

| Standard Fabrication Tolerances |               | NTS-EN-S-7.1 |             |
|---------------------------------|---------------|--------------|-------------|
| Revision #                      | Revision Date | Approved By  | Page(s)     |
| 00                              | 08/09/2024    | BCT          | Page 1 of 5 |

| Component                                  | Dimension   | Tolerance |
|--|---|-----------|
| Flat Plate<br>Tolerances Before<br>Cutting | Permitted variations over specified thickness for widths<br>given in inches | ASTM A6   |
|  | Permitted variations in waviness  | ASTM A6   |

| Cut<br>Tolerances |                                   |                |
|-------------------|-----------------------------------|----------------|
|                   | <u>Trapezoid</u>                  |                |
|                   | Length:                           | + 1", - 1/8"   |
|                   | Width:                            | ±1/8"          |
|                   | Squareness:                       | ±1/8"          |
|                   | Bevels (All Sides):               | +10°, -5°      |
|                   | <u>Cut or Drilled Holes/Slots</u> |                |
|                   | Diameter:                         | +1/16", -1/16" |
|                   | Location (Elevation):             | ±1/8"          |
|                   | Location (Flat Centerline):       | ±1/4"          |
|                   | Spacing:                          | ±1/8"          |
|                   | <u>Lifting Holes/Slots</u>        |                |
|                   | Height, Width, Radius:            | ±1/8"          |
|                   | Location (Elevation):             | ±1/4"          |
|                   | Location (Flat Centerline):       | ±1/4"          |
|                   | <u>Ground Sleeve</u>              |                |
|                   | Length:                           | + 1", - 1/8"   |
|                   | Width:                            | ±1/8"          |
|                   | Squareness:                       | ±1/8"          |
|                   | Bevels (All Sides):               | +10°, -5°      |
|                   | <u>Bearing Plates</u>             |                |
|                   | Diameter:                         | +1", - 1/8"    |
|                   | Diameter of cutout:               | +1/8", -1/2"   |
|                   | Thickness:                        | + 1/4", -0"    |
|                   | <u>Pole Caps (Non-Structural)</u> |                |
|                   | Diameter:                         | +1", - 1/8"    |
|                   | Thickness:                        | + 1/16", -0"   |
|                   | <u>Pole Caps (Structural)</u>     |                |
|                   | Diameter:                         | ±1/8"          |
|                   | Thickness:                        | + 1/4", -0"    |
|                   | <u>Cut or Drilled Holes/Slots</u> |                |
|                   | Diameter:                         | +1/16", -1/32" |
|                   | Location:                         | ±1/16"         |
|                   | Spacing:                          | ±1/16"         |

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|---------------------------------|---------------|--------------|-------------|
| Revision #                      | Revision Date | Approved By  | Page(s)     |
| 00                              | 08/09/2024    | BCT          | Page 2 of 5 |

| Component | Dimension                                | Tolerance      |
|-----------|--|----------------|
|           | <b><u>Flange Plates</u></b>              |                |
|           | Diameter:                                | +1", - 1/8"    |
|           | Diameter of cutout:                      | +1/8", -1/2"   |
|           | Thickness:                               | +1/16" -0      |
|           | <b><u>Cut or Drilled Holes/Slots</u></b> |                |
|           | Diameter:                                | +1/16", -1/32" |
|           | Location:                                | ±1/16"         |
|           | Spacing:                                 | ±1/16"         |
|           | <b><u>Base Plates</u></b>                |                |
|           | Diameter:                                | +1", - 1/8"    |
|           | Diameter of cutout:                      | +1/8", -1/2"   |
|           | Thickness:                               | +3/4", -0      |
|           | <b><u>Cut or Drilled Holes/Slots</u></b> |                |
|           | Diameter:                                | +1/8", -1/16"  |
|           | Location:                                | ±1/8"          |
|           | Spacing:                                 | ±1/8"          |
|           | <b><u>Boxes/Brackets</u></b>             |                |
|           | Length:                                  | ±1/8"          |
|           | Width:                                   | +1/8", -1/16"  |
|           | Thickness:                               | ASTM A6        |
|           | <b><u>Cut or Drilled Holes/Slots</u></b> |                |
|           | Diameter:                                | +1/16", -1/32" |
|           | Location:                                | ±1/16"         |
|           | Spacing:                                 | ±1/16"         |
|           | Hole to edge:                            | ±1/8"          |
|           | <b><u>Vangs/Through Plates</u></b>       |                |
|           | Length:                                  | ±1/8"          |
|           | Width:                                   | ±1/16"         |
|           | Radius:                                  | ±1/16"         |
|           | Thickness:                               | ASTM A6        |
|           | Chamfer:                                 | ±1/16"         |
|           | <b><u>Cut or Drilled Holes/Slots</u></b> |                |
|           | Diameter:                                | +1/16", -1/32" |
|           | Location:                                | ±1/16"         |
|           | Spacing:                                 | ±1/16"         |
|           | Hole to edge:                            | ±1/8"          |
|           | <b><u>Anchor Bolt Templates</u></b>      |                |
|           | Length:                                  | +1", - 1/8"    |

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|---------------------------------|---------------|--------------|-------------|
| Revision #                      | Revision Date | Approved By  | Page(s)     |
| 00                              | 08/09/2024    | BCT          | Page 3 of 5 |

| Component                        | Dimension                         | Tolerance                |
|----------------------------------|-----------------------------------|--------------------------|
|                                  | Width:                            | +1", - 1/8"              |
|                                  | Thickness:                        | ASTM A6                  |
|                                  | <b>Cut or Drilled Holes/Slots</b> |                          |
|                                  | Diameter:                         | ±1/16"                   |
|                                  | Location:                         | ±3/32"                   |
|                                  | Spacing:                          | ±1/8"                    |
|                                  | <b>Ground Brackets/Pads</b>       |                          |
|                                  | Length:                           | ±1/8"                    |
|                                  | Width:                            | +1/8", -1/16"            |
|                                  | Thickness:                        | ASTM A6                  |
|                                  | <b>Cut or Drilled Holes/Slots</b> |                          |
|                                  | Diameter:                         | +1/16", -1/32"           |
|                                  | Location:                         | ±1/16"                   |
|                                  | Spacing:                          | ±1/16"                   |
|                                  |                                   |                          |
| <b><u>Forming Tolerances</u></b> | <b>Trapezoid</b>                  |                          |
|                                  | Layout Lines:                     | ±1/8"                    |
|                                  | Width:                            | ±1/8"                    |
|                                  | Bend Lines:                       | ±1/8"                    |
|                                  | Bend Angle:                       | ±2°/Bend, ±5° Cumulative |
|                                  | Bend Angle at long seam:          | ±5°                      |
|                                  | <b>Ground Sleeve</b>              |                          |
|                                  | Layout Lines:                     | ±1/8"                    |
|                                  | Width:                            | ±1/8"                    |
|                                  | Bend Lines:                       | ±1/8"                    |
|                                  | Bend Angle:                       | ±2°/Bend, ±5° Cumulative |
|                                  | <b>Boxes/Brackets</b>             |                          |
|                                  | Bend Angle:                       | 3°                       |
|                                  | Leg Length:                       | ±1/8"                    |
|                                  | Leg Spacing:                      | +1/4", -1/16"            |
|                                  | Squareness:                       | ±3/16"                   |
|                                  |                                   |                          |
| <b><u>Seamer Tolerances</u></b>  | <b>All Sections</b>               |                          |
|                                  | Mismatch(Hi-lo):                  | ±10% Material Thickness  |
|                                  | Misalignment:                     | ±1/16"                   |



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| Revision #                      | Revision Date | Approved By  | Page(s)     |
| 00                              | 08/09/2024    | BCT          | Page 5 of 5 |

| <u>Component</u> | <u>Dimension</u>           | <u>Tolerance</u> |
|------------------|----------------------------|------------------|
|                  | <b><u>Hardware</u></b>     |                  |
|                  | ID Tags                    | ± 1" any axis    |
|                  | Grounding                  | ± 1" any axis    |
|                  | Climbing                   |                  |
|                  | Ladder Clip Groups         | ±1/2"            |
|                  | Clips within a group       | ±1/8"            |
|                  | Jacking Nut Spacing        | ±1/16"           |
|                  | Through Vangs              |                  |
|                  | Elevation                  | ±1/8"            |
|                  | Straightness               | 1/8"             |
|                  | Holes on one side          | +0", -1/8"       |
|                  | Holes on both sides        | 1", -0           |
|                  | Base Plate to pole shaft   |                  |
|                  | Centered on pole           | ±1/4"            |
|                  | Squareness                 | 1°               |
|                  | Flange Plate to pole shaft |                  |
|                  | Centered on pole           | ±1/4"            |
|                  | Squareness                 | .3°              |
|                  | Brackets                   | 1/4"             |
|                  | <b><u>Anchor Bolts</u></b> |                  |
|                  | Overall Length             | +1", -0          |
|                  | Thread Length              | +1", -0          |
|                  | Galvanized Length          | +6", -0          |
|                  | Twist                      | 2°               |
|                  | <b><u>Dents</u></b>        | 1/8"             |