

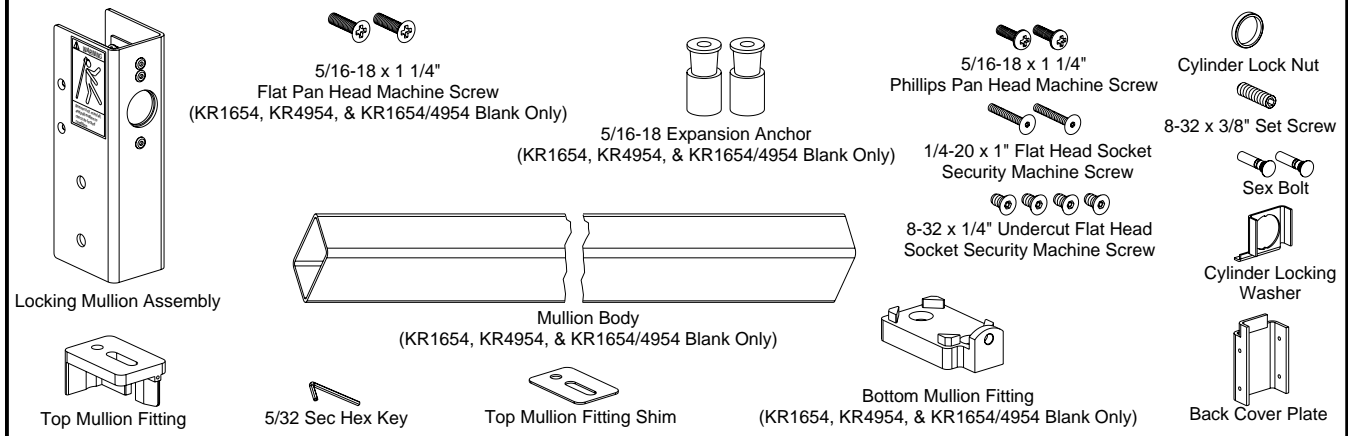
# INSTALLATION INSTRUCTIONS

## KR54, KR1654, & KR4954 Keyed Removable Mullion

**NOT FOR USE ON ELECTRIC OR FIRE RATED MULLIONS.**



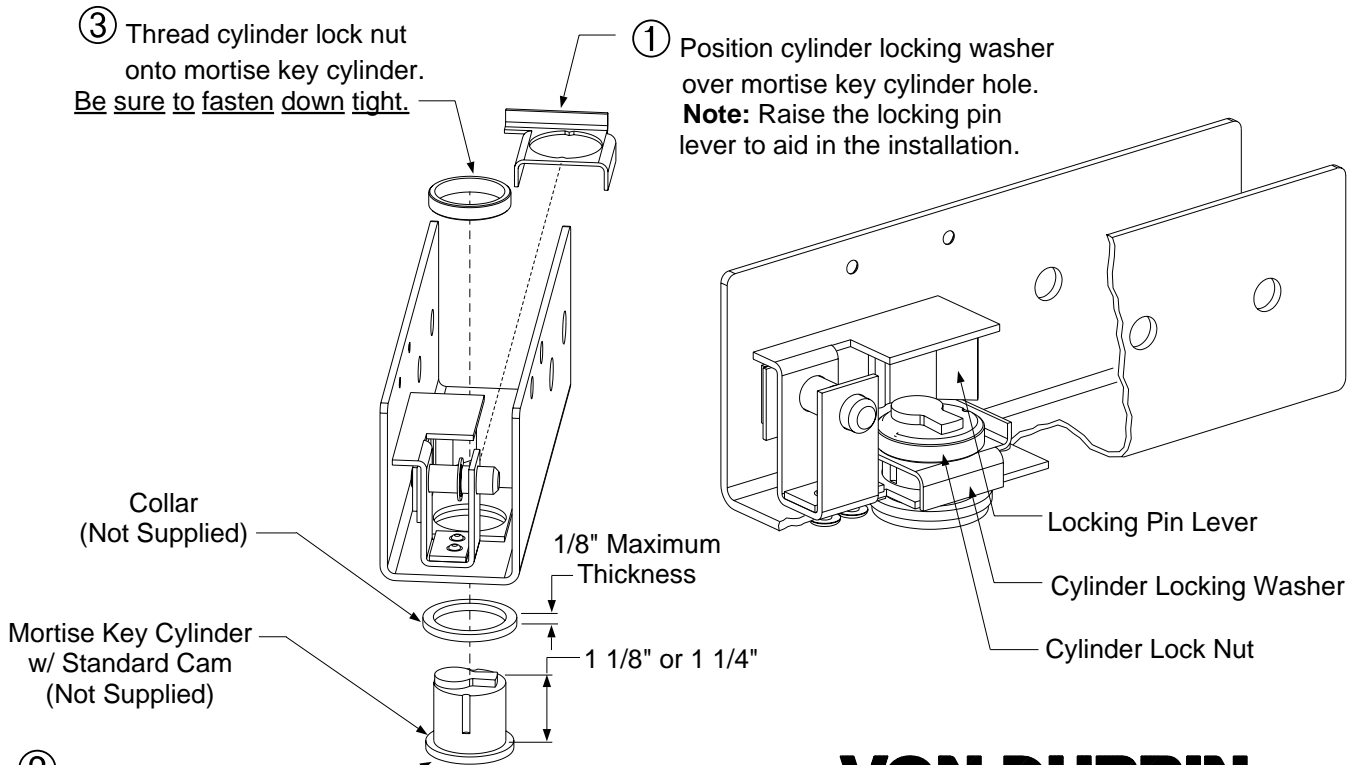
This kit includes the following parts: (Not to scale)



### 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 the installation.

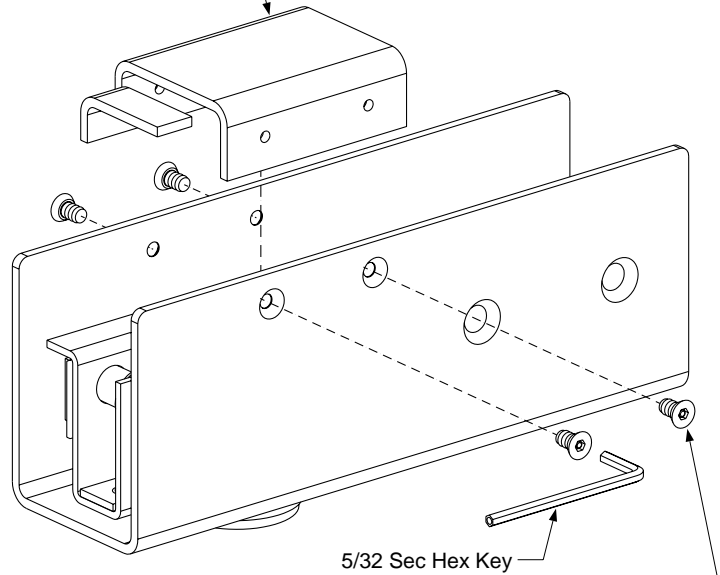


② Insert mortise key cylinder through collar and into hole. **Note:** Cylinder must be oriented as shown.

# VON DUPRIN

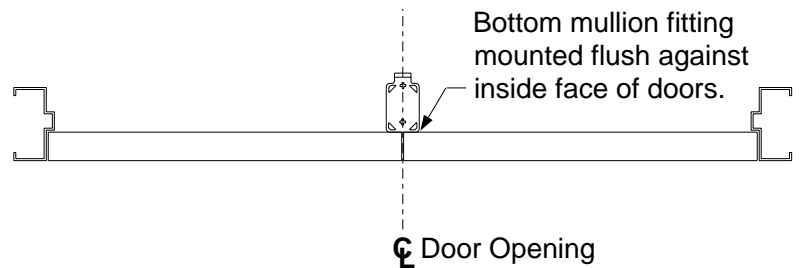
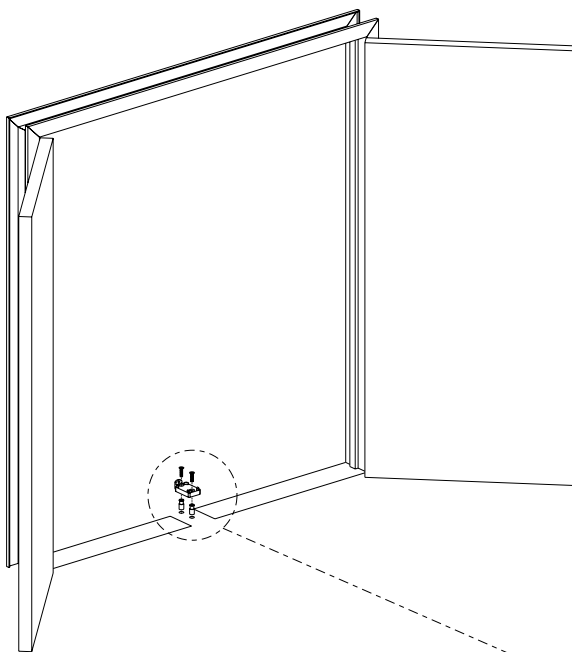
Part of worldwide Ingersoll-Rand

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 6.)



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.

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

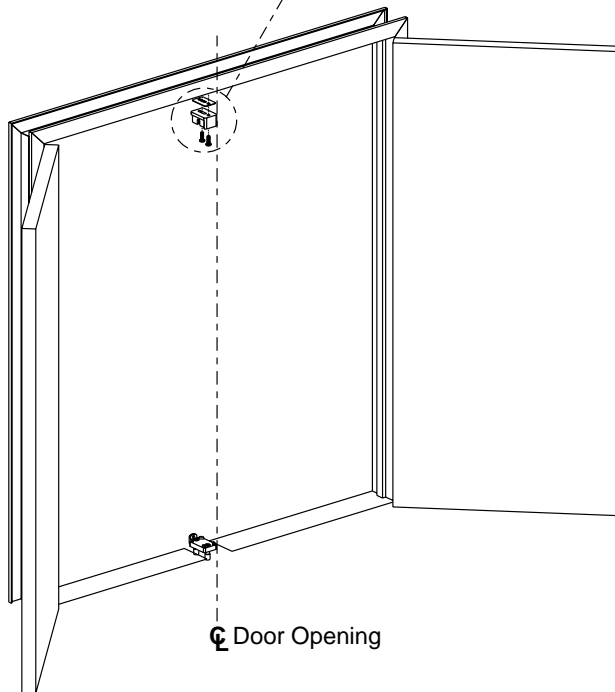
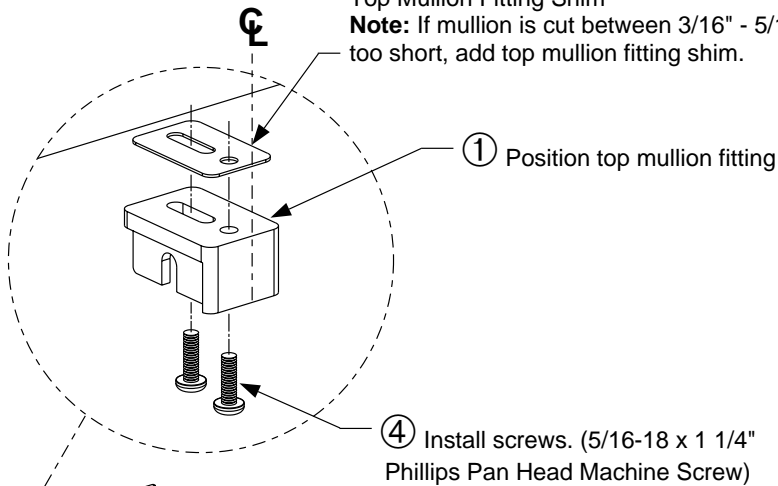
**Do not** cut end of mullion with warning label.

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.



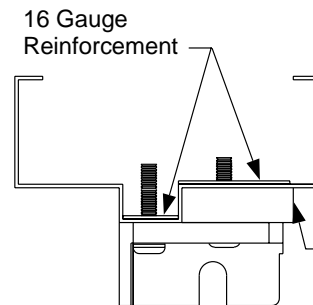
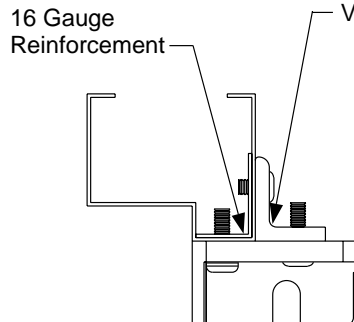
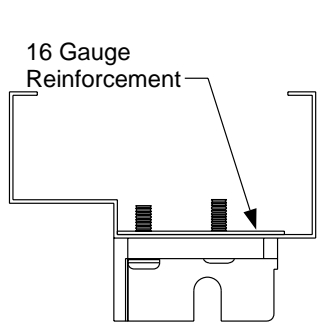
16 Gauge Reinforcement. Supplied by frame manufacturer.

- 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.

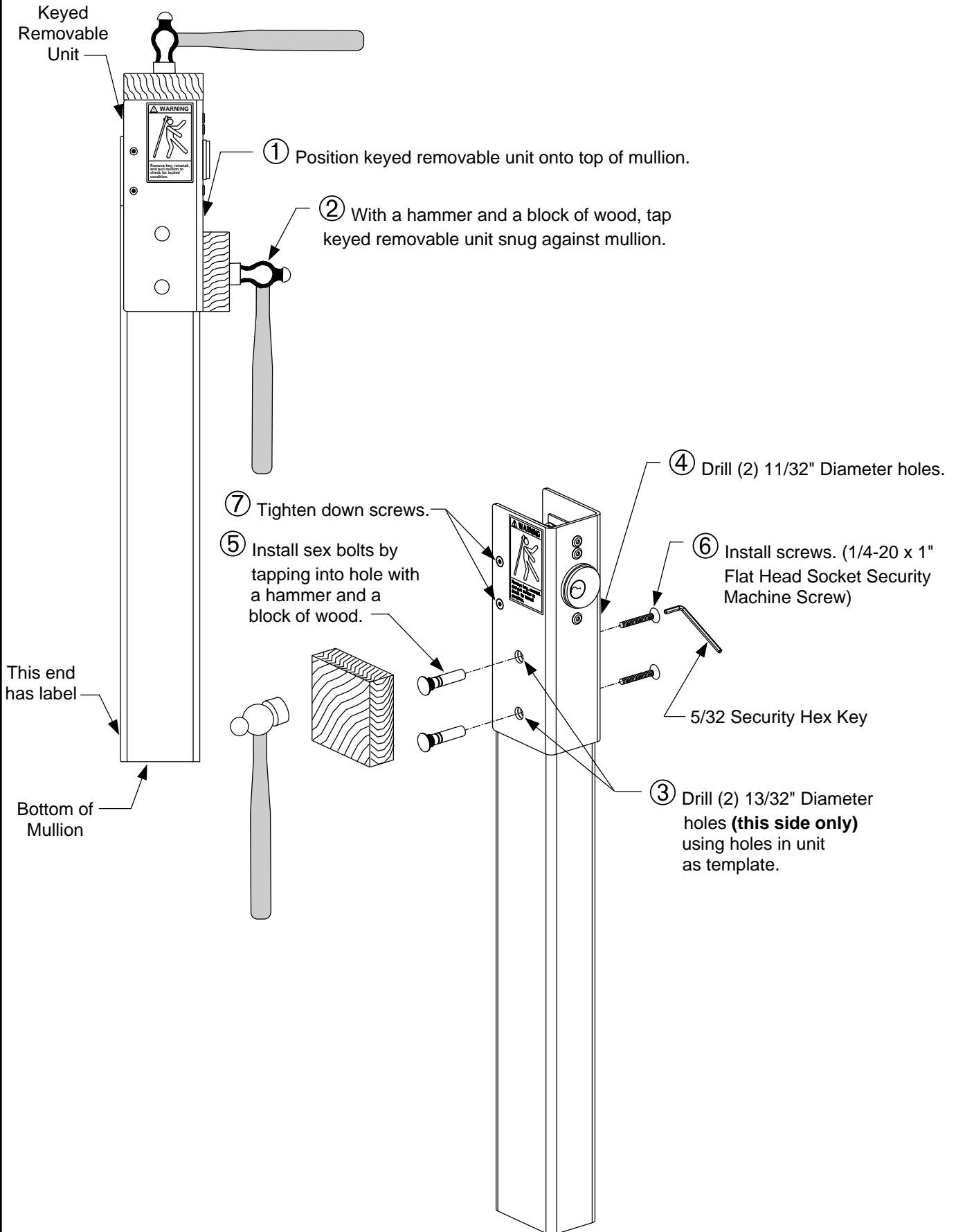
## Mounting Top mullion fitting on optional frame styles:

Angle Bracket can be purchased through Von Duprin.

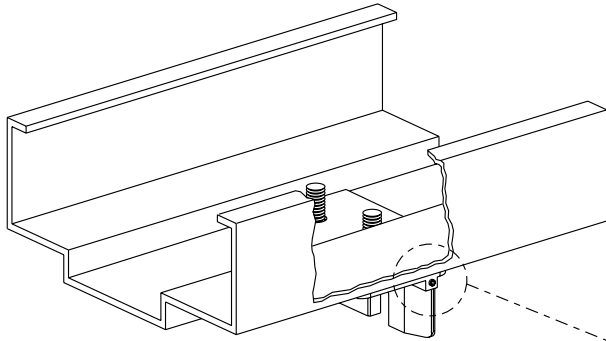


Filler block is to be supplied by frame manufacturer.

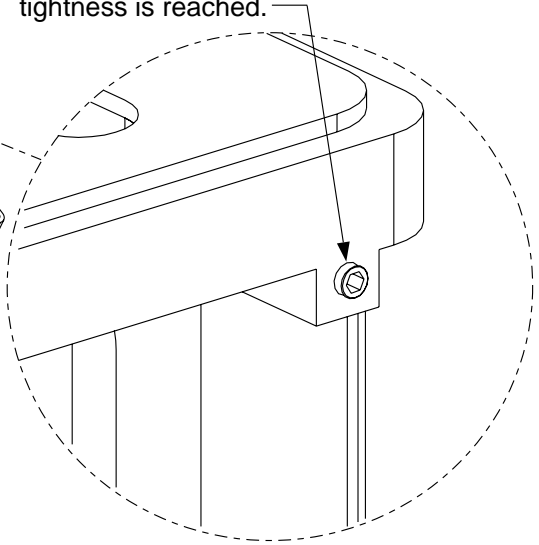
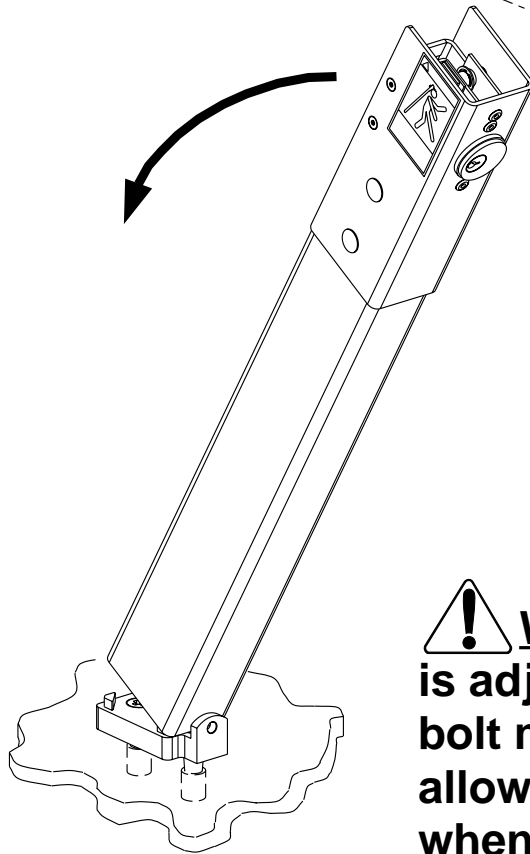
# Step 5 Attach keyed removable unit to mullion.



## Step 6 Final Installation & Adjustment.

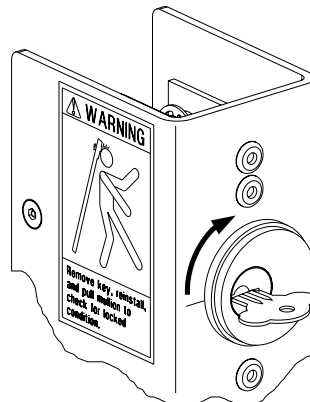


- ① Install screw. (8-32 x 3/8" set screw) until flush with face of top mullion fitting. Install mullion.
- ② Check for tightness of mullion by pushing and/or pulling on mullion. To tighten, remove mullion (see Step 7) and rotate set screw out 1/2 turn. Repeat this procedure until desired tightness is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