

Building a 2XTM drum feed AK

Only experienced gunsmiths and competent gun builders should attempt to convert an AK from gas operation to blow back operation. Our intent here is not to tell you every step in building a 2XTM. Build it your self forums are available to help you do and answer questions. This is just a rough outline of some of the major steps required to build a 2XTM from a prepared AK parts kit and a completed receiver with the 2XTM mag well installed. Note use of an AK74 bolt should be used to fit the 9mm case head.

- 9mm barrel modifications:
 - Turned and sleeved barrel to fit the front trunnion
 - Turn barrel and install front and rear sites
 - Install gas block but do not drill the port
 - Make barrel extension if building riffle with barrel less than 16" long
 - Relief in breach face for extractor
- Bolt and bolt carrier modifications:
 - Relocate the cocking handle back.
 - Remove bolt cam groove
 - Grind away a significant portion of shaft extending forward of the bolt face to enhance ejection
 - Provide hole for firing pin retainer pin removal
 - Secure (weld) bolt to carrier
 - Modify rear side of bolt to set back in the carrier as far as practical
 - Shorten bolt shaft end and firing pin to align with the hammer.
 - Provide a surface for the bolt to cock the hammer.
 - Provide a bolt stop to assure proper headspacing
 - If a AK47 bolt carrier is used, a sleeve has to be fabricated to match the smaller AK74 bolt shaft to the larger carrier hole.
- Shorten the safety lever to clear the drum
- Make a new mag catch
- Modify the rear trunnion if needed to allow bolt installation
- Modify the upper rail opening at the rear to allow installation of the longer bolt and carrier
- Modify the bolt cover by enlarging the ejection port opening
- Install buffer and possibly buffer extension to prevent over travel of bolt
- Shorten piston, gas tube, hand guard and fore end if required.
- Install necessary USA made 922r compliant parts for a riffle

Help is available online though the various build it your self forums. The insight here from these forums is invaluable and limitless. Beside they are really great people who have been there and done that and really want to help you.

My favorite is:

<http://www.gunsnet.net> "build it your self 2 forum"

Other great ones are:

www.ar15.com

www.homegunsmith.com