



Legion Quick Start Guide

Bulletin #: V070826-01

Issue Date: July 8, 2026

Thank You for Purchasing an Orion Flex Stretch Wrapper!

Your new FLEX stretchwrapper was designed to get up and running quickly upon delivery. This guide will help you begin using your machine effectively by providing step by step instructions in the basic operations of the machine. More advanced capabilities are described in the manual. You can download the complete manual, electrical prints, and mechanical drawings at this location:

<https://www.orionpackaging.com/products/service-manuals/>



Unpacking

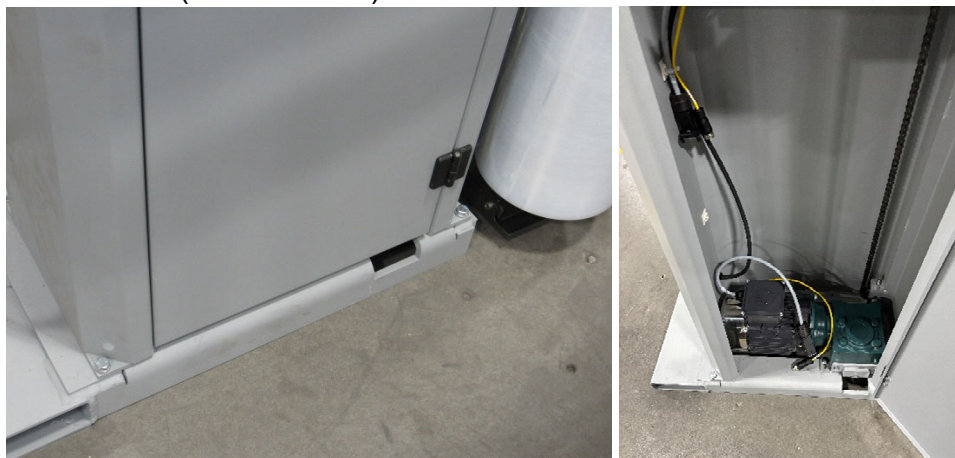
Machine can be easily unloaded and transported by a forklift with a minimum capacity of 2500 lbs. If your machine is a standard machine without options, proceed to the inspection section. See below for unpacking instructions for different options.

If your machine has the tower removed, you will need to follow this procedure to upright the tower prior to use:

WARNING Use caution when lifting the tower. Injury could occur.

1. If your model is a tall tower, the tower will be removed and skidded separately.
2. Use a secured strap attached to the eye bolt on top of the tower to pivot the tower, securely hold the tower upright. Bolt the tower to the base using the four provided 3/8"x1 1/4" bolts and lock washers. Make sure not to pinch any electrical connectors.

Illustration 1 - Tower to Base Bolts (2 of 4 shown)



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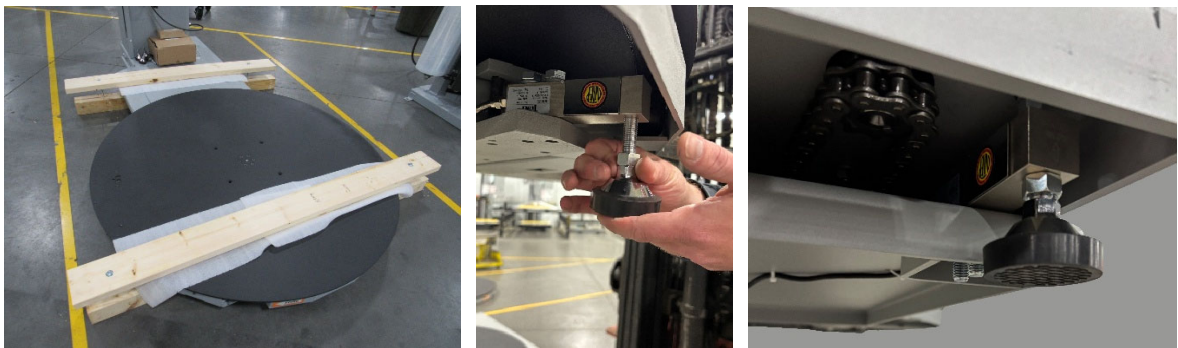
3. Connect the 2 quick disconnects for the electrical connections inside the tower.
4. Carefully insert the forks into the lifting pockets to the maximum possible depth.
The fork truck tine width may have to be adjusted.

Illustration 2 - Machine Lifting Fork Pockets



5. Lift the machine only to the necessary height to move it with no bouncing or friction on the floor.
6. If there is a scale package, then machine must be lifted from the fork pockets and shipping materials must be removed and scale legs installed.

Illustration 3 – Scale Package Shipping Materials and Scale Legs Installation



7. Sit the machine down assuring uniform contact with the floor, which is necessary to ensure correct and smooth operation.
8. If your machine has the optional ramp, set the ramp up next to the turntable. If it has the ramp option only, see the photo below. If it has the ramp and scale option, then the ramp does not attach directly to the machine.

Illustration 4 – Ramp Only Option Connection





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Inspection

1. Remove all packing and supporting additions.

Note: When removing the stretchwrap film covering the machine, care must be taken not to cut any of the electrical wires and/or polyurethane covering on the film carriage rollers.

2. Perform a visual inspection of the electrical and mechanical parts for loosened joints and/or broken connections. Any suspected shipping damage must be reported immediately to the freight carrier. Any transport damage cannot be claimed to Orion Packaging Inc.

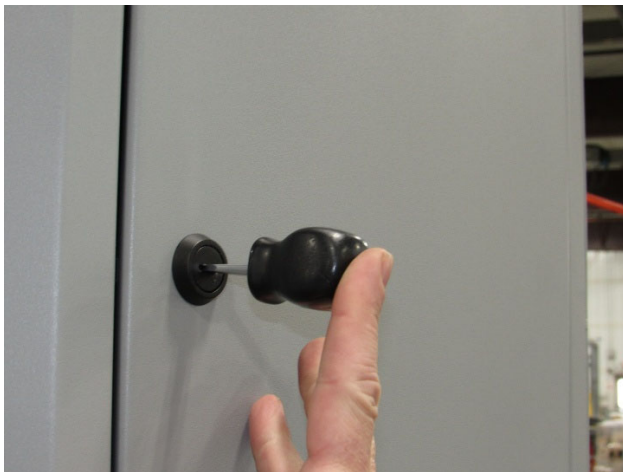
Items that are vulnerable to damage and must be inspected are as follows:

- Motors and gearboxes
- Junction boxes
- Electrical conduits
- Proximity and limit switches
- Photocells

3. Verify the following:

- Check wires and conduits for crushed sections or loose fittings.
- Verify the film carriage to be sure that it is correctly aligned with the tower
- Inspect the HMI screen for damage and ensure all push buttons are intact.
- Use a screwdriver to open the panel and motor access door.

Illustration 5 - Panel Access



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Machine Installation

Note: The structural frames of the machine have to be placed on a leveled floor. The base deviation from vertical must not exceed 1/4" on the distance of 10 feet (angle: 0 degrees 6').

1. Move the wrapper into its final position.
2. Verify the status of all assemblies before proceeding.

Connect Power

- Make sure the **MAIN DISCONNECT** switch on the wrapper's panel is set to the OFF position.
- Orion Packaging insists that a dedicated circuit is used for this wrapper. **Extension cords are not allowed** and can void your warranty.
- Plug the machine into the 115 VAC/ 60 Hz/ 1 Phase / 15 Amp outlet.

Power Up/Boot Up

- After verifying that the area around the machine is safe, you may apply power to the machine by turning the MAIN POWER switch to the ON position.
- Please allow 90 seconds before pressing any buttons to allow the program to boot up.
- Release the E-stop button, if pressed.
- Press and release the Start button once to gain Control Power.
- Initializing will display in the information banner momentarily.
- See jogging on the next page to begin testing your machine.



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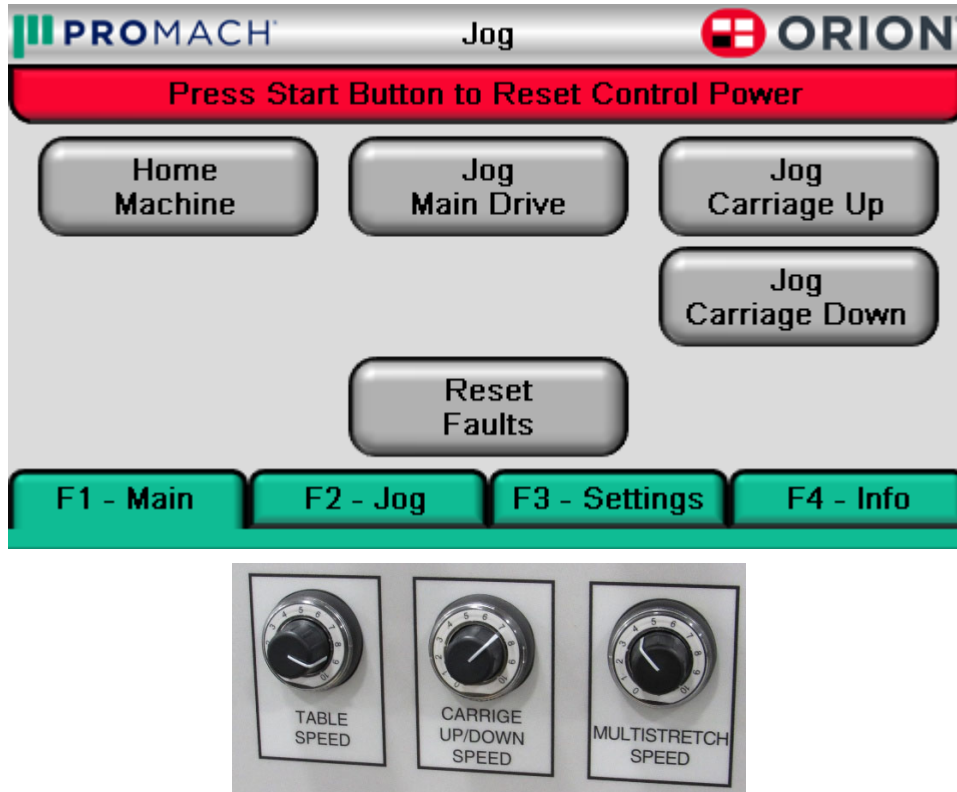
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Jogging

- Go to the Jog Tab. You can either press the tab or the function buttons below the HMI display to navigate to the screens.
- It's advisable to jog the machine prior to wrapping your first load to ensure components run smoothly and there are no mechanical binds caused by shipping.
 - Press and hold the Jog Main Drive button to jog the turntable. Allow it to travel about one full revolution, then release the button.
 - Press and hold the Jog Carriage Up button. Allow it to travel to the adjustable top limit on the mast, then release the button.
 - Rotate the Carriage Up/Down Speed panel potentiometer dial to change the speed of the carriage, in terms of percentage with a minimum of 0% and a maximum of 100%. The slower the move, the more film overlap on the load. **Note:** If the carriage speed potentiometer dial is adjusted to 0% the carriage will not move.
 - The turntable (Main Drive) speed and carriage multistretch speed also can be adjusted with the potentiometer dials.
 - Press the Home Machine button to bring the turntable and carriage back to the home position.

Illustration 6 – Jog Screen and Potentiometer Dials



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Set Up Load

- Carefully place the load to be wrapped on the turntable. Be sure the load is centered and stable.

Load the Film

- The film roll can be loaded on the carriage mandrel from either end of the roll. When using tackyfilm, please verify that the tacky surface of the film is inward on the load.
- Press the E-stop. (When an E-stop is pressed, the multistretch will not run and control power is lost.)
- Lift up on the top mandrel holding the film.
- Put the roll of film on the bottom mandrel.
- Install the top mandrel on top of the roll to secure roll on the carriage.
- Rotate the carriage door handle and pull out on the carriage door to open the carriage.

Illustration 7 – Threading the Film

Top Mandrel



- Pass the roped tail of the film through opening, following the diagram on the carriage cover.
- Lift the carriage door to the closed position and rotate the handle to lock the door.
- When the film feeding is completed, release the E-stop.
- Press the Start button once to reset control power.
- The system is now ready to begin the first wrapping cycle.

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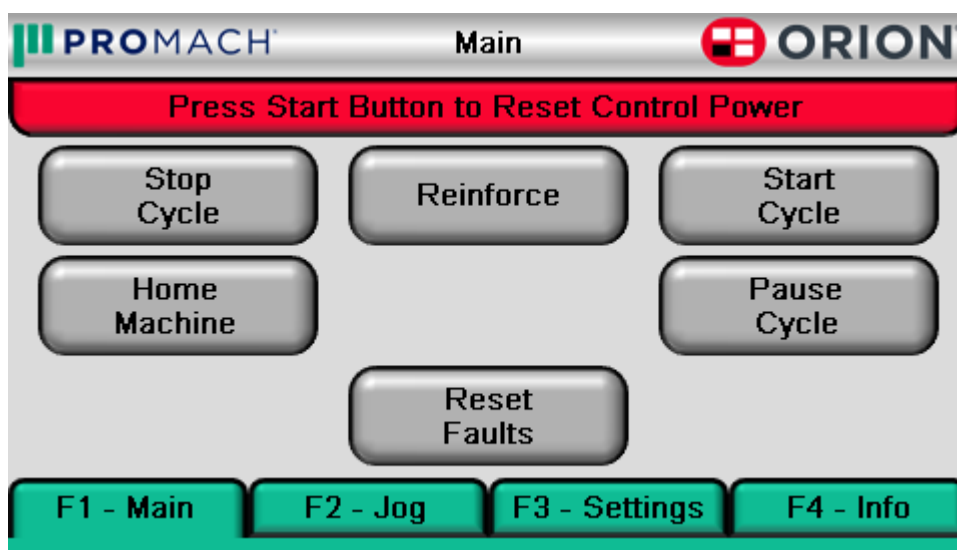
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Running a Test Load

Now that you have the machine unloaded, unpacked, powered up, have jogged all the components, and a load is ready to wrap; let's run a factory settings test wrap.

- Go to the Main Screen.
- Press the Start button once to reset control power.
- If everything is clear, press the Home Machine button to ensure the machine is at the home position. The turntable (Main Drive) and carriage will move the home position if they are in different position currently.
- Attach the film tail to the load.
- You are now ready to run, press and hold the Start button until the turntable begins to rotate, or about 1.5 seconds.
- Allow the load to wrap.
- When the carriage is halfway up the load, press Reinforce. This will pause the carriage, when pressed and the number of reinforce wraps set in wrap settings will be applied, and then the load will continue its cycle.
- The Stop Cycle button will stop the current wrap cycle. The Pause Cycle button will pause the machine at its current position and will Resume Cycle when pressed again. Press Reset Faults to reset any active faults.
- See the Wrap Settings section below for more information on available wrap settings.

Illustration 8 – Main Screen





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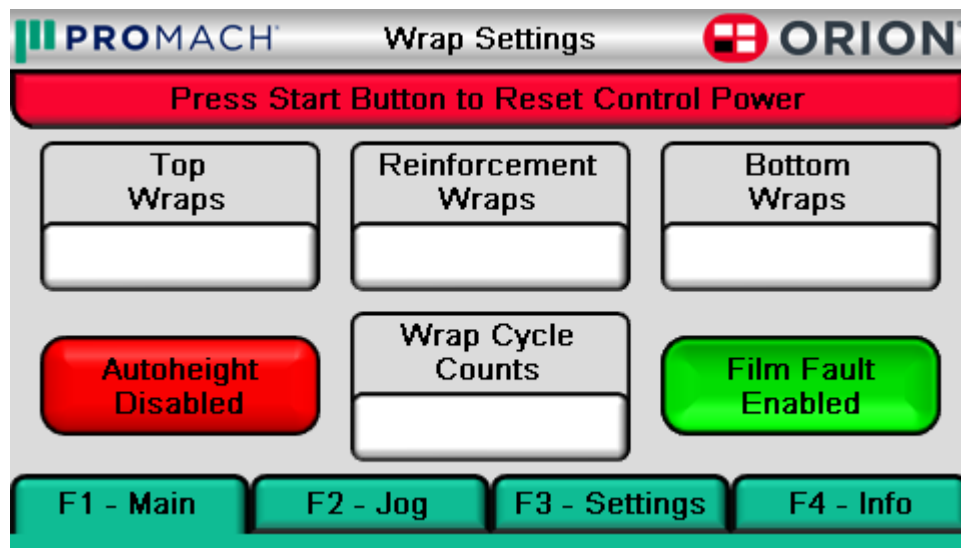
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Adjusting Wrap Settings

- Press the Settings tab and then select the Wrap Settings Screen.
- Press the Top Wraps button to set the number of top wraps applied to the load. Parameters are 1-20.
- Press the Bottom Wraps button to set the number of bottom wraps applied to the load. Parameters are 1-20.
- Set the number of reinforcement wraps that are applied to the load when reinforce button is pressed.
- Set the number of complete wrap cycle counts that are run when the machine cycle is started. The machine pauses at the end of a cycle and then restarts after 3 seconds. Factory default and recommendation is 1 wrap cycle.
- Enable or disable the carriage autoheight photoeye or the film fault. By disabling the autoheight; the photoeye will no longer recognize the top of load and the carriage will travel to the top limit. By disabling the film fault; the machine will no longer recognize a film break (not factory recommended).

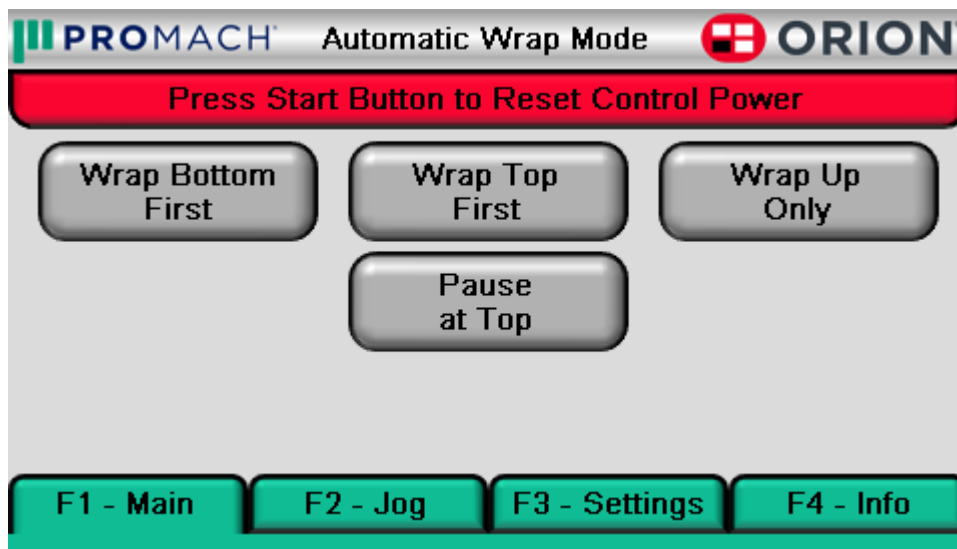
Illustration 9 – Wrap Settings Screen



Automatic Wrap Mode

- Press the Settings tab and then select the Automatic Wrap Mode Screen.
- You may choose the mode to wrap the load, wrapping either the bottom or top first, or only wrapping up.
- Pause at top, allows the wrapper to wrap to the top of the load. It then waits for the operator to start the wrap cycle again to finish the cycle. This allows the operator to adjust the load or make other changes to the load during the cycle.

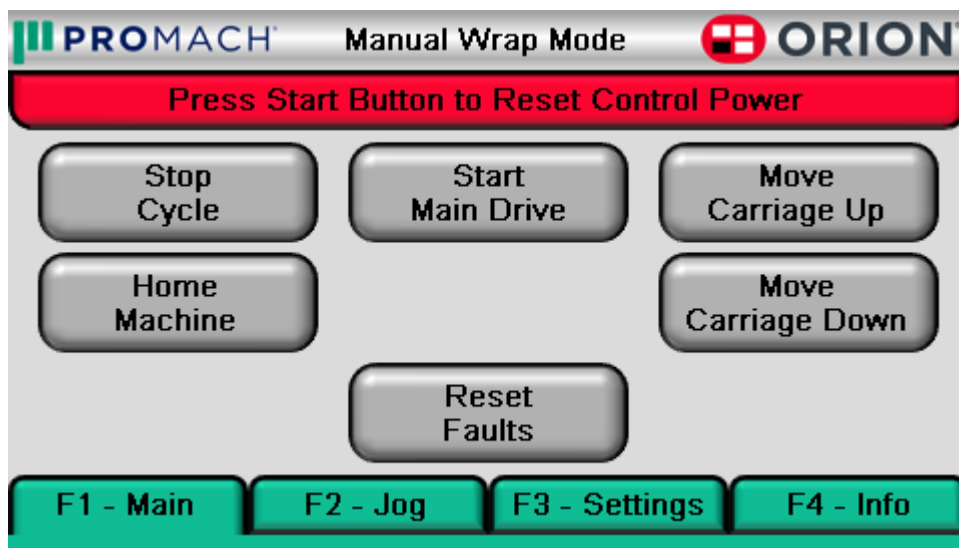
Illustration 10 – Automatic Wrap Mode Screen



Manual Wrap Mode

- Press the Settings tab and then select the Manual Wrap Mode Screen.
- This screen allows an operator to run the wrapper in manual mode to manually wrap the load.
- The Stop Cycle button will stop the current wrap cycle. Press Reset Faults to reset any active faults.
- Press the Start Main Drive button to start the turntable (Main Drive) rotation. The main drive will continue rotating until the button is pressed off.
- While the main drive is rotating, press the Move Carriage Up button to start the carriage moving up. The carriage will continue to move up until the button is pressed off, or the top limit is reached.
- While the main drive is rotating, press the Move Carriage Down button to start the carriage moving down. The carriage will continue to move down until the button is pressed off, or the bottom limit is reached.

Illustration 11 – Manual Wrap Mode Screen



There are additional adjustments you can make on the HMI. For complete details, see your user manual.