

Patent No's. 5,814,182 6,212,748 6,212,747 6,021,832 (other patents pending)



No.618

McElroy's No.618 line of fusion machines come in multiple model configurations to meet the demands of your pipeline project. They will butt fuse pipe sizes from **6" IPS to 18" OD (180mm to 450mm)**. One of our best sellers the **Rolling No.618** bridges the gap between small and large diameter pipe fusion.

The **TracStar No.618** offers a self-contained, self-propelled track mounted vehicle that can handle grades up to 30%. It is the number one choice on the job site for its ease of maneuverability and productivity gains. The **PitBull No.618** is used for special applications where the wheeled or tracked vehicle is not needed.

All units incorporate the interchangeable No.618 four jaw carriage, which can be easily removed for in-ditch

fusion. For tight installations the outer fixed jaw and skid can be removed from the carriage converting it to a 3 jaw carriage for an even more compact fusion unit. These machines can fabricate segmented ells with optional mitered inserts and are DataLogger® compatible.

New to the TracStar No.618 is an option that allows automated control and monitoring over the heat, soak, fuse, and cool cycles. The **Automated TracStar No.618** system guides the operator through a step by step procedure for fusing pipe. It has a built-in data logging feature that keeps a record of each fusion joint, which allows you to verify joint integrity.

Rolling No.618

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

TracStar® No.618

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

PitBull® No.618

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

MACHINE PLUG TYPE
To find the right electrical plug type see
Page 107

GENERATOR
To size your generator see
Page 114

CYLINDER FORCE
For help selecting a cylinder force see
Page 102

DataLogger
To learn more about the DataLogger see
Page 78



Visit the Fusion Experts at www.mcelroy.com

Machine Type	Model No.	Cylinder Force	Input Voltage Requirements	Minimum Power Requirements *	Plug Type **
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Rolling No.618

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



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

TracStar® No.618

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



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

PitBull® No.618

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



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

* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 114.

** Refer to the plug type reference chart on page 107 for your correct plug type.

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

McElroy PolyHorse™

The PolyHorse is a new pipe handling system that consists of a series of adjustable racks to store and help install the pipe on the jobsite. For use with PE pipe sizes 3" through 20", the PolyHorse can reduce manpower expense, provide an efficient, less hazardous environment for handling pipe bundles, and enhance productivity by 150%. **See Page 84**



150%
Production
Increase!

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



Economical blade must be positioned for different pipe sizes.	
T1208603	Standard blades.
T1208603C	Extended life blades.

Spare 9.12" Facer Blade Set - 6 blades, screws and wrench



Spans the entire facer range without repositioning.	
T1812602	Standard blades.
T1812602C	Extended life blades.

Spare Heater Plate Kit - Includes: attaching screws and wrench



Plates have an anti-stick coating & are required for butt fusion.	
A1242108	Set of two 6" IPS - 12" DIPS plates.
A1852013	Set of two 12" IPS - 18" OD plates.

Pipe Support Stand - See page 82 for more information



1223201	Adjustable pipe stand to properly support, position and align pipe to be fused.
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PolyHorse™ - To Learn More See Page 84

NEW



1875501	Pipe handling system that consists of a series of adjustable racks to store and help install the pipe on the job site.
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DataLogger® - To Learn More See Page 78



DL6303	Used to record and document fusion process parameters.
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Stub End Holder - See page 111 for stub end size capability



Holds stub end for butt fusion.	
1808507	Aluminum stub end holder.
1808504	Steel stub end holder.

Part No.	Description
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Pyrometer Kit



A218803	Measures surface temperature of heater.
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6" IPS - 12" DIPS Heater - 220-240V, 50/60Hz, 1Ph



S 1855502	Microprocessor controlled with dial thermometer to monitor temperature. Includes heater plates insulated heater stand and stripper bars.
A T1813401	

Spare 12" IPS - 18" OD Heater - 220-240V, 50/60Hz, 1Ph



S 1852019	Microprocessor controlled with dial thermometer to monitor temperature. Includes heater plates insulated heater stand and stripper bars.
A T1813301	

25' Hydraulic Extension Hoses



1219105	Set of four 25' hydraulic extension hoses required for in-ditch fusion. Extension hoses are included with PitBull HPU.
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25' Heater Extension Cord 240V, 1Ph, 15A



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

NEW



T1801101	Facer stand provides a convenient place to protect and store your facer out of the dirt and mud when fusing in-ditch.
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Heat Shield

NEW



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



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

Automated In-Ditch Extension Kit



T5002003	Set of four 25' hydraulic extension hoses and extension cables for both heater and pendant. This kit is required for automated in-ditch fusion.
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Spare Automated Pendant



T5007109	Spare user interface for Automated TracStars No.28, 250, No.412, No.618 and 500.
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Spare Automated Control Box

NEW



T5001808	Spare control box for quick replacement. For use with Automated TracStars No.28, 250, No.412, No.618 and 500.
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Spare Automated USB Thumb Drive & Adapter

NEW



AT5040101	Used for downloading fusion records from the Automated Pendant to a USB thumb drive.
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SPARE HEATER LEGEND

- S** Heater for No.618, PitBull & TracStar No.618
- A** Heater for Automated TracStar No.618

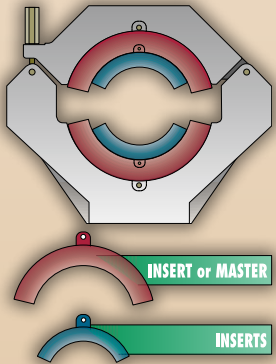
Butt Inserts



Set = 8 Inserts

All cast inserts are surface hardened for longer life and are serrated for maximum grip on the pipe. Inserts are made for one size pipe only and are required for pipe sizes less than 18" OD.

Not all inserts fit directly in the jaws. Some inserts nest inside other inserts, called master inserts. See graphic below for example.



NOTE: Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs. **For JIS sizes see page 96.**

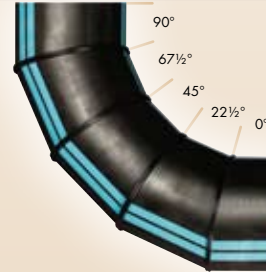
All inserts below fit in 18" OD Jaws

Inserts	Pipe OD	Set No.
18" OD Jaw	18.00 (457mm)	N/R
450mm	17.72 (450mm)	2418201
16" DIPS	17.40 (442mm)	2412117
16" OD	16.00 (406mm)	2412110
400mm	15.75 (400mm)	2412111
14" DIPS	15.30 (389mm)	2412215
14" OD	14.00 (355mm)	2412206
340mm	13.39 (340mm)	2411811
12" DIPS	13.20 (335mm)	2411826
12" IPS <i>Master</i>	12.75 (324mm)	2411810

All inserts below require 12" IPS Master inserts

315mm	12.40 (315mm)	1211202
10" DIPS	11.10 (282mm)	1207221
280mm	11.02 (280mm)	1207205
10" IPS	10.75 (273mm)	1207204
250mm	9.84 (250mm)	1213503
8" DIPS	9.05 (230mm)	1207107
225mm	8.86 (225mm)	1207010
8" IPS	8.63 (219mm)	1207104
200mm	7.87 (200mm)	1207009
7-1/8"/180mm OD	7.13 (180mm)	1207008
6" DIPS	6.90 (175mm)	1207020
6" IPS <i>Master</i>	6.63 (168mm)	1207007
160mm	6.30 (160mm)	1207011

Mitered Inserts



Standard Ell Configuration 11 1/4° miter shown

Mitered inserts are used to fabricate segmented ells. All inserts are surface hardened for longer life and are serrated for maximum grip on the pipe.

Inserts are made for one size pipe only. Some inserts nest inside other insert called master inserts.



**Set =
4 Inserts & 1 Template**

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

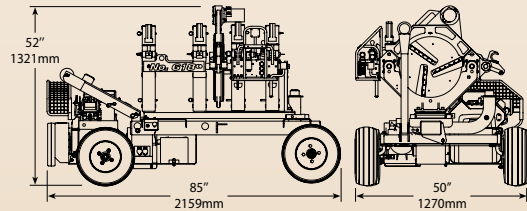
All inserts below fit in 18" OD Jaws

Inserts	Pipe OD	Set No.
16" OD x 11 1/4°	16.00 (406mm)	2420619
400mm x 11 1/4°	15.75 (400mm)	2420618
14" DIPS x 11 1/4°	15.30 (389mm)	24206122
370mm x 11 1/4°	14.57 (370mm)	24206125
14" OD x 11 1/4°	14.00 (355mm)	2420617
12" DIPS x 11 1/4°	13.20 (335mm)	24206110
12" IPS x 11 1/4°	12.75 (324mm)	2420615
315mm x 11 1/4°	12.40 (315mm)	2420614
10" DIPS x 11 1/4°	11.10 (282mm)	24206116
12" IPS <i>Master</i>	12.75 (324mm)	2411810

All inserts below require 12" IPS Master inserts

280mm x 11 1/4°	11.02 (280mm)	1214284
10" IPS x 11 1/4°	10.75 (273mm)	1214232
250mm x 11 1/4°	9.84 (250mm)	1214235
8" DIPS x 11 1/4°	9.05 (230mm)	1214269
225mm x 11 1/4°	8.86 (225mm)	1214281
8" IPS x 11 1/4°	8.63 (219mm)	1214230
200mm x 11 1/4°	7.87 (200mm)	1214234
180mm x 11 1/4°	7.09 (180mm)	1214290
6" DIPS x 11 1/4°	6.90 (175mm)	1214275
6" IPS x 11 1/4°	6.63 (168mm)	1214228

Rolling No.618 Gas Powered



CAPACITY

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

WEIGHT

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

HYDRAULICS

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

ENGINE (Gas Powered Only)

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

ELECTRICAL

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

POWER

Heater Power: 3000 Watt
 Facer Power: Hydraulic

CHASSIS

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

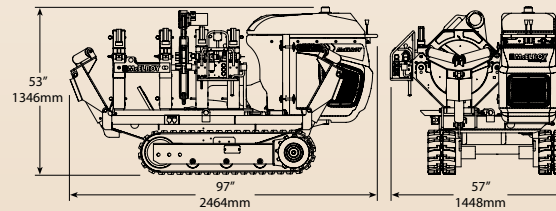
MOBILITY

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

WARRANTY

Term: 3 Years see page 7 for details

TracStar® No.618



CAPACITY

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

WEIGHT

Machine: 2000 lbs (850Kg)
 4 Jaw Carriage Configuration: 445 lbs (202Kg)
 3 Jaw Carriage Configuration: 350 lbs (158Kg)
 Facer: 91 lbs (41.3Kg)
 6" IPS - 12" DIPS Heater: 28 lbs (13Kg)
 12" IPS - 18" OD Heater: 34 lbs (15.4Kg)

HYDRAULICS

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

ENGINE

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

ELECTRICAL

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

POWER

Heater Power: 3000 Watt
 Facer Power: Hydraulic

CHASSIS

Frame: Welded steel construction
 Brake: Self locking

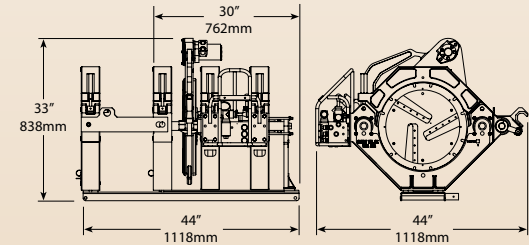
MOBILITY

Tracked: Rubber crawler tracks
 Transportation: Self Propelled
 Vehicle speed: 1.5 Mph Max.
 Lifting Lift points & lifting assembly

WARRANTY

Term: 3 Years see page 7 for details

PitBull® No.618



CAPACITY

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

WEIGHT

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

POWER

Heater Power: 3000 Watt
 Facer Power: Hydraulic

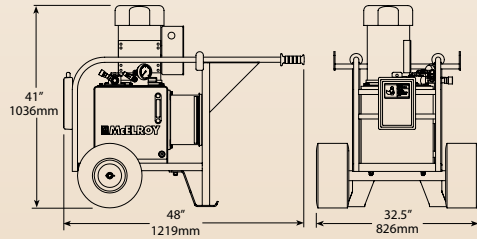
CHASSIS

Frame: Welded steel construction

WARRANTY

Term: 3 Years see page 7 for details

HPU (Hydraulic Power Unit)



WEIGHT

Machine: 390 lbs (149Kg)

HYDRAULICS

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

POWER

Power Requirement: 5.2KVA/4.5Watt

MOTOR

Electric: 5 HP

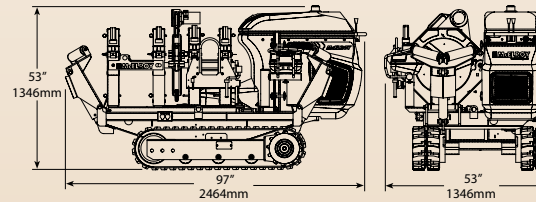
MOBILITY

Tires: High flotation inflatable tires
 Transportation: Two wheel cart

WARRANTY

Term: 3 Years see page 7 for details

Automated TracStar® No.618



CAPACITY

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

WEIGHT

Machine: 2000 lbs (850Kg)
 4 Jaw Carriage Configuration: 445 lbs (202Kg)
 3 Jaw Carriage Configuration: 350 lbs (158Kg)
 Facer: 91 lbs (41.3Kg)
 6" IPS - 12" DIPS Heater: 28 lbs (13Kg)
 12" IPS - 18" OD Heater: 34 lbs (15.4Kg)

HYDRAULICS

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

ENGINE

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

ELECTRICAL

Input: None, self-contained

POWER

Heater Power: 3000 Watt
 Facer Power: Hydraulic

CHASSIS

Frame: Welded steel construction
 Brake: Self locking

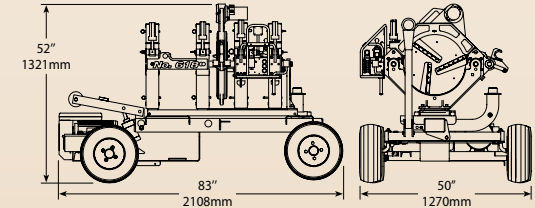
MOBILITY

Tracked: Rubber crawler tracks
 Transportation: Self Propelled
 Vehicle speed: 1.5 Mph Max.
 Lifting: Lift points & lifting assembly

WARRANTY

Term: 3 Years see page 7 for details

Rolling No.618 Electric Powered



CAPACITY

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

WEIGHT

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

HYDRAULICS

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

POWER

Heater Power: 3000 Watt
 Facer Power: Hydraulic

MOTOR

Electric Motor: 5 HP

CHASSIS

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

MOBILITY

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

WARRANTY

Term: 3 Years see page 7 for details