

# X-TRACTOR® 1GC

## FUMES DON'T STAND A CHANCE



Shown: X-Tractor® 1GC  
One-Pak® Pkg. [K4260-4]

### 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 »



#### 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.

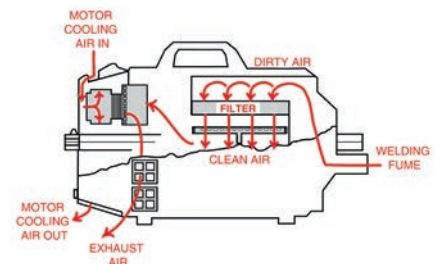
High vacuum welding fume extraction systems utilize higher pressure of 70-90 in. WG and low volume of 55-115 CFM with an air speed of 4000-5000 ft/min. The air handling configuration of high vacuum equipment allows the use of small diameter rigid duct and small diameter flex hose to easily reach extraction 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.

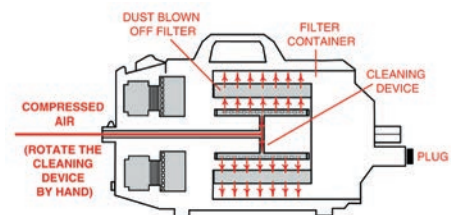
## FILTRATION PROCESS

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.

NORMAL OPERATION



CLEANING THE FILTER



## 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

HOSE		Product Number	Included Adapters	HOSE TO HOSE CONNECTOR		
Dia. (ID), in. (mm)	Length, ft. (m)			1 in. Dia.	1-3/4 in. Dia.	3 in. Dia.
1 (25)	8 (2.5)	K4111-8	—	—	K4115-3	—
1 (25)	25 (7.6)	K4111-25	—	—	K4115-3	—
1-3/4 (45)	8 (2.5)	K4113-8	—	K4115-3	K2389-10	—
1-3/4 (45)	25 (7.6)	K4113-25	—	K4115-3	K2389-10	—

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

Connect K4113-8 and K4113-25 To:	Tube Size, in. (mm)	USE THIS ADAPTER TO CONNECT 1-3/4 DIA. HOSE	
		Product Number	Former Product Number
Inlet of X-Tractor 1GC	2 (50)	K3492-4	S20591-8
K639-1, -4, -5, -6 Suction Nozzles <sup>(1)</sup>	1-1/2 (38)	K3492-2	S20591-7
EN-20 and EN-40 Nozzles <sup>(1)</sup>	1-3/4 (45)	K3492-3	S20591-17
Magnum® Pro Fume Extraction Guns	2 (50)	K3492-4	S20591-8
Magnum® 250XA, 400XA Fume Extraction Guns	2 (50)	K3492-4	S20591-8
K206, K289 FCAW-SS Fume Extraction Guns	1-1/4 (32)	S20591-6 <sup>(2)</sup>	—

<sup>(1)</sup> Adapter included with Nozzle

<sup>(2)</sup> Order using 9S prefix

## 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

#### 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

#### SHM Aluminum Suction Nozzle

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



#### 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 to 1-3/4 in.

Order K2389-3

NOTE: Gun not included, sold separately



#### Extraction Hoses, 1 in. Diameter

Flexible high temperature hoses with spring steel reinforcement.

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

Order K4111-25 for 25 ft. (7.6 m) Length x 1 in. (25 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)

## RECOMMENDED ACCESSORIES, CON'T.

### HOSE TO TUBE ADAPTERS



**Adapter, Hose to Tube, 1 to 1 in.**  
Use to connect a 1 in. diameter hose to a 1 in. diameter tube. The gun-mounted nozzle in the NKT Nozzle Kit (K2389-3) has this tube size.  
**Order K3492-1**



**Adapter, Hose to Tube, 1-3/4 to 1-1/2 in.**  
Use to connect a 1-3/4 in. diameter hose to a 1-1/2 in. diameter tube. The various suction nozzles have this tube size and include this adapter.  
**Order K3492-2**



**Adapter, Hose to Tube, 1-3/4 to 1-3/4 in.**  
Use to connect a 1-3/4 in. diameter hose to a 1-3/4 in. diameter tube. The EN 20 Nozzle (K2389-5) has this tube size and includes this adapter. The inlet tube of the Miniflex® is also this size.  
**Order K3492-3**



**Adapter, Hose to Tube, 1-3/4 to 2 in.**  
Use to connect a 1-3/4 in. diameter hose to a 2 in. diameter tube. The X-Tractor® 1GC and the side inlets of the VV-50 valve have this tube size.  
**Order K3492-4**

### HOSE TO HOSE CONNECTORS



**Connector, Hose to Hose, 1 to 1-3/4 in.**  
Use to connect a 1 in. diameter hose to a 1-3/4 in. diameter hose. This connector is included in the NKT Nozzle Kit (K2389-3).  
**Order K4115-3**



**Connector, Hose to Hose, 1-3/4 to 1-3/4 in.**  
Use to connect a 1-3/4 in. diameter hose to another 1-3/4 in. diameter hose.  
**Order K2389-10**

### REPLACEMENT FILTERS



**Filter, X-Tractor 1GC & 3A**  
**Order KP2069-1**

## PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power Voltage / Phase / Hertz	Input Current	H x W x D inches (mm)	Net Wt. lbs. (kg)
X-Tractor® 1GC Base Model	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		
One-Pak® Pkg.	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.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.com](http://www.lincolnelectric.com) for any updated information.

The Lincoln Electric Company  
22801 St. Clair Avenue · Cleveland, OH · 44117-1199 · U.S.A.

[www.lincolnelectric.com](http://www.lincolnelectric.com)