

VON DUPRIN®

Installation Instructions

KR54, KR1654 & KR4954 Keyed Removable Mullions

Not for use on electric or fire rated removable mullions

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

- Locking mullion assembly
- Top mullion fitting
- 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)
- 5/32" Hex Key
- Top Mullion Fitting Shim
- 5/16-18 x 1-1/4" Phillips Pan Head Machine Screw
- 1/4-20 x 1" Flat Head Socket Security Machine Screw
- 8-32 x 1/4" Undercut Flat Head Socket Security Machine Screw
- Bottom Mullion Fitting (KR1654, KR4954 & KR1654/4954 Blank Only)
- Cylinder Lock Nut
- 8-32 x 3/8" Set Screw
- Sex Bolt
- Cylinder Locking Washer
- Back Cover Plate

Step 1 Prepare the Keyed Removable Unit.

- Position cylinder locking washer over mortise key cylinder. **Note:** Raise the locking pin lever to aid in installation.
- Insert mortise key cylinder through collar and into hole. **Note:** Cylinder must be oriented as shown.
- Thread cylinder lock nut onto mortise key cylinder. **Be sure to fasten down tight.**

Labels in diagram:

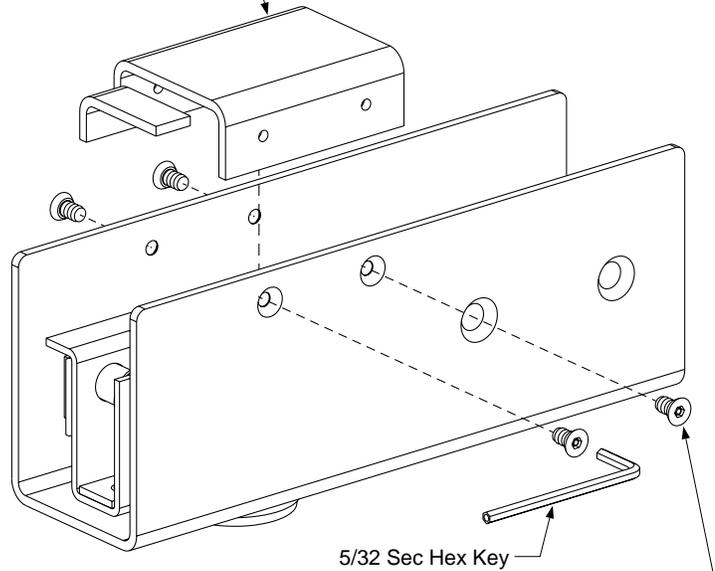
- Collar (not supplied)
- Mortise key cylinder w/standard cam (not supplied)
- 1/8" maximum thickness
- 1-1/8" or 1-1/4"
- Locking pin lever
- Cylinder locking washer
- Cylinder lock nut



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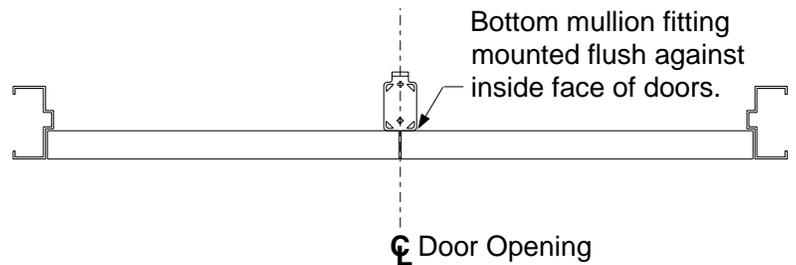
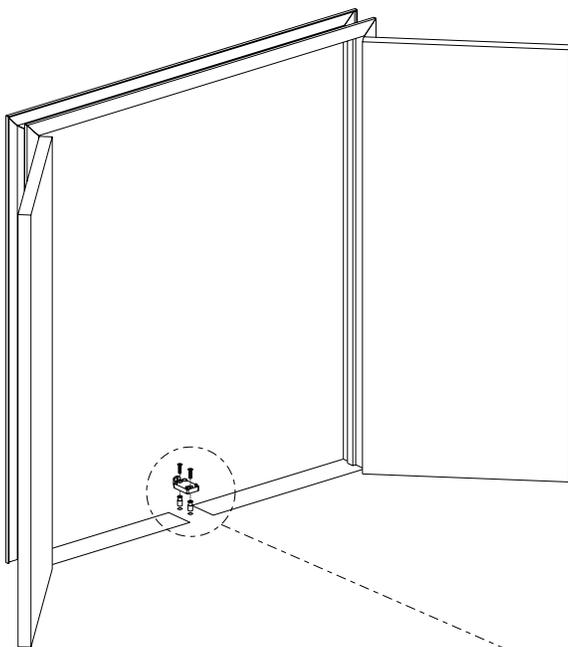


④ Position back cover plate.



⑤ Install screws. (8-32 x 1/4" Undercut Flat Head Socket Security Machine Screw)
Do not tighten down.

Step ② Install bottom mullion fitting. (If bottom mullion fitting already exists, go to Step ④.)



Bottom mullion fitting mounted flush against inside face of doors.

☩ Door Opening

④ Install screws. (5/16-18 x 1 1/4" Flat Pan Head Machine Screw)

③ Position bottom mullion fitting.

② Install 5/16" x 18 expansion anchors.

① Drill 5/8" Diameter x 1 1/2" Deep holes.

Cut threshold to allow bottom mullion fitting to sit on the floor. (Use bottom mullion fitting as template)

☩ Door Opening

Step ③ Size mullion.

Measure from this edge.

Measure to this edge.

① Measure distance from frame to bottom mullion fitting.

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

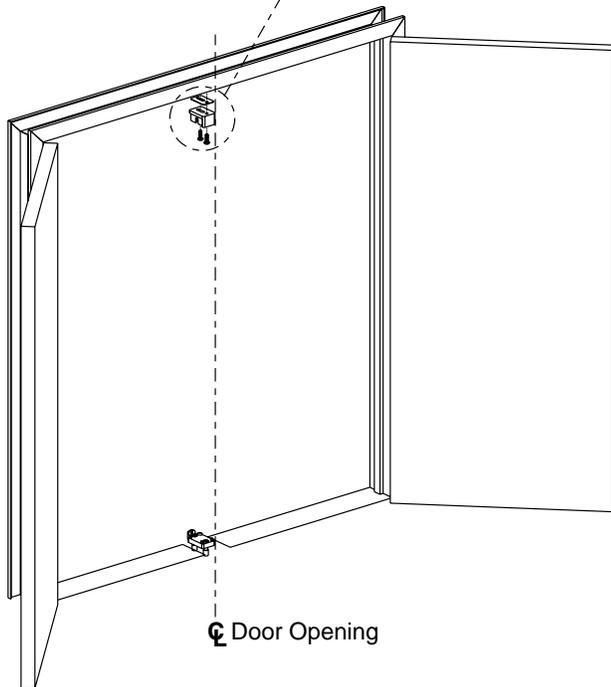
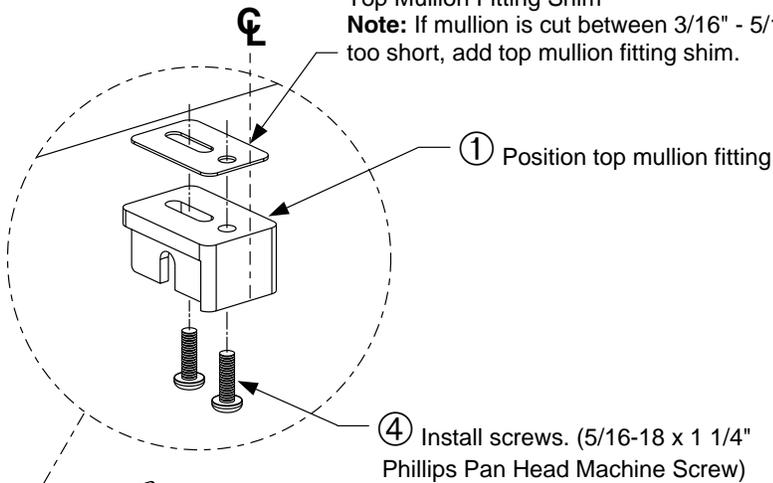
Do not cut end of mullion with warning label.

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

90°

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.



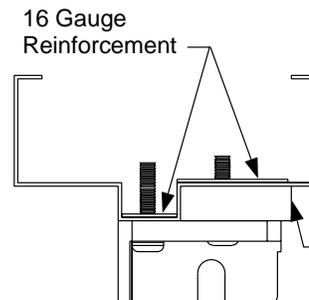
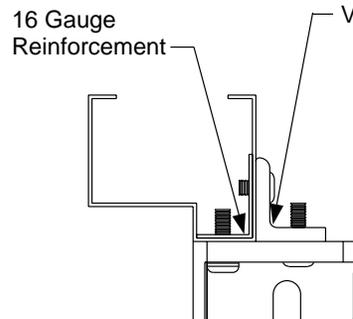
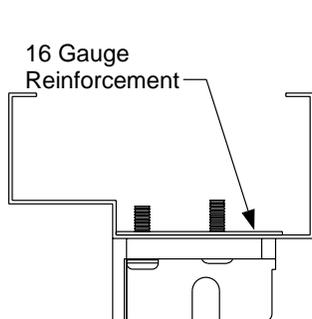
16 Gauge Reinforcement. Supplied by frame manufacturer.

- 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.

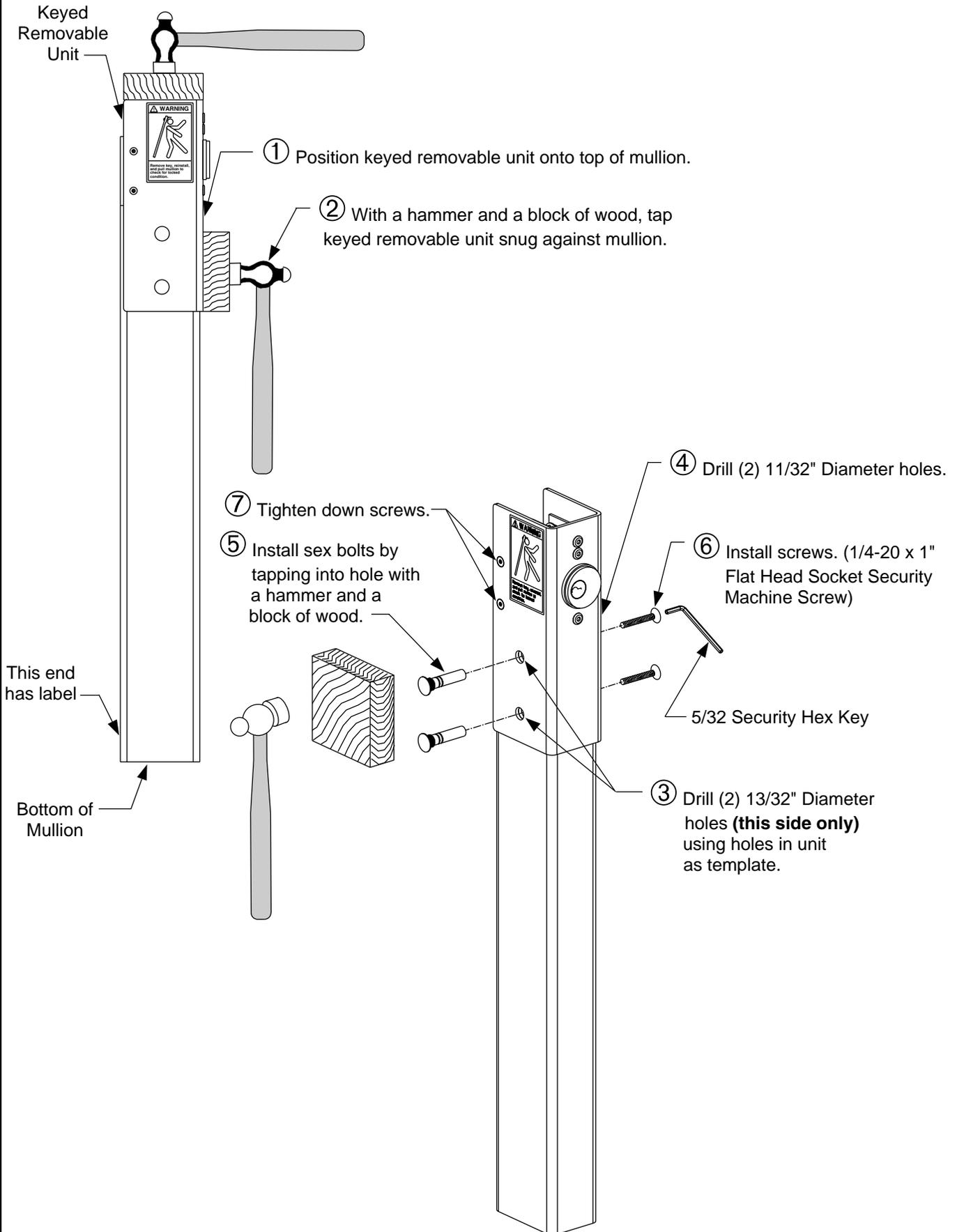
Mounting Top mullion fitting on optional frame styles:

Angle Bracket can be purchased through Von Duprin.

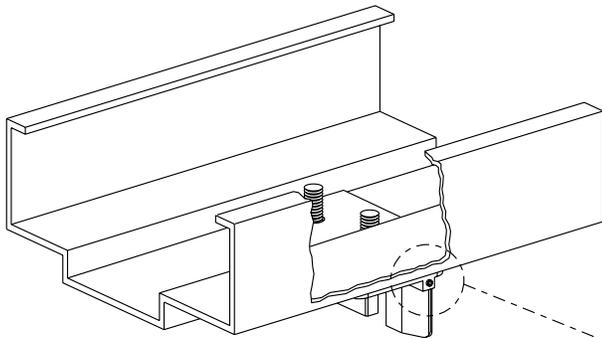


Filler block is to be supplied by frame manufacturer.

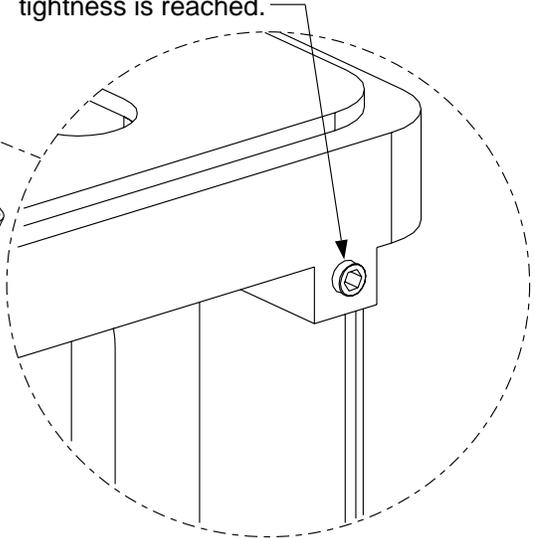
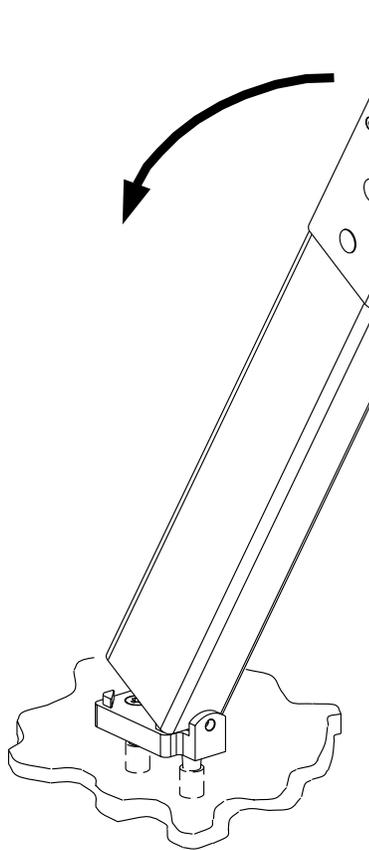
Step 5 Attach keyed removable unit to mullion.



Step 6 Final Installation & Adjustment.

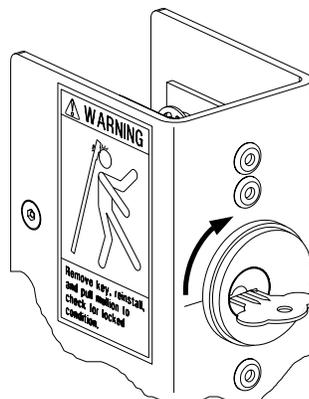


- ① Install screw. (8-32 x 3/8" set screw) until flush with face of top mullion fitting. Install mullion.
- ② Check for tightness of mullion by pushing and/or pulling on mullion. To tighten, remove mullion (see Step 7) and rotate set screw out 1/2 turn. Repeat this procedure until desired tightness is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