

# FUMES DON'T STAND A CHANCE

## WELD FUME CONTROL



Shown with optional  
K639-5 Suction Nozzle

### Portable Welding Fume Extractor

Lincoln Electric's X-Tractor® 1GC is a high vacuum extraction system designed for the removal and filtration of welding fume. The 1GC is a great choice for fume removal on the light duty welding applications typically found in shops or companies with a small number of welding stations. The compact size and light weight of the X-Tractor® 1GC make the unit easy to move to where it's needed.

- » Economical fume movement and ventilation option
- » Easily disassemble the unit for cleaning and maintenance
- » Maximum extraction distance up to 32 ft. (9.7 m)
- » Quiet operation

#### Processes »

Stick, TIG, MIG, Flux-Cored

#### Product Number »

K652-1

K652-2

K4260-4 X-Tractor® 1GC One-Pak®

#### Input »



## KEY FEATURES

- » **Simple to Configure** – Uses a single fume extraction welding gun or suction nozzle attachment
- » **Filter Cleaning System** – Unique rotary air jet system allows the polyester filter to be cleaned using compressed air without removing it from the X-Tractor® 1GC
- » **Automatic Start/Stop Sensor** – Provides extraction only when needed, extends motor life, and reduces energy consumption
- » **Wide Variety of Extraction Nozzles Available** – Easily adapt the X-Tractor® 1GC for many different welding applications
- » **Low Noise Operation – 74 dBA**

## WHAT'S INCLUDED

### Base Unit (K652-1)

- » Adapter for 1-3/4 in. (45 mm) hose (S20591-8)
- » 8 ft. (2.4 m) long x 1-3/4 in. (45 mm) diameter flexible hose
- » 2 spare sets of carbon brushes for motors
- » Filter cartridge
- » 12 ft. (3.6 m) power cord

### One-Pak® Package (K4260-4)

- » Base Unit K652-1
- » Aluminum Suction Nozzle with Magnetic Mounting K639-1

## WEIGHT AND DESIGN

The X-Tractor® 1GC is lightweight and portable at only 37 lbs. (17 kg) and can easily be carried anywhere. This unit is perfect for light duty, intermittent use such as maintenance and construction applications.

High vacuum welding fume extraction systems utilize higher pressure of 70-90" WG and low volume of 55-115 CFM with an air speed of 4000-5000 ft/min. The air handling configuration of high vacuum equipment allows the use of small diameter rigid duct and small diameter flex hose to easily reach extraction points. It is perfect for applications such as short welds when using fume suction nozzles or larger fixture welding using integrated fume extraction guns. This process is designed for close proximity source extraction from 2-4" to the welding source.

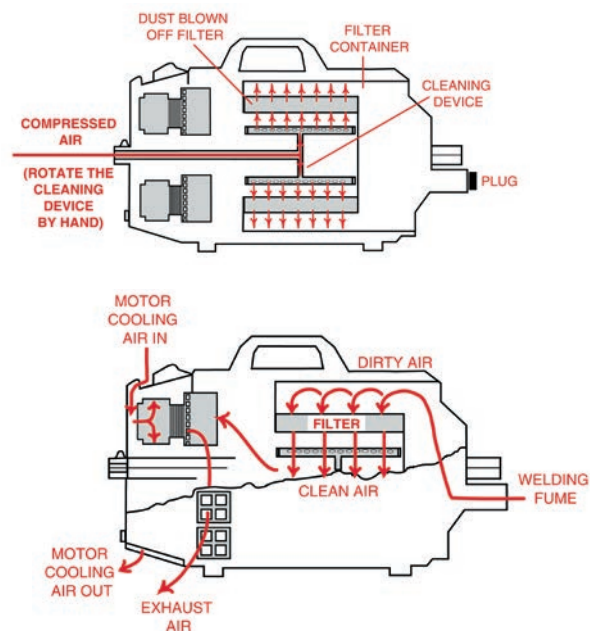
Since the hoses and suction nozzles are smaller than those of low vacuum systems, it is much easier to carry the extraction nozzle and/or flex hose into confined spaces (45 ft. maximum distance). The mobility of the hoses allows the main filter unit to be kept at a central location. Due to the low air volume (CFM) extracted make-up air and negative room air pressures are kept to a minimum when exhausting outside the facility.

## FILTRATION PROCESS

The X-Tractor® 1GC has a unique internal manual cleaning system. Using a customer supplied compressed air source and manual rotation, the internal rotary air jet device supplies a burst of air from inside the filter cartridges. This in turn causes the particulate that has collected on the outside of the filter cartridge to drop into the bottom of the unit. The cover where the flex hose inlet is located is then removed and the particulate can be disposed of by following federal, state, and local environmental regulations.

## CABLE SENSOR

At the bottom of the X-Tractor® 1GC unit is an automatic start/stop sensor. The unit automatically switches on as the welder begins to weld and automatically switches off approximately 15 seconds after the arc is extinguished. The result is less energy consumption and non-continuous noise. For the automatic start/stop function to work, the welding power source's work cable or power cable must be laid in the sensor hook.



## RECOMMENDED ACCESSORIES

### GENERAL OPTIONS



#### EN 20 Extraction Nozzle

The EN 20 nozzle is designed for a wide array of welding applications. With its funnel extraction opening and magnetic mounting stand, the EN 20 gives the welder a greater amount of versatility.

**Order**  
K2389-5



#### SHMS-400 Low Noise Nozzle

16 in. (400 mm) aluminum suction nozzle with magnetic mounting. Includes S20591-7 adapter for 1-3/4 in. (45 mm) hose. Best capture distance:- 1-1/2 in. (38 mm).

**Order**  
K639-4



NKT  
K2389-3

#### Nozzle Kits

Kit provides extraction capacity to standard welding torches. The NKT kit is for mounting the extraction hose on top of gun. The NKC kit is for circular extraction. Note: guns not included.

**NKT Order**  
K2389-3



#### EN 40 Extraction Nozzle

The EN 40 nozzle is designed for stick electrode applications. With its L-shaped tube and an elongated slotted opening, the EN 40 nozzle is designed to coincide with the time it takes the welder to use one stick electrode. This design alleviates the welder from having to continuously reposition the nozzle. Magnetic mounting stand included.

**Order**  
K2389-6



#### UNM Suction Nozzle for Heavy Smoke

8 in. (200 mm) aluminum suction nozzle with magnetic mounting. Includes S20591-7 adapter for 1-3/4 in. (45 mm) hose. Best capture distance: < 4 in. (100 mm)

**Order**  
K639-6



#### Hose-to-Hose Adapter

To connect hoses together, a 2 in. (50 mm) hose-to-hose adapter screws over hose ends, providing a tight connection and seal.

**Order**  
K2389-10



#### Extraction Hoses

Flexible high temperature hoses with spring steel reinforcement. Use to extend or replace the hose included with the base unit. To ensure an effective performance level, it is recommended that a maximum hose length of 45 ft. (15 m) be used.

**Hose 16 ft. (5 m) x 1-3/4 in. (45 mm)**

**Order**  
K2389-8

**Hose 8 ft. (2.5 m) x 1-3/4 in. (45 mm)**

**Order**  
K2389-9



#### SHFA Flat Suction Nozzle

150 mm (6 in.) aluminum suction nozzle with 20 in. (500 mm) flexible steel hose and magnetic mounting. Includes S20591-7 adapter for 1-3/4 in. (45 mm) hose. Best capture distance: < 4 in. (100 mm).

**Order**  
K639-5



#### Aluminum Suction Nozzles with Magnetic Mounting

Includes S20591-7 adapter for 1 3/4 in. (45 mm) hose. Best capture distance:- 1-1/2 in. (38 mm). SHM-300 Nozzle - 12 in. (300 mm)

**Order**  
K639-1



#### Gun Mounted Nozzle Kit (OT-25)

Nickel plated brass nozzle slips over the gun's gas nozzle and secures with screw. Includes a total of 16 ft. (5 m) of hose and all necessary adapters including SS-3245 for connection to 1-3/4 in. (45 mm) hose

**Order**  
K639-20

**PRODUCT SPECIFICATIONS**

Product Name	Product Number	Input Power Voltage / Phase / Hertz	Input Current	H x W x D inches (mm)	Net Weight lbs. (kg)
X-Tractor 1GC	K652-1	120V/1/50/60	15A	13.4 x 26.8 x 15.8 (340 x 680 x 400)	37 (17)
	K652-2	220V/1/50/60	9A		
X-Tractor 1GC One-Pak	K4260-4	120V/1/50/60	15A		49 (22.2)

The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, maintenance of the equipment and the specific welding procedure and application involved. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is within applicable OSHA PEL and ACGIH TLV limits.

**CUSTOMER ASSISTANCE POLICY**

The business of The Lincoln Electric Company® is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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