Materials List:
1. Valve operating nut or 1½" by 1¼" by 2" high, solid steel welded to riser shaft.
2. ½" thick by 7¼" diameter guide plate welded to riser shaft.
3. 1¼" by ¾" square steel tubing, length as required. Edge weld operating nut at both ends.
4. 2½" by ¾" square steel tubing 2½" in length welded to riser shaft.

Notes:
1. If valve is installed so that the top of the operating nut is less than 30" below finished grade, the stem riser is not required.
2. All welds to riser shaft shall be fillet weld all around, as specified below.
3. All steel required for riser fabrication shall be structural steel per ASTM A36.
4. The top of the valve stem shall be peened slightly to secure the 2" operating nut to the valve stem.
5. All external bolts and nuts on valves shall be 304 stainless steel or the entire valve shall be wrapped tightly with polyethylene film held securely with adhesive tape.
6. After fabrication entire valve stem extension assembly shall be hot dip galvanized.