

824/630 Fusion Machines Fusion Capability for 8" IPS – 24" OD pipe (225mm – 630mm)

Patent Numbers: 5,814,182 6,212,748 6,212,747 6,021,832 Japanese Patent No 4285806 European Patent No 0903215 (other patents pending)



824 & TracStar® 630

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

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

propelled tracks and features a wireless remote driving control.

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

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

824

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

TracStar® 630

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

MACHINE PLUG TYPE
To find the right electrical plug type see
Page 139

GENERATOR
To size your generator see
Page 145

CYLINDER FORCE
For help selecting a cylinder force see
Page 134

DataLogger
To learn more about the DataLogger see
Page 108



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



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

TracStar® 630 Includes fusion machine, facer, heater, 24" OD butt fusion inserts, remote control with batteries and 12V charger. Optional heater/facer stand sold separately.



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

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

* This is the minimum generator requirement at sea level, see your generator supplier or refer to the generator sizing form on page 145.

** Refer to the plug type reference chart on page 139 for your correct plug type.

824/630 Accessories

Part No.	Description
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Spare 9" Facer Blade Kit - Six blades, screws and wrench



Economical blade must be positioned for different pipe sizes.

3615710	Standard blades.
3615710 C	Extended-life blades.

Spare 11" Facer Blade Kit - Six blades, screws and wrench



Spans the entire facer range without repositioning.

3615712	Standard blades.
3615712 C	Extended-life blades.

Spare Heater Plate Kit



A2428506	Set of 2 plates with anti-stick coating required for butt fusion. Kit includes attaching screws and wrench.
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Pipe Support Stand - See page 103 for more information



2429101	824 stand for rolling unit.
T9017401	TracStar 630/900 pipe stand
4823901	Heavy-duty pipe stand

MegaMc® Pipe Stand - To learn more, see page 102

NEW!



Gas powered pipe stand with lateral and vertical movement.

3645001	8" - 36" pipe sizes
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Low Profile Rollers - To learn more, see page 104

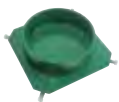
NEW!



A1867501	Aids by reducing the drag on the pipe and protecting the pipe from damage. Case includes 40 complete roller assemblies.
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Part No.	Description
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Stub End Holder - To learn more, see page 115



2419501	Holds stub end for butt fusion.
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DataLogger® - To learn more, see page 108



Used to record and document fusion process parameters.

DL6303	Wireless DataLogger
DL6304	Wired DataLogger

NEW!

Pyrometer Kit



A218804	Accurately checks surface temperatures of heater.
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In-Ditch Heater/Facer Stand



T2409101	Heater/Facer stand recommended for tight in-ditch installations where top loading of the heater and facer is necessary.
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In-Ditch Extension Kit



T2408301	Set of 40' hydraulic extension hoses and cable. Required for use when doing in-ditch fusion.
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Part No.	Description
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Auto-Only Accessories

In-Ditch Automatic Extension Kit



T9002005	Set of 40' hydraulic extension hoses, cable, facer stand and pendant strap. Required for use when doing automatic in-ditch fusion.
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Spare Automated Pendant



T5007110	Spare user interface for Automatic TracStar 630 and 900.
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Spare Automatic Control Box



T5001809	Spare control box for quick replacement. For use with Automatic TracStars 630 and 900.
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Spare Automated USB Thumb Drive & Adapter



AT5040101	Used for downloading fusion records from the Automated Pendant to a USB thumb drive.
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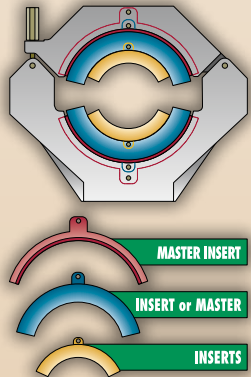
INTRODUCING THE NEW DATALOGGER®.
Now available in Wired and Wireless versions to record the time, temperature and pressure of each fusion joint. To learn more, see page 108.

NOW RECORDING

Butt Fusion Inserts

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

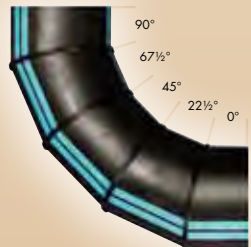
NOTE: Other sizes of inserts are available upon request. Contact your McElroy representative about inserts to fit your needs.



Mitered Inserts

Mitered inserts are used to fabricate segmented ells. Our standard miter is 11¼°, other mitered angles are available upon request.

Standard Ell Configuration
90° Ell 11¼° miter shown



Butt Fusion Inserts Set = 8 Inserts

All inserts below fit in 24.80" (630mm) jaws			
Inserts	Pipe OD	Cast	Fabricated
24" OD	24.00 (610mm)	N/A	2402301 Inc w/pkg
22" OD	22.00 (560mm)	2411919	N/A
20" DIPS	21.60 (549mm)	2411922	N/A
20" OD	20.00 (508mm)	2412010	N/A
500 mm	19.69 (500mm)	2412011	N/A
18" DIPS	19.50 (495mm)	2412023	N/A
18" Master	18.00 (457mm)	2411708	N/A

All inserts below require 18" OD Master Inserts			
450 mm	17.72 (450mm)	N/A	2418201
16" DIPS	17.40 (442mm)	2412117	2418301
16" OD	16.00 (406mm)	2412110	N/A
400 mm	15.75 (400mm)	2412111	N/A
14" DIPS	15.30 (389mm)	2412215	N/A
14" OD	14.00 (355mm)	2412206	N/A
340 mm	13.39 (340mm)	2411811	N/A
12" DIPS	13.20 (335mm)	2411826	N/A
12" Master	12.75 (324mm)	2411810	N/A

All inserts below require 18" OD & 12" Master			
315 mm	12.40 (315mm)	1211202	N/A
10" DIPS	11.10 (282mm)	1207221	N/A
280 mm	11.02 (280mm)	1207205	N/A
10" IPS	10.75 (273mm)	1207204	N/A
250 mm	9.84 (250mm)	1213503	N/A
8" DIPS	9.05 (230mm)	1207107	N/A
225 mm	8.86 (225mm)	1207010	N/A
8" IPS	8.63 (219mm)	1207104	N/A

11¼° Mitered Inserts Set = 4 Inserts & 1 Temp.

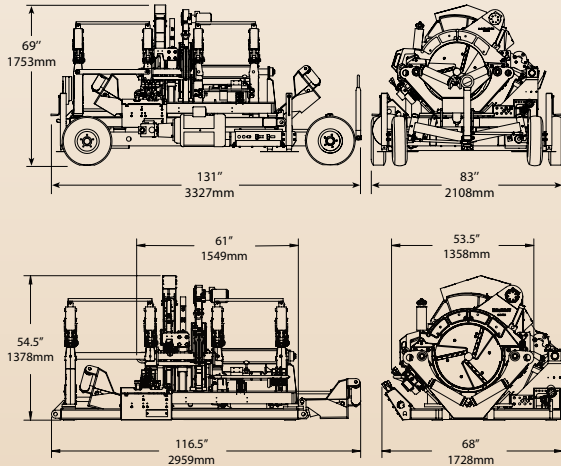
All inserts below fit in 24.80" (630mm) jaws		
Inserts	Pipe OD	Set No.
22 OD/560mm	22.00 (560mm)	2421229
20" DIPS	21.60 (549mm)	2421257
20" OD	20.00 (508mm)	2421217
500mm	19.69 (500mm)	2412014
18" DIPS	19.50 (495mm)	2421251
450mm	17.72 (450mm)	2421214
18" OD	18.00 (457mm)	2421215
16" DIPS	17.40 (442mm)	2421245
420mm	16.53 (420mm)	2421266
18" Master	18.00 (457mm)	2411708

All inserts below require 18" OD Master Inserts		
16" OD	16.00 (406mm)	2420619
400mm	15.75 (400mm)	2420618
14" DIPS	15.30 (389mm)	24206122
370mm	14.57 (370mm)	24206125
14" OD	14.00 (355mm)	2420617
12" DIPS	13.20 (335mm)	24206110
12" IPS	12.75 (324mm)	2420615
315mm	12.40 (315mm)	2420614
10" DIPS	11.10 (282mm)	24206116
12" Master	12.75 (324mm)	2411810

All inserts below require 18" OD & 12" Master		
280mm	11.02 (280mm)	1214284
10" IPS	10.75 (273mm)	1214232
250mm	9.84 (250mm)	1214235
8" DIPS	9.05 (230mm)	1214269
225mm	8.86 (225mm)	1214281
8" IPS	8.63 (219mm)	1214230
200mm	7.87 (200mm)	1214234
180mm	7.09 (180mm)	1214290

824/630 Specifications

824



CAPACITY

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

WEIGHT

Machine: 5905 lbs (2678Kg)
 4 Jaw Carriage Configuration: 3790 lbs (1719Kg)
 3 Jaw Carriage Configuration: 1350 lbs (612Kg)
 Facer: 390 lbs (177Kg)
 Heater: 240 lbs (109Kg)

HYDRAULICS

System Pressure: 2300 PSI (158 BAR) Max.
 Hydraulic Reservoir Capacity: 28 Gallons (106 Liters)
 Motor: 20 HP, 3 Phase, 240V

POWER

Heater Power: 10,950 Watt
 Facer Power: Hydraulic

CHASSIS

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

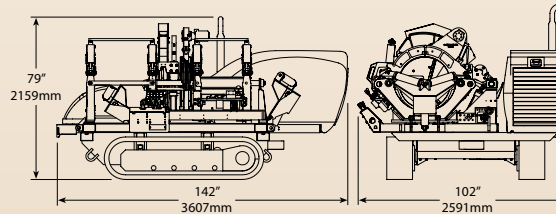
MOBILITY

Tires: 6.90 - 9NHS, 75 PSI Max.
 Transportation: Pulled via towing ring
 Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 5 for details

TracStar® 630



CAPACITY

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

WEIGHT

Machine: 8600 lbs (3900Kg)
 4 Jaw Carriage Configuration: 3790 lbs (1719Kg)
 3 Jaw Carriage Configuration: 1350 lbs (612Kg)
 Facer: 390 lbs (177Kg)
 Heater: 240 lbs (109Kg)

HYDRAULICS

System Pressure: 2300 PSI (158 BAR) Max.
 Hydraulic Reservoir Capacity: 12 Gallons (45 Liters)

ENGINE

Engine Type: 84.5 HP, 3600cc, 4-cylinder turbo
 Fuel Type: Diesel
 Fuel Tank Capacity: 23 Gallons (87 Liters)
 Operational Tank Capacity: 17 Hours
 Starting System: Electric

ELECTRICAL

Input: None, self-contained

POWER

Heater Power: 10,950 Watt
 Facer Power: Hydraulic

CHASSIS

Frame: Welded steel construction
 Brake: Self-locking

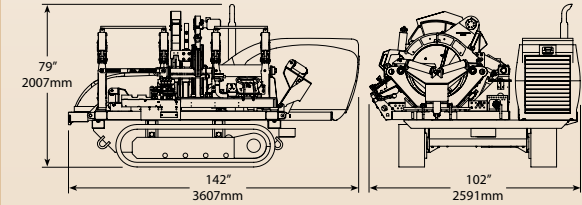
MOBILITY

Tracked: Rubber crawler tracks
 Transportation: Self-propelled
 Vehicle speed: Low 1mph / High 1.7mph
 Lifting Lift points and lifting assembly

WARRANTY

Term: 3 Years, see page 5 for details

Automatic TracStar 630



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WARRANTY

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Note: All carriage weights are without facer and heater. Specifications subject to change without notice. Additional dimensions available on page 143.

