



## AMBI EQUIPPED BILLET LOWER

Our billet lowers come with the ambidextrous bolt catch release lever and bolt catch already installed. They also have the upper to lower tension screw with jam screw and the small 4-40x1/8" screw for the rear takedown pin.

The enhanced bolt catch must be removed to install the magazine catch. You will need a 1/16 th Allen wrench to remove the dowel pin. When the bolt catch comes out you will notice a standard bolt catch detent with spring and a metal ambidextrous bolt pin. The order they go in from the bolt catch side is the bolt pin, spring, and then detent.

The upper to lower tension screw and jam are located on the flat behind the grip screw. This screw is used to take any slack out of the upper and lower. This can be tested by placing your upper on the lower with the pins in to hold it and tighten the tension screw (green tipped) up until it touches the upper. Too much tension will make it difficult to remove the pins to separate the halves. It can be removed or screwed down until it is flush with the lower if desired and will have no ill effects on the function of the lower. Once this is set you can use lock-tite if desired or use the jam screw to set it at the desired height.

The 4-40x1/8" set screw (uses a 0.050 Allen wrench) that is located on the rear face of the receiver is used to hold the take down detent and spring against the take down pin. To get proper tension on the pin you will need to install the takedown pin, the detent and spring. Make sure to run the pin through its range of motion and the detent is set into the deepest part of the pin. Add pressure to the spring and make sure it's seated and count up 3 to 5 coils off the flat of the lower receiver to then cut the spring. This is done to ensure pressure on the pin and get the screw flush with the lower. Too much pressure on the pin will make it difficult to remove the pin to separate the halves