

## SPG to SPG2 Conversion Process:

*To ensure a smooth transition, it is recommended to use as much of the existing SPG ink as possible before initiating the conversion.*

*A complete replacement of all five inks is required, as SPG2-CL is not compatible with first-generation SPG inks. ONLY SPG2-CL can be used after an SPG2 cartridge has been installed in the BY-20.*

## Required Materials

Prepare the **SPG2 Conversion Kit** (available through your local dealer for \$299.99)

## Conversion Process Overview

*Once you are ready to begin, remove all SPG ink cartridges and discard the SPG-CL cleaning solution.*

Follow the step-by-step instructions below to complete the conversion process in the correct sequence.

S-PG2 Ink Conversion		
Description	Part	Qty
S-PG2 Cleaning Liquid	6000007710	1
Dummy Cart	1000008644	4
Cleaning Cart	US-IJ-CL	1
Cap top	6000007417	1
Wiper Head	1000006517	1
Wiper Felt	1000027150	1
Ink	S-PG2-2CY	1
Ink	S-PG2-2MG	1
Ink	S-PG2-2YE	1
Ink	S-PG2-2BK	1
Ink	S-PG2-2WH	2
Total		

When ready to start the conversion process, follow the instructions below.

*All steps need to be completed in a specific order*

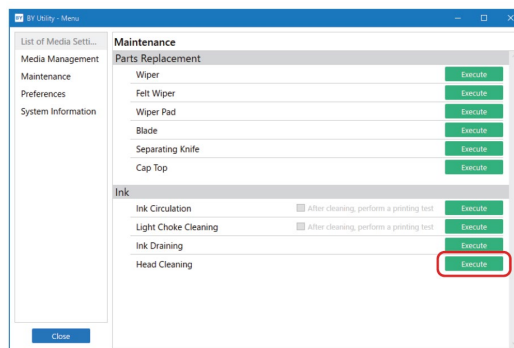
## Pre-Conversion Documentation for reference

**Step 1:** Print a nozzle test print and keep it for reference. [Nozzle Check](#)

**Step 2:** Wash the printhead following the steps provided below:

## Steps for Cleaning the Print Head

Start BY-20 Utility and Click the menu icon 



Next, Click [Execute] under [Maintenance]>[Ink]>[Head Cleaning]

User will be prompted to insert 4 rubber dummy cartridges and use the US-IJ-CL cartridge to clean each channel moving from left to right.

The US-IJ-CL will be removed and reinserted several times for each color channel.

Once the BY-20 has completed the head wash the unit will power down.

### **Step 3: Ink Fill with new S-PG2 220cc**

Turn on the Sub Power. When preparing to fill the machine with SPG2 ink, the BY-20 utility will display a prompt once the device is powered on. You will be instructed to select the ink type as **SPG (5-color)**. Following this selection, the device will prompt you to insert all five SPG2 cartridges. Once the cartridges are installed, the system will automatically begin the ink filling process.

**NOTE: Do not do any of the procedures below prior to cleaning the print head and ink fill of SPG2 inks has completed. This ensures all SPG ver. 1 has been removed from the ink delivery system.**

**Step 4: Replace the Cap top** [Cap Top Replacement](#)

**Step 5: Replace Wiper Pad** [Wiper](#)

**Step 6: Replace** [Felt Wiper](#)

### **Post-Conversion Verification**

- Print a new nozzle test print and compare it with the initial test.

### **Final Notes:**

- Ensure the printer is functioning properly before returning it to service.
- If any nozzle gaps or issues persist, perform additional cleaning cycles as needed.
- **Dispose of the old cleaning solution safely per company guidelines.**
- All procedures listed are also in the User Manual with additional troubleshooting if errors occur
- Contact your service dealer if cleanings fail to improve nozzle test results