

## 2XTM Magazine Well

### How does a gun builder convert an AK to a drum fed 9mm?

The typical solution has been to cut away a donor sub-machinegun magazine well, like a Finnish Suomi, and install it in an AK receiver. But attempting to utilize scavenged portions can lead to many problems - sloppy torch cut sections leave little room for error during cleaning and re-shaping, all grinding is critical, and working with hardened steel is difficult. For the screw-builder, drilling holes in narrow portions of the scavenged magazine well section compromises integrity and strength. It's a real challenge even for the most advanced builder. Not to mention, while kits are drying up, prices are going up - and mistakes become very expensive.

The 2XTM Magazine Well will adapt a Suomi 71-round drum magazine to an AK receiver. It is much more user-friendly and easier to locate than a salvaged Suomi magazine well. The 2XTM Magazine Well has its own built-in feed ramp. What this means is that now a builder does not have to find a Suomi kit. The only Suomi item needed is the drum mag. Any chambered 9mm barrel, such as a UZI or others, can be used.

This photo depicts a typical torch-cut Suomi magazine well from a parts kit. This part alone has been advertised recently in a popular gun newspaper for \$50.



### Description

The intent of the 2XTM Magazine Well is to provide the advanced gun builder a simple, low-cost resource for a magazine well to convert an AK-47 or AK-74 to 9mm Luger

(9x19) cal that uses Suomi 71-round drum magazines. The 2XTM Magazine Wells are not a perfect fit out-of-the-box. If you don't feel comfortable doing tasks like this, please don't order this product. The 2XTM Magazine Well can be installed into a standard .040" thick receiver and is designed to use Finnish Suomi 71-round Drum magazines. With additional effort it is possible to adapt it to also use the 36-round stick magazine. The product is approximately 80% complete. This means that the part is larger in some areas and material may have to be removed by filing or grinding to achieve proper fit and function. The builder will have to cut away part of the AK receiver and front trunnion for the 2XTM Magazine Well to be installed. The 2XTM Magazine Well can be attached to the receiver by rivets, screws or welding. The 2XTM Magazine Well can be hardened once the metal removal and fitting process is complete. The 2XTM Magazine Well is designed to fit between the rails and locate under the lower rails of a standard .040" thick receiver. It can be fitted to thicker receivers by grinding away material on the sides. It is made from two layers of .080" thick 4130 steel and is spot welded together. The 2XTM Magazine Well gains additional strength from the receiver once installed.

This is an 80% 2XTM Magazine Well



Each one is hand made and no two parts are exactly alike. The patterns for this part are cut by a laser with high precision, then these parts are formed and assembled using a press, precision bend dies, vice, file, grinder, Dremel, hammer and anvil. This 2XTM Magazine Well will have to be fitted to the AK receiver using similar techniques. If during the installation process a spot weld breaks loose just re-weld it by spot, wire feed, stick or TIG. Oxy-Acetylene is not recommended because too much of the part will be heated and possibly hardened as it cools.

The main tasks for the builder are:

- Effort is required to fit the 2XTM Magazine Well to the receiver.
- Effort is required to locate the feed ramp in relation to the chamber and center it up. A finely calibrated eyeball and good judgment is helpful here..
- Effort is also required to locate the drum to the bolt and chamber.

## **Warning**

Gun building and modification is not for unsupervised amateurs. You can hurt yourself and others, or even kill someone if you get something wrong. This is strictly for advanced gunsmiths and AK builders. These instructions are not to be considered complete and are not intended to cover all variations. Any gun modification could be considered inherently unsafe. It is possible for the gun to fire without the bullet being fully seated in the chamber. This can result in the case exploding. Case metal can exit the firearm toward the shooter or bystanders. These fragments can easily blind or seriously injure someone. Always wear safety glasses and personal protective equipment when shooting any firearm. Always shoot an AK with the top cover on to provide maximum protection to the shooter and any bystanders. Be particularly cautious when shooting any AK rifle left handed. The shooter's face is not protected if the bullet case or primer ruptures.