

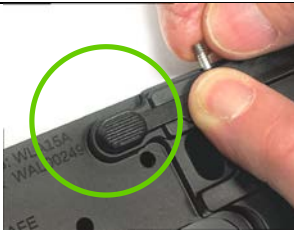



AR15 Billet Lower Receiver Assembly Instructions

	<p>INCLUDED INSTALLATION PARTS:</p> <ul style="list-style-type: none"> • Right Side Bolt Release Lever (1) • Extended Bolt Catch Detent (1) • Bolt Catch Springs (2) • Cap Screw for Rear Takedown Pin Detent Spring (1) • Upper Receiver Tensioning Screw (1) • Bolt Catch Screw (1) • Bolt Release Lever Screw (1) • Right Side Bolt Release Lever Screw (1)
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1. Bolt release lever installation:




<p>1a. With the lower receiver laying on its left side, place one of the bolt catch springs into the round recess in the release lever pocket.</p>		<p>1b. Place the bolt release lever into the pocket with the spring lined up with the protrusion on the underneath side of the bolt release lever. Compress the bolt release lever into the pocket and insert the bolt release lever screw from the top of the lower receiver. <i>The bolt release lever screw is the one with the shorter threads.</i></p>	
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<p>1c. Hand tighten the screw with a 1/16" hex driver. Medium strength thread locker is optional on this screw.</p>	
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DO NOT OVER-TORQUE AND STRIP THE THREADS

2. Bolt catch installation:

Turn the lower receiver over so that it is resting left side up and follow these steps:

<p>2a. Install the right side bolt release transfer rod into the detent pocket, followed by the bolt catch spring and bolt catch detent.</p>		<p>2b. 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.</p>		
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3. Rear takedown pin installation:

3a.

Install your rear takedown pin from the bottom with the milled groove facing toward the bottom of the receiver.



3b.

Insert your takedown pin detent and make sure that it engages with the milled slot in the pin to prevent it from rotating.

Hint: User wire cutters and snip off approx. 1/8" of detent spring and insert it behind the detent. This will alleviate tension in the spring.



4. Rear takedown pin spring installation:

4a.

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



4b.

Tighten the cap screw until it is flush with the rear of the receiver.

NOTE: Do not use thread locker with this cap screw.



5. Upper receiver tension screw installation:

NOTE: 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.
- Too much tension will make it difficult to remove the rear takedown pin and cause premature wear in buffer tube from BCG rub.
- Once satisfied with the tension, install pistol grip as normal.
- **NOTE: May use a dab of medium strength thread locker with this screw.**

