



941043-00

KR54, KR1654 & KR4954

VON DUPRIN®

Keyed Removable Mullions

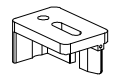
Installation Instructions

Not for use on electric or fire rated removable mullions

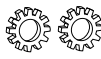
All parts below are included for KR1654 and KR4954 (Mullion with Keyed Removable Option)



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



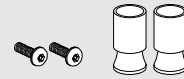
Sex Bolt



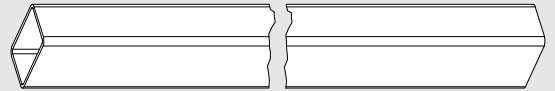
Cylinder Locking Washer



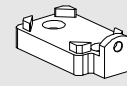
Back Cover Plate



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.

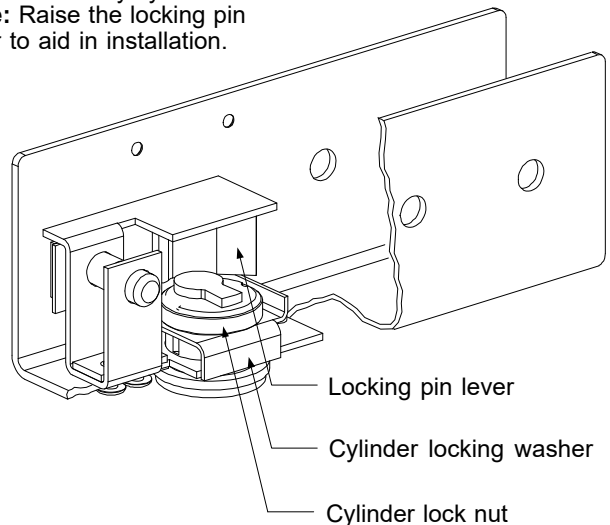
Collar (not supplied)

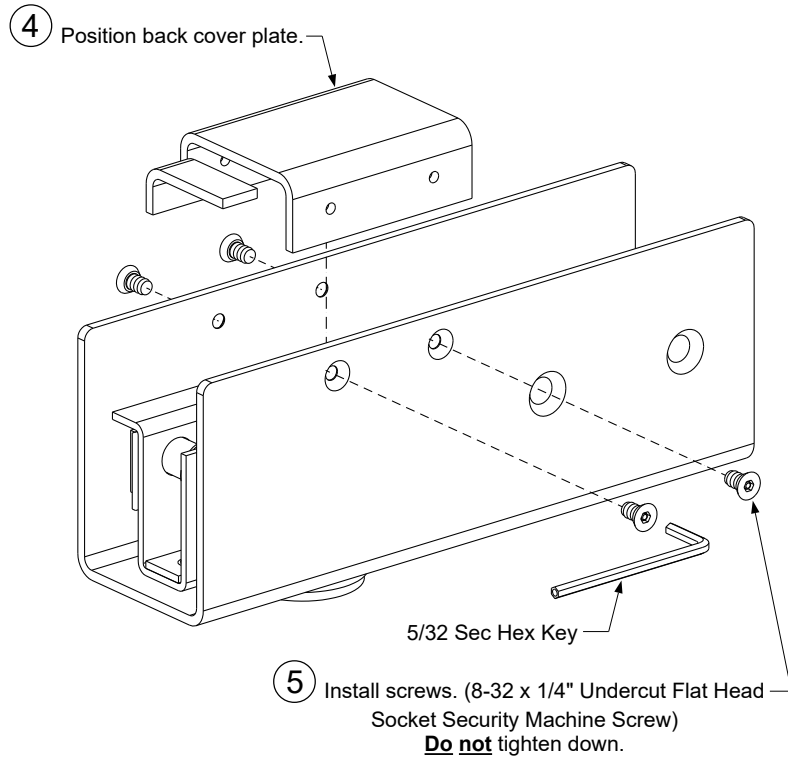
Mortise key cylinder w/standard cam (not supplied)

1/8" maximum thickness

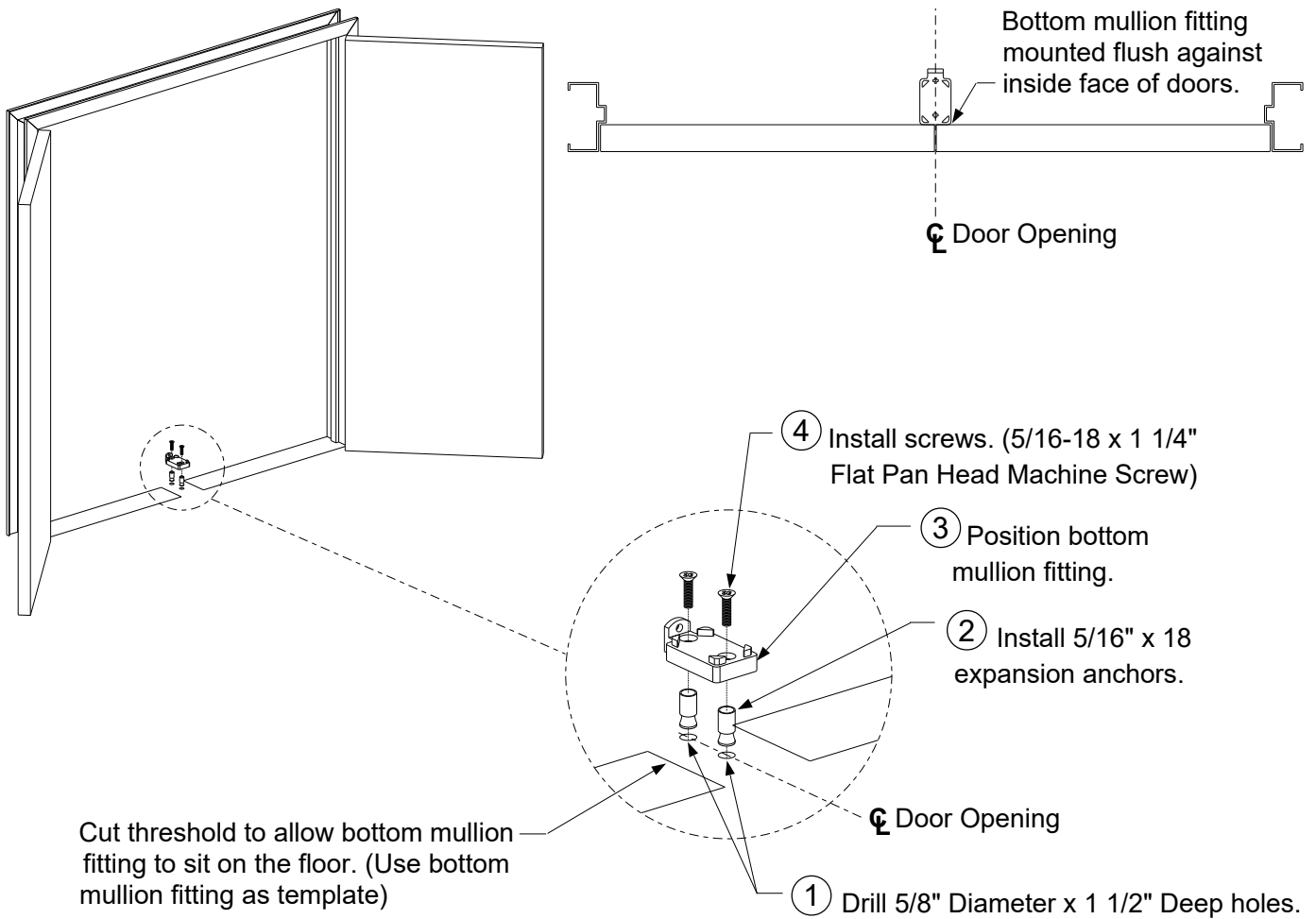
1-1/8" or 1-1/4"

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



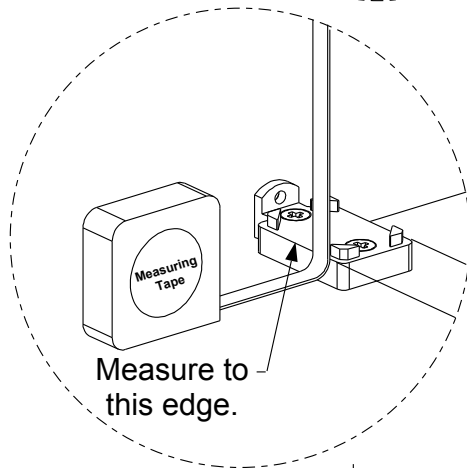


Step 2 Install bottom mullion fitting. (If bottom mullion fitting already exists, go to Step 3.)



Step 3 Size mullion.

Measure from this edge.

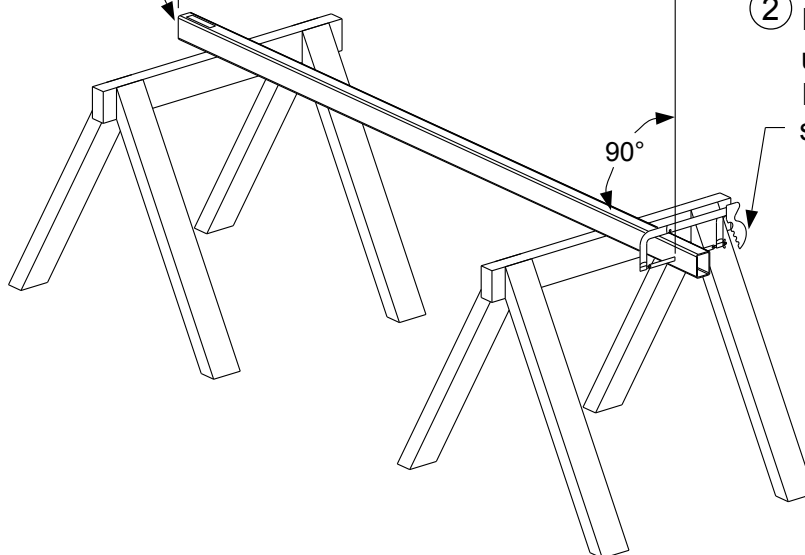


① Measure distance from frame to bottom mullion fitting.

$$\text{Mullion Length} = 'X' - 4 \frac{3}{16}"$$

Do not cut end of mullion with warning label.

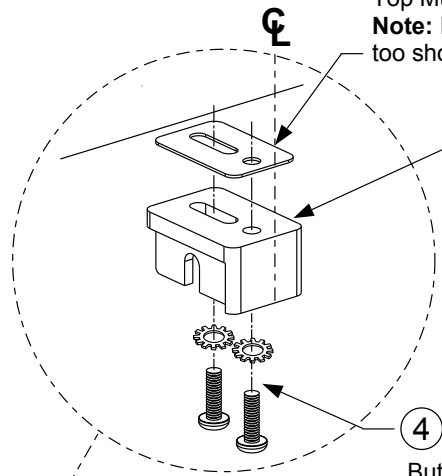
② Determine mullion length using formula and cut. Remove all burrs and sharp edges.



Step 4 Install top mullion fitting.

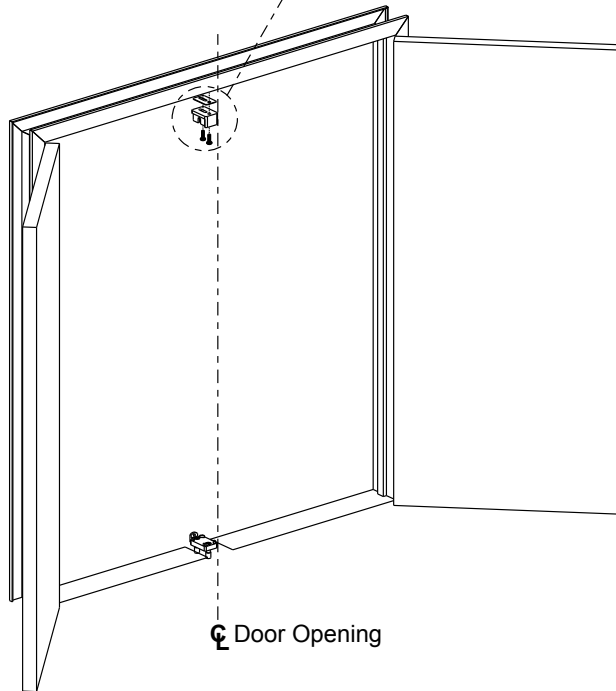
Top Mullion Fitting Shim

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)



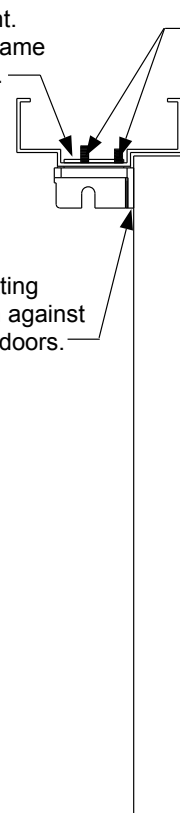
Door Opening

16 Gauge Reinforcement. Supplied by frame manufacturer.

2 Mark holes.

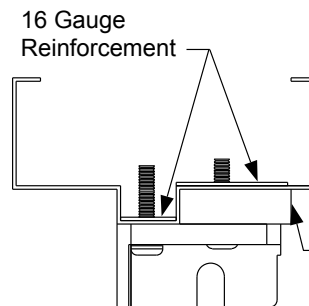
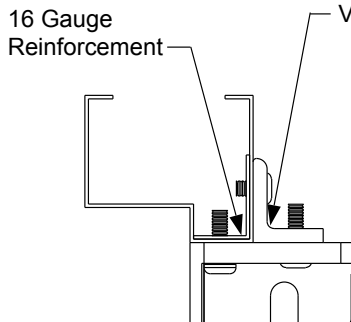
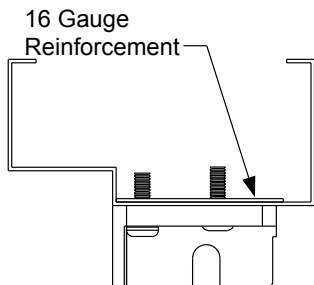
3 Drill and tap frame for 5/16-18 screws using top mullion fitting as template.

Top mullion fitting mounted flush against inside face of doors.



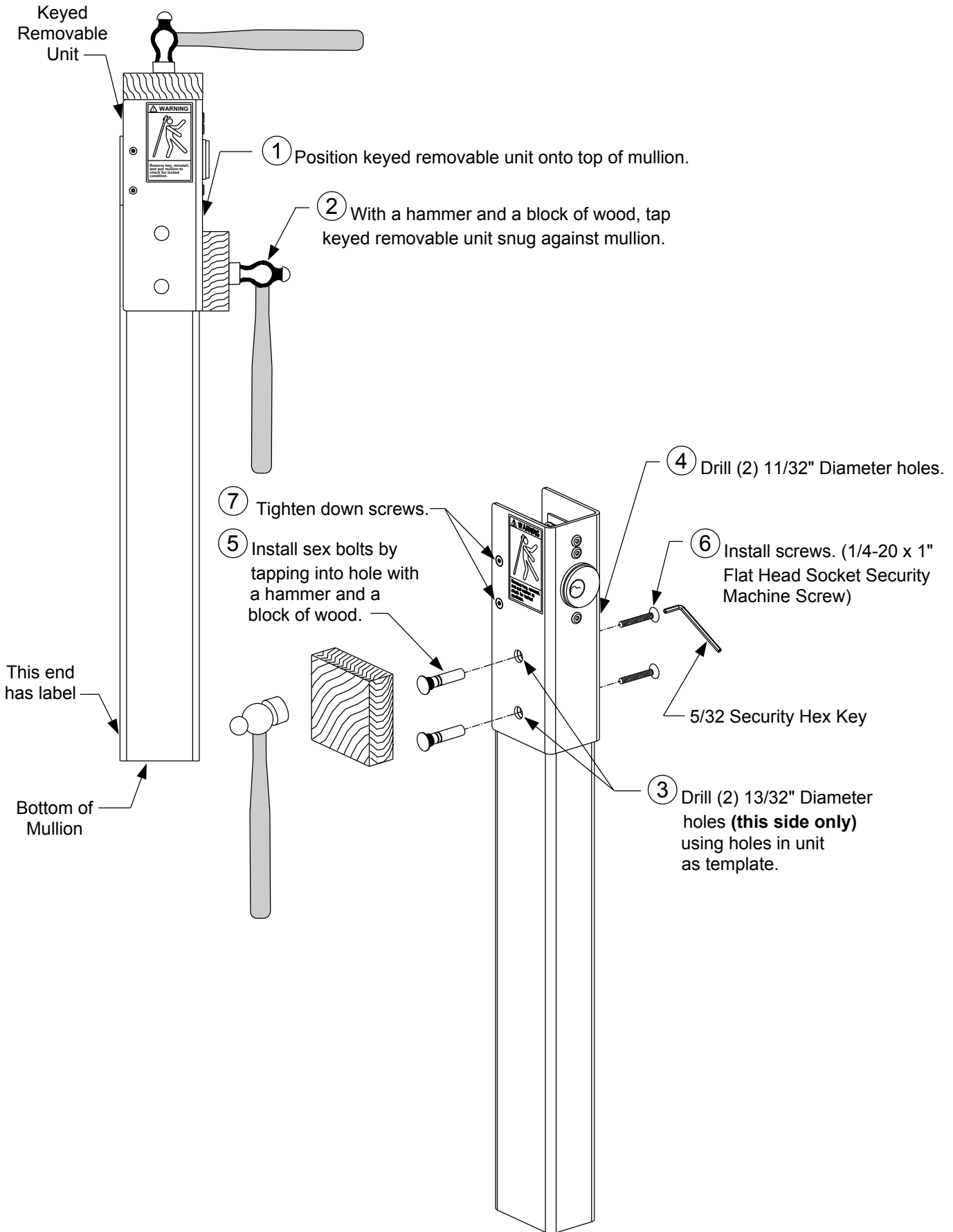
Mounting Top mullion fitting on optional frame styles:

Angle Bracket can be purchased through Von Duprin.

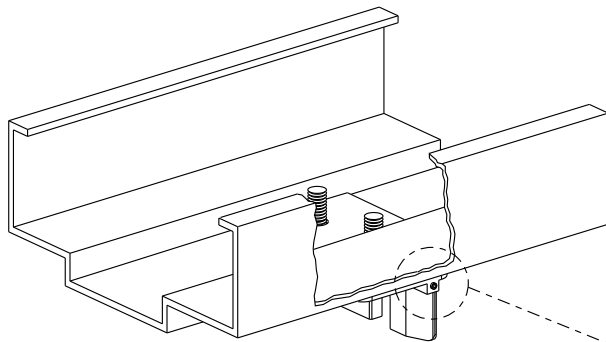


Filler block is to be supplied by frame manufacturer.

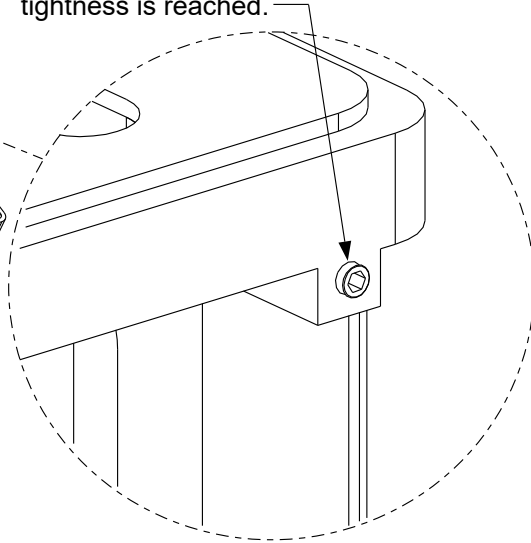
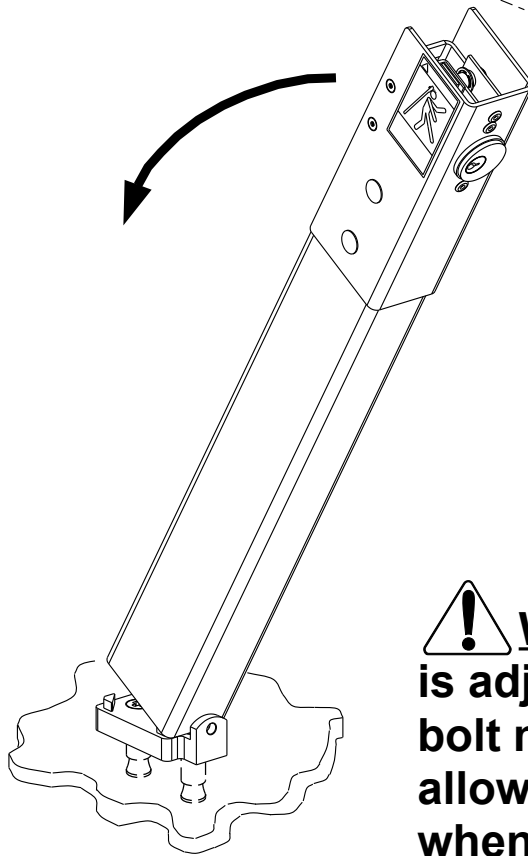
Step 5 Attach keyed removable unit to mullion.



Step 6 Final Installation & Adjustment.

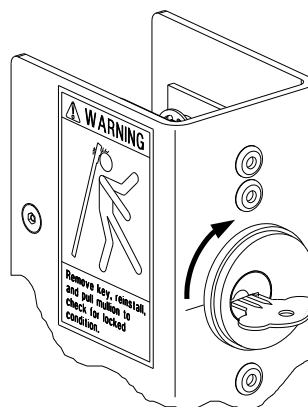


- 1 Install screw. (8-32 x 3/8" set screw) until flush with face of top mullion fitting. Install mullion.
- 2 Check for tightness of mullion by pushing and/or pulling on mullion. To tighten, remove mullion (see Step 7) and rotate set screw out 1/2 turn. Repeat this procedure until desired tightness is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

Customer Service

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