419501	3606901	4812601	6315501

FLANGE

	For 14 Machines	For 824 Machines	For 1236 Machines	For 1648 Machines	For 2065 Machines
Minimum Dia.	1.5" (38mm)	7" (178mm)	13.625" (346mm)	16.625" (422mm)	21.125" (536mm)
Maximum Dia.	7.59" (193mm)	26.25" (667mm)	36.75" (933mm)	49.25" (1,251mm)	68.875" (1,749mm)
Minimum Height	no over clamps	.25" (6.35mm)	.25" (6.35mm)	.25" (6.35mm)	1.375" (35mm)
Maximum Height	no over clamps	3.375" (86mm)	3.375" (86mm)	3.375" (86mm)	4.375" (111mm)



STUB END HOLDER WITH OVER CLAMPS



STUB END HOLDER WITH SIDE CLAMPS



HOT TAP TOOL

TAP LIVE MAINS WITHOUT SERVICE DISRUPTIONS

The McElroy Hot Tap Tool is the most precise and economical way to tap through 2", 3", 4" or 6" branch saddles. The gland is customized to meet the user's material of choice, eliminating the need for material compatibility fusion in the field.

The cutter collects and extracts pipe shavings and the coupon, preventing main line contamination. 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 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.



HOT TAP TOOL

2" IPS - 6" IPS BRANCH SADDLES

MODELS ⓘ	2" IPS	3" IPS	4" IPS	6" IPS
Medium Density (2406/2708)	220002	220106	220206	220302
High Density (3408/4710)	220003	220107	220207	220303

INCLUDES

Hot Tap tool, ratchet wrench and storage case

FEATURED ACCESSORIES



SPARE CUTTERS

Pipe Size	Cutter Diameter	Maximum Coupon Depth	Part Number
2" IPS	1.48"	1 1/16"	221501
3" IPS	2.20"	1 7/16"	221601
4" IPS	2.95"	2 1/4"	221702
6" IPS	4.44"	3"	221902



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

ⓘ Tools for other pipe materials available upon request. Contact your McElroy representative.

HYDRAULIC CLAMPING

RETROFIT KIT FOR ROLLING AND TRACSTAR® MACHINES

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, ells and tie-ins
- Retrofit kit can be installed at your local McElroy distributor
- Can be purchased, factory-installed on new machines

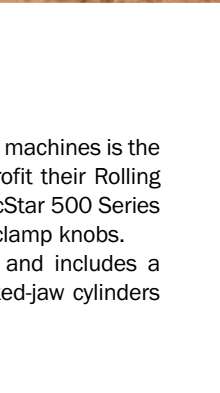


HYDRAULIC CLAMPING KITS

RETROFIT KIT FOR ROLLING AND TRACSTAR MACHINES

MODELS	Rolling & TracStar 412	Rolling & TracStar 618	TracStar 500 Series II	TracStar 500 Series II Auto
	A1262301 ⓘ	A1870301 ⓘ	AT5044801	AT5045201

ⓘ Kits are compatible with 412 and 618 Rolling machines introduced after 2003 under the model number series 1248.1xx & 1869.1xx. Components for individual kits may vary.






QUICKCAMP™ 630
8" IPS - 24" OD (225mm - 630mm)

MODELS			
Input Voltage	208V, 60Hz, 3Ph	240V, 50Hz, 3Ph	415V, 50Hz, 3Ph
High Force	A3658701	A3658704	A3658707
Medium Force	A3658702	A3658705	A3658708
Low Force	A3658703	A3658706	A3658709

WEIGHT			
Shelter with carriage	15,065 lbs (6,833.4 Kg)		
Shelter only	11,160 lbs (5,062.1 Kg)		

POWER			
Motor	20 HP		
Electrical Outlets	120V, 60Hz	240V, 50Hz	240V, 50Hz
Electrical Outlets Plug Type 	A	M	M

HYDRAULICS			
Capacity	35 Gallons (132.5 Liters)		
System Pressure	2,300 PSI (158 BAR)		

DIMENSIONS			
Length	240" (6,100mm)		
Width	96" (2,440mm)		
Height	102" (2,590mm)		


INCLUDES			
QuickCamp Shelter, fusion machine carriage, MegaMc PolyHorse and MegaMc Rollers pipe handling systems, two pipe support stands and three standard 20' dry freight containers			



LOW PROFILE ROLLERS
4" IPS - 18" IPS (100mm - 450mm)

MODELS	Part Number
Roller Set (includes 2 individual rollers)	A1867502
40 complete rollers (1,875 lbs.)	A1867501

CAPACITY	
Maximum Load	2,000 lbs (907.1 Kg)

 See **Reference** section for plug types



QUICKCAMP 900
12" IPS - 36" OD (340mm - 900mm)

MODELS					
	208V, 60Hz, 3Ph	240V, 50Hz, 3Ph	415V, 50Hz, 3Ph		208V, 60Hz, 3Ph
					A3658501
					A3658502
					A3658503

WEIGHT					
	15,950 lbs (7,234.8 Kg)				
	11,160 lbs (5,062.1 Kg)				

POWER					
	20 HP				
	120V, 60Hz	240V, 50Hz	240V, 50Hz		240V, 50Hz
	A	M	M		M

HYDRAULICS					
	35 Gallons (132.5 Liters)				
	2,300 PSI (158 BAR)				

DIMENSIONS					
	240" (6,100mm)				
	96" (2,440mm)				
	102" (2,590mm)				

INCLUDES					
	QuickCamp Shelter, fusion machine carriage, MegaMc PolyHorse and MegaMc Rollers pipe handling systems, two pipe support stands and three standard 20' dry freight containers				



MEGAMC® ROLLERS
12" IPS - 78" OD (340mm - 2,000mm)

MODELS	Machine Range	Part Number
54" roller assembly	412 - 1,648	4842401
2,000mm roller assembly	900 - 2,000	7828301

CAPACITY		
Maximum Load (54" roller)	9,000 lbs (4,082.3 Kg)	
Maximum Load (2,000mm roller)	14,175 lbs (6429.7 Kg)	



POLYHORSE®
3" IPS - 20" OD (90mm - 500mm)

MODELS	With PowerAssist	With Manual Roller
Standard	1875502	1875501
Compact	1875505	1875504

WEIGHT		
Standard	1,200 lbs (544.3 Kg)	1,000 lbs (453.6 Kg)

ELECTRICAL		
Minimum Power Req.	Powered by hydraulic fusion machine	N/A

CAPACITY		
Maximum Load	36,000 lbs (16,329.33 Kg)	
Maximum Load Per Stick	N/A	

INCLUDES		
	3 trusses, 3 stanchions, 6 screw jacks, 1 pivot roller support, 2 stationary rollers and wrench	



POLYPORTER®
2" IPS - 8" DIPS (63mm - 250mm)

MODELS	
Pipe Stand and Dolly	864201

WEIGHT	
Machine	63 lbs (28.6 Kg)

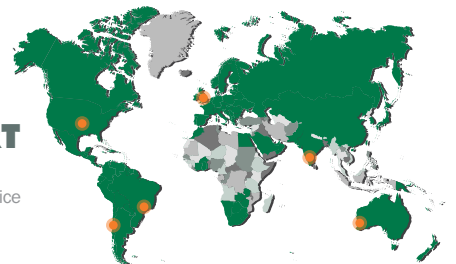
CAPACITY	
Height Range	20.5" - 38" (521mm - 965mm) at center of 8" DIPS pipe
Maximum Load	300 lbs (136 Kg)

DIMENSIONS	
Length	51.5" (1,308mm)
Width	31" (787mm)
Height	32" (811mm)



INDUSTRY LEADING WARRANTY
McElroy leads the industry by standing by our products. We warrant all products manufactured, sold and repaired to be free from defects in materials and workmanship for 5 years. **See inside back cover for details.**


WORLDWIDE SALES, SERVICE & SUPPORT
FIND A DISTRIBUTOR NEAR YOU!
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.



MEGAMC® POLYHORSE
20" - 48" OD (500mm - 1,200mm)

MODELS	220-240V, 50/60Hz, 3Ph	380-415V, 50Hz, 3Ph
Standard	4834001	4834002

WEIGHT	
Racks (4 total)	4,700 lbs (2,132 Kg)
Tracked pipe stand	3,810 lbs (1,728 Kg)
Roller pipe stand	3,180 lbs (1,442 Kg)

POWER		
Motor	5 HP	
Minimum Power Req.	7.5 kVA / 6.4 kW	7.2kVA/6.2kW
Plug Type 	F	K

CAPACITY	
Maximum Load	70,000 lbs (31,751 Kg)
Maximum Load Per Stick	10,500 lbs (4,763 Kg)

DIMENSIONS


Tracked or roller pipe stand with trolley centered, ramps on and lowering arm assembly attached

Length	130" (3,302mm)
Width	91" (2,311mm)
Height	65" (1,651mm)

<i>Rear rack (each)</i>	
Length	173" (4,394mm)
Width	30" (762mm)
Height	65" (1,651mm)

<i>Front rack (each)</i>	
Length	173" (4,394mm)
Width	30" (762mm)
Height	38" (965mm)

INCLUDES	
	2 rack sets, powered tracked pipe stand, roller pipe stand, lifting sling, 4 outrigger pads, 8 safety cones and remote control

 See **Reference** section for plug types



MANUAL PIPE STANDS

MODELS	Size Range	Maximum Load	Weight	Part Number
14 Pipe Stand ¹	1" IPS - 4" DIPS (32mm - 110mm)	2,500 lbs (1,134 Kg)	37 lbs (16.8 Kg)	422801
28 Pipe Stand ²	1" IPS - 8" DIPS (32mm - 250mm)	2,500 lbs (1,134 Kg)	57 lbs (26 Kg)	812501
Pipe stand with manual chain height adjustment	4" IPS - 20" OD (110mm - 500mm)	2,750 lbs (1,247 Kg)	100 lbs (45 Kg)	AT5066701
Large Standard Pipe Stand	8" IPS - 36" OD (225mm - 900mm)	4,500 lbs (2,041 Kg)	240 lbs (109 Kg)	T9055801
Heavy-Duty Pipe Stand	8" IPS - 48" OD (225mm - 1,200mm)	6,500 lbs (2,948 Kg)	595 lbs (270 Kg)	4823901
2065 Pipe Stand	20" OD - 65" OD (500mm - 1,600mm)	11,000 lbs (4,989 Kg)	1,025 lbs (465 Kg)	6314001



HYDRAULIC, SELF-CONTAINED PIPE STANDS

MODELS	Size Range	Maximum Load	Weight	Part Number
8" - 36" MegaMc® Pipe Stand Gas powered	8" IPS - 36" OD (225mm - 900mm)	9,000 lbs (4,082 Kg)	2,160 lbs (980 Kg)	3645001
8" - 36" MegaMc Pipe Stand Diesel powered	8" IPS - 36" OD (225mm - 900mm)	9,000 lbs (4,082 Kg)	2,160 lbs (980 Kg)	3645002
36" - 65" MegaMc Pipe Stand Gas powered	12" IPS - 65" OD (340mm - 1,600mm)	16,000 lbs (7,257 Kg)	3,025 lbs (1,372 Kg)	6513501
36" - 65" MegaMc Pipe Stand Diesel powered	12" IPS - 65" OD (340mm - 1,600mm)	16,000 lbs (7,257 Kg)	3,025 lbs (1,372 Kg)	6513502

¹ For use with the 14 Cart (434001) only

² When used with 14 and 26 - use Manual Fusion machine stand (439001)



HYDRAULIC, HAND-PUMP-POWERED PIPE STANDS

MODELS	Size Range	Maximum Load	Weight	Part Number
Pipe stand with hydraulic height adjustment (no pump kit)	4" IPS - 20" OD (110mm - 500mm)	2,750 lbs (1,247 Kg)	112 lbs (51 Kg)	AT5066702
Pipe stand with manual chain height adjustment	4" IPS - 20" OD (110mm - 500mm)	2,750 lbs (1,247 Kg)	137 lbs (62 Kg)	AT5066703



HYDRAULIC, FUSION MACHINE-POWERED PIPE STANDS

MODELS	Size Range	Maximum Load	Weight	Part Number
Large Hydraulic Pipe Stand	4" IPS - 20" OD (110mm - 500mm)	4,500 lbs (2,041 Kg)	350 lbs (159 Kg)	T9055701

FEATURED ACCESSORIES



HYDRAULIC PUMP KIT
Hand pump kit for use with AT5066702 pipe stand.

T5067001

HYDRAULIC PIPE STAND VALVE/HOSE KIT

Two section valves and one set of hoses to power a hydraulic stand. *For use with T9055701 and T9055801 only.*

AT9055901

EXTENSION HOSES

One set of hoses for T5067001 kit to power two hydraulic pipe stands. *For use with T9055701 and T9055801 only.*

T9055902



POLYHORSE[®] HELPS CONTRACTOR TACKLE CROSS-COUNTRY FUSIONS

MANY PEOPLE HAVE HEARD OF A CROSS-COUNTRY FOOT RACE. A CROSS-COUNTRY RACE IS A TIMED EVENT WHERE COMPETITORS FACE DIFFERENT CHALLENGES OVER A FIXED DISTANCE. THE OBSTACLES CAN RANGE FROM WEATHER TO ADVERSE TERRAIN. THE THRILL OF THE RACE MIGHT BE THE OBSTACLES AWAITING THE COMPETITORS AT EVERY TURN. HOWEVER, NO ONE WOULD BLAME A COMPETITOR FOR USING A SHORTCUT IN THE RACE, IF IT WERE LEGAL AND WITHIN THE RULES.

Near Loudonville, Ohio, R&R Pipeline just finished a cross-country race of sorts. They were one of two contractors used to fuse a great distance of pipe in less than two months. Under a time limit and with several obstacles, R&R turned to some productivity shortcuts to gain speed and efficiency in efforts to meet the deadline.

The first stage of the race was a one-week time period to get the bid drawn up. R&R was awarded the contract by Dominion East Ohio to install 38,000 feet of high density polyethylene pipe (HPDE) on April 2nd. Four days later, the first six trucks delivered pipe. The finish line for the project was a very speedy May 31st.

The cross-country metaphor extends even further. R&R Pipeline was forced to perform some of the fusions and directional bores far away from the roads. The boring of holes across fields and pastures was required by the Environmental Protection Agency (EPA). The measure was in place to protect cornfields that could hold artifacts from the Mohican Indians, as well as other Native American tribes.

With 30,000 feet of 12-inch and 8,000 feet of 8-inch pipe to install, R&R began mobilizing resources, which included 50 fusion operators in the 140-person firm, immediately after winning the bid. Along with the miles of pipeline to be fused, 29 tie-ins and tapping tees were required.

The rural hills created a few hurdles, leaving spotty to non-existent cell phone reception to communicate between the 38 R&R workers on site. Multiple job sites operated in unison, but at distances just out of walkie-talkie range. Also, tree-covered hillsides offered little in terms of right-of-ways.

Mixed with the EPA concerns and out-right speed required to complete the job on time, a McElroy PolyHorse PowerAssist was put into the field. The PowerAssist is a hydraulically-powered roller that replaces the pivoting roller on the original PolyHorse design. The PolyHorse is a pipe-handling system for 3" to 20" pipe (90mm to 500mm) that allows the pipe to be delivered and stored at a single location. The powered roller aids in maneuver-



ing sticks of pipe up, down and into the fusion machine.

With the PolyHorse PowerAssist and a TracStar 412, R&R's fusion operators averaged 29 joints of 12-inch pipe per work day. However, the productivity didn't stop there. When fusing some of the longer lengths of pipe out of the 38,000 total

machine to machine, using the downtime of the cooling period to the operator's advantage.

R&R also found value in a simple, but often overlooked piece of the McElroy productivity tool lineup. On the opposite end of the fusion site from the PolyHorse, R&R used pipe stands to save wear and tear on the TracStar, keeping the length of pipe close to parallel for faster facing and hi/low adjustment, and for ease in pulling the length of pipe after a completed joint.

When all was said and done, R&R completed the job a week and a half early. The productivity of all the tools, finding a job-site setup that works and working hand-in-hand with a local McElroy distributor proved highly productive in the long run.

"THE TRACSTAR JUST HAS TOO MANY BENEFITS"

JEFF EMERY

feet of pipe, R&R used a technique called piggybacking. Piggybacking is the practice of having two machines staged at one location so that a fusion technician can fuse one joint while another cools. Once a joint is cooled and pulled out of the machine, the process starts over and rotates from

To read the complete article, go to mcelroy.com/en/articles/phwithpaidsOhiocontractor.htm



FIND COURSES ONLINE & REGISTER TODAY

Fusion training for small-, medium- and large-diameter pipe. McElroy University Courses are offered year-round, with new classes added frequently. Troubleshooting, Rebuild and Inspector courses are also available. www.mcelroy.com/university



CUSTOMER/TECH SUPPORT

Whether you prefer email, discussion forums 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.

(918) 831-9236

businesssupport@mcelroy.com

The need for better record keeping and increased accountability is growing among those who build and manage pipeline infrastructures. New standards, including ASTM F3124, have been implemented to govern the collection of data from plastic pipe fusions. The new DataLogger® 6 from McElroy meets these requirements while capturing the most information related to fusion operations. It is now easier than ever before to add improved traceability and assurance that pipelines were fused properly before they go into service.

BETTER TRACEABILITY FOR PIPE FUSION OPERATIONS DATA LOGGER 6

**STRAIGHT
FORWARD DATA
COLLECTION**
CAPTURE MORE INFORMATION

The DataLogger 6 features the tools necessary to properly capture the most important data from your jobsite. Scan the barcode on your pipe or fitting to automatically enter pipe material, size, manufacture date and lot. Add operator and machine information, along with GPS location of each joint and photos of the completed fusion.



ANDROID POWERED RUGGED TABLET

IP67 WATER & DUST RESISTANT

The DataLogger® 6 is ready for almost any jobsite challenge with the highest-rated dust protection along with water resistance up to 1 meter in depth. The capacitive touchscreen is glove-friendly and uses LumiBond® display technology to produce excellent visibility even in direct sunlight.

DataLogger VAULT

STORE, SHARE & ANALYZE YOUR DATA

The DataLogger wirelessly syncs with the Vault™ – allowing safe and secure storage of fusion joint records online. Joint records can be viewed, shared or analyzed anywhere you have an internet connection.

Learn more at vault.mcelroy.com

USER-FRIENDLY INTERFACE

The interface of the DataLogger® 6 was designed to be easy to use. It features large, touchscreen buttons and concise on-screen instructions to guide users through the process.



REAL-TIME ANALYSIS

MONITOR JOINT INTEGRITY DURING THE FUSION PROCESS



The DataLogger is used to record and document key parameters of the fusion process to determine if a joint was fused with correct pressure and times according to supported standards. Heat soak times, heating pressure, open/close times, fusion time, fusion pressure and cool time are all recorded. The real-time fusion graph gives the operator immediate visual feedback and information regarding the integrity of each fusion joint.

ON-SCREEN HELP

CONTEXT-SENSITIVE RESOURCES DURING THE FUSION PROCESS

The DataLogger 6 includes context-sensitive resources during key points of the fusion process. Just tap the question mark icon in the lower left of the screen to view videos or other information based on the current stage of the fusion process.



STANDARD FEATURES

- Android-powered, 7-inch tablet
- Water and dust resistant
- Meets ASTM F3124 standard for data recording of heat fusion joints
- Real-time visual graph generation
- Support for butt fusion, sidewall fusion and dual-containment fusion
- On-screen, contextual resources
- Captures GPS or GLNSS location
- Barcode scanner inputs pipe and fitting information
- Dual cameras for pictures of fusion joints, jobsite, face-off and bead-up
- Wirelessly syncs to Vault™
- Multilingual support



DATALOGGER 6

MODEL	DL18001
DIMENSIONS & WEIGHT	
Weight	1.77 lbs (0.8 Kg)
Tablet Dimensions	8.58" x 5.6" x 1.06"
DISPLAY	
Resolution	1280 x 720, HD, capacitive touch-screen
SYSTEM	
Operating System	Android 5.1
Memory	2 GB MDDR
Microprocessor	Intel® Atom x5-Z8350
Storage	32GB NAND Flash
CAMERA	
Front/Back	2 / 8 megapixels
POWER	
Requirements	100-240 V, 24 Watt, 12V, 2Amp, 50/60 Hz
Battery	Lithium-Polymer 7600 mAh
CONNECTIVITY	
	Bluetooth®, Wi-Fi, 4G LTE
INCLUDES	
	Tablet, transducer, A/C adapter, machine mount, stylus, carrying case

Thermoplastic pipe offers amazing durability and longevity, and when you're installing it, you expect decades of service. Don't leave your pipeline to chance. Use McElroy's quality assurance tools to support your fusion operations and know that your fusion joints meet the highest standards.

PUT PEACE OF MIND IN YOUR PIPELINE

TESTING TOOLS



QUALIFY OPERATORS & PIPE

McElroy quality assurance tools can be used at the beginning of the day or the onset of a project to validate the machine operator, fusion process and pipe materials. The In Field® Tensile Tester and Guided Side Bend Tester allow for quick, on-site analysis.



In Field® Tensile Tester

Guided Side Bend Tester



ONSITE TENSILE TESTING

The In Field® Tensile Tester provides a quick and easy qualitative test of a fusion joint in the field — even from thick-walled pipe. Tensile testing of fusion joints took days or even weeks in the past, but results are immediate with the In Field Tensile Tester. A template is used so that a drill and reciprocating saw can produce a dual-reduced section coupon in minutes.

The coupon is inserted into the tensile test unit, which conducts a destructive test on the sample for a quick comparison of the integrity of the joint versus the parent pipe. The hand-pump system tests coupons from 2" OD and larger pipe sizes.



TEST FUSION JOINTS MORE QUICKLY

Testing fusion joints in the past often required cutting a coupon from the pipe and sending it to a lab for analysis and waiting for the results to come back. With McElroy's In Field Tensile Tester and Guided Side Bend Tester, technicians can easily and quickly conduct a qualitative test of those same joints right on the jobsite.



DUCTILITY TESTING IN THE FIELD

The Guided Side Bend Tester is a qualitative test that assures the ductility of a fusion joint on the job in a safe and quick manner. It meets the ASTM F3183 standard for guided side bend evaluations of polyethylene pipe fusion joints. The hydraulically-powered device puts three points of pressure on test coupons with up to 7" pipe walls. If no gaps or breaks are present in the fusion joint after the test, the result is a passing grade.

FIND THE RIGHT TESTING TOOL FOR YOUR JOBSITE

	Guided Side Bend Tester	In Field® Tensile Tester	McSnapper®
Tensile with impact testing machine			●
Meets ASTM F2634 laboratory testing procedures			●
Provides accurate testing for fused joints	●	●	●
Qualitative testing of the ductility of a joint	●	●	
Field suitable	●	●	
Hydraulic hand-pump system	●	●	
Template accommodates 2" IPS and larger pipe		●	
Process takes minutes, not days or weeks	●	●	
Meets ASTM F3183 standard for side bend testing	●		
Maximum wall thickness	7"	5"	2.6"

TENSILE IMPACT TESTING IN THE LAB

FUSION JOINT TESTING UP TO 2.6" WALL THICKNESS

The McSnapper® is designed to meet the requirements of ASTM F2634, the standard test method for laboratory testing of polyethylene (PE) butt fusion joints using tensile impact testing.

The McSnapper can be used in the development of new materials, quality assurance for existing materials or in fusion compatibility to determine lot uniformity, strength and fusibility of pipe and fittings.

Part number: **S00108**



FEATURED REPLACEMENT PARTS & ACCESSORIES



95% IN FIELD COUPON DRILL FIXTURE
In Field Tensile Tester coupon template for 2" OD and larger pipe.

Part number: **S04801**



DRILL BIT FOR IN FIELD TENSILE TESTER
Specially-designed drill bit for coupon drill fixture.

Part number: **MJL00074**



IN FIELD TENSILE TESTER

FIELD TESTER FOR 2" IPS & LARGER PIPE

MODELS	AS03501
WEIGHT	
Machine	105 lbs (48 Kg)
Coupon Drill Fixture	18 lbs (8 Kg)
DIMENSIONS	
Length	24" (610mm)
Width	15" (381mm)
Height	22" (559mm)
INCLUDES	
Hand-pump testing unit, 95% coupon template and 1/2" shank drill bit. Drill driver and reciprocating saw sold separately	



GUIDED SIDE BEND TESTER

DUCTILITY TESTING FOR 1" - 7" PIPE WALLS

MODELS	S05501
WEIGHT	
Machine	31 lbs (14.1 Kg)
CAPACITY	
Maximum Test Coupon Thickness	1/2"
Mandrel Diameter	1"
DIMENSIONS	
Length	6" (152.4mm)
Width	10.04" (255mm)
Height	14.59" (370.6mm)
INCLUDES	
Testing unit and hydraulic hand-pump. Planer, reciprocating saw and calipers sold separately	

TEST CAPS

AIR PRESSURE TESTING FOR 1/2" CTS - 2" IPS

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 U.S. Code of Federal Regulation 49 CFR192.513. 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. McElroy Test Caps also include a safety lanyard for added operator protection.

FEATURES

- Quick and easy air pressure testing of polyethylene pipe ●
- Easily installed and removed for repeated use ●
- Test caps meet 49 CFR 192.513 ●
- Tests pipe sizes from 1/2" CTS to 2" IPS ●
- Safety lanyard for added operator protection ●



PIPE SIZE	PART NUMBER
1/2" CTS	TP-301
1/2" IPS	TP-302
3/4" CTS	TP-303
3/4" IPS	TP-304
1" CTS	TP-305

PIPE SIZE	PART NUMBER
1" IPS	TP-306
1 1/4" CTS	TP-307
1 1/4" IPS	TP-308
1 1/2" IPS	TP-309
2" IPS	TP-310

Includes: Test cap and lanyard assembly.
1/4" MPT adapter fitting and pressure gauge sold separately



REPLACEMENT PARTS & ACCESSORIES



BUTT FUSION HEATER
 1LC through TracStar® 500 feature microprocessor-control and dial thermometer to monitor temperature.

MACHINE	VOLTAGE REQUIREMENTS	PLUG TYPE 1	PART NUMBER
Mini-Mc®	100-120V, 50/60Hz, 1Ph	A	CTS00702
	220-240V, 50/60Hz, 1Ph	C	CTS00703
1LC	100-120V, 50/60Hz, 1Ph	A	CTS20101
	220-240V, 50/60Hz, 1Ph	C	CTS20001
2LC, 2CU	100-120V, 50/60Hz, 1Ph	A	A215505
	220-240V, 50/60Hz, 1Ph	C	A215506
Pit Bull® 14	100-120V, 50/60Hz, 1Ph	A	A424317
	220-240V, 50/60Hz, 1Ph	C	A424318
		M	424319
Pit Bull 26	100-120V, 50/60Hz, 1Ph	A	707701
	220-240V, 50/60Hz, 1Ph	C	707601
Acrobat™ 180	100-120V, 50/60Hz, 1Ph	A	707701
	220-240V, 50/60Hz, 1Ph	M	707602
DynaMc® HP & EP, Pit Bull, Rolling, TracStar® 28	100-120V, 50/60Hz, 1Ph	A	848709 3
	220-240V, 50/60Hz, 1Ph	C	848803 3
DynaMc HP & EP, Pit Bull, Rolling, TracStar 250	220-240V, 50/60Hz, 1Ph	C	T2501002 3
DynaMc HP & EP, Pit Bull, Rolling, TracStar 412	220-240V, 50/60Hz, 1Ph	C	1242112 3
Pit Bull, Rolling, TracStar 618	220-240V, 50/60Hz, 1Ph	C	1855502 3 (6" IPS-12" DIPS) 1852019 3 (12" IPS-18" OD)
TracStar 500	220-240V, 50/60Hz, 1Ph	N/A	T5048001

- 1 See **Reference** section for plug types
- 2 Heater stands also hold facer
- 3 Includes heater stand



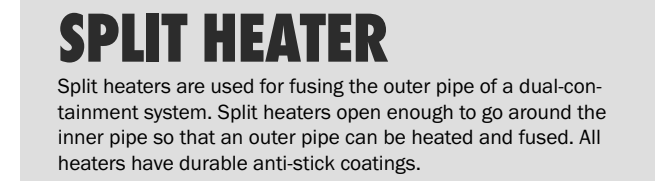
BUTT FUSION HEATER PLATES
 Set of plates with anti-stick coating required for butt fusion. Kit includes plates, attaching screws and wrench.

MACHINE	PART NUMBER
2LC, 2CU	A215701
Pit Bull 14	A425201
Pit Bull 26, Acrobat 180	A707901
DynaMc HP & EP, Pit Bull, Rolling, TracStar 28	A848706
DynaMc HP & EP, Pit Bull, Rolling, TracStar 250	AT2501101
DynaMc, Pit Bull, Rolling, TracStar 412	A1242108
Pit Bull, Rolling, TracStar 618	A1242108 (6" IPS - 12" DIPS)
	A1852013 (12" IPS - 18" OD)
TracStar 500 Series 3	AT5048011
TracStar 630, MegaMc® 824	A2428506
TracStar 900, MegaMc 1236	A3617201
TracStar 1200, MegaMc 1648	A6311805
MegaMc 2065, 1600	A6311805 (20" - 48" OD)
	A6512701 (48" - 65" OD)
Talon™ 2000	7805013

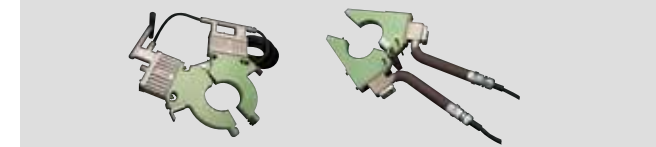


HEATER STAND/SLING
 Holds heater for easier carrying and protection. Helps maintain constant temperature.

MACHINE	PART NUMBER
Mini-Mc, 1LC	CTS08301
2LC, 2CU 2	218301
Pit Bull 14 2	433104
Pit Bull 26, Acrobat 180	712001
DynaMc, Pit Bull, Rolling, TracStar 28 & 250	821802
2x8, 3x8, 4x8 Split Heaters	1234202
DynaMc, Pit Bull, Rolling, TracStar 412 & 618	
6x10 Split Heater	
8x14 Split Heater	1835102
TracStar 500	T5008313
TracStar 630, MegaMc 824 2	T2409101
TracStar 900, MegaMc 1236 2	T9027301
TracStar 1200, MegaMc 1648 2	T4829801

SPLIT HEATER
 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.



The first character of the heater name (i.e. 2x8) 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 NAME	MACHINE RANGE	HEATER ID/OD	INPUT	OUTPUT	PART NUMBER
1x4, 2x4	14	3.19"/5.38"	120V	800 Watt	425601
2x5, 2x6	28	3.87"/8.62"	120V	1,574 Watt	829801
2x6, 3x6, 2x7, 3x7, 2x8, 3x8	28	5.00"/10.25"	120V	1,754 Watt	829501
2x8, 3x8, 4x8	28 412 4	6.00"/10.25"	120V	1,754 Watt	829901
4x10, 5x10, 6x10	412 618 4	7.75"/12.50"	240V	2,200 Watt	1238801
6x12, 7x12, 6x14, 7x14, 8x12, 8x14	618	9.94"/14.75"	240V	2,800 Watt	1239201

4 Guide-rod bracket kits required for adaptation to this size machine.

GUIDE ROD BRACKET ADAPTER KIT

DESCRIPTION	PART NUMBER
4x8 Split Heater to 412 fusion machine	A1239301
6x10 Split Heater to 618 fusion machine	A1839301



MANUAL MACHINE STAND

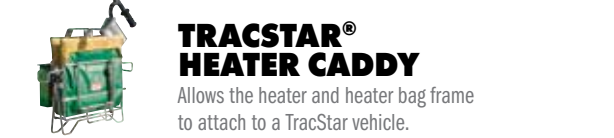
The Manual Fusion Machine Stand makes working with the 14, 2LC and 26 much easier. This stand expands to a comfortable operator level. The height corresponds to the McElroy pipe stands, PolyPorter® and PolyHorse® for easy pipe loading into the machine. When you are finished, it folds for easy storage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

DESCRIPTION	PART NUMBER
Manual Machine Stand	439001

REPLACEMENT PARTS & ACCESSORIES



TRACSTAR® HEATER CADDY
 Allows the heater and heater bag frame to attach to a TracStar vehicle.

MACHINE	PART NUMBER
28, 250, 412, 618	AT1818602
28, 250 (built between 9/2010 - 10/2016)	AT808902
28, 250 (built before 9/2010)	AT808901
412, 618 (built before 9/2010)	AT1818601



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

MACHINE	PART NUMBER
2LC, 2CU	203004
Pit Bull® 14, Sidewinder®	203005
Rolling, Pit Bull, DynaMc®, TracStar 28 & 250	203006
Rolling, Pit Bull, DynaMc, TracStar 412	203007
Rolling, Pit Bull, DynaMc, TracStar 618	203009



DIGITAL PYROMETER
 Accurately check surface temperatures of heater.

TEMPERATURE RANGE	PART NUMBER
-100+600° Fahrenheit	A218804

TRACSTAR CARRIAGE CONVERSION KIT

For attaching a TracStar Series 1 carriage to a Series 2 vehicle.

MACHINE	PART NUMBER
TracStar 630, 900 and MegaMc® 824, 1236	AT2421801



ELECTRIC FACER
 Used to face pipe ends to be fused.

MACHINE	VOLTAGE REQUIREMENTS	PLUG TYPE 1	PART NUMBER
Mini-Mc®	N/A	N/A	CTS15014 (ratchet)
			CTS01701 (knurled)
1LC			CTS17601
2LC, 2CU			216101
Pit Bull 14	100-120V, 50/60Hz, 1Ph	A	433701
	200-240V, 50/60Hz, 1Ph	C	433702
Pit Bull 26	100-120V, 50/60Hz, 1Ph	M	433704
		200-240V, 50/60Hz, 1Ph	A
Acrobat™ 180	220-240V, 50/60Hz, 1Ph	M	711601
		A	709601
DynaMc 28 HP & EP	100-120V, 50/60Hz, 1Ph	A	899301
		M	899401
DynaMc 250 HP & EP	220-240V, 50/60Hz, 1Ph	A	900801
		M	900901
DynaMc 412	100-120V, 50/60Hz, 1Ph	A	1275101
		M	1275201



FACER STAND
 Provides a convenient place to protect and store your facer out of the dirt and mud.

MACHINE	PART NUMBER
2LC, 2CU 6	218301
Pit Bull 14 6	433104
Pit Bull 26, Acrobat 180	711801
DynaMc, Pit Bull, Rolling, TracStar 28 & 250	T801101
DynaMc, Pit Bull, Rolling, TracStar 412	T1201101
Pit Bull, Rolling, TracStar 618	T1801101
TracStar 500	T5004701
TracStar 630, MegaMc® 824 6	T2409101
TracStar 900, MegaMc 1236 6	T9027301
TracStar 1200, MegaMc 1648 6	T4829801

- 6 See **Reference** section for plug types
- 6 Facer stands also hold heater

SIDEWALL REPLACEMENT PARTS & ACCESSORIES



DATALOGGER® ADAPTER KIT FOR SIDEWINDER®

DataLogger adapter kit for Sidewinder machines made before 1994.

DESCRIPTION	PART NUMBER
DataLogger adapter kit	ADL6603



LINE PIPE BOLSTER ⁴

For chain-clamp Sidewinder, 2CU and 28/250 machines. Supports and rerounds main sizes from 1 1/4" IPS to 8" IPS.

MAIN SIZE	PART NUMBER
1 1/4" IPS	413304
1 1/2" IPS	413305
2" IPS	413301
3" IPS	413302
4" IPS	413303
4" DIPS	413315
6" IPS	413306
6" DIPS	413316
8" IPS	827801



SIDEWALL INSERT

For Sidewinder, 2CU and 28/250 machines. Helps re-round 18" OD mains and smaller.

MAIN SIZE	PART NUMBER
1 1/4" IPS	410211
1 1/2" IPS	410212
2" IPS	410213
3" IPS	410305
4" IPS	410405
4" DIPS	410411
6" IPS	821403
6" DIPS	821405
8" IPS	835812
10" IPS	835813
12" IPS	835814
14" OD	835815
16" OD	835816
18" OD	835817

⁴ Performance Pipe recommends 411002 for their 2" IPS rectangular base branch saddles



HEATER ADAPTERS FOR 2CU, 28/250 & SIDEWINDER BRANCH SADDLES

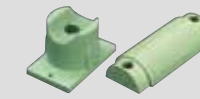
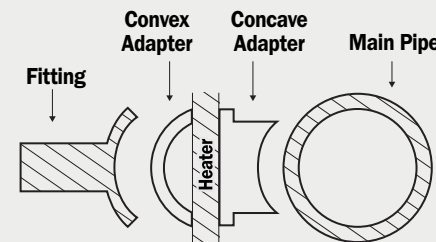
Adapters with anti-stick coating required for sidewall fusion.

FITTING BASE	FITTING BASE DIMENSIONS		MAIN SIZE	CONCAVE ADAPTER	CONVEX ADAPTER	MULTI-MC® HEATER REQUIRED					
	A	B									
Burr Outlet Service Saddle	Round	1.7"	N/A	1.25" IPS	S210166212	S200166300	2"				
				1.5" IPS	S210190212	S200190300					
				2" IPS	S210237212	S200237300					
				3" IPS	S210350212	S200350300					
				4" IPS	S210450212	S200450300					
				4" DIPS	S210480212	S200480300					
				6" DIPS	S210690212	S200690300					
				8" DIPS	S210905212	S200905300					
				10" DIPS	S211110212	S201110300					
				Rectangle	1.9"	2.5"		1.25" IPS	S230166287	S200166300	2"
1.5" IPS	S230190287	S200190300									
2" IPS	S230237287	S200237300									
3" IPS	S230350287	S200350300									
4" IPS	S230450287	S200450300									
2" IPS Outlet Branch	Rectangle	4.34"	4.20"				2" IPS	S430237462	S420237500	4"	
							3" IPS	S430350462S	S420350500		
							4" IPS	S430450462S	S420450500		
							4" DIPS	S430480462	S420480500		
							6" IPS	S430662462	S420662500		
				6" DIPS	S430690462	S420690500					
				8" IPS	S430862462	S420862500					
				8" DIPS	S430905462	S420905500					
				10" IPS	S431075462	S421075500					
				10" DIPS	S431110462	S421110500					
				12" IPS	S431275462	S421275500					
				12" DIPS	S431320462	S421320500					

FIND THE CORRECT HEATER ADAPTER

Sidewall fusions require two heater adapters; one for each side of the heater. Reference the charts above to find the correct heater based on your fitting base type and dimensions. A convex adapter is used on the fitting side while a concave adapter is used for the main pipe side.

Contact your McElroy representative for more sizes.



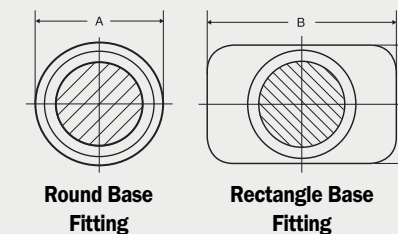
HEATER ADAPTERS FOR 2CU, 28/250 & SIDEWINDER BRANCH SADDLES

Adapters with anti-stick coating required for sidewall fusion.

FITTING BASE	FITTING BASE DIMENSIONS		MAIN SIZE	CONCAVE ADAPTER	CONVEX ADAPTER	MULTI-MC® HEATER REQUIRED					
	A	B									
2" IPS Outlet Branch	Round	2.63"	N/A	2" IPS	S210237288	S200237300	2"				
				3" IPS	S210350288	S200350300					
				4" IPS	S210450288	S200450300					
				4" DIPS	S210480288	S200480300					
				6" IPS	S210662288	S200662300					
				6" DIPS	S210690288	S200690300					
				8" IPS	S210862288	S200862300					
				8" DIPS	S210905288	S200905300					
				10" IPS	S211075288	S201075300					
				10" DIPS	S211110288	S201110300					
				12" IPS	S211275288	S201275300					
				12" DIPS	S211320288	S201320300					
3" IPS Outlet Branch	Round	3.88"	N/A	4" IPS	S450450426	S420450500	4"				
				4" DIPS	S450480426	S420480500					
				6" IPS	S450662426	S420662500					
				6" DIPS	S450690426	S420690500					
				8" IPS	S450862426	S420862500					
				8" DIPS	S450905426	S420905500					
				10" IPS	S451075426	S421075500					
				10" DIPS	S451110426	S421110500					
				12" IPS	S451275426	S421275500					
				12" DIPS	S451320426	S421320500					
				Round	4.5"	N/A		4" IPS	S450450550	S440450550	4"
								6" IPS	S450662550	S440662550	
8" IPS	S450862550	S440862550									
10" IPS	S451075550	S441075550									
12" IPS	S451275550	S441275550									

MEASURE THE FITTING DIMENSIONS

Common sidewall fittings are available with either round or square bases. Correctly measure your fitting base and reference the charts above to find the right heater adapters for your job.



SIDEWALL REPLACEMENT PARTS & ACCESSORIES

FITTING BASE	FITTING BASE DIMENSIONS		MAIN SIZE	CONCAVE ADAPTER	CONVEX ADAPTER	MULTI-MC® HEATER REQUIRED						
	A	B										
3" IPS Outlet Branch	Round	3.88"	N/A	4" IPS	S450450426	S420450500	4"					
				4" DIPS	S450480426	S420480500						
				6" IPS	S450662426	S420662500						
				6" DIPS	S450690426	S420690500						
				8" IPS	S450862426	S420862500						
				8" DIPS	S450905426	S420905500						
				10" IPS	S451075426	S421075500						
				10" DIPS	S451110426	S421110500						
				12" IPS	S451275426	S421275500						
				12" DIPS	S451320426	S421320500						
				4" IPS Outlet Branch Saddle	Round	4.5"		N/A	4" IPS	S450450550	S440450550	4"
									6" IPS	S450662550	S440662550	
8" IPS	S450862550	S440862550										
10" IPS	S451075550	S441075550										
12" IPS	S451275550	S441275550										

INSERTS - BUTT FUSION

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. Other sizes are available upon request. Contact your McElroy representative.

ROLLING, PIT BULL®, DYNAMC® & TRACSTAR® 412

BUTT FUSION INSERTS, Set = 8 inserts

INSERTS	PIPE OD	2-JAW PART NUMBER ③	4-JAW PART NUMBER
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All inserts below fit in machine jaws: 12" DIPS (13.20"/335mm)

12" IPS/DIPS Master	12.75" (324mm)	1203103 ②	1203102 ②
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All inserts below require 12" IPS/DIPS Master inserts

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
180mm / 7 1/8" OD	7.13" (180mm)	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 and 12" IPS/DIPS Master inserts

5" IPS	5.56" (141mm)	809435	809409
140mm	5.51" (140mm)	809439	809428
5 3/8" OD	5.38" (137mm)	809437	809411
5 1/4" 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

② Included in machine package

③ Applicable to DynaMc machines only

ROLLING, PIT BULL & TRACSTAR 618

BUTT FUSION INSERTS, Set = 8 inserts

INSERTS	PIPE OD	CAST PART NUMBER	FABRICATED PART NUMBER
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All inserts below fit in machine jaws: 18" OD (457mm)

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

All inserts below require 12" IPS Master inserts

315mm	12.40" (315mm)	1211202	N/A
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	
180mm / 7 1/8" OD	7.13" (180mm)	1207008	
6" DIPS	6.90" (175mm)	1207020	
6" IPS Master	6.63" (168mm)	1207007	
160mm	6.30" (160mm)	1207011	

CAST VS. FABRICATED

Fabricated inserts are constructed out of precision laser cut carbon steel and rolled components to ensure proper alignment in the jaws. They are also normally lighter weight than cast 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. Other sizes are available upon request. Contact your McElroy representative.

TRACSTAR® 500

BUTT FUSION INSERTS, Set = 8 inserts

INSERTS	PIPE OD	CAST PART NUMBER	FABRICATED PART NUMBER
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All inserts below fit in machine jaws: 20" OD (508mm)

500mm	19.69 (500mm)	T5029803	N/A
18" DIPS	19.50 (495mm)	T5029706	
18"/20" OD Master	18.00 (457mm)	T5029703	

All inserts below fit in 500mm (19.69" OD) jaws

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

All inserts below require 18" OD/500mm Master inserts

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

All inserts below require 12" IPS & 18" OD/500mm Master inserts

315mm	12.40" (315mm)	1211202	N/A
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	
180mm / 7 1/8" OD	7.13" (180mm)	1207008	
6" DIPS	6.90" (175mm)	1207020	
6" IPS Master	6.63" (168mm)	1207007	
160mm	6.30" (160mm)	1207011	

MEGAMC® 824 & TRACSTAR 630

BUTT FUSION INSERTS, Set = 8 inserts

INSERTS	PIPE OD	CAST PART NUMBER	FABRICATED PART NUMBER
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All inserts below fit in machine jaws: 24.80" (630mm)

24" OD	24.00 (610mm)	2411604 ②	N/A
22" OD	22.00 (560mm)	2411919	
20" DIPS	21.60 (549mm)	2411922	
20" OD	20.00 (508mm)	2412010	
500mm	19.69 (500mm)	2412011	
18" DIPS	19.50 (495mm)	2412023	
18" OD Master	18.00 (457mm)	2411708	

All inserts below require 18" OD Master inserts

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

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

315mm	12.40" (315mm)	1211202	N/A
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	

② Included in machine package

MITERED INSERTS

See Replacement Parts & Accessories: page 19 for mitered inserts.

INSERTS - MITERED

Mitered inserts are used to fabricate segmented ells. Our standard miter is 11 ¼°. Other mitered angles are available upon request.

ROLLING, PIT BULL®, DYNAMC® & TRACSTAR® 28

11 ¼° MITERED INSERTS, Set = 4 inserts & 1 template

INSERTS	PIPE OD	PART NUMBER
<i>All inserts below fit in machine jaws: 8" DIPS (9.05"/230mm)</i>		
8" IPS/DIPS Master	8.63" (219mm)	807203
<i>All inserts below require 8" IPS Master insert</i>		
180mm / 7 ⅜" OD	7.13" (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

Included in machine package



ROLLING, PIT BULL, DYNAMC® & TRACSTAR 250

11 ¼° MITERED INSERTS, Set = 4 inserts & 1 template

INSERTS	PIPE OD	PART NUMBER
<i>All inserts below fit in machine jaws: 250mm (9.84" OD)</i>		
225mm/250mm	8.86" (225mm)	T2503510
200mm/250mm	7.87" (200mm)	T2503513
8" IPS/250mm Master	8.63" (219mm)	T2503504
<i>All inserts below require 8"/250mm Master insert</i>		
180mm / 7 ⅜" OD	7.13" (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

ROLLING, PIT BULL, DYNAMC® & TRACSTAR 412

11 ¼° MITERED INSERTS, Set = 4 inserts & 1 template

INSERTS	PIPE OD	PART NUMBER
<i>All inserts below fit in machine jaws: 12" DIPS (13.20"/335mm)</i>		
12" IPS/DIPS Master	12.75" (324mm)	1203102
<i>All inserts below require 8"/250mm Master insert</i>		
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 ⅜" OD	7.09" (180mm)	1214290
6" DIPS	6.90" (175mm)	1214275
6" IPS	6.63" (168mm)	1214228
160mm	6.30" (160mm)	1214239
5" IPS	5.56" (141mm)	1214242
125mm	4.92" (125mm)	12142108
4" DIPS	4.80" (122mm)	1214287
4" IPS	4.50" (114mm)	1214226
110mm	4.33" (110mm)	1214255

ROLLING, PIT BULL® & TRACSTAR® 618

11 ¼° MITERED INSERTS, Set = 4 inserts & 1 template

INSERTS	PIPE OD	PART NUMBER
<i>All inserts below fit in machine jaws: 18" OD (457mm)</i>		
16" OD	16.00" (406mm)	2420619
400mm	15.75" (400mm)	2420618
14" DIPS	15.30" (389mm)	24206122
370mm	14.57" (370mm)	24206125
14" OD / 355mm	14.00" (355mm)	2420617
12" DIPS	13.20" (335mm)	24206110
12" IPS	12.75" (324mm)	2420615
12" IPS Master	12.75" (324mm)	2411810
315mm	12.40" (315mm)	2420614
10" DIPS	11.10" (282mm)	24206116
<i>All inserts below require 12" IPS Master insert</i>		
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 ⅜" OD	7.09" (180mm)	1214290
6" DIPS	6.90" (175mm)	1214275
6" IPS	6.63" (168mm)	1214228

TRACSTAR 500

11 ¼° MITERED INSERTS, Set = 4 inserts & 1 template

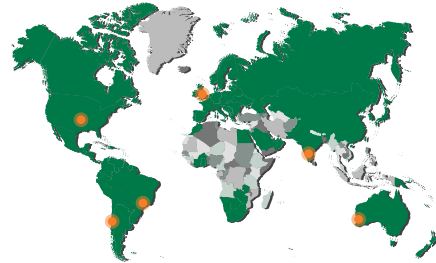
INSERTS	PIPE OD	PART NUMBER
<i>All inserts below fit in machine jaws: 20" OD (508mm)</i>		
18"/20" OD Master	18.00" (457mm)	T5029703
18" OD	18.00" (457mm)	T5030803
450mm	17.72" (450mm)	T5031103
<i>All inserts below fit in 500mm jaws</i>		
18" OD	18.00" (457mm)	T5004403
18" OD / 500mm Master	18.00" (457mm)	T5004206
<i>All inserts below require 18"/20" OD Master insert</i>		
16" OD	16.00" (406mm)	2420619
400mm	15.75" (400mm)	2420618
14" DIPS	15.30" (389mm)	24206122
370mm	14.57" (370mm)	24206125
14" OD / 355mm	14.00" (355mm)	2420617
12" DIPS	13.20" (335mm)	24206110
12" IPS	12.75" (324mm)	2420615
12" IPS Master	12.75" (324mm)	2411810
315mm	12.40" (315mm)	2420614
10" DIPS	11.10" (282mm)	24206116
<i>All inserts below require 12" IPS & 18"/20" OD Master inserts</i>		
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 ⅜" OD	7.09" (180mm)	1214290
6" DIPS	6.90" (175mm)	1214275
6" IPS	6.63" (168mm)	1214228

MEGAMC® 824 & TRACSTAR 630

11 ¼° MITERED INSERTS, Set = 4 inserts & 1 template

INSERTS	PIPE OD	PART NUMBER
<i>All inserts below fit in machine jaws: 24.80" (630mm)</i>		
22" OD/560mm	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" Master	18.00" (457mm)	2411708
18" OD	18.00" (457mm)	2421215
450mm	17.72" (450mm)	2421214
16" DIPS	17.40" (442mm)	2421245
420mm	16.53" (420mm)	2421266
<i>All inserts below require 18" OD Master insert</i>		
16" OD	16.00" (406mm)	2420619
400mm	15.75" (400mm)	2420618
14" DIPS	15.30" (389mm)	24206122
370mm	14.57" (370mm)	24206125
14" OD / 355mm	14.00" (355mm)	2420617
12" DIPS	13.20" (335mm)	24206110
12" IPS	12.75" (324mm)	2420615
12" IPS Master	12.75" (324mm)	2411810
315mm	12.40" (315mm)	2420614
10" DIPS	11.10" (282mm)	24206116
<i>All inserts below require 12" IPS & 18" OD Master inserts</i>		
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 ⅜" OD	7.09" (180mm)	1214290
6" DIPS	6.90" (175mm)	1214275
6" IPS	6.63" (168mm)	1214228

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FIND A DISTRIBUTOR NEAR YOU!
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

See **Replacement Parts & Accessories: page 13** for butt fusion inserts.

INSERTS - MITERED

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

FACER BLADES FOR OLDER EQUIPMENT

MEGAMC® 1236 & TRACSTAR® 900

11 1/4° MITERED INSERTS, Set = 4 inserts & 1 template

INSERTS	PIPE OD	SET
<i>All inserts below fit in machine jaws: 36" OD (914mm)</i>		
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
630mm	24.80" (630mm)	3606610
630mm <i>Master</i>	24.80" (630mm)	3606604
24" OD	24.00" (610mm)	3606613
24" DIPS	25.80" (655mm)	3606620
<i>All inserts below require 630mm Master insert</i>		
22" OD/560mm	22.00" (560mm)	2421229
20" DIPS	21.60" (549mm)	2421257
20" OD	20.00" (508mm)	2421217
500mm	19.68" (500mm)	2421014
18" DIPS	19.50" (495mm)	2421251
18" OD <i>Master</i>	18.00" (457mm)	2411708
18" OD	18.00" (457mm)	2421215
450mm	17.72" (450mm)	2421214
16" DIPS	17.40" (442mm)	2421245
420mm	16.53" (420mm)	2421266
<i>All inserts below require 630mm & 18" OD Master inserts</i>		
16" OD	16.00" (406mm)	2420619
400mm	15.75" (400mm)	2420618
14" DIPS	15.30" (389mm)	24206122
370mm	14.57" (370mm)	24206125
14" OD / 355mm	14.00" (355mm)	2420617
12" DIPS	13.20" (335mm)	24206110
12" IPS	12.75" (324mm)	2420615
315mm	12.40" (315mm)	2420614

MEGAMC 1648 & TRACSTAR 1200

11 1/4° MITERED INSERTS, Set = 4 inserts & 1 template

INSERTS	PIPE OD	SET
<i>All inserts below fit in machine jaws: 48" OD (1,219mm)</i>		
42" OD	42.00" (1,067mm)	4813115
36" OD	36.00" (914mm)	4813010
36" OD <i>Master</i>	36.00" (914mm)	4813006
<i>All inserts below require 36" OD Master insert</i>		
32" OD	32.00" (813mm)	3603526
800mm	31.50" (800mm)	3603523
30" OD	30.00" (762mm)	3603520
28" OD / 711mm	28.00" (711mm)	3603529
26" OD	26.00" (660mm)	3606623
24" DIPS	25.80" (655mm)	3606620
630mm	24.80" (630mm)	3606610
630mm <i>Master</i>	24.80" (630mm)	3606604
24" OD	24.00" (610mm)	3606613
<i>All inserts below require 36" OD & 630mm Master inserts</i>		
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

② Included in machine package

MEGAMC 2065 & 1600

11 1/4° MITERED INSERTS, Set = 4 inserts & 1 template

INSERTS	PIPE OD	SET
<i>All inserts below fit in machine jaws: 65.25" OD (1,657mm)</i>		
63.51" OD <i>Master</i>	63.51" (1,613mm)	6312101 ②
<i>All inserts below require 63.51" OD Master insert</i>		
48" IPS <i>Master</i>	48.00" (1,219mm)	6304506
<i>All inserts below require 63.51" & 48" IPS Master inserts</i>		
42" OD	42.00" (1,067mm)	4813115
36" OD	36.00" (914mm)	4813010
36" OD <i>Master</i>	36.00" (914mm)	4813006
900mm OD	35.43 (900mm)	4813016
<i>All inserts below require 63.51" OD, 48" IPS & 36" OD Master inserts</i>		
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
630mm	24.80" (630mm)	3606610
24" OD	24.00" (610mm)	3606613
24" DIPS	25.80" (655mm)	3606620

MACHINE	APPLICABLE MODEL NUMBER	MODEL MANUFACTURE DATE	BLADE SET PART NUMBER	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 ①		5" x 1 7/32"
Pit Bull® 28	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 ①	4 Blades	5" x 1 7/32"
412 (DIPS)	1245000	Before 10/03	3615714, 3615714C ①	6 Blades	5 3/8" x 1 7/32"
TracStar® 412	T1200100	Before 1/05	T1208610, T1208610C ①	6 Blades	6 1/8" x 31/32"
18	1800900	Before 5/90	1804802	6 Blades	6 3/4" x 15/32"
			3615710, 3615710C ①		9" x 1 7/32"
618	1855600	Before 10/03	3615703, 3615703C ①	6 Blades	5" x 1 7/32"
TracStar 618	T1800100	Before 1/05	T1812603, T1812603C ①	6 Blades	4 5/8" x 31/32"
TracStar 500	T5000101	Before 1/02	T5005002, T5005002C ①	6 Blades	9 7/8" x 31/32"
TracStar 500 Series II	T5000102,3,6,7		T5005006, T5005006C ①	6 Blades	10 1/4" x 31/32"
TracStar 500 Series II (mm)	T5000104,5,8,9		T5005006, T5005006C ①	6 Blades	10 1/4" x 31/32"
Pit Bull 500	AT5034000		T5005006, T5005006C ①	6 Blades	10 1/4" x 31/32"
24	2400100	Before 1/88	3603698	6 Blades	9 3/8" x 15/32"
		Before 10/03	3615710, 3615710C ①		9" x 1 7/32"
MegaMc® 824	2400700	After 10/03	3615712	6 Blades	11" x 1 7/32"
MegaMc 1236	3600100	Before 1/89	3603699	6 - 9.38" Blades & 6 - 5" Blades	5" x 15/32"
TracStar 900	T9000100		3615707, 3615707C ①	6 Blades	15" x 1 7/32"

① Part numbers ending in "C" = extended life blades

BUTT FUSION INSERTS

See **Replacement Parts & Accessories: page 13** for butt fusion inserts.



CUSTOMER/TECH SUPPORT

Whether you prefer email, discussion forums 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.



(918) 831-9236



businesssupport@mcelroy.com

DETERMINING FUSION PARAMETERS

To meet the required force needed to successfully fuse thermoplastic pipe, we must first calculate some basic fusion parameters.

STEP 1 CALCULATE WALL THICKNESS (t):

$$t = \frac{OD}{DR}$$

STEP 3 FIND THE TOTAL EFFECTIVE PISTON AREA (TEPA):

MACHINE	HIGH FORCE	MEDIUM FORCE	LOW FORCE
Acrobat™ 180	N/A	N/A	0.90
28, 250	4.71	3.24	1.66
412, 618	11.78	6.01	3.14
500	N/A	6.01	3.14
824/630, 1236/900	29.44	15.32	9.45
1648, 1600, 1200	31.42	14.14	N/A
2065	31.42	N/A	N/A

STEP 2 CALCULATE GAUGE PRESSURE:

$$\frac{(OD - t) \times t \times 3.14 \times IFP}{TEPA \text{ (chosen from table)}} + \text{Drag}$$

DEFINITIONS

OD: Outside Diameter (inches), **t:** Wall Thickness (inches), **π:** 3.14, **IFP:** Manufacturer's Recommended Interfacial Pressure (IFP), **TEPA:** Total Effective Piston Area, **Drag:** Pressure required to move pipe (PSI), **DR:** Dimensional Ratio

EXAMPLE

Using the following information, we can first determine the wall thickness of the pipe, then determine our gauge pressure. Pipe used in this example is 8" IPS, DR 11, with an actual OD of 8.63". Our pipe manufacturer's recommended interfacial pressure is 75 PSI. Our measured drag is 30 PSI using a Rolling 28 fusion machine.

STEP 1

$$t = \frac{8.27''}{11} = .78$$

STEP 2

$$\frac{(8.63 - .78) \times .78 \times 3.14 \times 75}{TEPA (4.71)} + 30 \text{ PSI} = 338 \text{ PSI}$$

THE McCALC® APP CALCULATES FUSION PRESSURES FOR YOU

DOWNLOAD TODAY TO SAVE TIME ON THE JOBSITE

The McCalc Fusion Pressure Calculator is designed to help you quickly find the correct fusion pressure for your job. To properly heat-fuse thermoplastic 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.

Visit www.mcelroy.com/mccalc, or search for it in your device's app store.

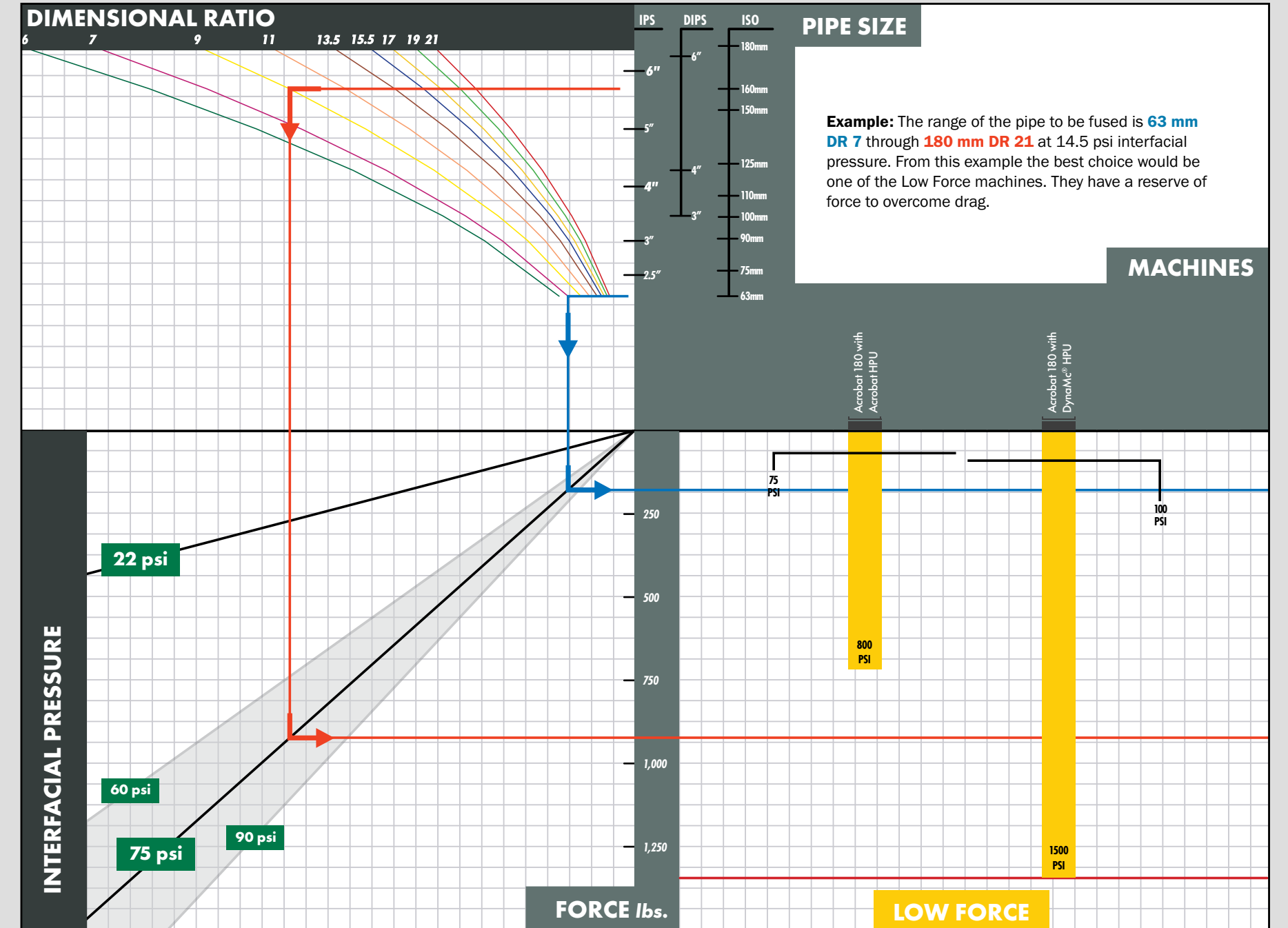


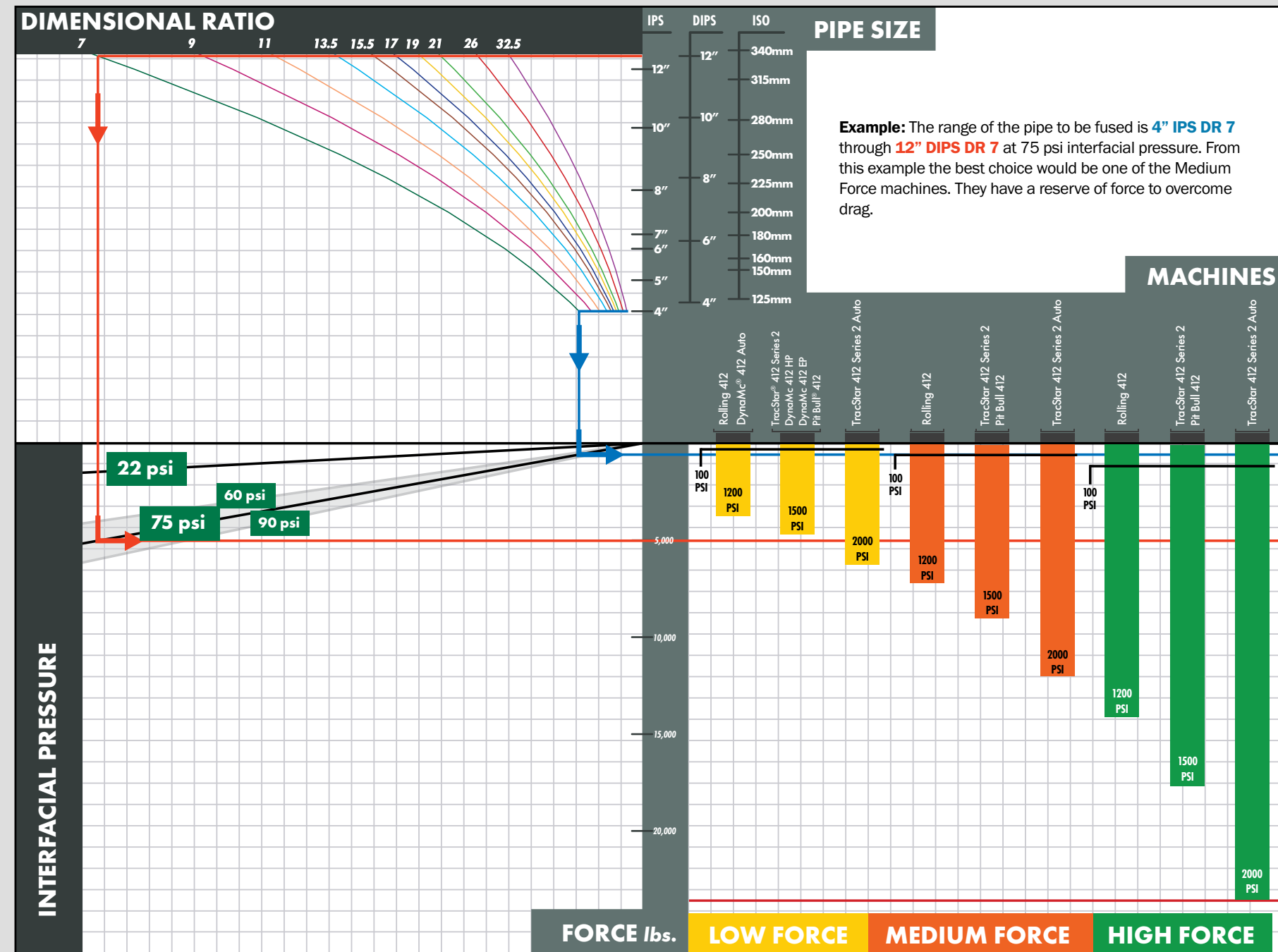
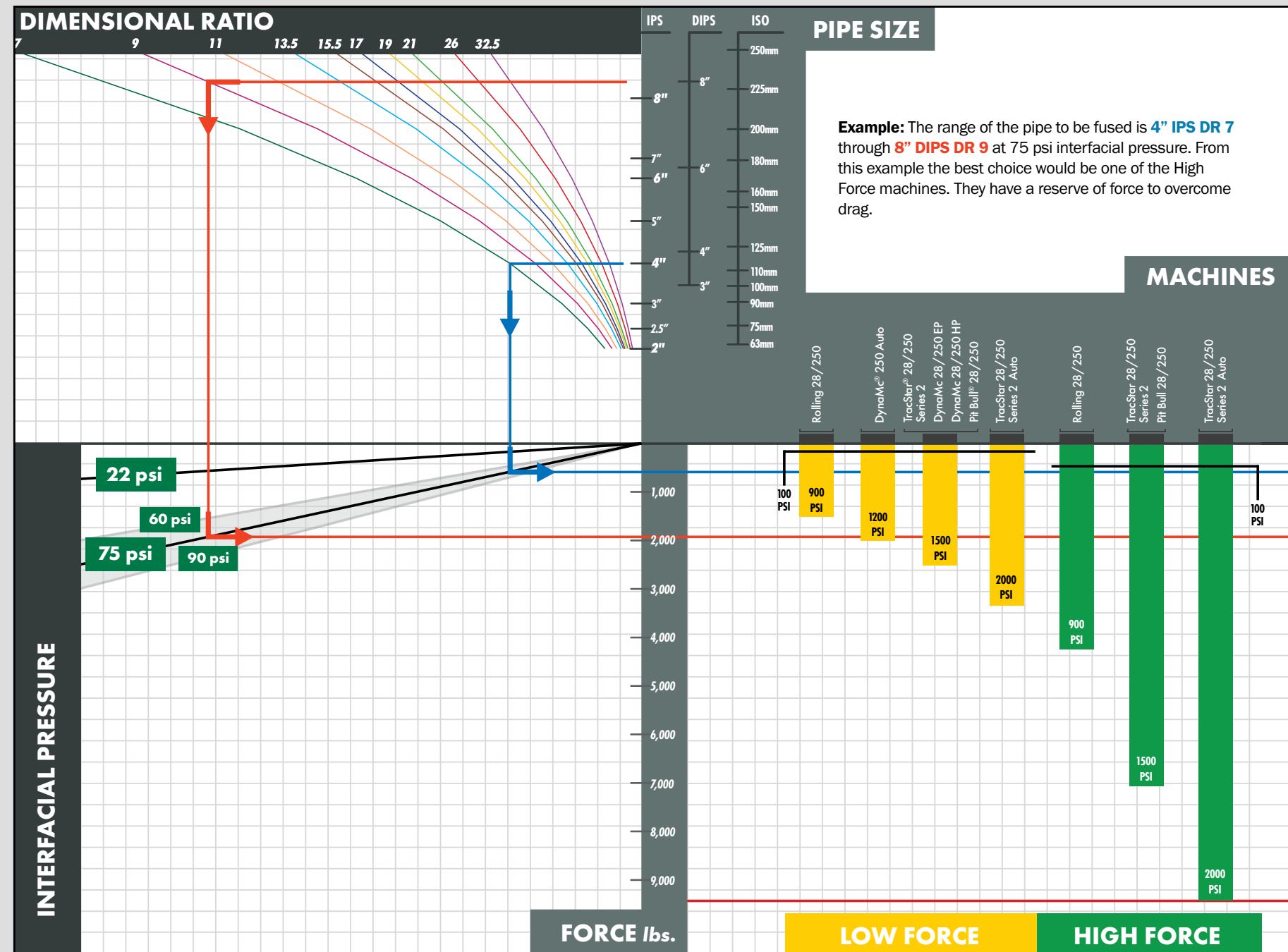
CHOOSING CORRECT CYLINDER FORCE

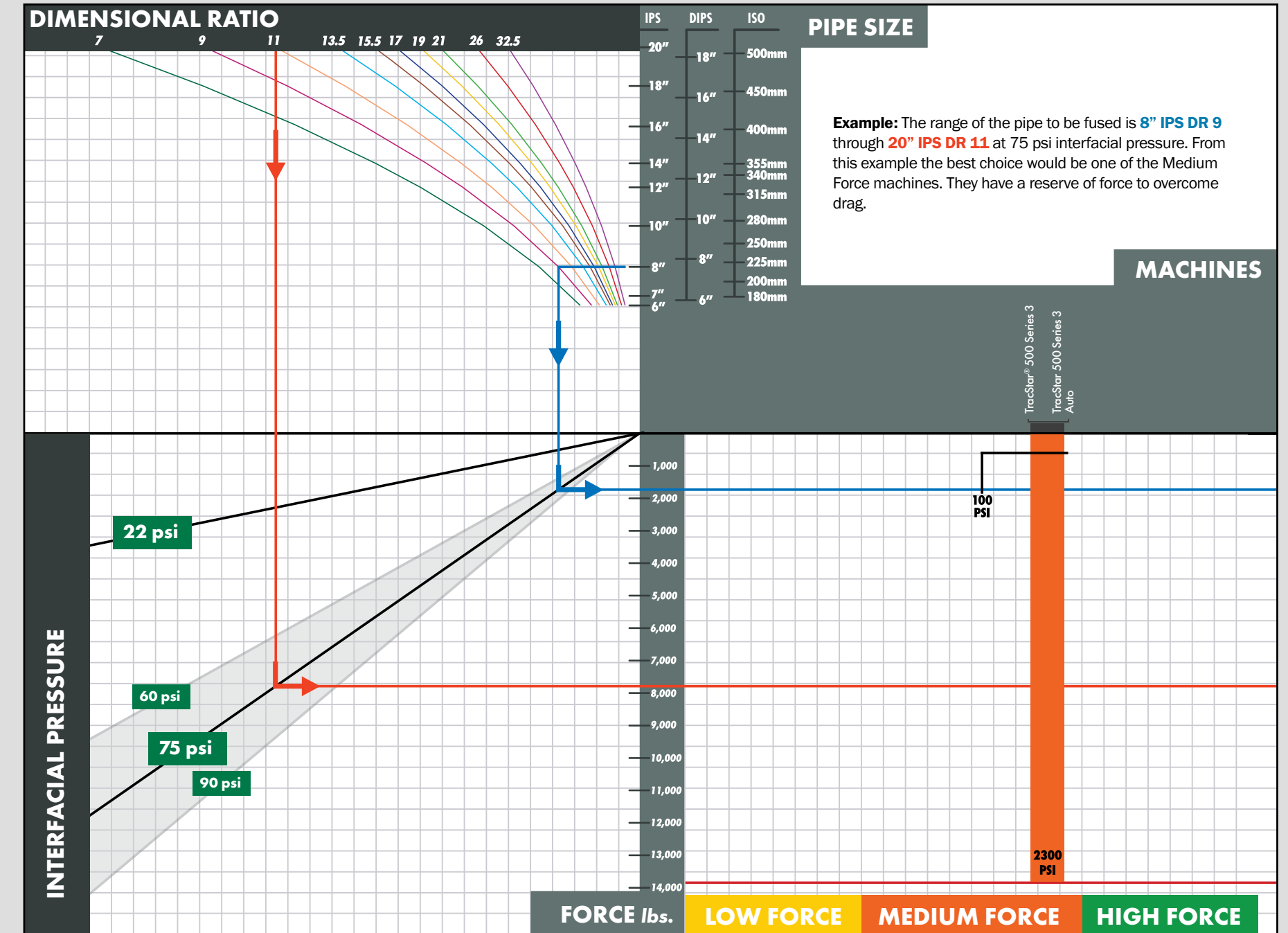
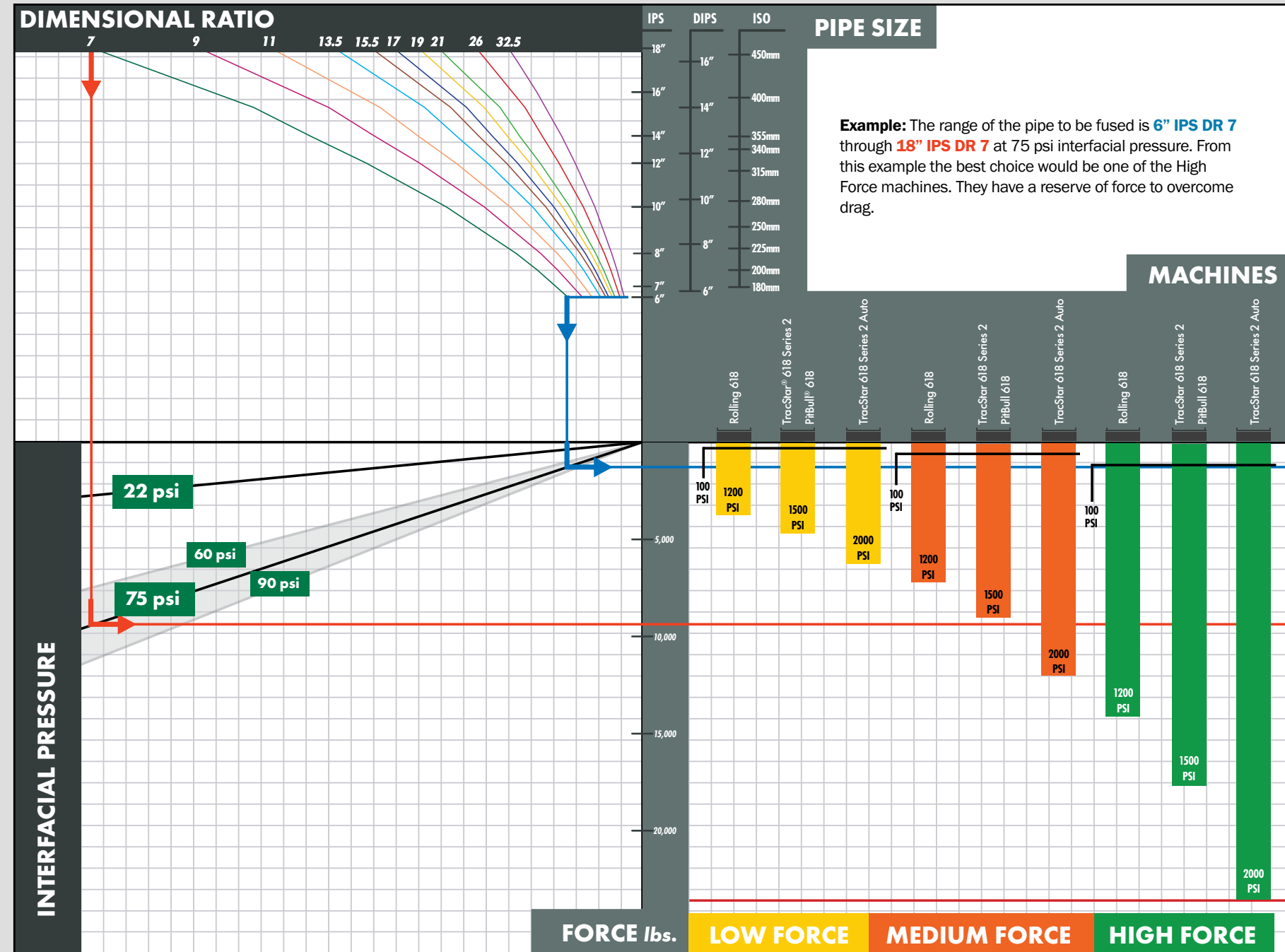
The charts on the following pages will aid in the selection of the correct fusion machine cylinder force option. First, select the range of pipe and DR to be fused in the machine (largest pipe – smallest DR and smallest pipe – highest DR). Second, select the type of pipe to be fused. The pipe type will 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.

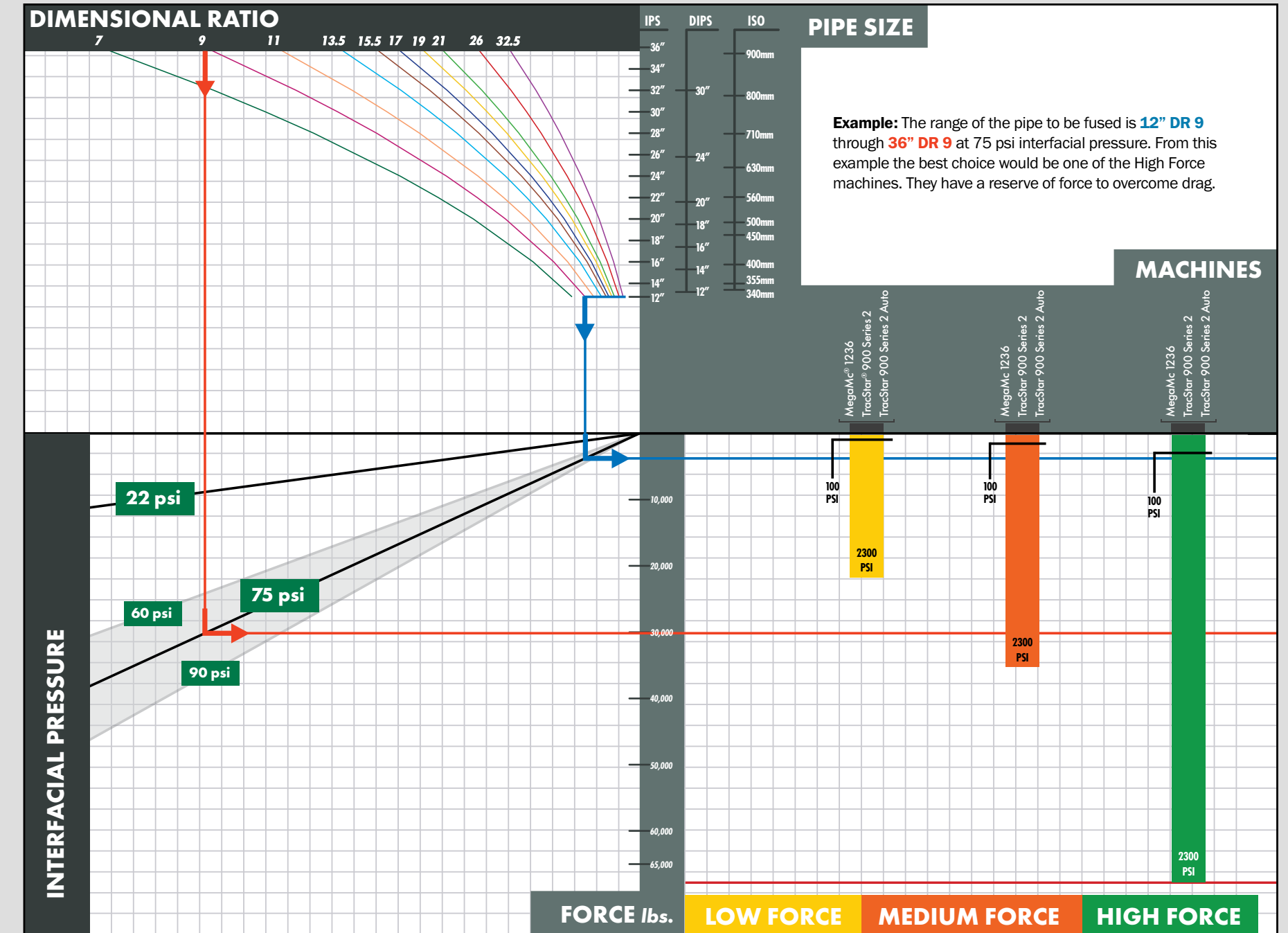
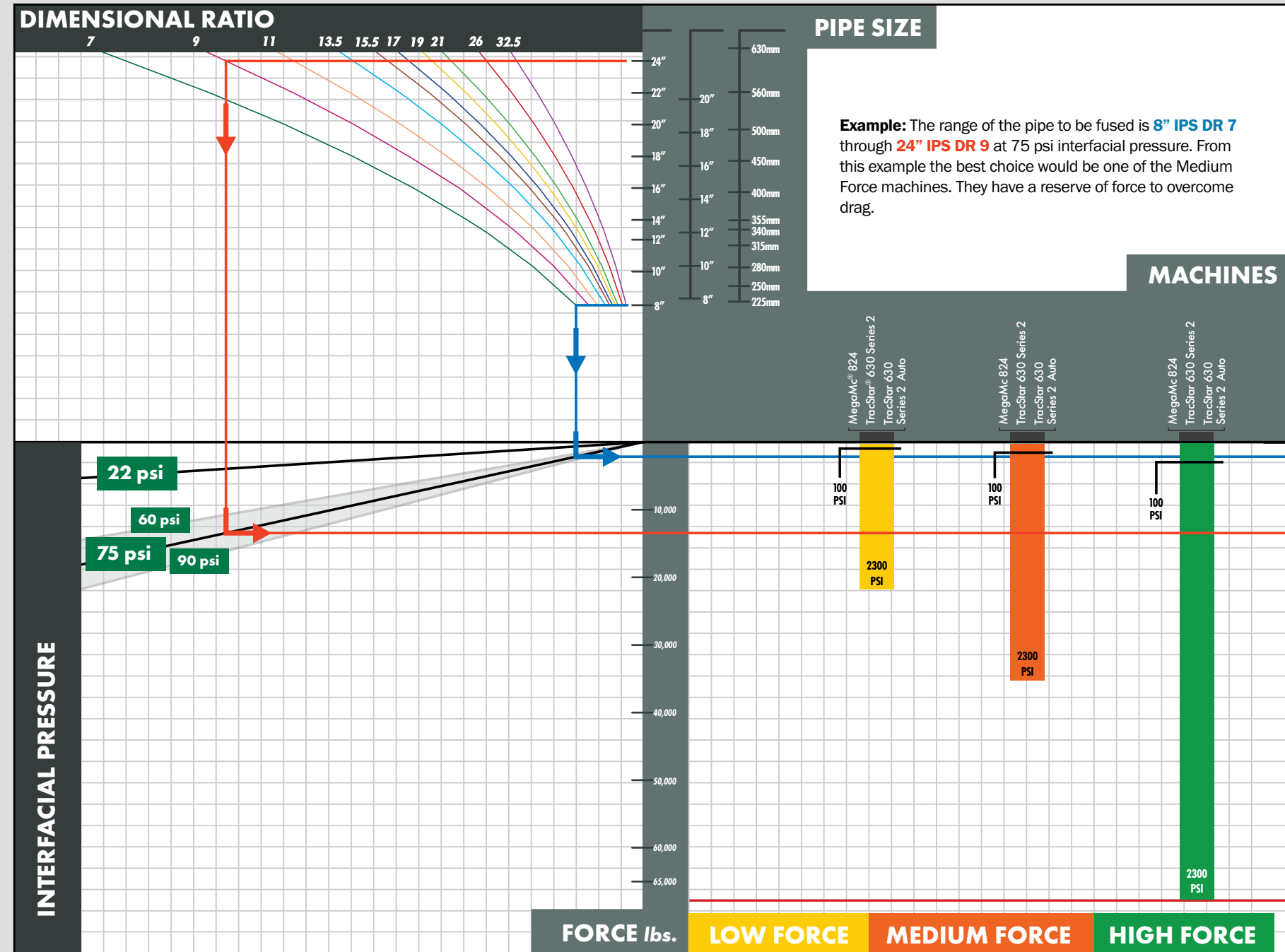
You can derive from the graph, that when using high interfacial pressures, the best choice is a High Force machine. When fusing at low interfacial pressures, such as 22 PSI, the best choice is a Low Force machine. It is important to note that if the pipe sizes chosen results in a low gauge pressure (less 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.

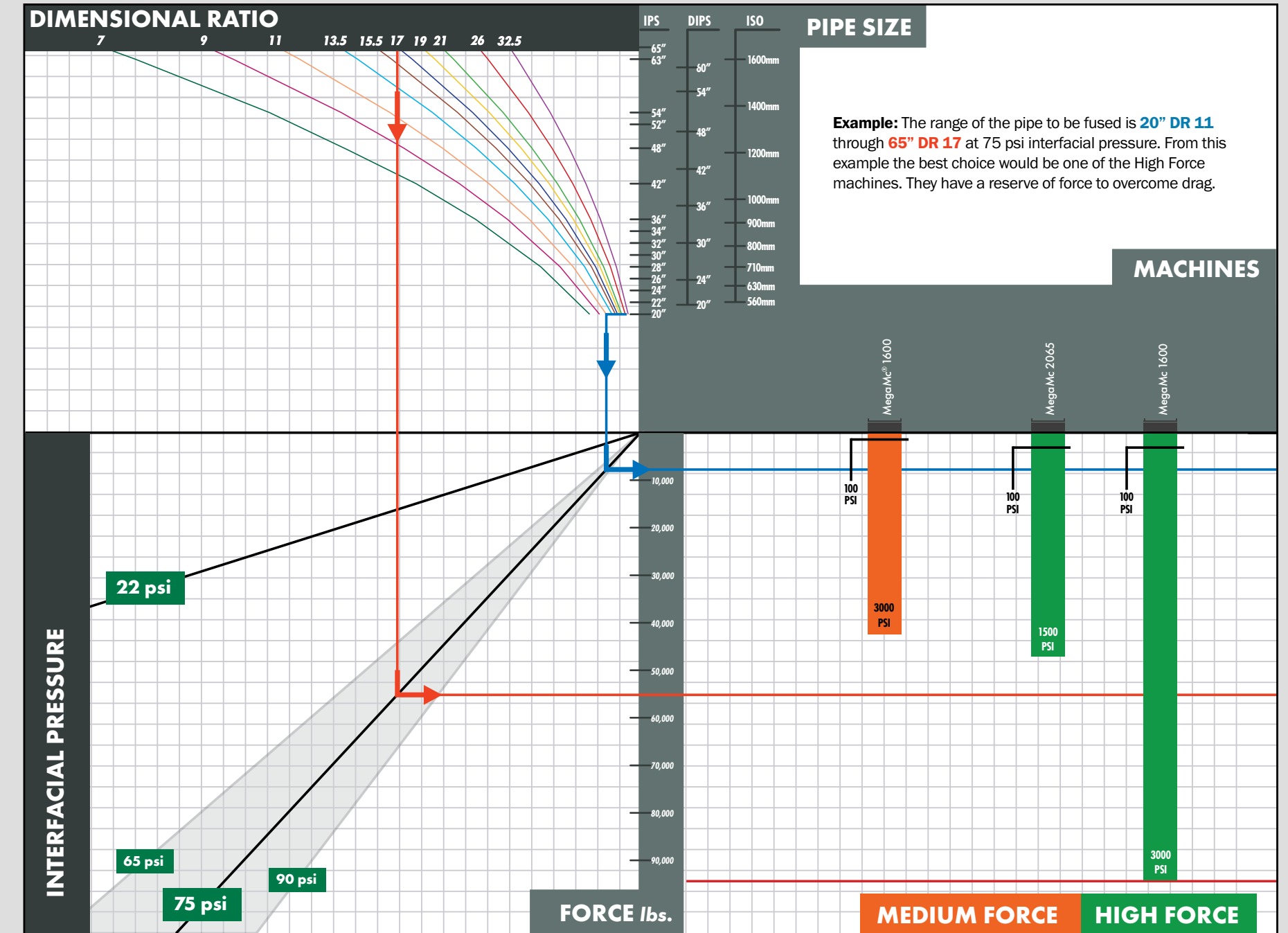
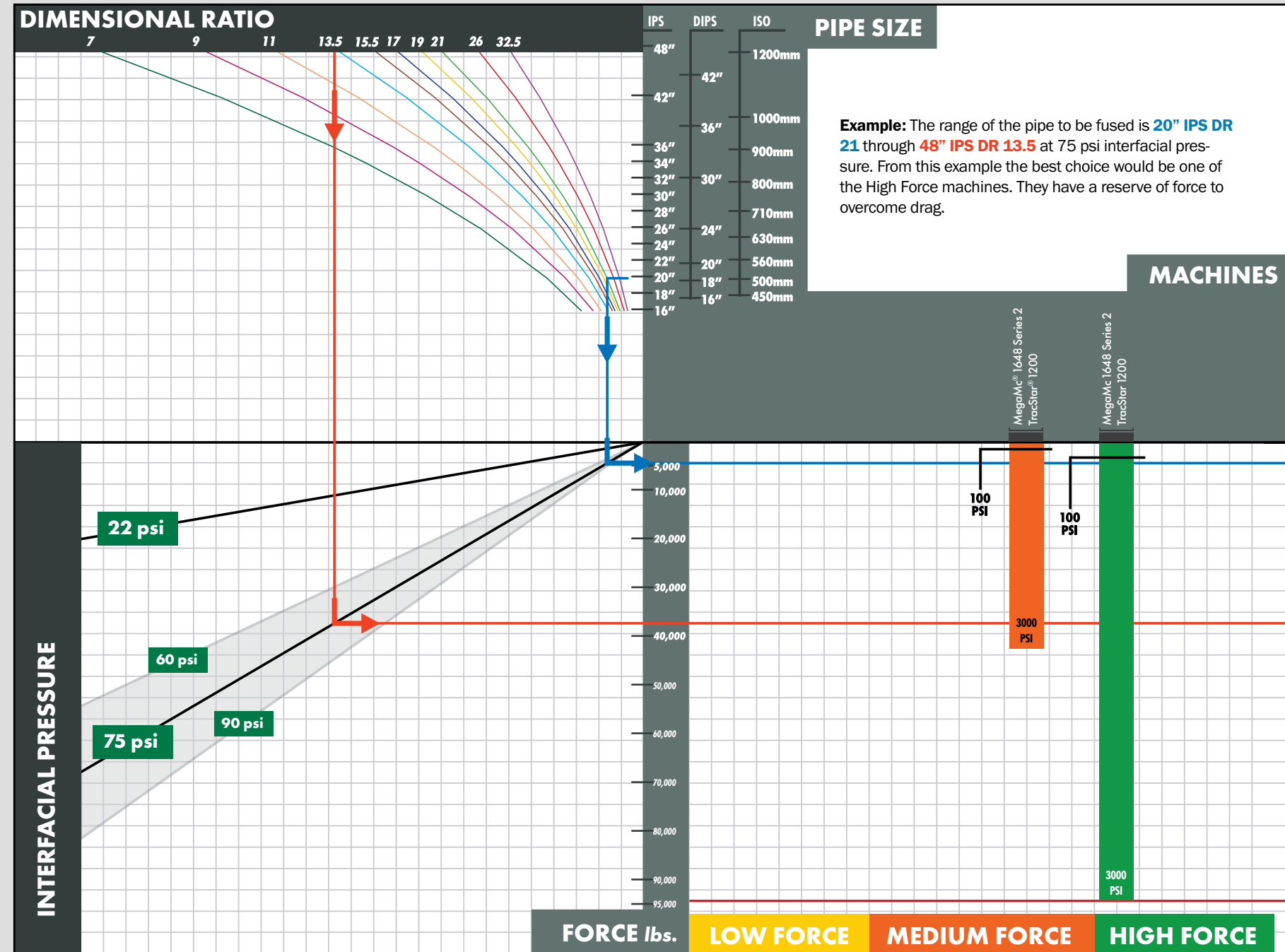
ACROBAT™ 180 CYLINDER FORCE











PLUG TYPES

PLUG TYPE	DESCRIPTION
<i>Plug Letter Designations</i>	
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

MILLIMETER TO INCH CONVERSION

mm	Inch	mm	Inch	mm	Inch	mm	Inch
1	0.04	26	1.02	51	2.00	76	2.99
2	0.08	27	1.06	52	2.04	77	3.03
3	0.12	28	1.10	53	2.09	78	3.07
4	0.16	29	1.14	54	2.12	79	3.11
5	0.20	30	1.18	55	2.16	80	3.15
6	0.24	31	1.22	56	2.20	81	3.19
7	0.28	32	1.26	57	2.24	82	3.23
8	0.31	33	1.30	58	2.28	83	3.27
9	0.35	34	1.34	59	2.32	84	3.31
10	0.39	35	1.38	60	2.36	85	3.35
11	0.43	36	1.42	61	2.40	86	3.39
12	0.47	37	1.46	62	2.44	87	3.42
13	0.51	38	1.50	63	2.48	88	3.46
14	0.55	39	1.53	64	2.52	89	3.50
15	0.59	40	1.57	65	2.56	90	3.54
16	0.63	41	1.61	66	2.60	91	3.58
17	0.67	42	1.65	67	2.64	92	3.62
18	0.71	43	1.69	68	2.68	93	3.66
19	0.75	44	1.73	69	2.72	94	3.70
20	0.79	45	1.77	70	2.76	95	3.74
21	0.83	46	1.81	71	2.80	96	3.78
22	0.87	47	1.85	72	2.83	97	3.82
23	0.91	48	1.89	73	2.87	98	3.86
24	0.94	49	1.93	74	2.91	99	3.90
25	0.98	50	1.97	75	2.95	100	3.94

CONVERSION FORMULAS

Inches	x	25.4	=	Millimeters	Liters	x	1.057	=	Quarts
Millimeters	x	0.03937	=	Inches	Gallons	x	3.785	=	Liters
Feet	x	304.8	=	Millimeters	Liters	x	0.2642	=	Gallons
Millimeters	x	0.00328	=	Feet	Pounds	x	0.4536	=	Kilograms
SQ. Inches	x	645.16	=	Millimeters ²	Kilograms	x	2.205	=	Pounds
SQ. mm	x	0.00155	=	Inches ²	Bar	x	14.503	=	psi
Ounces	x	0.02957	=	Liters	mPa	x	145.03	=	psi
Quarts	x	0.9463	=	Liters	Kg/cm2	x	14.223	=	psi

FRACTION TO DECIMAL CONVERSION

FRACTIONS	DEC.	mm	FRACTIONS	DEC.	mm
			33/64	.516	13.097
			17/32	.531	13.494
			35/64	.547	13.891
1/16			9/16		
			37/64	.578	14.684
			19/32	.594	15.081
			39/64	.609	15.478
1/8			5/8		
			41/64	.641	16.272
			21/32	.656	16.669
			43/64	.672	17.066
3/16			11/16		
			45/64	.703	17.859
			23/32	.719	18.256
			47/64	.734	18.653
1/4			3/4		
			49/64	.766	19.447
			25/32	.781	19.844
			51/64	.797	20.241
5/16			13/16		
			53/64	.828	21.034
			27/32	.844	21.431
			55/64	.859	21.828
3/8			7/8		
			57/64	.891	22.622
			29/32	.906	23.019
			59/64	.922	23.416
7/16			15/16		
			61/64	.953	24.209
			31/32	.969	24.606
			63/64	.984	25.003
1/2			1		
				1.000	25.400

PIPE SIZES

IPS

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	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	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	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"

METRIC ISO

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"
1,000mm	39.37"	123.68"
1,200mm	47.24"	148.42"
1,400mm	55.12"	173.16"
1,600mm	62.99"	197.90"

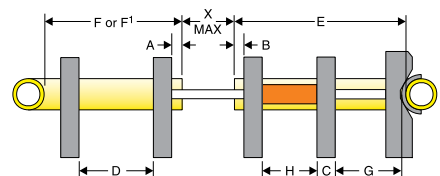
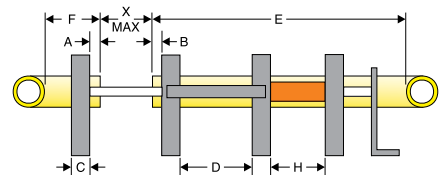
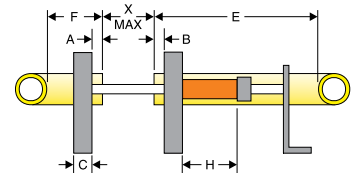
PIPE & FITTING INSTALLATION DIMENSIONS¹

NOTES

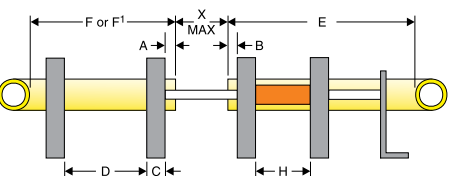
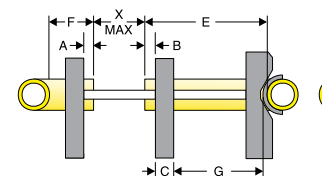
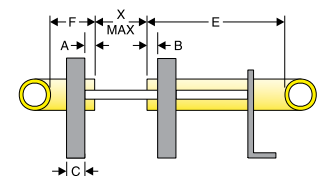
A and **B** dimensions are after face-off

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.

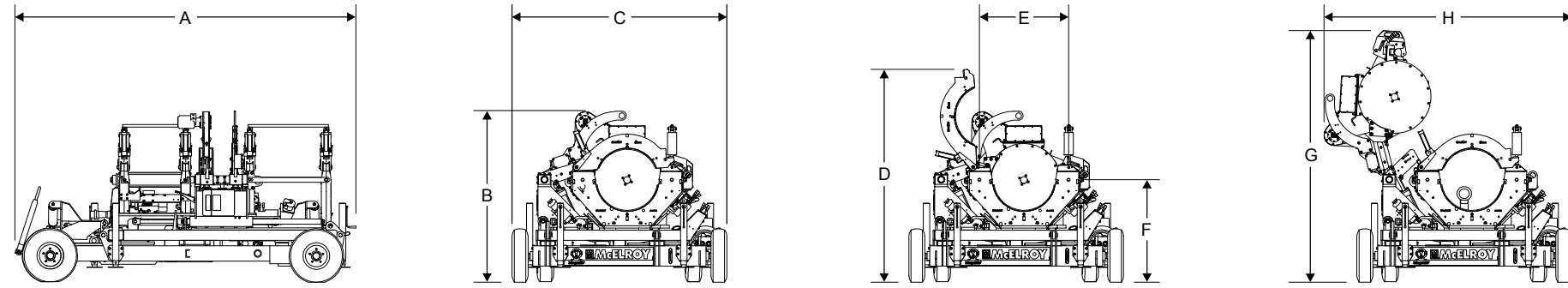


MACHINE	A	B	C	D	E	F	F1	G MAX.	G MIN.	H	X MAX.
2CU	0.37	0.33	1	--	9.5	2.5	--	7.17	1.17	--	5.55
2LC	0.37	0.33	1	--	10	2.5	--	--	--	--	3.3
Pit Bull® 14	0.50	0.50	1.75	--	11.63	5.25	--	--	--	--	4
Pit Bull 26	0.69	0.69	2	--	10.58	3.05	--	--	--	--	--
Acrobat™ 180	0.68	0.64	1.13	3.04	17.33	6.15	1.99	--	--	7.55	5.41
28 Rolling	0.50	0.50	2	17.5	28	23	3	11.25	2.5	9.5	8.5
Pit Bull, TracStar® 28	0.50	0.50	2	12	63	15	3	11.25	2.5	9.5	8.5
Rolling 250	0.76	0.76	2	17.5	28	23	3	11.25	2.5	9.5	8.5
Pit Bull, TracStar 250	0.76	0.76	2	12	63	15	3	11.25	2.5	9.5	8.5
Rolling 412	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
Rolling 618	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	15.38	5.37	--	--	8.65	9.88
Pit Bull 500	1	1	3.75	6	17.50	17	6	--	--	7	6.50
MegaMc® 824	1	1.37	3.75	26.25	52.06	35.01	7	--	--	17	18.50
TracStar 630 Series 2	1	1.37	3.75	26.25	52.06	35.01	7	--	--	17	18.50
MegaMc 1236	1	1.37	5	25	50.93	36.81	6.79	--	--	18	20
TracStar 900 Series 2	1	1.37	5	25	50.93	36.81	6.79	--	--	18	20
MegaMc 1648 Series 2	2.25	2.25	6	22.00	57.72	39.57	10.78	--	--	--	--
TracStar 1200	2.25	2.25	6	22.00	57.72	39.57	10.78	--	--	--	--
MegaMc 2065	2.10	2.10	12.50	--	62.75	31	--	--	--	--	16
MegaMc 1600	2.10	2.10	12.50	43.88	62.75	71.50	15	--	--	6.50	16
Talon™ 2000	3	3	12.37	18.12	66.63	20.62	--	--	--	29.37	20.50
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	4.72
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



¹ All dimensions are in inches

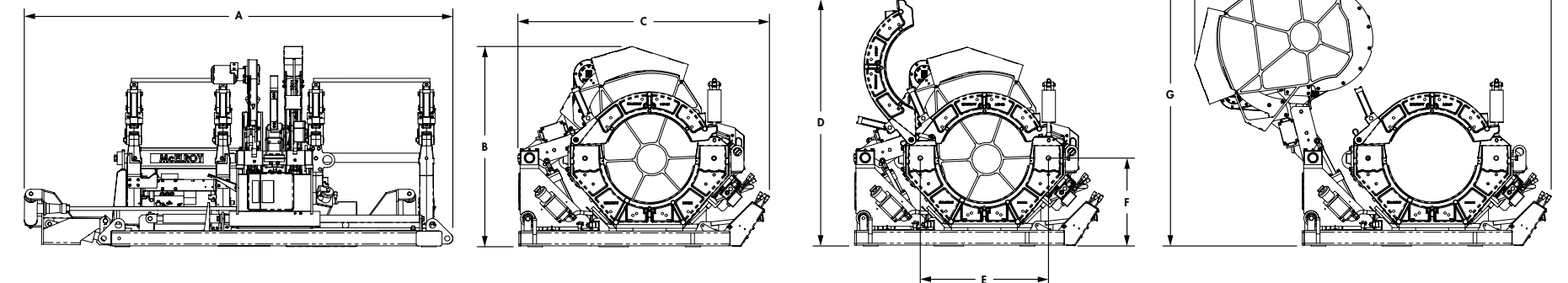
MACHINE DIMENSIONS ¹



	A	B	C	D	E	F	G	H	
MACHINE	MACHINE LENGTH	MACHINE HEIGHT	MACHINE WIDTH	MACHINE HEIGHT JAWS OPEN	BETWEEN CENTER LINE OF GUIDE RODS	GROUND TO GUIDE ROD CENTER LINE	MACHINE HEIGHT HEATER OUT	MACHINE WIDTH FACER OUT	GUIDE ROD DIAMETER
Rolling 28/250	66	39	38	42	15	24.37	48	45	1
Rolling 28/250 HP	66	39	38	42	15	24.37	48	45	1
TracStar® 28/250 Series 2	97.18	53.07	52.64	53.07	28.13	28.22	53.07	52.64	1
Rolling 412	86	46	51	52	19	32	62	51	1.75
TracStar 412 Series 2	98	53	55	53	19	31.25	61	55	1.75
Rolling 618	86	57	51	64	24	34	68	58	1.75
TracStar 618 Series 2	98	53	57	63	24	33.87	67	58	1.75
TracStar 500 Series 3	95	51	68	61.78	25.25	32.32	71.28	64.58	1.75
MegaMc® 824	134	68	85	84	35	40	99	98	2.5
TracStar 630 Series 2	149.73	78.68	97.85	89.87	35	46.47	102.78	97.85	2.5
MegaMc 1236	134	80	85	103	46	46.25	101	121	2.5
TracStar 900 Series 2	149.73	85.56	98.83	108.64	46	52.47	104.05	103.80	2.5
MegaMc® 1648 Series 2	192.22	98.82	89.10	110	60	59	99	135	3.75
TracStar 1200	160.05	99.85	109.43	110	60	60	99	135	3.75
MegaMc 2065	186	106	108	156	78	64.25	152	192	4
MegaMc 1600	205	117	102	160	78	68	152	189	4
Talon™ 2000	148.5	256.1	257.5	193 - 222	94	42 - 65	256.1	256.1	6

¹ All dimensions are in inches

CARRIAGE DIMENSIONS ¹



	A	B	C	D	E	F	G	H	J	
MACHINE	CARRIAGE LENGTH	CARRIAGE HEIGHT	CARRIAGE 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
2CU	20	17	12	--	6.375	6.125	--	--	--	0.75
2 LC	14	14	14	--	6.375	5.75	--	--	--	0.75
Pit Bull® 14	16	16	17	--	8.625	8.5	--	--	--	1
Acrobat™ 180	23.50	13.69	14.93	--	12	7.52	--	--	26.58	--
Pit Bull 26	16	18	20	--	12	9	--	--	--	--
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
1200/1648 (4-Jaw)	107	77	85			37.5				
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

¹ All dimensions are in inches

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).

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	
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
DTE 10 Excel 100	99.8	13	127																		55°F to 214°F 13°C to 101°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
Synthetic SCH 525	46	8.5	154																		19°F to 180°F -7°C to 82°C

This chart is based on pump manufacturer recommendations of 13 to 500 cSt. Temperatures shown are fluid temperatures not ambient temperatures

GENERATOR SIZING FORM

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.

- Horsepower of Motor:** _____ HP
- Motor Voltage:** _____ Volts
- Motor Phases:** 1 Phase or 3 Phase
- Motor Frequency:** 50Hz or 60Hz
- Heater Wattage Rating:** _____ Watts
- Heater Voltage:** _____ Volts
- Operational Altitude Range:** _____ Minimum _____ Maximum
- Ambient Temperature Range:** _____ Minimum _____ Maximum
- Duty Cycle:** Standby (Not continuous 24 hours a day)
- Allowable Voltage Dip:** 20%
- Allowable Frequency Dip:** 5%
- Starting Load Application:** Simultaneous turn-on of both motor and heater
- Running Load:** Motor continuous, heater cycling on and off at approximately 5 minute intervals
- Generator Fuel Preference:** Gasoline Diesel
- Special Requirements for Customer Application:**



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