

# X-TRACTOR® 1GC

## Processes

Stick, TIG, MIG, Flux-Cored

## Product Number

K652-1, K652-2

*See back for complete specs*

## Extraction Capacity

Low Speed: 55 CFM  
High Speed: 115 CFM

## Weight/Dimensions (H x W x D)

37 lbs. (17 kg)  
13.4 x 26.8 x 15.8 in.  
(340 x 680 x 400 mm)

## 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.

### 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.**



*Shown with optional K639-5 Suction Nozzle*

### WHAT'S INCLUDED

#### Base Unit Includes:

- ▶ 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.

### INPUT



### 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

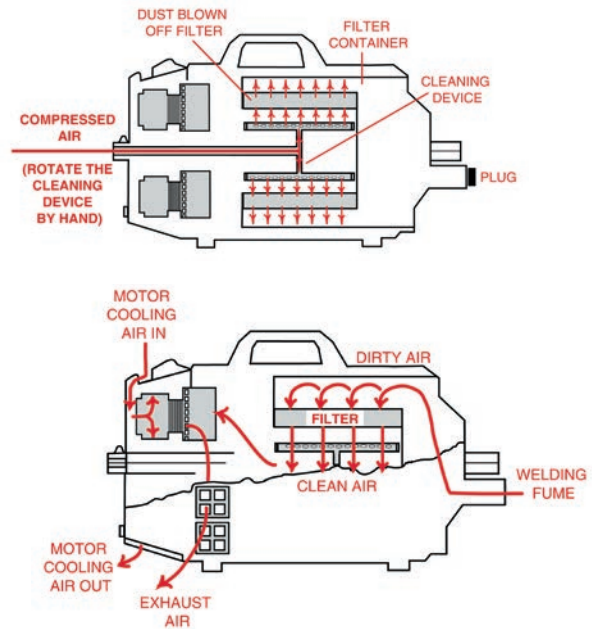
The X-Tractor® 1GC has a unique internal manual cleaning system. Using a customer supplied compressed air source and manual rotation, the internal rotary air jet device supplies a burst of air from inside the filter cartridges. This in turn causes the particulate that has collected on the outside of 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.



Cable Sensor



## 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**



#### 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**



#### 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**



#### 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**



#### 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**



#### 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.

**Order K2389-8**

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

**Order K2389-9**

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



#### 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**



NKT  
K2389-3



NKC  
K2389-4

#### Nozzle Kits

The NKT and NKC nozzle kits provide 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.

**Order K2389-3 for NKT**

**Order K2389-4 for NKC**



#### 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**



#### Fume Guns

Designed for MIG, Metal-Cored and Gas-Shielded Flux-Cored welding, these lightweight flexible fume extraction welding guns are ideal for any shop welding application. Select the 250FG model for lower amperage welding applications, the 340FG model for mid-range applications and the 500FG water-cooled model for higher amperage welding applications.

**Order:**

**M20909-1 for X-Tractor® 250FG**

**M20909-2 for X-Tractor® 340FG**

**M20909-3 for X-Tractor® 500FG**

## 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		



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.