

9MM BILLET LOWER ASSEMBLY INSTRUCTIONS

INCLUDED PARTS

- ✓ Magazine Catch Lever x1
- ✓ Magazine Catch Spring x1
- ✓ Ejector x1
- ✓ Ejector Set Screws x2
- ✓ Cap Screw for Rear Takedown Pin Detent Spring x1
- ✓ Upper Receiver Tension Screw x1
- ✓ Bolt Catch Screw x1



1. Magazine Catch Lever Installation



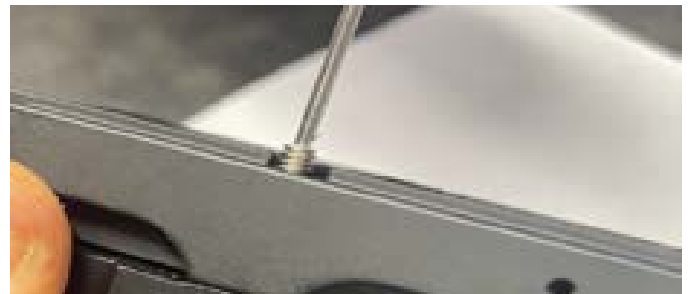
1a. With the lower receiver laying on its left side, place the magazine catch spring into the round recess in release lever pocket.



1b. Place the magazine catch lever into the pocket with the spring lined up with the protusion on the underneath side of the magazine catch lever.



1c. Compress the magazine catch lever into the pocket and insert the magazine catch screw from the top of the receiver.



1d. Hand tighten the screw with a 1/16" hex driver. **Medium strength thread locker is optional on this screw.**

2. Ejector Installation



2a. To fit ejector, insert the magazine being used into the magazine well. Push ejector down to make sure it is bottomed out on the magazine



2b. Install both ejector set screws. **Use Loctite 242 or 243 Blue when installing the ejector set screws.**

DO NOT OVER-TORQUE AND STRIP THE THREADS

3. Bolt Catch Installation



3a. Install the bolt catch spring with the bolt catch detent into the detent pocket.



3b. Place your bolt catch into the proper location and insert the bolt catch screw so that the bolt catch is retained. Place a small amount of medium strength thread locker onto the threads and hand tighten using a 1/16" hex driver.

4. Rear Takedown Pin Installation



4a. Install your rear takedown pin from the right side with the milled groove facing the rear of the lower receiver.

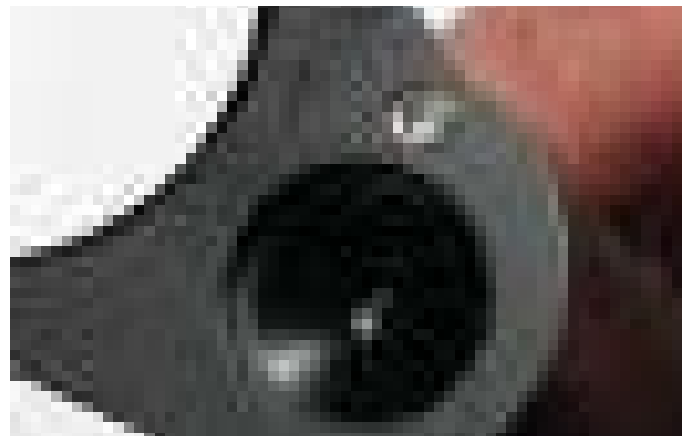


4b. Insert takedown pin detent so it engages with the milled slot in the pin which prevents it from rotating. **Use wire cutters and snip off approx. 1/8" of your detent spring and insert it behind the detent. This will alleviate tension in the spring.**

5. Rear Takedown Pin Detent Spring Installation



5a. Insert rear takedown pin detent spring. With a 1/16" hex driver, use the cap screw to compress the spring into the threaded takedown pin detent hole and rotate clockwise to engage the threads.



5b. Tighten the cap screw until it is flush with the rear of the receiver. **Do not use thread locker with this cap screw.**

6. Upper Receiver Tension Screw Installation

This screw is not required and is used to remove any excessive play between the upper and the lower receiver.

- Place the unloaded upper receiver onto lower receiver and secure with the pivot pin and takedown pin.
- Insert the receiver tension screw from the bottom using a 1/8" hex driver.
- Turn the screw until the nylon tip contacts the upper receiver.
- Increasing pressure will tighten the upper receiver to the lower.
- **May use a dab of medium strength thread locker with this screw.**

