



941043-00

# KR54, KR1654 & KR4954

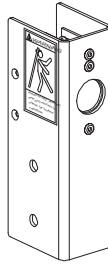
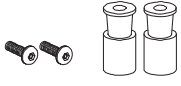



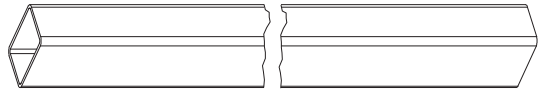




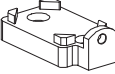

# VON DUPRIN®

Keyed Removable Mullions

Installation Instructions

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

This kit includes the following parts: (Not to scale)

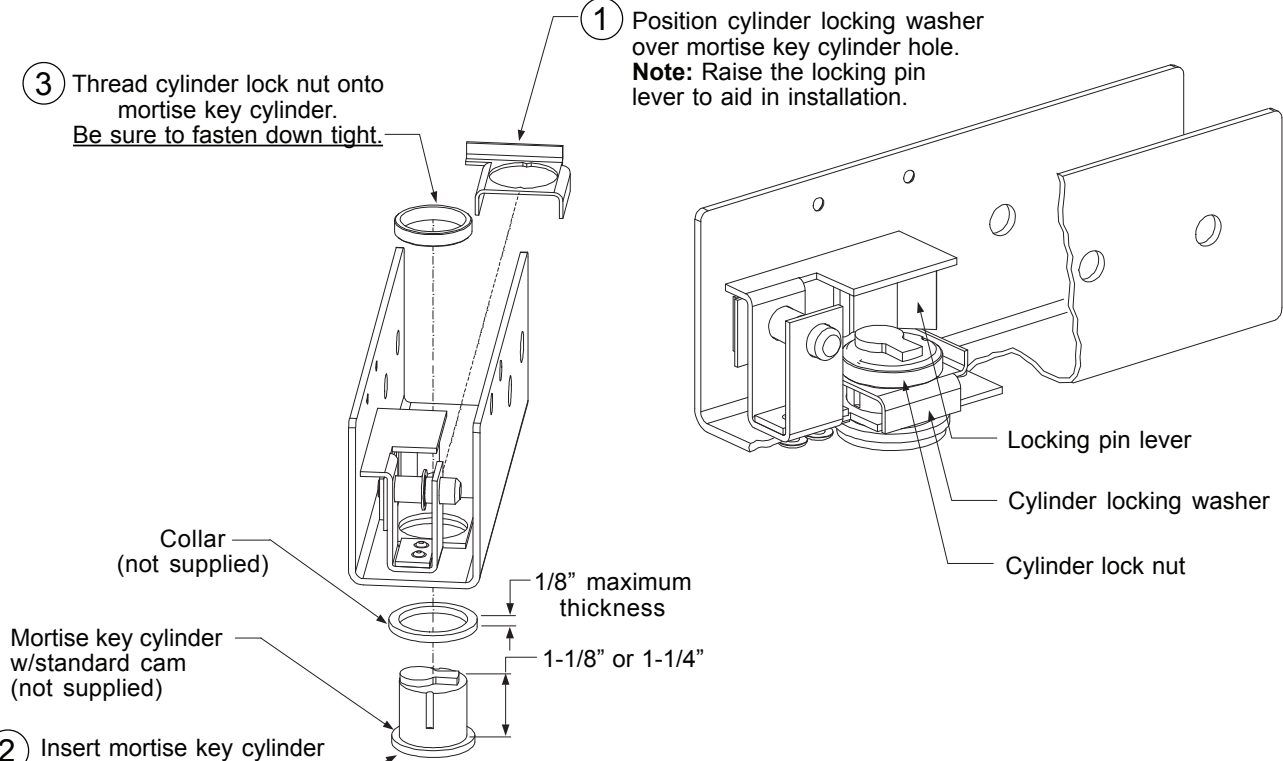
			
<b>Locking mullion assembly</b> (KR1654, KR4954 & KR1654/4954 Blank Only)	<b>5/16-18 x 1-1/4" Flat Pan Head Machine Screw and Expansion Anchor</b> (KR1654, KR4954 & KR1654/4954 Blank Only)	<b>5/16-18 x 1-1/4" Button Socket Head Cap Screw</b>	<b>8-32 x 3/8" Set Screw</b>
			
<b>Top mullion fitting</b>	<b>Mullion Body</b>	<b>8-32 x 1/4" Undercut Flat Head Socket Security Machine Screw</b>	<b>Cylinder Locking Washer</b>
			
<b>5/32" Hex Key</b>	<b>Top Mullion Fitting Shim</b> (KR1654, KR4954 & KR1654/4954 Blank Only)	<b>Bottom Mullion Fitting</b>	<b>Back Cover Plate</b>

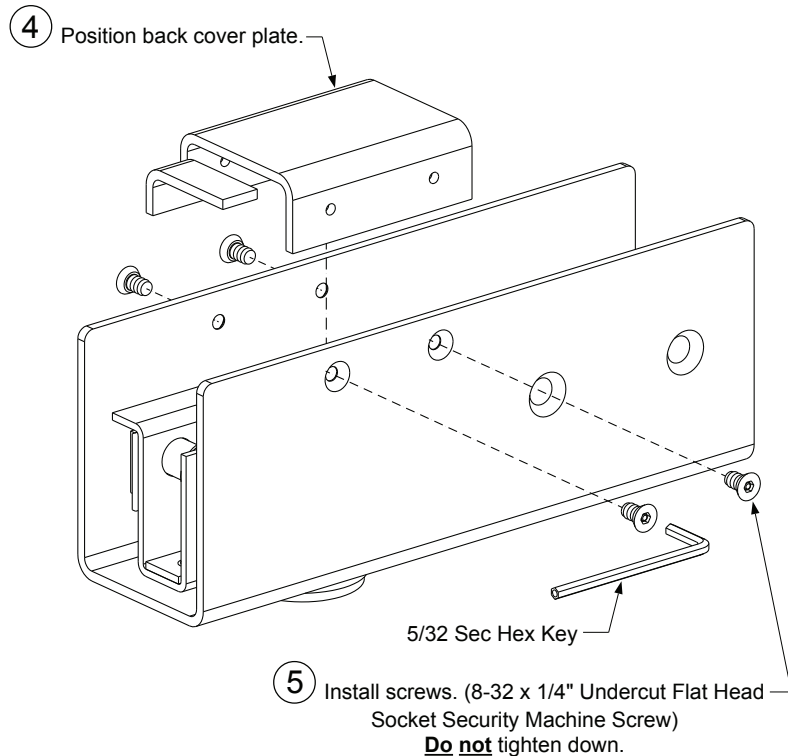
## Step 1 Prepare the Keyed Removable Unit.

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

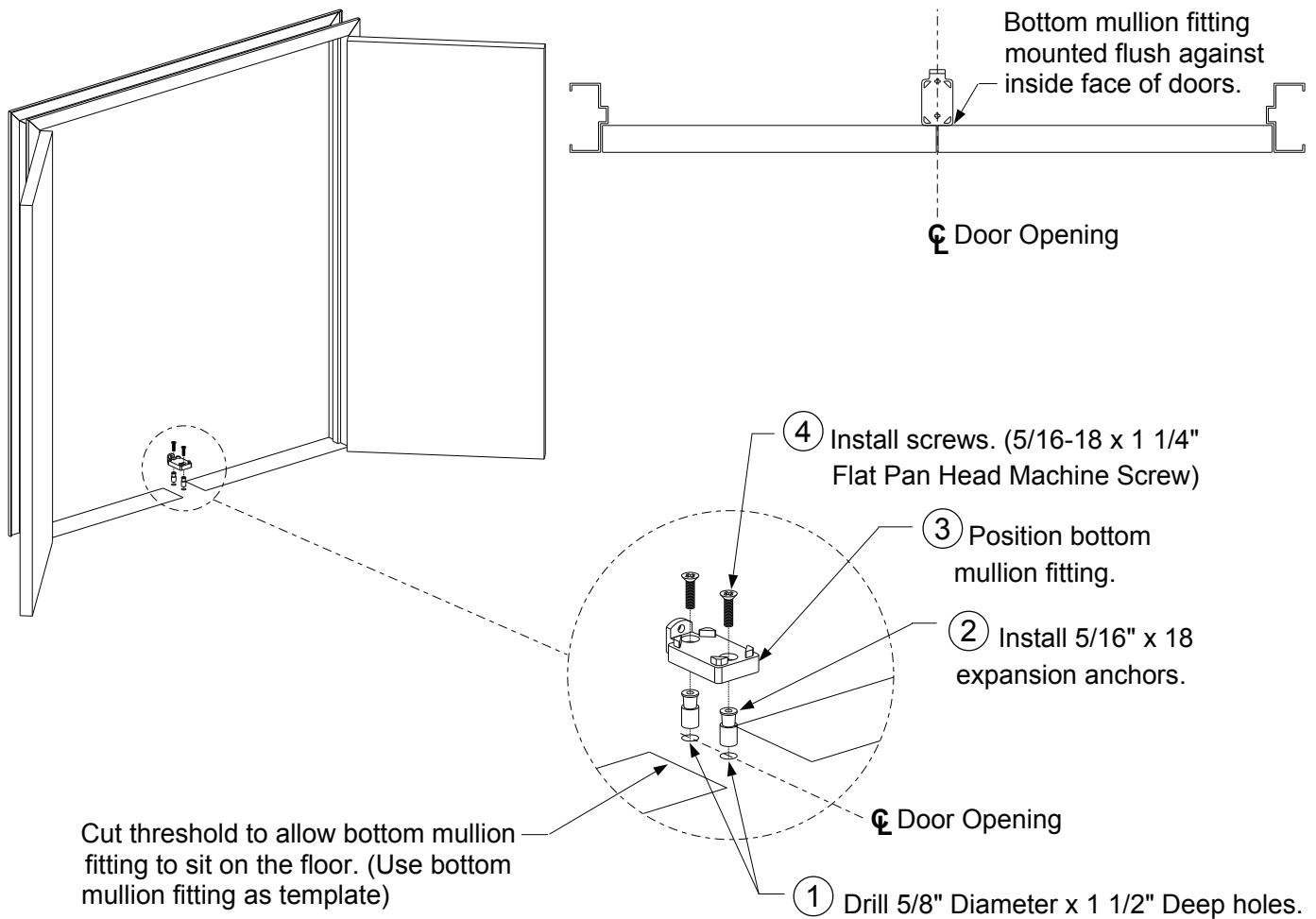
**2** Insert mortise key cylinder through collar and into hole.  
**Note:** Cylinder must be oriented as shown.

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

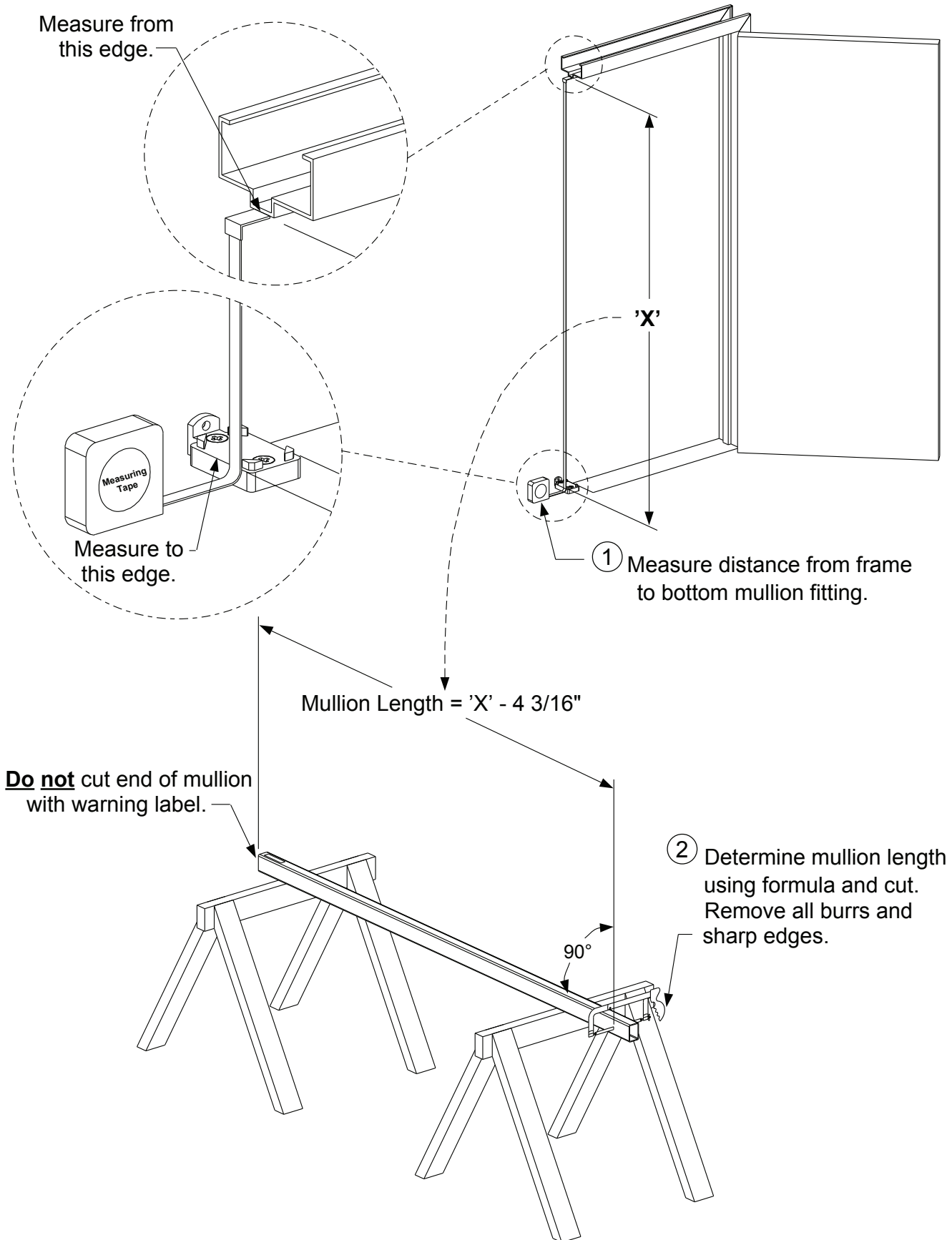




**Step 2** Install bottom mullion fitting. (If bottom mullion fitting already exists, go to Step 3.)



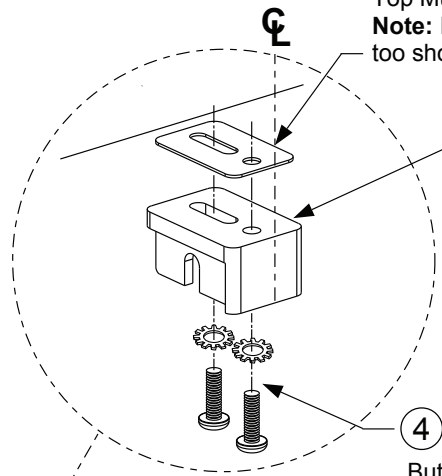
### Step 3 Size mullion.



# Step 4 Install top mullion fitting.

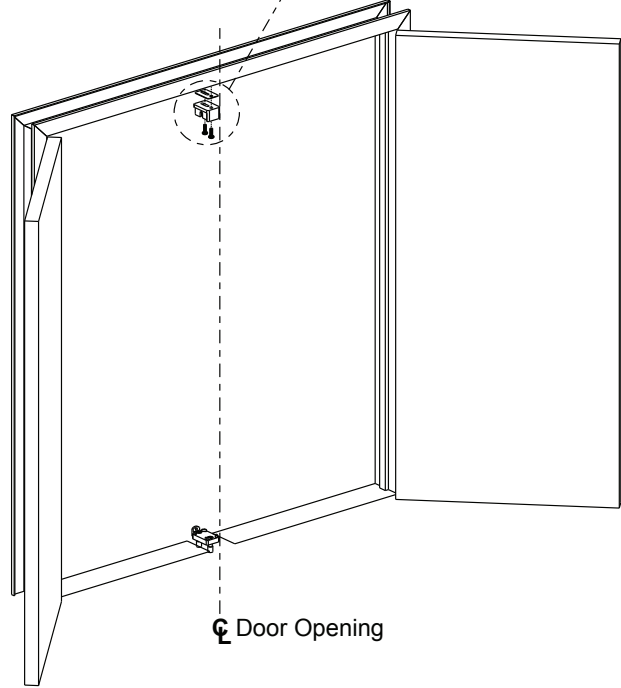
Top Mullion Fitting Shim

**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)



Door Opening

16 Gauge Reinforcement. Supplied by frame manufacturer.

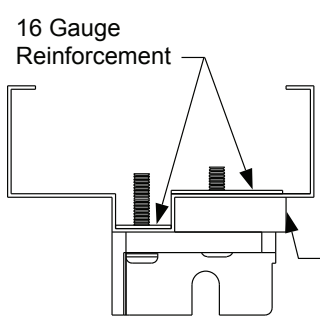
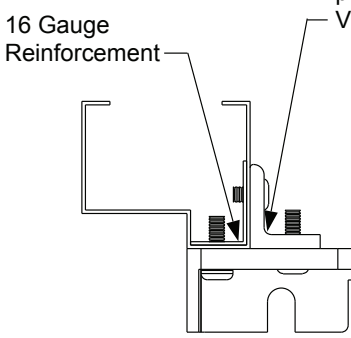
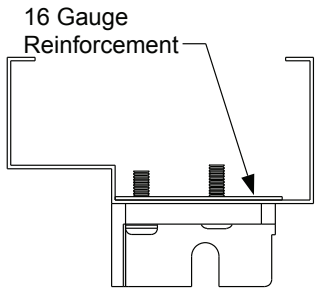
2 Mark holes.

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.

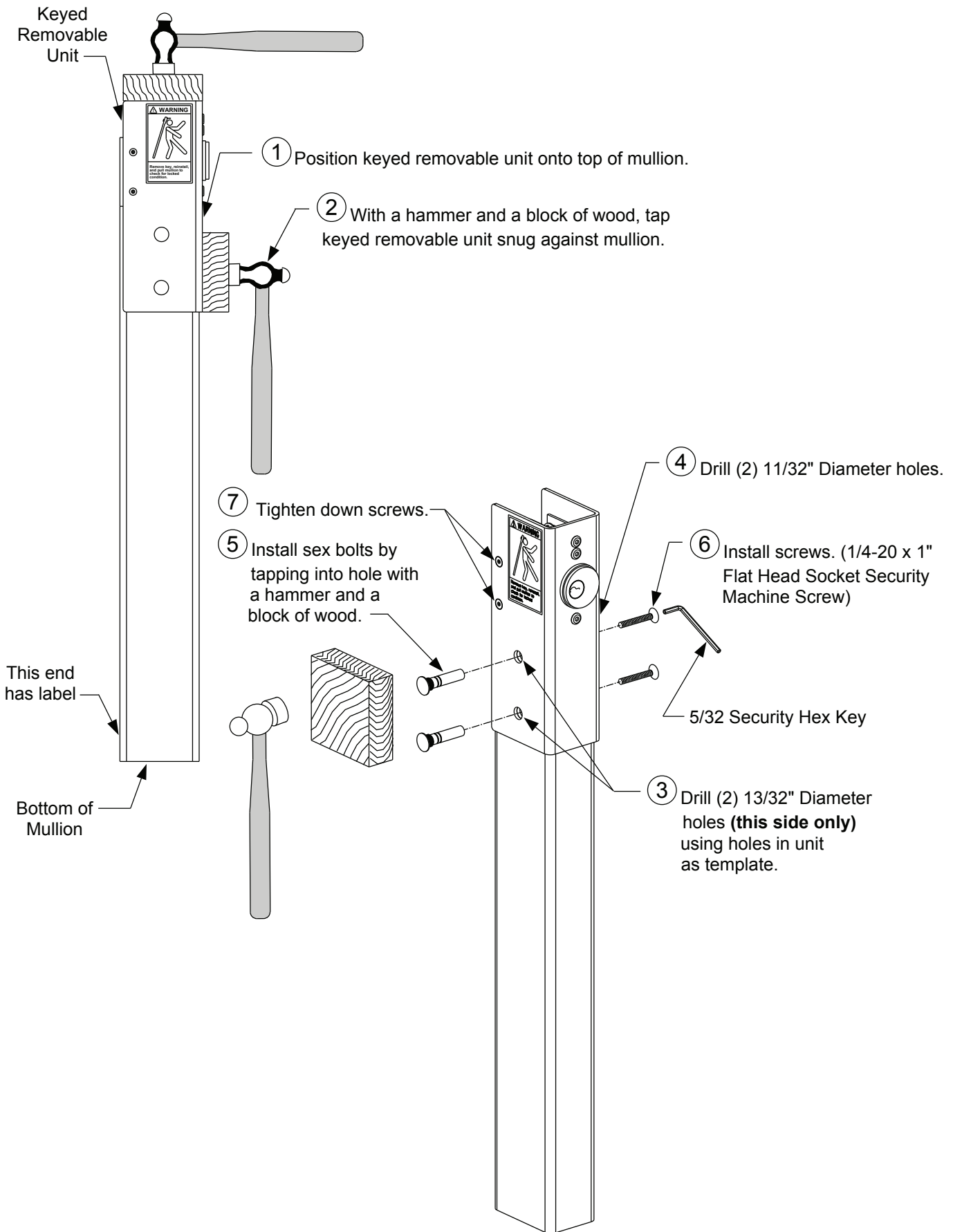
## Mounting Top mullion fitting on optional frame styles:

Angle Bracket can be purchased through Von Duprin.

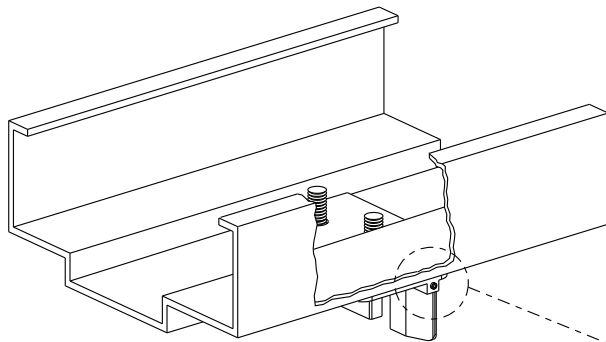


Filler block is to be supplied by frame manufacturer.

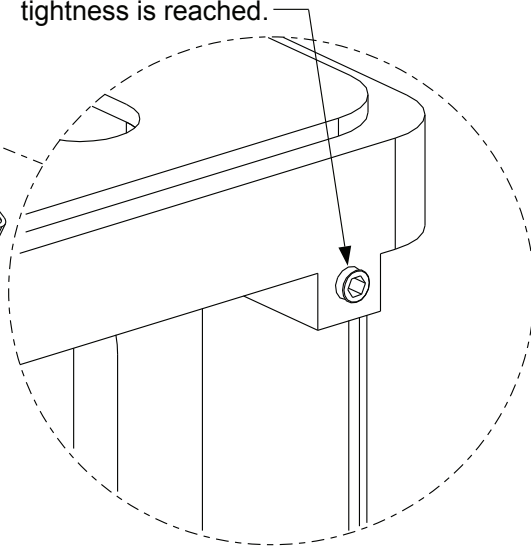
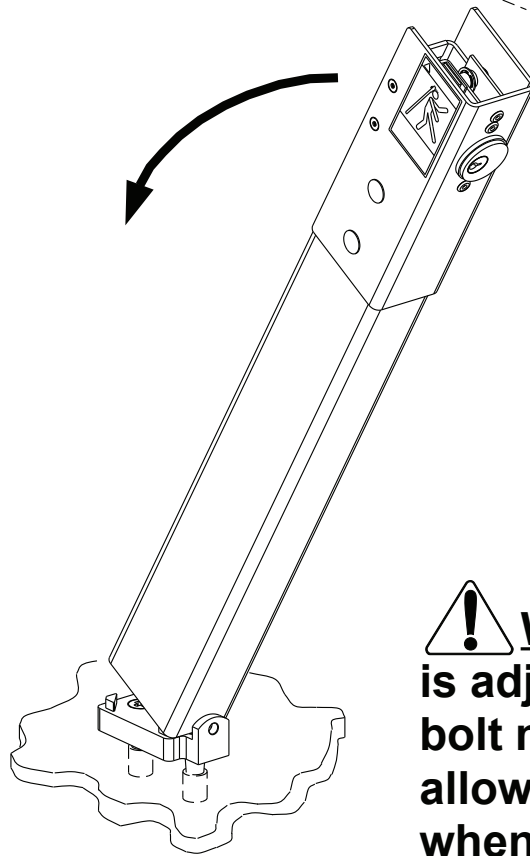
# Step 5 Attach keyed removable unit to mullion.



## Step 6 Final Installation & Adjustment.

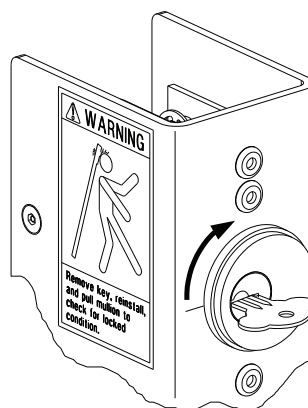


- 1 Install screw. (8-32 x 3/8" set screw) until flush with face of top mullion fitting. Install mullion.
- 2 Check for tightness of mullion by pushing and/or pulling on mullion. To tighten, remove mullion (see Step 7) and rotate set screw out 1/2 turn. Repeat this procedure until desired tightness is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