

# 2065/1600 Fusion Machines

Fusion Capability for 20" OD – 65" OD pipe (500mm – 1600mm)



## 2065/1600

Designed for the largest of pipe applications, the **MegaMc® 2065** and new **1600** machines will butt fuse pipe sizes from **20" OD to 65" OD (500mm to 1600mm)**. The 2065 has been used around the world on large-diameter polyethylene projects in a variety of industries. The 2-jaw 2065 allows for butt fusion of most fittings without special holders. Mitered inserts are available for fabricating ells. McElroy's unique semi-automatic control system requires only one operator.

Recently, McElroy developed the 4-jaw 1600 machine to tackle large pipe jobs, with 30,000 lbs. of clamping force per jaw for improved gripping and rounding of pipe. With 88,000 lbs. of fusion force, operators will find they have extra force in reserve to overcome drag. The 1600 boasts a road-approved 102" width, extendable hydraulic outriggers/levelers for stabilization and an improved facer design that is 40% faster. Like the 2065, hydraulic power assists all fusion functions including complete operation of the jaws, pipe lifts, heater and facer.

### 2065

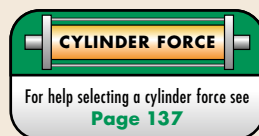
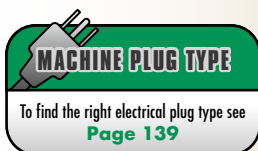
- DataLogger® compatible
- Hydraulic clamping
- Hydraulic pipe lifts aid in loading and unloading pipe
- Serrated jaws and inserts keep pipe from slipping
- Hydraulic pivoting heater and facer

### 1600

**NEW!**

All the features of the 2065 plus:

- 4-jaw machine with 30,000 lbs. of clamping force per jaw help round pipe ends and offer better gripping
- 88,000 lbs. of available fusion force is more than twice the force of the 2065, allowing you to fuse thicker wall pipes and overcome heavier drag forces
- Stronger, more powerful facer is 40% faster, making it easier to face heavy-wall pipe
- Extendable hydraulic outriggers/levelers stabilize the machine on level or uneven job site locations
- Complete fourth jaw can be removed as a whole unit, for enhanced convenience in fusing prefabricated fittings onto the pipe
- Automatic hydraulic heater stripping improves open and close times
- 102" width suitable for most flatbed trailers and is road shippable without permit in most of the U.S.



Visit the Fusion Experts at [www.mcelroy.com](http://www.mcelroy.com)



# Fusion Machines & Accessories 2065/1600

Machine Type	Model No.	Cylinder Force	Input Voltage Requirements	Minimum Power Requirements *	Plug Type **
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**2065** Includes fusion machine, facer, 48" and 65" heaters and lifting assembly.



Rolling	A6300102	High	220V - 240V, 50/60Hz, 3Ph	48.4KVA/47.2KW	J
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**1600** Includes fusion machine, facer, 48" and 65" heaters and lifting assembly.




Rolling	A6500103	High	220V - 240V, 50/60Hz, 3Ph	65KVA/52KW	J
Rolling	A6500102	Medium	220V - 240V, 50/60Hz, 3Ph	65KVA/52KW	J


\* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 145.  
 \*\* Refer to the plug type reference chart on page 139 for your correct plug type.

Part No.	Description
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**Spare Facer Blade Set** - Includes 8 blades screws and wrench

	3615708	Standard blades.
	3615708C	Extended-life blades.

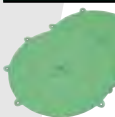
**DataLogger®** - To learn more, see page 108

	Used to record and document fusion process parameters.	
	DL6303	Wireless DataLogger
	DL6304	Wired DataLogger

**NEW!**

Part No.	Description
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**Spare Heater Plate Kit** - Includes attaching screws and wrench


	Plates have an anti-stick coating and are required for butt fusion.	
	A6314301	Set of 2 plates 48" to 65".
	A6311805	Set of 2 plates 20" to 48".

**Stub End Holder** - To learn more, see page 115

	6315501	Holds stub end for butt fusion.
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Part No.	Description
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**Pipe Support Stand** - See page 103 for more information


	6314001	Heavy-duty stand. Height is adjustable to properly support pipe to be fused.
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**MegaMc® Pipe Stand** - To learn more, see page 102

**NEW!**

	Gas-powered pipe stand with lateral and vertical movement.	
	6513501	36" - 65" pipe sizes

**Pyrometer Kit**

	A218804	Accurately checks surface temperatures of heater.
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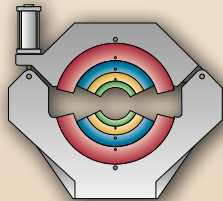
# 2065/1600 Butt Fusion & Mitered Inserts

## Butt Fusion Inserts

Our cast inserts have been surface-hardened for longer life. Fabricated inserts are constructed out of precision laser-cut carbon steel and are normally lighter in weight than cast inserts. All inserts are serrated for maximum grip on the pipe. Inserts are made for one size pipe only. Not all inserts fit directly in the jaws. Some inserts nest inside other inserts, called master inserts.

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

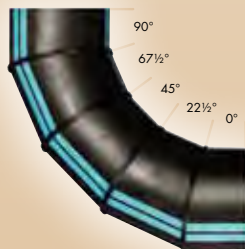
**FAB = Fabricated Inserts**



## Mitered Inserts

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

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



### Butt Fusion Inserts Set = 8 Inserts

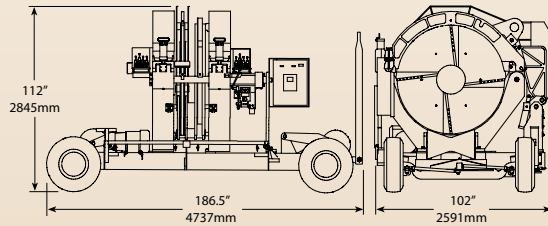
		2 Jaw Inserts		4 Jaw Inserts	
<b>All Inserts below fit in 65.25 (1657mm) jaws</b>					
Inserts	Pipe OD	Cast	FAB	Cast	FAB
65" OD	65.00 (1651mm)	N/A	6512011*	N/A	6512010
63" Master	63.51 (1613mm)	Inc w/pkg*	N/A	Inc w/pkg	N/A
63" OD	63.00 (1600mm)	N/A	6317301*	N/A	6512004
54" DIPS	57.10 (1450mm)	Call	6316401*	Call	6316402
1400mm	55.12 (1400mm)	Call	6317401*	Call	6317407
54" OD	54.00 (1372mm)	6308706*	6317201*	6308707	6317206
52" OD	52.00 (1321mm)	Call	6315401*	Call	6315406
48" DIPS	50.80 (1290mm)	Call	6316201*	Call	6316206
48" Master	48.00 (1219mm)	6304504*	N/A	6304506	N/A
<b>All inserts below require 63.51" &amp; 48" Master Inserts</b>					
1200mm	47.25 (1200mm)	N/A	4819501	N/A	4819501
42" DIPS	44.50 (1130mm)	Call	4821201	Call	4821201
1100mm	43.31 (1100mm)	4813127	Call	4813127	Call
42" OD	42.00 (1067mm)	4813104	4827501	4813104	4827501
1000mm	39.38 (1000mm)	4813111	4819601	4813111	4819601
36" DIPS	38.30 (973mm)	Call	4821101	Call	4821101
36" Master	36.00 (914mm)	4813006	N/A	4813006	N/A
<b>All inserts below require 63.51", 48" &amp; 36" Master Inserts</b>					
900mm	35.43 (900mm)	3617504	3629401	3617504	3629401
34" OD	34.00 (864mm)	3603532	N/A	3603532	N/A
32" OD	32.00 (813mm)	3603512	3629501	3603512	3629501
800mm	31.50 (800mm)	3603509	3629601	3603509	3629601
30" OD	30.00 (762mm)	3603515	3629701	3603515	3629701
28" OD	28.00 (711mm)	3603418	3619705	3603418	3619705
26" OD	26.00 (660mm)	3606614	3629801	3606614	3629801
24" DIPS	25.80 (655mm)	3606617	3629901	3606617	3629901
630mm Master	24.80 (630mm)	3606604	N/A	3606604	N/A
<b>All inserts below require 63.51", 48", 36" &amp; 630mm Master Inserts</b>					
24" OD	24.00 (610mm)	2411604	2402301	2411604	2402301
20" DIPS	21.60 (549mm)	2411922	N/A	2411922	N/A
20" OD	20.00 (508mm)	2412010	N/A	2412010	N/A

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

2065/1600 Inserts			
<b>All inserts below fit in 65.25 (1657mm) jaws</b>			
Inserts	Pipe OD	Cast	FAB
63" Master	63.51 (1613mm)	Inc w/pkg	N/A
54" OD x 11.25	54.00 (1372mm)	Call	N/A
48" OD x 11.25	48.00 (1219mm)	Call	N/A
1200mm x 11.25	47.25 (1200mm)	Call	N/A
<b>All inserts below require 63.51" OD Master Inserts</b>			
48" Master	48.00 (1219mm)	6304504	N/A
<b>All inserts below require 63.51", 48" OD Master Inserts</b>			
42" OD x 11.25	42.00 (1067mm)	4813115	N/A
1000mm x 11.25	39.37 (1000mm)	Call	N/A
36" OD x 11.25	36.00 (914mm)	4813010	N/A
900mm x 11.25	35.43 (900mm)	4813016	N/A
34" OD x 11.25	34.00 (864mm)	Call	N/A
36" Master	36.00 (914mm)	4813006	N/A
<b>All inserts below require 63.51", 48", 36" OD Master Inserts</b>			
32" OD x 11.25	32.00 (813mm)	3603526	N/A
800mm x 11.25	31.50 (800mm)	3603523	N/A
30" OD x 11.25	30.00 (762mm)	3603520	N/A
28" OD x 11.25	28.00 (711mm)	3603529	N/A
26" OD x 11.25	26.00 (660mm)	3606623	N/A
24" DIPS x 11.25	25.80 (655mm)	3606620	N/A
630mm x 11.25	24.80 (630mm)	3606610	N/A
24" OD x 11.25	24.00 (610mm)	3606613	N/A

\* Set = 4 Inserts

## 2065



### CAPACITY

Fuses Pipe Sizes: ..... 20"OD – 65" OD pipe (500mm – 1600mm)

### WEIGHT

Machine: ..... 14,000 lbs (6350Kg)  
 Facer: ..... 1200 lbs (544Kg)  
 20-48" Heater: ..... 600 lbs (272.2Kg)  
 48-65" Heater: ..... 713.5 lbs (323.6Kg)  
 Spreader Bar: ..... 1000 lbs (453.6Kg)

### HYDRAULICS

System Pressure: ..... 1500 PSI (103 BAR) Max.  
 Hydraulic Reservoir Capacity: ..... 24 Gallons (90.85 liters)  
 Motor: ..... 10 HP, 3 Phase, 240V

### POWER

20-48" Heater Power: ..... 35,000 Watt  
 48-65" Heater Power: ..... 38,437 Watt  
 Facer Power: ..... Hydraulic

### CHASSIS

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

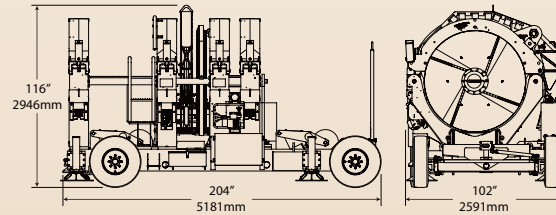
### MOBILITY

Tires: ..... 12 - 16.5LTF, F-12  
 Transportation: ..... Pulled via towing ring  
 Lifting ..... Lift points and lifting assembly

### WARRANTY

Term: ..... 3 Years, see page 5 for details

## 1600



### CAPACITY

Fuses Pipe Sizes: ..... 20"OD – 65" OD pipe (500mm – 1600mm)

### WEIGHT

Machine: ..... 21,000 lbs (9525Kg)  
 Facer: ..... 1200 lbs (544Kg)  
 20-48" Heater: ..... 600 lbs (272.2Kg)  
 48-65" Heater: ..... 713.5 lbs (323.6Kg)  
 Spreader Bar: ..... 1000 lbs (453.6Kg)

### HYDRAULICS

System Pressure: ..... 3000 PSI (207 BAR) Max.  
 Hydraulic Reservoir Capacity: ..... 35 Gallons (132 liters)  
 Motor: ..... 25 HP, 3 Phase, 240V

### POWER

20-48" Heater Power: ..... 35,000 Watt  
 48-65" Heater Power: ..... 38,437 Watt  
 Facer Power: ..... Hydraulic

### CHASSIS

Frame: ..... Welded steel tube construction  
 Front Axle: ..... Articulating

### MOBILITY

Tires: ..... 8.25 - 15LT High Load Rating  
 Transportation: ..... Pulled via towing ring  
 Lifting ..... Lift points and lifting assembly

### WARRANTY

Term: ..... 3 Years, see page 5 for details