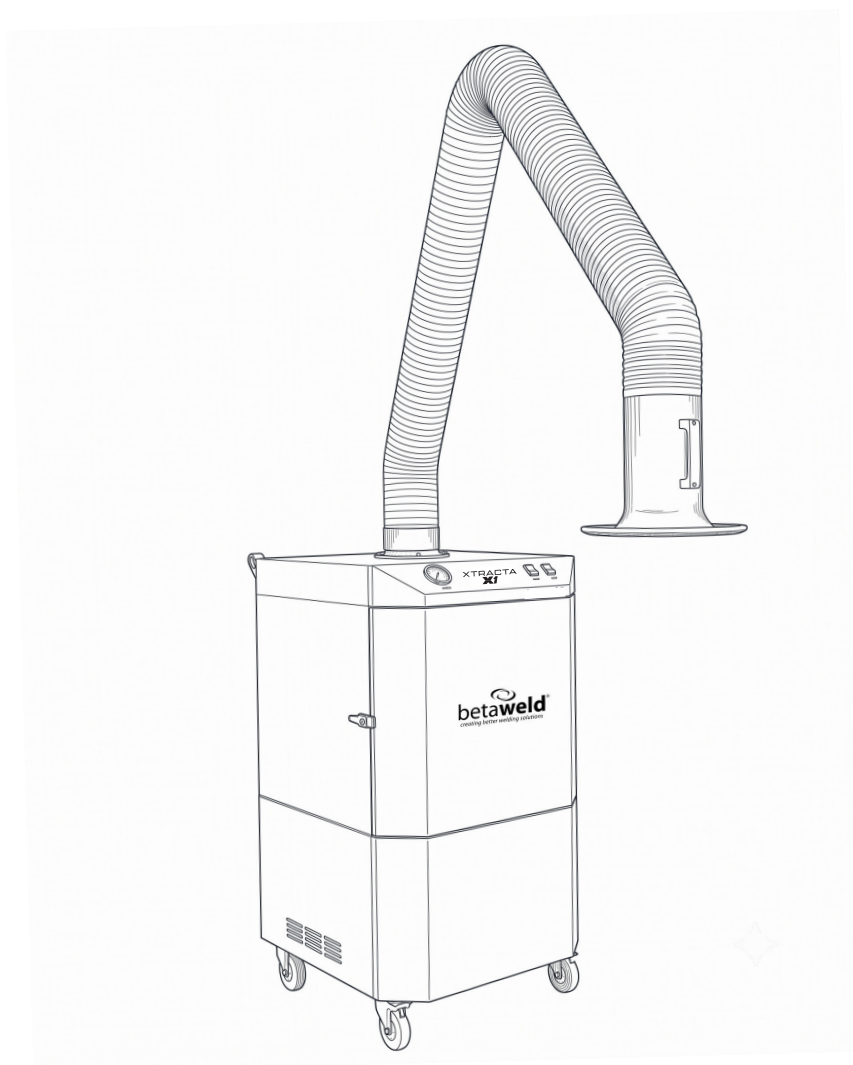




OPERATING INSTRUCTIONS



XTRACTA X1

**MOBILE WELDING FUME EXTRACTION
UNIT WITH CARTRIDGE CLEANABLE FILTER**

VERSION
V1 | 01.10.2026

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IMPORTANT WARNING! **APPLICATION AND USAGE RESTRICTIONS**

These products are designed exclusively for use with dry dust and fume extraction. Do not use the product in the following applications: polishing operations combined with grinding; welding or any other spark-generating processes (polishing fibres or abrasive flap discs are highly flammable and pose a serious fire risk — filters may ignite upon exposure to sparks); aluminium laser cutting; heavy welding fumes; arc-air gouging; extraction of aggressive fumes and gases (e.g., vapors from acids, alkalis, or solder paste containing lithium); high-temperature gas removal; grinding of aluminium and magnesium; flame spraying; cement dust extraction; sawdust, wood dust, etc.; cigarettes, cigars, oily tissues, and other burning materials, particles, objects, or acids; explosive environments or explosive materials/gases.

SAFETY PRECAUTIONS

Be Sure To Follow All Safety Rules In This User Manual

Explanation Of Safety Informations

- Safety symbols found in the manual are used to identify potential hazards.
- When any one of the safety symbols are seen in this manual, it must be understood that there is a risk of injury and the following instructions should be read carefully to avoid potential hazards.
- During operation of the welding fume extraction systems, keep third parties other than the operators, especially children, away from the working area.

Comprehending Safety Precautions

- Read the user manual, the label on the machine and the safety instructions carefully.
- Make sure that the warning labels on the machine are in good condition. Replace missing and damaged labels.
- Learn how to operate the machine, how to make the checks in a correct manner.
- Use your machine in suitable working environments.
- Improper changes made in your machine will negatively affect the safe operation and its longevity.
- Operate your machine in convenient working areas. Improper modifications that can be made on your machine affect the safety of your machine negatively and shorten its lifetime.

Electric Shocks Can Kill

Make certain that the installation procedures comply with national electrical standards and other relevant regulations, and ensure that the machine is installed by authorised persons.

- Installation procedure must comply with national electricity standards and other relevant regulations and ensure that installation is performed by qualified persons.
- Wear dry insulating gloves free of damage and body protection.
- If damage is detected on any of the cables of the machine, please contact the authorised persons and disconnect the power supply cable from the electrical outlet.
- The unit is manufactured according to CE security standards.
- Turn off the machine, when not in use.
- Disconnect the power connections and/or plugs or turn off the machine before repairing the unit.
- Be careful while working with a long input power cord.
- Frequently inspect all the cables against damages. Repair or replace the damaged or uninsulated cables immediately if damaged.
- Make sure that the electric line is properly grounded.

Welding Wires Can Cause Injuries

- During the closing and positioning of the flex arm, avoid impacts and limb entrapment, as this may cause serious injuries and loss of limbs.
- During adjustment of the flex arms, use suitable gloves and an appropriate wrench. Do not disassemble the springs attached to the arms as they may cause injury.
- Failure to make the motion adjustments of the flex arms correctly may cause the machine to overturn and this may cause serious injuries.
- Keep all the protectors such as covers, panels, doors, etc. of the machines and devices close and locked.

Maintenance Done By Unauthorised Persons On The Machines And Apparatus May Cause Injuries

- Electrical equipment should not be repaired by unauthorised persons. Failure to do so may result in serious injuries or death.
- Serious malfunctions and fire may occur and the users can be seriously injured as a result of the services provided by unauthorised people regarding the smoke, dust, odor absorption and filtration systems.

Falling Parts May Cause Injuries

- Incorrect positioning of the smoke, dust, odor absorption and filtration systems and other equipment may cause serious injuries for people or may damage objects.
- Always use the handles when relocating the filtration system. Never pull from the cables or the flex arms.
- Before carrying the smoke, dust, odor absorption and filtration systems, unscrew all the interconnections, lift and carry the small ones from their handles and the large ones from their carriage rings or by using appropriate lifting equipment, such as forklifts.
- Install your machine on flat platforms having maximum 8-10° slope ensuring it does not fall over and overturn. Choose areas where there will be no risk of tripping over cables, flex arms and hoses and preventing the exit of the air absorbed. In order to restrict the movement of the mobile system, lock the front wheels.
- Ensure that operators can easily access the settings and connections on the machine.
- Observe the warning lights on the control panel and follow the instruction manual.

Overuse Can Cause Overheating Of The Machine

- Allow the machine to cool according to the operating cycle rates.
- Observe the coarse filter and main filter operating hours and replace them when due.
- Do not block the filtered air outlet of the machine.
- Do not place filters in the ventilation openings of the machine without the manufacturer's approval.

Power Supply Failure

- The energy supply or fluctuations in the power supply after any interruption or interruption in the power supply to the machine can cause a hazardous situation.
- Machines should not start unexpectedly.
- The parameters of the machines should not be changed if such a change may lead to a dangerous situation.
- No moving parts of the machine or any parts held by the machine should fall or dislodge.
- Automatic or manual stopping of moving parts in any way is prohibited.
- The protective devices must remain fully active or issue a stop command.

Protection

- Do not expose the machine to rain, avoid splashing water or exposing to steam.
- Do not absorb flammable, explosive, heavy oil vapor, petroleum products, liquids. This may cause serious injury, death, fire, explosion, and major damage.

Energy Efficiency

- Turn off the machine when not in use.
- This will also extend the life of the filters.

TECHNICAL INFORMATION

1.1 General Information

Flexible absorbing flex arms are used to absorb the polluted air such as dust, smoke and fumes from the environment. The flex arms have a mechanical structure and the outside of this mechanical structure is equipped with a flexible and heat resistant hose. This hose is selected by calculating the air flow to be absorbed. Flex absorbing arms are manufactured as 3m.

These arms are used with Betaweld XTRACTA X Series models. They can also be combined with wall equipment and can be used in central systems. In this case, they can also be combined with local ventilation systems in order to increase performance. During welding, fumes and particles are captured by the hood and sent to the suction unit that is connected via the hose. The suction can be adjusted with the adjustable valve in the hood, that is independent from the suction of system.

WARNING

Improper use may cause dust and smoke not to be absorbed correctly. The suction arm must be assembled on the filter unit before use. Approximate the suction arm as close as possible to a distance of ~35cm where the smoke occurs.

KEEP THIS USER MANUAL SAFELY STORED.

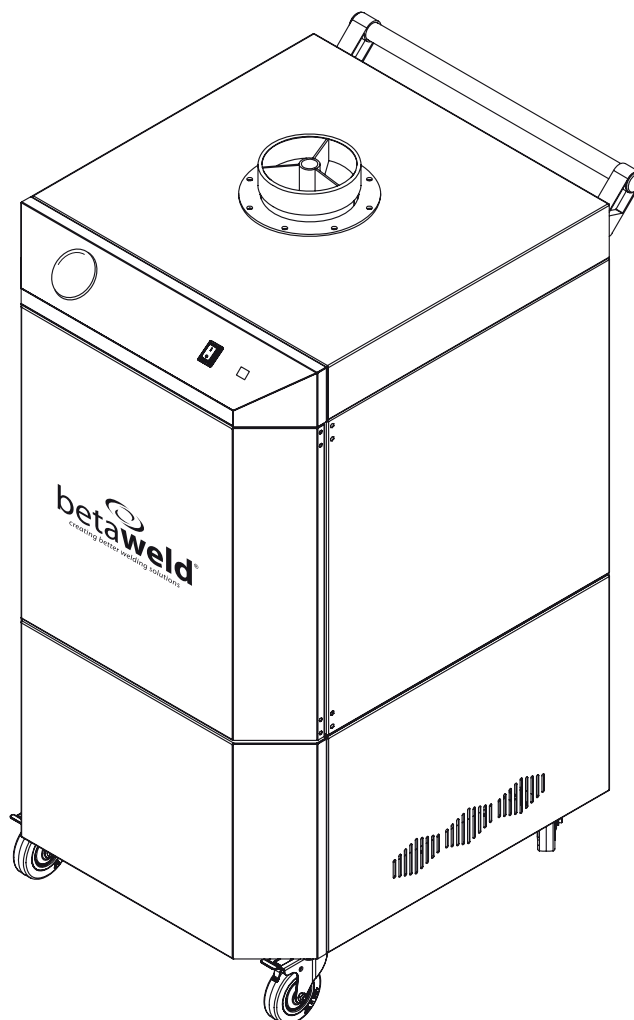


Figure 1 : XTRACTA X1 Isometric View
Single Acrobat Arm Version

1.2 Product Label

 creating better welding solutions 					
Art Name: XTRACTA X1	Serial Number:				
EN ISO 12100 / EN 61000-6-2 / EN 61000-6-4 / EN 60335-1 / EN 60335-2					
 1~N/50-60Hz	<table><tr><th>Voltage</th><th>Power</th></tr><tr><td>240V</td><td>1.5kW</td></tr></table>	Voltage	Power	240V	1.5kW
Voltage	Power				
240V	1.5kW				
betaweld.com.au					

1.3 Technical Details

SPECIFICATIONS	XTRACTA X1
Mains Voltage	240V
Mains Frequency	50 / 60Hz
Motor Output	1.5kW
Nominal Current	4A
Air Suction Rate Maximum	3000 m³/h
Depression Value Maximum	2000 Pa
Command Voltage	24 V/AC
Protection	IP X0
ISO	F
Weight	122kg
Filter Members	Cartridge Filter (2 Piece)
Purification Performance	> 99%
Noise Level	72db
Ambient	0 - 40C
Atmosphere	Maximum 72%

INSTALLATION

2.1 Structure of the Flex Arm

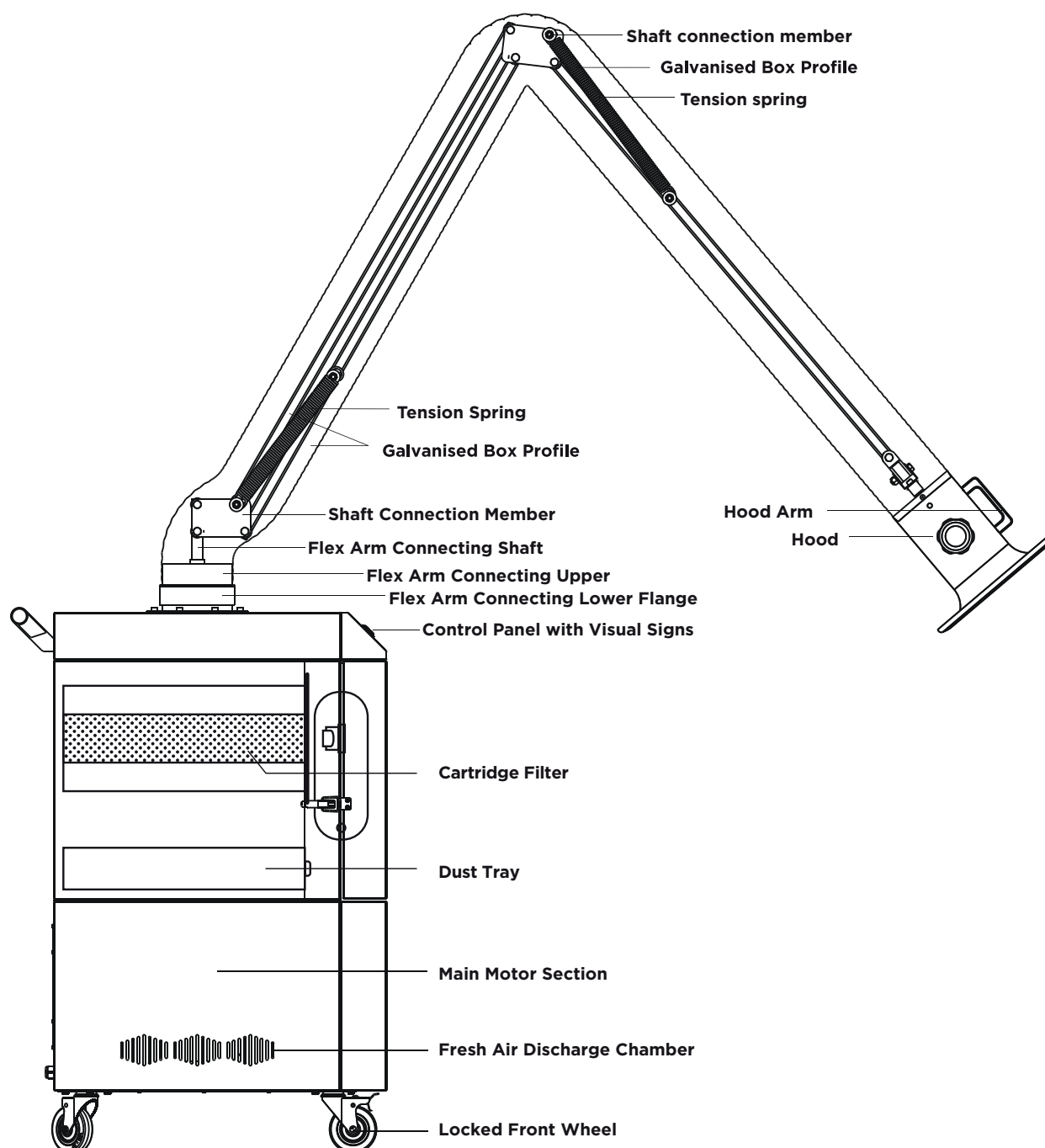


Figure 2: Structure of Mobile Units and Inner Structure of The Flexible Arm

2.2 Assembly of the Flex Arm



BETAWELD® XTRACTA X Series fume extraction flex arms and hoods are delivered in disassembled form in separate boxes. Assembly is to be performed by the user and the assembly sequence is as follows.

Open the package of the main unit and unload the unit from the wooden pallet. Unload the unit from the top of the pallet with a crane, forklift or with at least two people. Lock the front wheels. Do not connect the power cord to an electrical outlet without mounting the flex suction arm. Assemble the flex suction arm.

Open the box of the flex arm and remove the lower flange and the rubber seal on which the arm is to be installed, that is assembled on the main unit with 8 allen screws, and assemble it in the exhaust hole on the top of the unit as shown in the figure below. Then remove the flex arm out of the box and insert the shaft of the flex arm into the bottom flange that is assembled before. Close the gap between the two flanges with the rubber insulator that is located on the upper flange. Then, open the cover of the filters area of the unit and remove all filters. In the next step, insert the set screw into the M8 run hole that is under the shaft of the flex arm that was previously fitted. This screw will prevent the flex arm to dislocate. Re-insert all the filters, as shown in this user manual, and lock the cover of the filter.



All the movement settings of the flex arm are adjusted as to move in the most comfortable position and stand in any position. Depending on the frequency of motion, you may need to make very little adjustment over time. Apply as specified in this user manual.

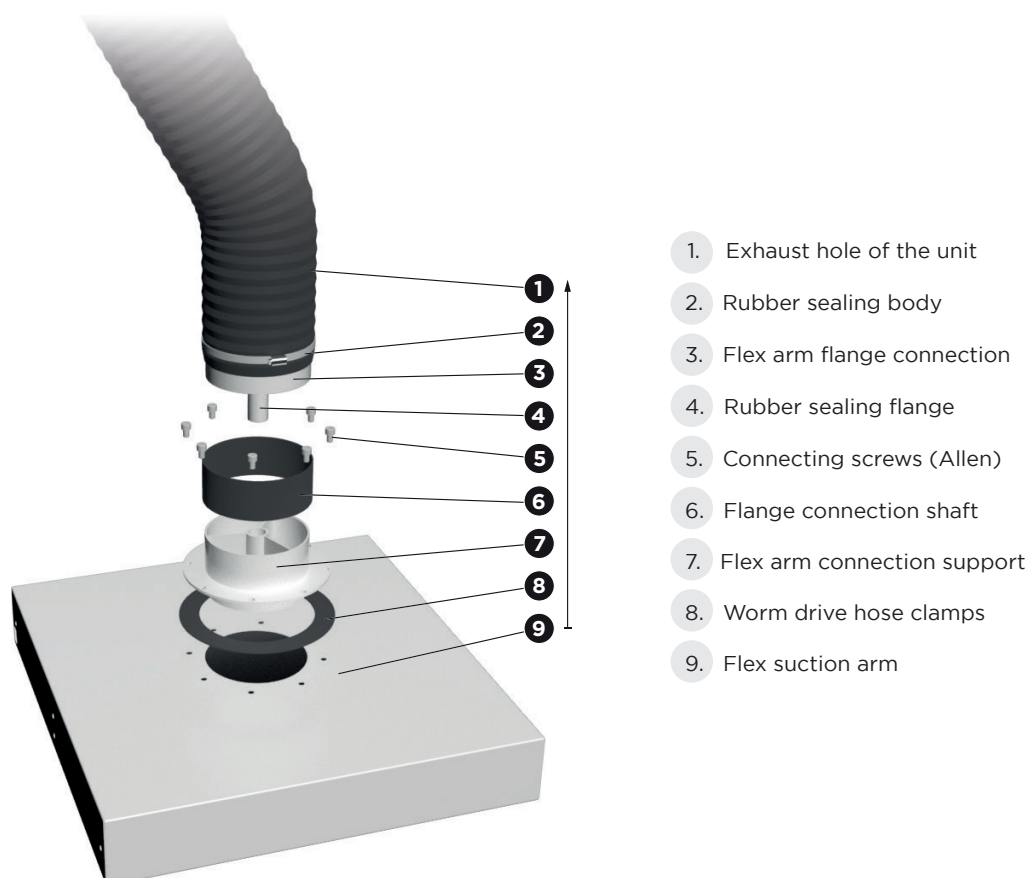


Figure 3: Assembly and Connections Details for Mobile Units

2.3 Assembly of the Suction Hood

Remove the hood from the box and assemble it with two special washers and a M12 / 45 wrench head bolt found inside the box to the end of the flex arm as shown in user manual.

Then, by using the open-end wrench, tighten the adjusting nut at the requested sensitivity and place the flexible hose on the flex arm over the hood.

Finally, place the flexible rubber insulator to seal between the hose and the hood.

Hood will be ready to use.

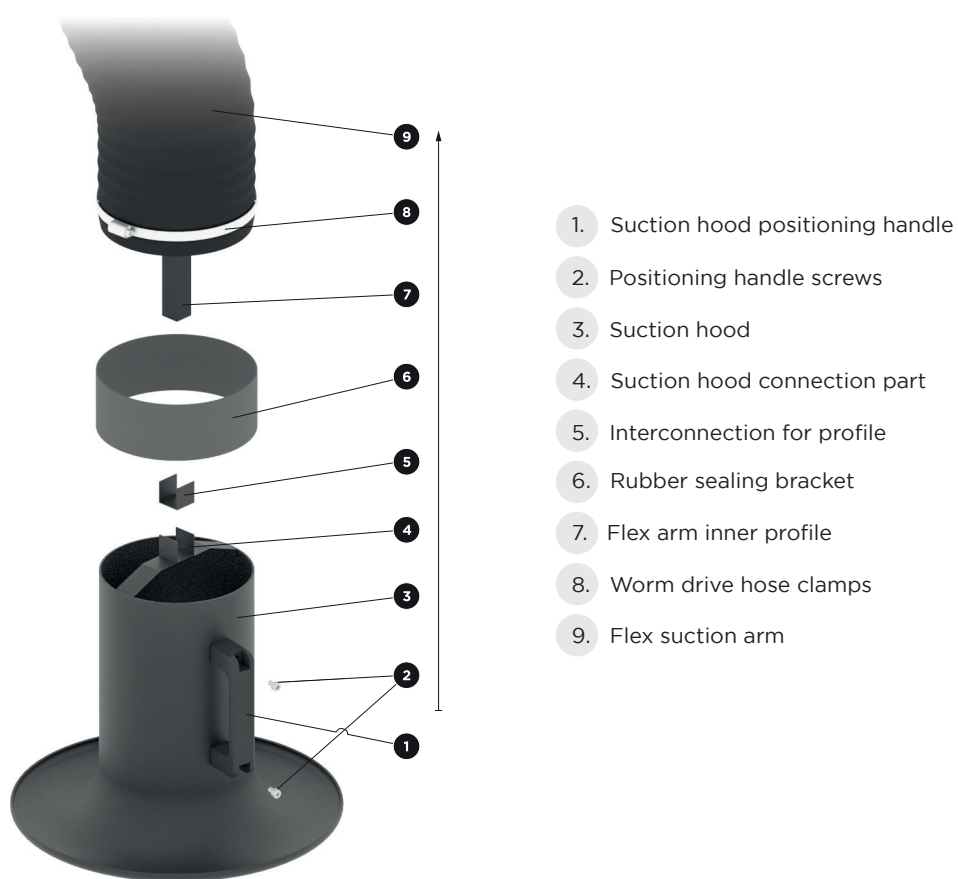


Figure 4: Suction Hood Connection Details

2.4 Implementation of the Unit

- Connect the 240V 10A round, spring-loaded, capped, single-phase socket on the device to a suitable outlet and make sure that the entire unit is complete as described in the user manual.
- Switch the unit on by the On-Off button.
- Control the “Motor-Incorrect Rotation Direction” red lamp on the control panel. If the red lamp illuminates, this indicates the suction motor is reversed and the suction is too weak. In this case, change the place of 2 phases through the three-phase electrical plug. This must be done by a qualified electrician.
- After the displacement of the phases, the suction motor will rotate in the correct direction and strong suction will start and the red warning light will go out. Your unit is ready to use.
- The Filter Indicator Gauge on the control panel will fall in the Green Zone. This indicates that the filter is not full.
- When the filter is full, the Filter Indicator Gauge will fall in the Red Zone. In this case, change the main filter immediately.



Use only BETAWELD® branded filters, because XTRACTA X Series fume extraction units are designed to use the filters in the most efficient and effective way. Our filters are Eurovent certified.

2.5 Control Panel Graphics

1. Start - Stop Switch

(Lights up when the unit is turned on)

2. Wrong Rotation

(Lights up to the Red when the electricity connections are wrong)

3. Filter Indicator Gauge

■ -Filter Good (Green zone)

■ -Filter Needs Attention (Yellow zone)

■ -Filter Needs to Change (Red zone)

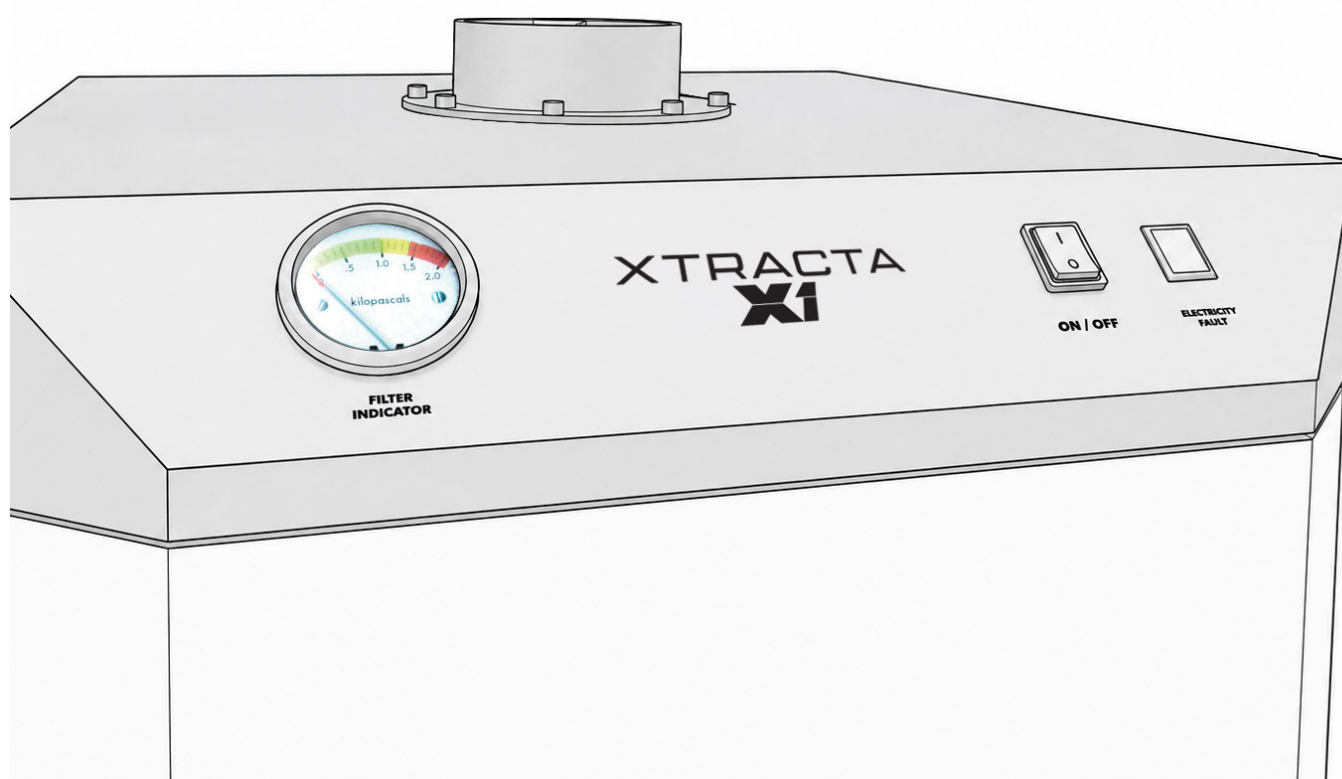


Figure 5: XTRACTA X Series Control Panel

 OPERATION

3.1 Filter Life

After a certain period of operation, the filters must be replaced. This is related to the amount of dust, gas and fume collection. However, if the filter change signal (3) is received, the filter should be immediately replaced. Depending on the application, filter exchange may also be required earlier.

Recommended replacement intervals are as follows:



NEVER OPERATE THE MACHINE WHEN THE FILTER COVERS ARE OPEN AND ELECTRICITY IS CONNECTED!!

FILTER MEMBER	CHANGING PERIOD
Cartridge Filter (2 piece)	650 hrs



NOTE: All filters are non-reusable. Manual cleaning may eliminate the filter characteristic. Contaminants can pose a threat for your health by penetrating into the air.

3.2 Maintenance and Annual Controls for Filters

1. Always comply with the applicable safety rules during maintenance and repair. The power supply must be disconnected from the mains before any maintenance or repair work.
 2. **Once Every 3 Months.** Clean the labels on the device. Repair and/or replace worn, and torn labels. Maintain broken, ruptured, worn cables and cords; if required, replace with new ones. Clean and tighten moving parts.
 3. **Once Every 6 Months.** Open the filters and clean drawers of the machine with dry air.
-

3.3 Filter Disposal

The operator of the Fume Extraction System is responsible for the safe disposal of the filters in accordance with state and local regulations.

Responsibility for the safe disposal of expired filters is also the responsibility of the operator.

3.4 Cleaning or Changing the Filters

1. Before cleaning the Cartridge Filters, turn off the unit with the on-off switch and pull out the mains plug.
2. When cleaning the filters, use gloves and a dust mask.
3. Open housing cover.
4. First, check inside for dust build up.
5. If the Cartridge Filters need changing (look at the Filter Indicator Gauge on the control panel), place them into a special ziplock bag and isolate for disposal.
6. If routine control and cleaning is to be performed, gently clean the inside of the unit cover and general areas using a low pressure air gun.
7. To clean cartridge filters, blow higher pressure air from the inside of the filters outwards.
8. Once the compressed air cleaning operations are completed, remove the dust waste drawer and dispose of it appropriately.
9. Lock the filter housing cover and the unit is ready to operate again.
10. If the filter clogged light is on replace filter immediately with a new one.

MAINTENANCE AND SERVICE

4.1 Troubleshooting



NOTE: If any damage happens on Flex Arm, please contact Betaweld for support.

4.2 Flex Arm Faults

FAULT	REASON OF THE FAULT	ACTIONS TO BE TAKEN
Flex arm cannot be fixed	Nuts have loosened at the hinges	Slightly tighten the fibre nut of the plate on the hinge
Flex arm extra hard to move	Nuts of the hinge plates are extra tightened	Slightly loosen the fibre nut
Flex arm falls down	It is out of adjustment	Adjust the screw adjustment locations on the fallen joint so that the arm will be on its previous position
Flex arm very difficult to move	Arm settings are not calibrated	Adjustment screws are over tightened
Motion of the hood cannot be controlled	Control the nut on the hinge	Tighten the nut
Suction hose is ruptured	Replace the hose	Do not operate with a faulty hose. Suction performance will decrease
	Valve of the hood is closed	Open the valve
	Rubbers at the joint are slipped	Adjust the rubbers in order to obtain a proper seal
	There is a contraction in the suction pipe	Check the suction arms, pipes, joints and hoses



NOTE: For any other malfunctions that may occur, please contact Betaweld for support.

4.3 Extraction Unit Faults

FAULT	REASON OF THE FAULT	ACTIONS TO BE TAKEN
Unit does not suck	Suction hose is not connected	Connect the suction hose
	Suction hose is out of order	Replace the suction hose
	Suction nozzle is obstructed	Control the suction channel, if required, repair the problem
	Fresh air output is closed	Control the fresh air flow, if required, repair the problem
Suction is low	Filter has reached the saturation point	Replace the filter. Apply the changes and the destruction process according to regulations
	Suction hose is out of order	Replace the suction hose
	Suction hose or suction arm is not properly connected	Make sure that the suction hose or suction arm is properly secured
	Motor is rotating in reverse direction	Control the return direction and the phase and change
	Fresh air output became contracted	Control the fresh air output, if required, repair the problem
	Suction channel is contracted	Control the fresh air output, if required, repair the problem
System does not activate	Malfunction indicator lamp illuminates	Replace the filter. Apply the changes and the destruction process according to regulations
	There is no electricity in the mains	Control the fresh air output, if required, repair the problem

4.4 Filtering System Maintenance Checklist

ITEM TO BE CHECKED	CHECKING TIME	MAINTENANCE TYPE	RESPONSIBLE PERSONNEL	CHECK PERIOD
Checking for Holes, Cracks, Leakage	Before the machine is started	Check the unit for any holes, cracks, leaks. Check that there is no hole or tear in the suction hose.	User	Daily Control
Sound and Vibration Check	Each time the machine is started	Check that the unit is not making a different sound and vibrating. Check if the Filter Indicator Gauge is in the Green Zone.	User	Daily Control
Cartridge Filter Check	Each time the machine is started	Check if the Filter Indicator Gauge is in the Green Zone. If the Filter Indicator Gauge is in the Red Zone, the filter needs to be changed.	User	Daily Control
Fan Rotation Direction Control	Each time the machine is started	Check if the Wrong Rotation light is on or not. If the light is on (red), then the phases need to be checked again and must be connected correctly.	Authorised Person	Daily Control
Dust Waste Tray	Once per day	Clean the dust collection tray to dispose of dust waste under appropriate conditions.	User	Daily Control
Paint and Rust Control	Every month	Check if the paint is in good condition and whether there is rusting or not on the main unit.	User	Monthly Control
Power Feed Cable Check	Every month	Check if there are any damages on the power feed cable.	User	Monthly Control
Cartridge Filter Change	Once in every 650 hours	Cartridge filter should be changed with a new one.	User	Monthly Control
General Control	Once every 3 months	Operation and durability control of all functions of the device.	User	Every 3 months
Detailed Control	Annually	Operation and stability control of all functions of the device + Motor + Fan Check ups.	Authorised BETAWELD® Service (According to customer request)	Once during the year



To eliminate water accumulation caused by condensation in the air tank, open the drain valve located under the tank weekly and ensure that it remains dry.



5.1 Mobile Unit Dimensions

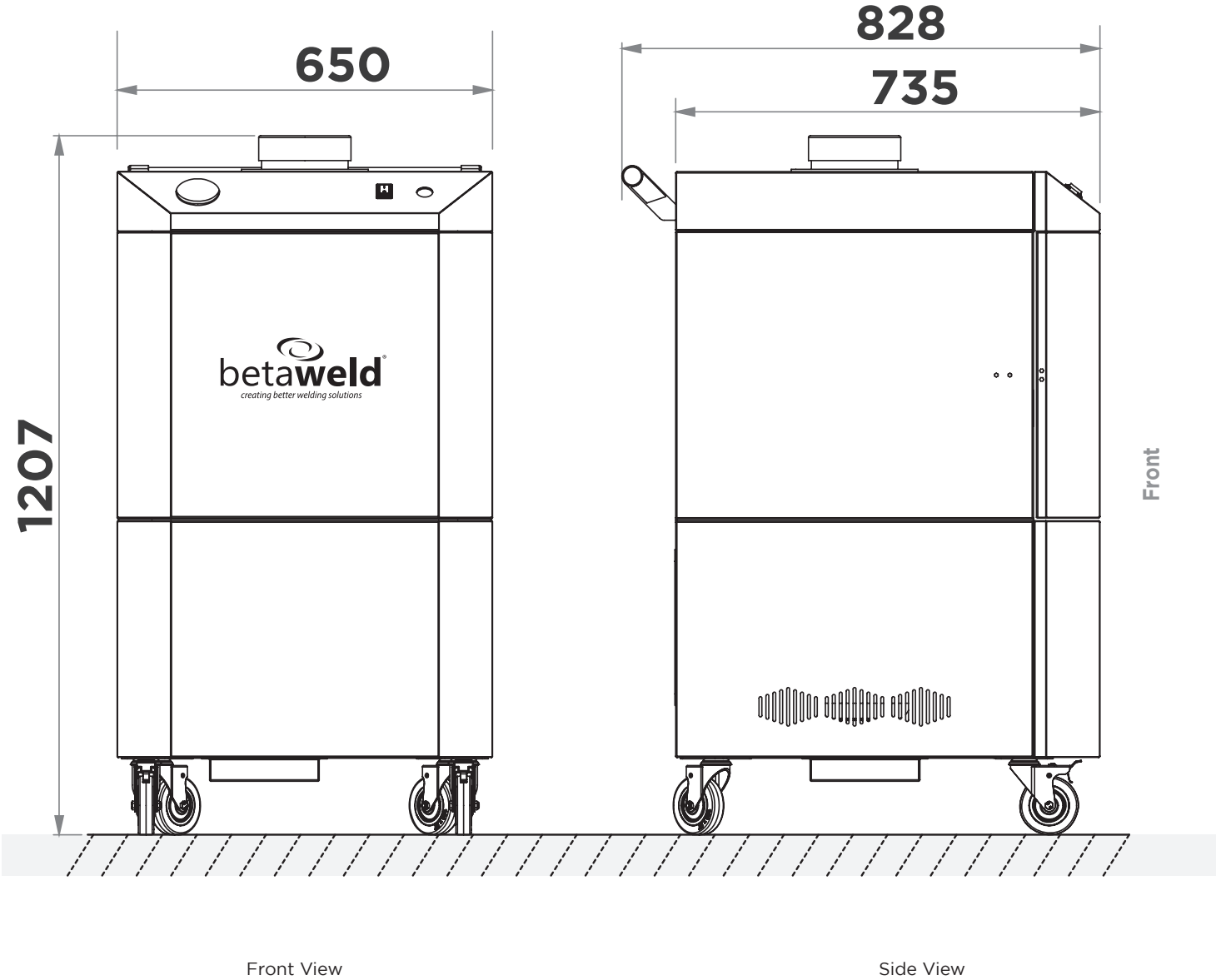


Figure 6: Dimensions for XTRACTA X Series Units

5.2 Unit Spare Parts

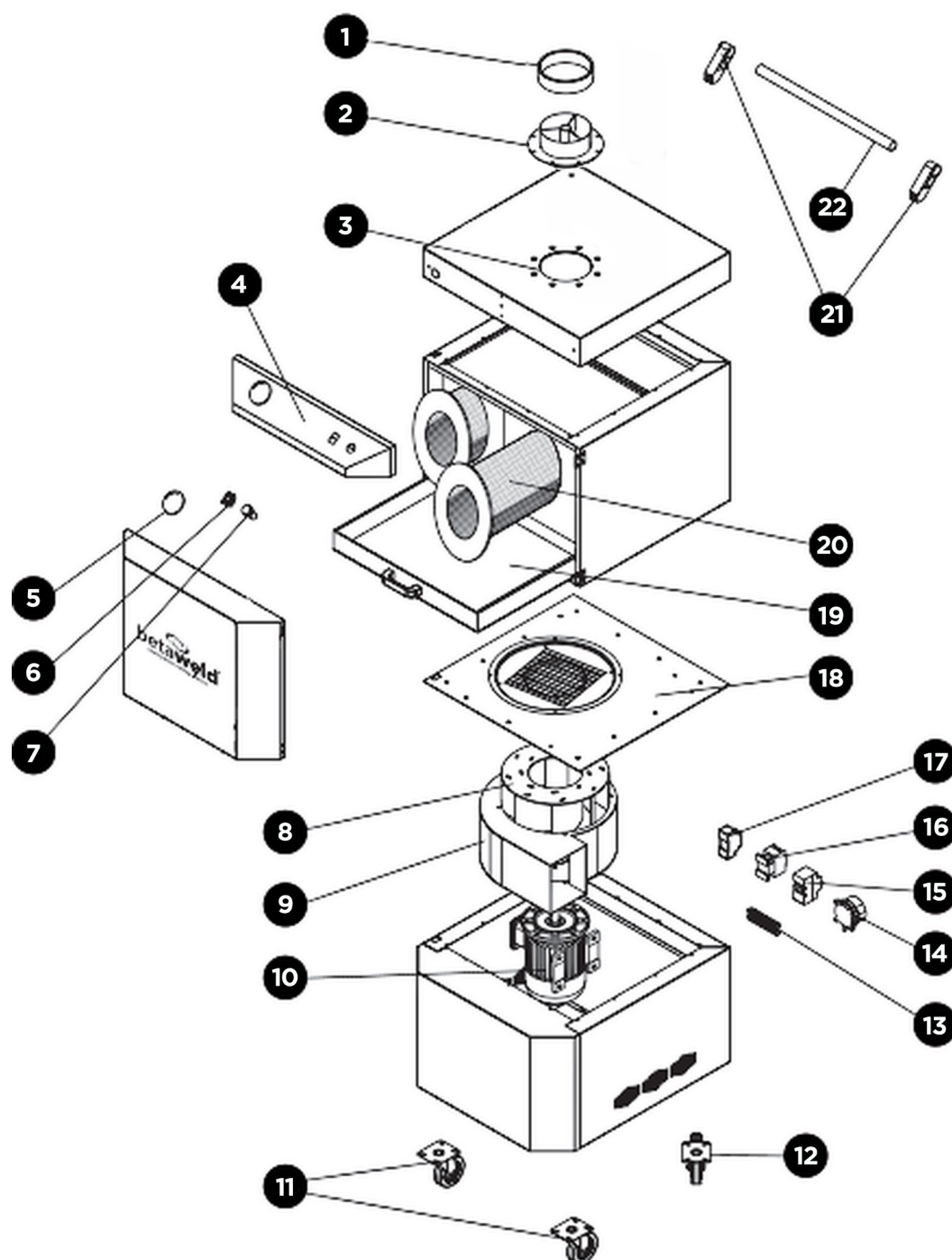


Figure 7: XTRACTA X1 Spare Parts

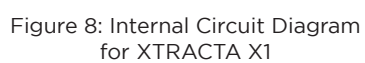
5.3 List of Unit Spare Parts X1

NO	PART CODE	DESCRIPTION	XTRACTA X1
1	6161	Tensioner Tire	✓
2	Refer to supplier	Top Flange Skirt	✓
3	Refer to supplier	Single Flex Arm Connection	✓
4	Refer to supplier	Control Unit Cover Part	✓
5	Refer to supplier	Filter Indicator Gauge	✓
6	Refer to supplier	On / Off Switch	✓
7	Refer to supplier	Wrong Rotation Signal (red)	✓
8	Refer to supplier	Snail Fan	✓
9	Refer to supplier	Snail Fan Air Cannal	✓
10	Refer to supplier	Induction Motor (1.5 kW)	✓
11	Refer to supplier	Swivel Wheel (rigid)	✓
12	Refer to supplier	Swivel Wheel (with lock brake)	✓
13	Refer to supplier	Phase Protection Relay	✓
14	Refer to supplier	Contactora	✓
15	Refer to supplier	Motor Protection Switch	✓
16	Refer to supplier	Pressure Difference Switch	✓
17	Refer to supplier	Terminal Block	✓
18	Refer to supplier	Motor Safety Part	✓
19	Refer to supplier	Dust Waste Tray	✓
20	6170	Main Cartridge Filters (2 pcs)	✓
21	Refer to supplier	Handle Slot	✓
22	Refer to supplier	Carry Handle	✓

Additional Spare Parts

PART CODE	DESCRIPTION	XTRACTA X1
6162	Internal Acrobatic Arm 3m	✓
6164	Hose 153mm (3.4m)	✓
6165	Hood Without Damper	✓
Refer to supplier	Flange Gasket	✓
Refer to supplier	Clamp	✓

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