



941043-00

# KR54, KR1654 & KR4954

# VON DUPRIN®

Keyed Removable Mullions

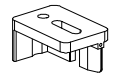
Installation Instructions

## Not for use on electric or fire rated removable mullions

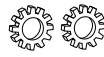
All parts below are included for KR1654 and KR4954 (Mullion with Keyed Removable Option)



Locking mullion assembly



Top mullion fitting



5/16 External Tooth Lock Washer



5/16-18 x 1-1/4" Button Socket Head Cap Screw



1/4-20 x 1" Flat Head Socket Security Machine Screw



8-32 x 1/4" Undercut Flat Head Socket Security Machine Screw



5/32" Hex Key



Top Mullion Fitting Shim



Cylinder Lock Nut



8-32 x 3/8" Set Screw



Sex Bolt



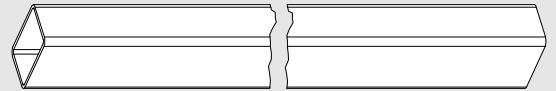
Cylinder Locking Washer



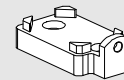
Back Cover Plate



5/16-18 x 1-1/4" Flat Pan Head Machine Screw and Expansion Anchor (KR1654, KR4954 & KR1654/4954 Blank Only)



Mullion Body (KR1654, KR4954 & KR1654/4954 Blank Only)



Bottom Mullion Fitting (KR1654, KR4954 & KR1654/4954 Blank Only)

Included with KR54 (KR Kit)

Not included with KR54 (KR Kit)

## Step 1 Prepare the Keyed Removable Unit.

3 Thread cylinder lock nut onto mortise key cylinder. Be sure to fasten down tight.

1 Position cylinder locking washer over mortise key cylinder hole. **Note:** Raise the locking pin lever to aid in installation.

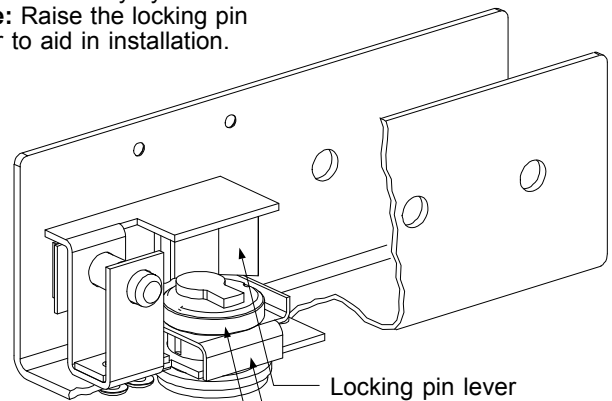
Collar (not supplied)

Mortise key cylinder w/standard cam (not supplied)

1/8" maximum thickness

1-1/8" or 1-1/4"

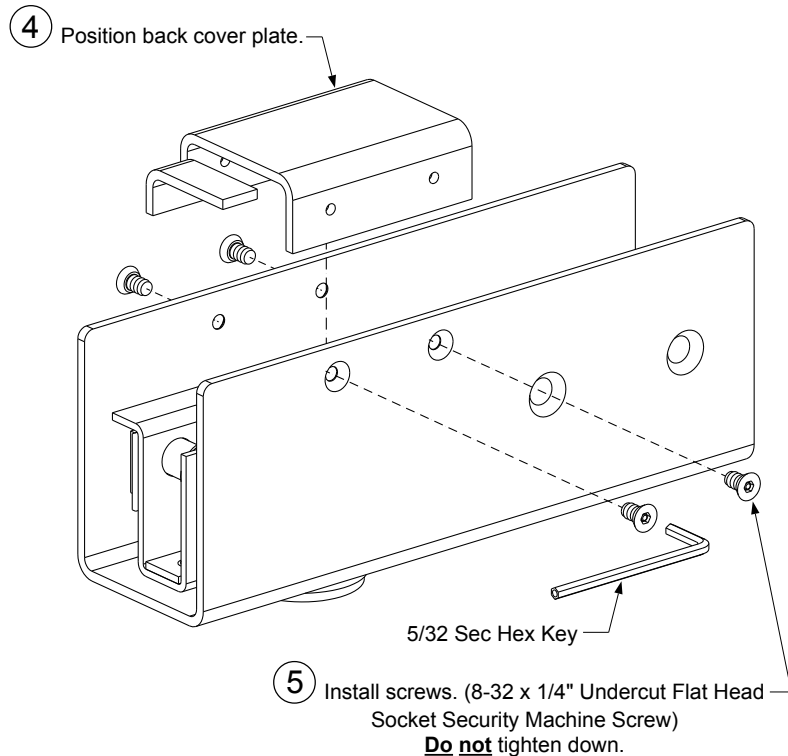
2 Insert mortise key cylinder through collar and into hole. **Note:** Cylinder must be oriented as shown.



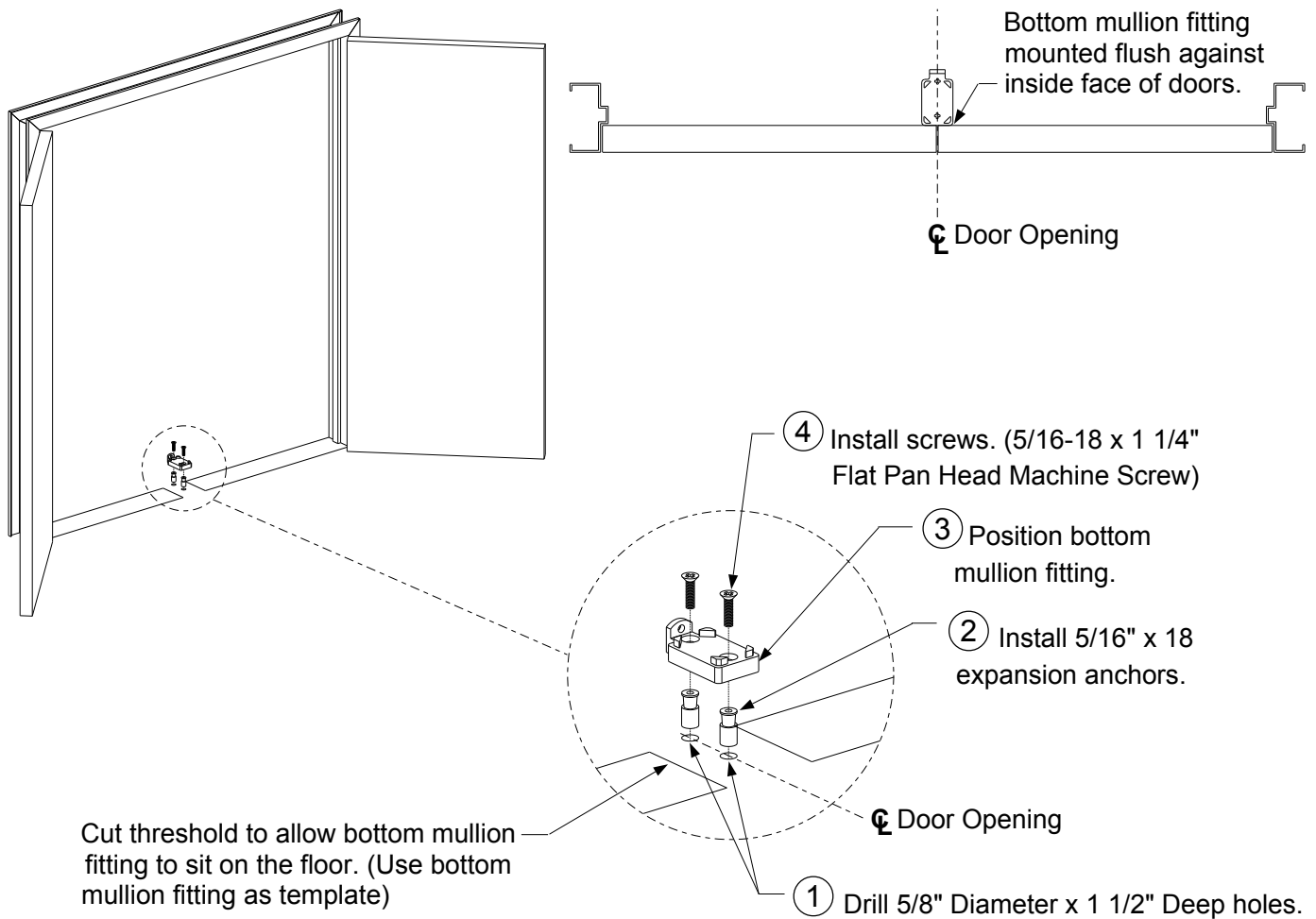
Locking pin lever

Cylinder locking washer

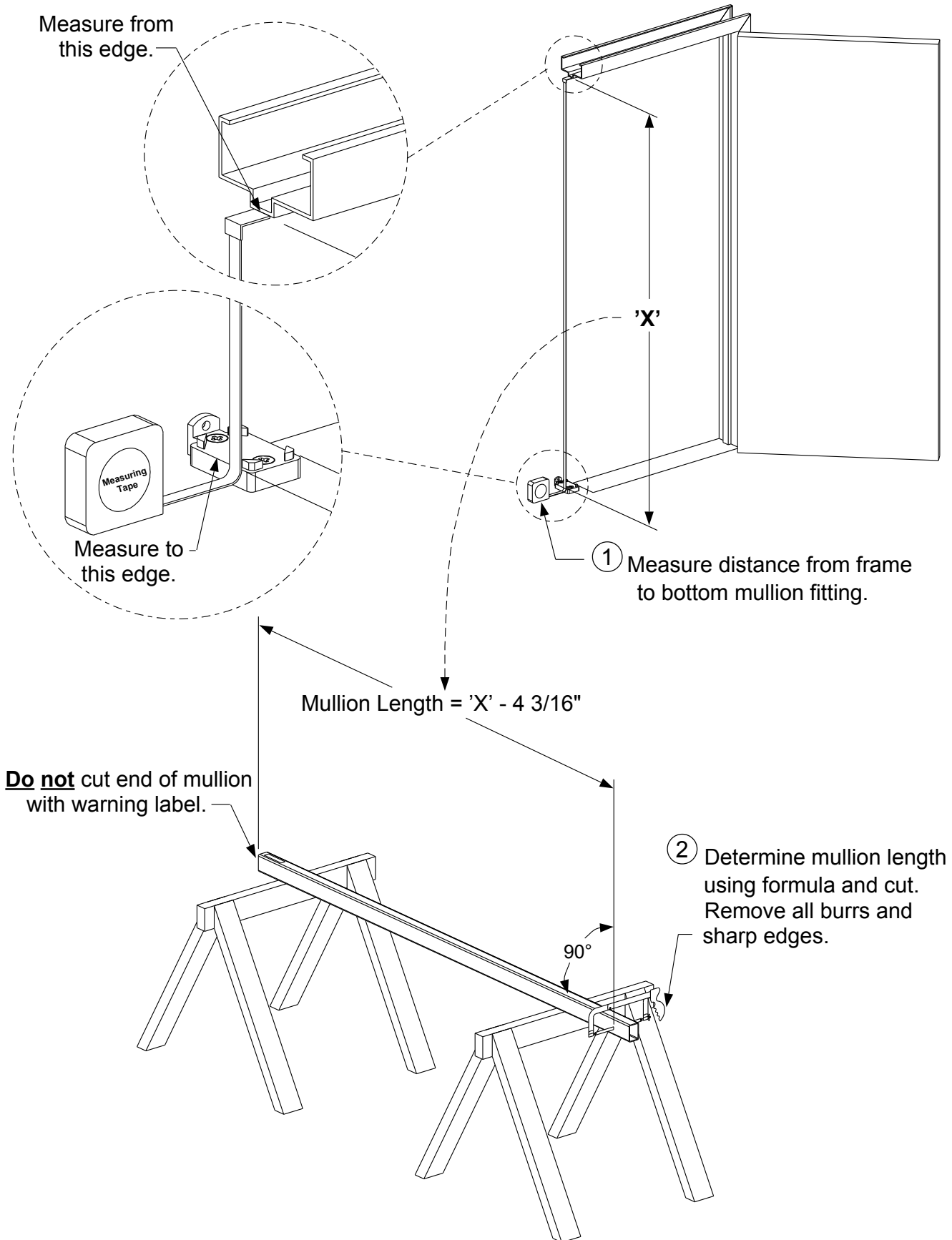
Cylinder lock nut



**Step 2** Install bottom mullion fitting. (If bottom mullion fitting already exists, go to Step 3.)



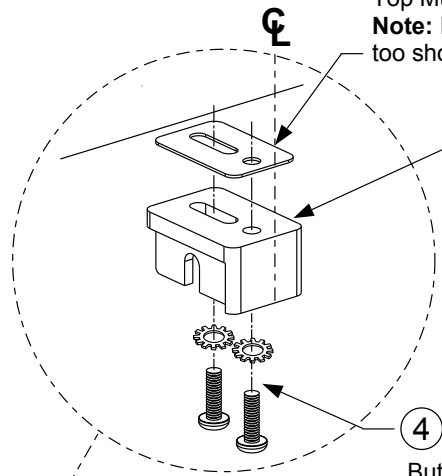
### Step 3 Size mullion.



# Step 4 Install top mullion fitting.

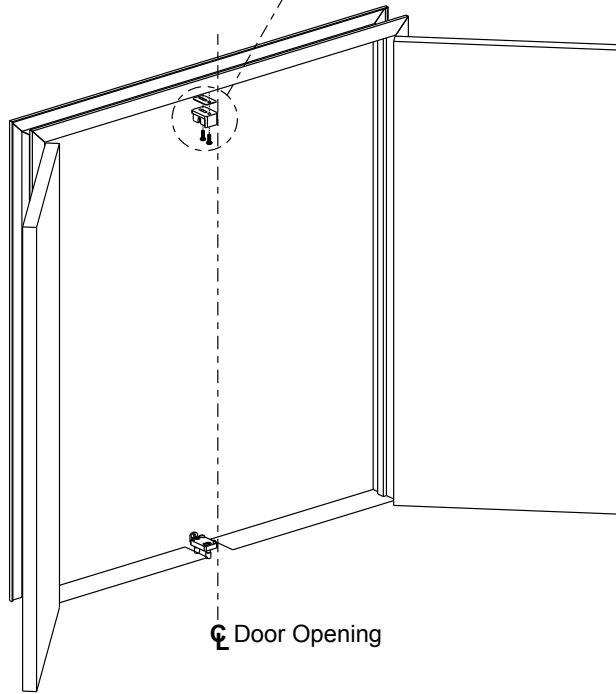
Top Mullion Fitting Shim

**Note:** If mullion is cut between 3/16" - 5/16" too short, add top mullion fitting shim.



1 Position top mullion fitting

4 Install screws and Lock Washers. (5/16-18 x 1 1/4" Button Socket Head Cap Screw & 5/16 External Tooth Lock Washer)



16 Gauge Reinforcement. Supplied by frame manufacturer.

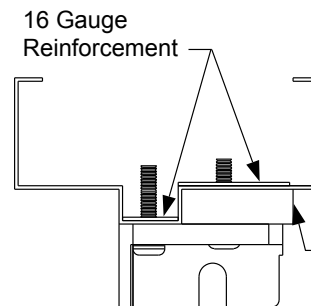
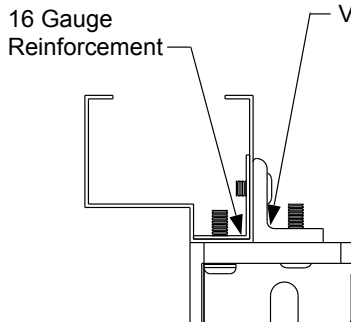
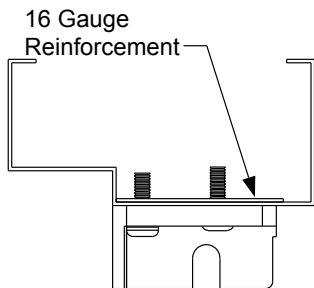
2 Mark holes.

3 Drill and tap frame for 5/16-18 screws using top mullion fitting as template.

Top mullion fitting mounted flush against inside face of doors.

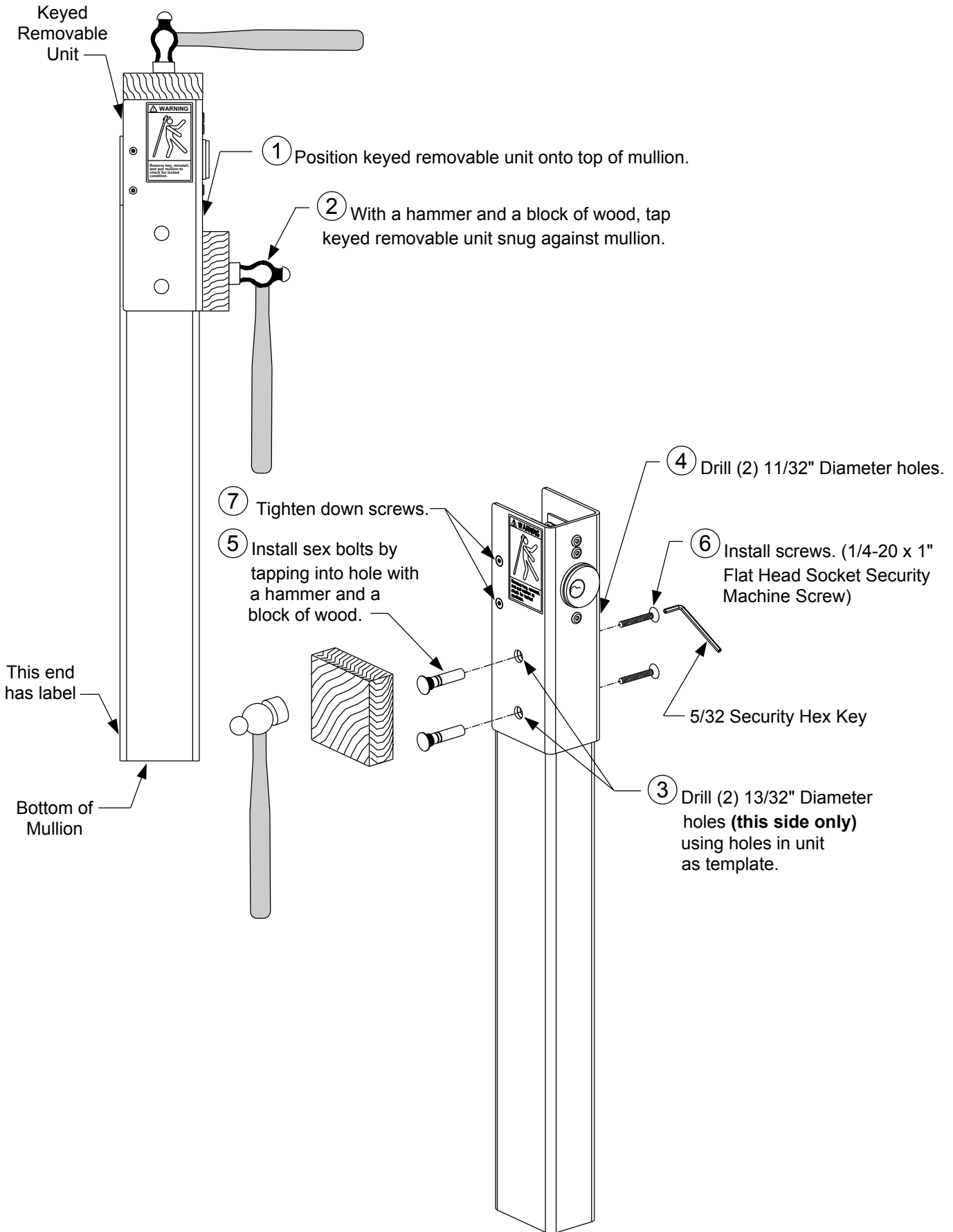
## Mounting Top mullion fitting on optional frame styles:

Angle Bracket can be purchased through Von Duprin.

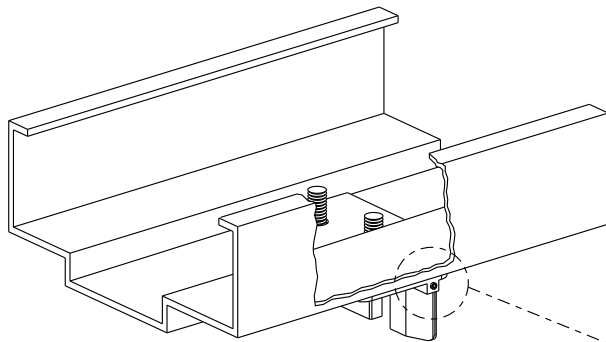


Filler block is to be supplied by frame manufacturer.

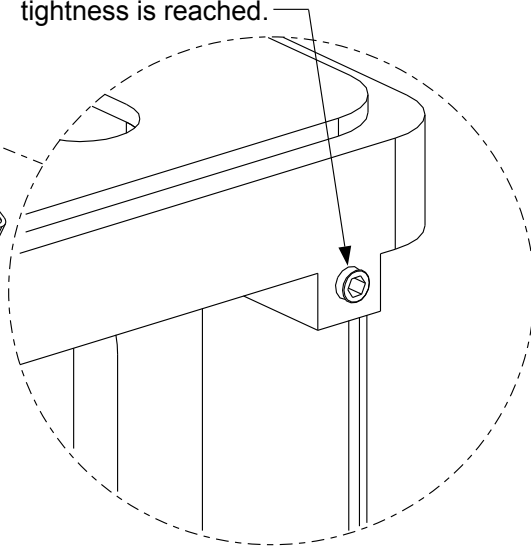
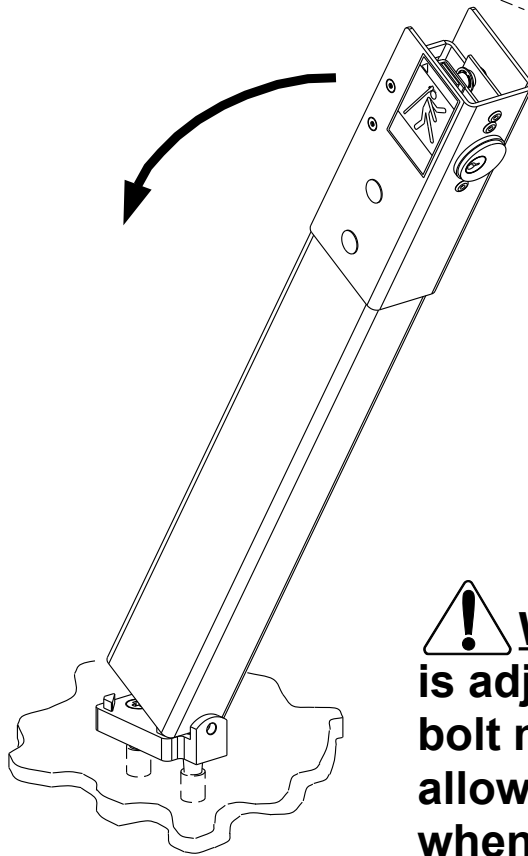
# Step 5 Attach keyed removable unit to mullion.



## Step 6 Final Installation & Adjustment.



- 1 Install screw. (8-32 x 3/8" set screw) until flush with face of top mullion fitting. Install mullion.
- 2 Check for tightness of mullion by pushing and/or pulling on mullion. To tighten, remove mullion (see Step 7) and rotate set screw out 1/2 turn. Repeat this procedure until desired tightness is reached.



**! WARNING!** If set screw is adjusted out too far, the bolt may not latch completely allowing the mullion to fall out when impacted.

## Step 7 Operation.



Rotate key 180°  
Clockwise to unlock  
and remove mullion