X-TRACTOR® 1GC
FUMES DON’T STAND A CHANCE

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 extraction and filtration
» Easily disassemble the unit for cleaning and maintenance
» Maximum extraction distance of 33 ft. (10 m)
» Quiet operation

Processes »
Stick, TIG, MIG, Flux-Cored

Input »
1 PHASE 50/60 Hz

Product Number »
K652-1 Base Model, 120V
K652-2 Base Model, 220V
K4260-4 X-Tractor® 1GC One-Pak®
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 @ 3.3 ft. (1 m)

» **1-Year Warranty**

WHAT’S INCLUDED

Base Unit (K652-1)

» Adapter for 1-3/4 in. (45 mm) hose (S20591-8)

» 16 ft. (5 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 in. 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 in. 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 (33 ft. [10 m] maximum distance; contact Lincoln Electric for longer lengths). 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

The X-Tractor® 1GC comes with a built-in automatic start/stop sensor for reduced energy consumption and non-continuous operating noise. To take advantage of this feature, the welding power source’s work cable or power cable must be laid in the sensor hook.

When the welding arc starts, the current flowing through the cable creates a magnetic field. The current sensor mounted in the X-Tractor® 1GC behind the loop will sense this field and turn on the machine. Approximately 10 seconds after the welding arc is extinguished the unit will switch off.
HOSES

<table>
<thead>
<tr>
<th>HOSE TO HOSE CONNECTOR</th>
<th>1 in. Dia.</th>
<th>1-3/4 in. Dia.</th>
<th>3 in. Dia.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Product Number Included Adapters</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Dia. (ID), in. (mm)</td>
<td>Length, ft. (m)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1 (25)</td>
<td>8 (2.5)</td>
<td>K4111-8</td>
<td>—</td>
</tr>
<tr>
<td>1 (25)</td>
<td>25 (7.6)</td>
<td>K4111-25</td>
<td>—</td>
</tr>
<tr>
<td>1-3/4 (45)</td>
<td>8 (2.5)</td>
<td>K4113-8</td>
<td>—</td>
</tr>
<tr>
<td>1-3/4 (45)</td>
<td>25 (7.6)</td>
<td>K4113-25</td>
<td>—</td>
</tr>
</tbody>
</table>

HOW TO CONNECT A 1-3/4 IN. DIAMETER HOSE TO HIGH VACUUM EQUIPMENT

<table>
<thead>
<tr>
<th>Connect K4113-8 and K4113-25 To:</th>
<th>Tube Size, in. (mm)</th>
<th>USE THIS ADAPTER TO CONNECT 1-3/4 DIA. HOSE</th>
</tr>
</thead>
<tbody>
<tr>
<td>Inlet of X-Tractor 1GC</td>
<td>2 (50)</td>
<td>K3492-4</td>
</tr>
<tr>
<td>K639-1, -4, -5, -6 Suction Nozzles</td>
<td>1-1/2 (38)</td>
<td>K3492-2</td>
</tr>
<tr>
<td>EN-20 and EN-40 Nozzles</td>
<td>1-3/4 (45)</td>
<td>K3492-3</td>
</tr>
<tr>
<td>Magnum® Pro Fume Extraction Guns</td>
<td>2 (50)</td>
<td>K3492-4</td>
</tr>
<tr>
<td>Magnum® 250XA, 400XA Fume Extraction Guns</td>
<td>2 (50)</td>
<td>K3492-4</td>
</tr>
<tr>
<td>K206, K289 FCAW-SS Fume Extraction Guns</td>
<td>1-1/4 (32)</td>
<td>S20591-6(2)</td>
</tr>
</tbody>
</table>

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 K3299-5

SHFA Flat Suction Nozzle
150 mm (6 in.) aluminum suction nozzle with 20 in. (500 mm) flexible steel hose and magnetic mounting. Includes 20591-7 adapter for 1-3/4 in. (45 mm) hose. Best capture distance: <4 in. (100 mm).

Order K639-5

SHM Aluminum Suction Nozzle
Includes 20591-7 adapter for 1 3/4 in. (45 mm) hose. Best capture distance: 1-1/2 in. (38 mm).

Order K639-1

SHMS-400 Low Noise Nozzle
16 in. (400 mm) aluminum suction nozzle with magnetic mounting. Includes 20591-7 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 20591-7 adapter for 1-3/4 in. (45 mm) hose. Best capture distance: <4 in. (100 mm).

Order K639-6

NKT Nozzle Kit for MIG Guns
The NKT Nozzle Kit provides extraction capacity to a standard MIG welding gun. Nickel plated brass nozzle slips over the gun’s gas nozzle and secures with screw.

Kit includes:
1 – Nozzle
1 – Adapter, Hose to Tube, 1 to 1 in.
1 – Hose, 1 in. (ID), 8 ft.
1 – Connector, Hose-to-Hose, 1 1/2-1 3/4 in.

Order K2389-3

Extraction Hoses, 1 in. Diameter
Flexible high temperature hoses with spring steel reinforcement. Standard hose to connect the various extraction devices to the X-Tractor base units.

Order K4111-8 for 8 ft. (2.5 m) Length x 1 in. (D5 mm) Diameter (ID)
Order K4111-25 for 25 ft. (7.6 m) Length x 1 in. (D5 mm) Diameter (ID)

Extraction Hoses, 1-3/4 in. Diameter
Flexible high temperature hoses with spring steel reinforcement. Standard hose to connect the various extraction devices to the X-Tractor base units.

Order K4113-8 for 8 ft. (2.5 m) Length x 1 3/4 in. (45 mm) Diameter (ID)
Order K4113-25 for 25 ft. (7.6 m) Length x 1 3/4 in. (45 mm) Diameter (ID)
PRODUCT SPECIFICATIONS

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Product Number</th>
<th>Input Power Voltage / Phase / Hertz</th>
<th>Input Current</th>
<th>H x W x D inches (mm)</th>
<th>Net Wt. lbs. (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>X-Tractor® 1GC</td>
<td>K652-1</td>
<td>120V/15/50/60</td>
<td>15A</td>
<td>13.4 x 26.8 x 15.8</td>
<td>37</td>
</tr>
<tr>
<td>Base Model</td>
<td>K652-2</td>
<td>220V/15/50/60</td>
<td>9A</td>
<td>(340 x 680 x 400)</td>
<td>(17)</td>
</tr>
<tr>
<td>One-Pak® Pkg.</td>
<td>K4260-4</td>
<td>120V/15/50/60</td>
<td>15A</td>
<td>49</td>
<td>(22.2)</td>
</tr>
</tbody>
</table>

CUSTOMER ASSISTANCE POLICY

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.

The Lincoln Electric Company
22801 St. Clair Avenue • Cleveland, OH • 44117-1199 • U.S.A.
www.lincolnelectric.com