

Material n.º / Material No: 709995

Data: _____

Alma BA de uma peça n.º:

Single-part LE web no.:

/MN-

O texto original está na língua inglesa. A tradução do texto é informativa e tem de ser revista antes da aplicação do protocolo. Em caso de dúvidas ou em caso de contrariedades aplica-se o texto original em inglês. / The English text is the original text. The translation of the text is informative and must be checked before using the protocol. In case of doubt or contradiction, the original English text shall prevail.

Etapa de trabalho / Work step		Assinatura/Signature
Laminados da alma / Web laminate		
Aquecimento(s) do molde ligado(s) (pré-têmpera do molde) <i>Mould heating system(s) switched on (mould pre-curing)</i>		
Laminado do bordo para colagem (LS e LP) colocado conforme documentos de construção <i>Gluing rim laminate (PS and SS) applied as per CD</i> Atenção: 1 camada G1+G1 LS e LP 150 mm de largura <i>Notice:</i> (travão adesivo integrado) 1 layer G1+G1, SS and PS, 150 mm wide R1153.150.10002- <u>X</u> (integrated glue brake)		
Encaixe de bypass colocado (centralmente R40000) <i>Bypass reinforcement insert laid (centred, R40000)</i>		
Camadas (laminado sandwich do lado oposto do molde) colocadas conforme os documentos de construção <i>Lay-up (sandwich laminate on side of mould) applied as per CD</i>		
Segmentos de espuma criados de acordo com o plano de camadas <i>Foam segments applied as per lay-up plan</i>		
Data de entrega / n.º de lote do kit de espuma: _____ / _____ <i>Foam kit delivery date/batch no.:</i>		
Camadas (laminado sandwich do lado oposto do molde) colocadas conforme os documentos de construção <i>Lay-up (sandwich laminate on side opposite mould) arranged as per CD</i>		
Corte alma bordo de ataque (BA) / <i>Cutting of LE web</i>	N.º: _____	
Placa do componente colocada em R6000 / <i>Type plate placed at R6000</i>		

Sistema de vácuo e infusão / Vacuum system and infusion

Sistema de vácuo concluído e teste de impermeabilidade efetuado <i>Vacuum system completed and leak test conducted</i>		
Temperatura da resina / <i>Resin temperature:</i> _____ °C		
Início da infusão <i>Infusion started</i>	Início/Start: _____ horas/o'clock	Fim/End: _____ horas/o'clock
		Quantidade de resina <i>Resin quantity:</i> _____ l

Têmpera / Curing

Início da têmpera / <i>Start of curing:</i> _____ horas/o'clock	
Fim da têmpera / <i>End of curing:</i> _____ horas/o'clock	

DF-1153-14 Alma BA uma peça - single-part LE we Rev0.1	Traduzido por (nome/data): TD/2020-06-17
Elaborado por (nome/data): A. Arndt/2019-11-11	Aprovado por (nome/data): J. Kannenberg/2019-11-11

Etapa de trabalho / Work step	Assinatura/Signature
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Rebarbação / Deburring

Rebarbação dos bordos de colagem/arestas do componente
 Deburring of gluing rims/component edges

SAP

Confirmação SAP concluída / SAP confirmation completed

Controlo de qualidade / Quality control

OK	Não OK
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Início do segmento: R4500, fim do segmento: R51048

Segment start: R4500; segment end: R51048

Laminado sandwich do lado do molde *)

Sandwich laminate on side of mould *)

<input type="checkbox"/> R04	<input type="checkbox"/> R05	<input type="checkbox"/> R06	<input type="checkbox"/> R07	<input type="checkbox"/> R08	<input type="checkbox"/> R09	<input type="checkbox"/> R10	<input type="checkbox"/> R11
<input type="checkbox"/> R12	<input type="checkbox"/> R13	<input type="checkbox"/> R14	<input type="checkbox"/> R15	<input type="checkbox"/> R16	<input type="checkbox"/> R17	<input type="checkbox"/> R18	<input type="checkbox"/> R19
<input type="checkbox"/> R20	<input type="checkbox"/> R21	<input type="checkbox"/> R22	<input type="checkbox"/> R23	<input type="checkbox"/> R24	<input type="checkbox"/> R25	<input type="checkbox"/> R26	<input type="checkbox"/> R27
<input type="checkbox"/> R28	<input type="checkbox"/> R29	<input type="checkbox"/> R30	<input type="checkbox"/> R31	<input type="checkbox"/> R32	<input type="checkbox"/> R33	<input type="checkbox"/> R34	<input type="checkbox"/> R35
<input type="checkbox"/> R36	<input type="checkbox"/> R37	<input type="checkbox"/> R38	<input type="checkbox"/> R39	<input type="checkbox"/> R40	<input type="checkbox"/> R41	<input type="checkbox"/> R42	<input type="checkbox"/> R43
<input type="checkbox"/> R44	<input type="checkbox"/> R45	<input type="checkbox"/> R46	<input type="checkbox"/> R47	<input type="checkbox"/> R48	<input type="checkbox"/> R49	<input type="checkbox"/> R50	<input type="checkbox"/> R51

Laminado sandwich do lado oposto do molde (lado oposto da mesa) *)

Mould opposite-side sandwich laminate (side opposite mould) *)

<input type="checkbox"/> R04	<input type="checkbox"/> R05	<input type="checkbox"/> R06	<input type="checkbox"/> R07	<input type="checkbox"/> R08	<input type="checkbox"/> R09	<input type="checkbox"/> R10	<input type="checkbox"/> R11
<input type="checkbox"/> R12	<input type="checkbox"/> R13	<input type="checkbox"/> R14	<input type="checkbox"/> R15	<input type="checkbox"/> R16	<input type="checkbox"/> R17	<input type="checkbox"/> R18	<input type="checkbox"/> R19
<input type="checkbox"/> R20	<input type="checkbox"/> R21	<input type="checkbox"/> R22	<input type="checkbox"/> R23	<input type="checkbox"/> R24	<input type="checkbox"/> R25	<input type="checkbox"/> R26	<input type="checkbox"/> R27
<input type="checkbox"/> R28	<input type="checkbox"/> R29	<input type="checkbox"/> R30	<input type="checkbox"/> R31	<input type="checkbox"/> R32	<input type="checkbox"/> R33	<input type="checkbox"/> R34	<input type="checkbox"/> R35
<input type="checkbox"/> R36	<input type="checkbox"/> R37	<input type="checkbox"/> R38	<input type="checkbox"/> R39	<input type="checkbox"/> R40	<input type="checkbox"/> R41	<input type="checkbox"/> R42	<input type="checkbox"/> R43
<input type="checkbox"/> R44	<input type="checkbox"/> R45	<input type="checkbox"/> R46	<input type="checkbox"/> R47	<input type="checkbox"/> R48	<input type="checkbox"/> R49	<input type="checkbox"/> R50	<input type="checkbox"/> R51

Laminado da borda para colagem (lado de sucção) **) / Gluing rim laminate (SS side) **)

<input type="checkbox"/> R04	<input type="checkbox"/> R05	<input type="checkbox"/> R06	<input type="checkbox"/> R07	<input type="checkbox"/> R08	<input type="checkbox"/> R09	<input type="checkbox"/> R10	<input type="checkbox"/> R11
<input type="checkbox"/> R12	<input type="checkbox"/> R13	<input type="checkbox"/> R14	<input type="checkbox"/> R15	<input type="checkbox"/> R16	<input type="checkbox"/> R17	<input type="checkbox"/> R18	<input type="checkbox"/> R19
<input type="checkbox"/> R20	<input type="checkbox"/> R21	<input type="checkbox"/> R22	<input type="checkbox"/> R23	<input type="checkbox"/> R24	<input type="checkbox"/> R25	<input type="checkbox"/> R26	<input type="checkbox"/> R27
<input type="checkbox"/> R28	<input type="checkbox"/> R29	<input type="checkbox"/> R30	<input type="checkbox"/> R31	<input type="checkbox"/> R32	<input type="checkbox"/> R33	<input type="checkbox"/> R34	<input type="checkbox"/> R35
<input type="checkbox"/> R36	<input type="checkbox"/> R37	<input type="checkbox"/> R38	<input type="checkbox"/> R39	<input type="checkbox"/> R40	<input type="checkbox"/> R41	<input type="checkbox"/> R42	<input type="checkbox"/> R43
<input type="checkbox"/> R44	<input type="checkbox"/> R45	<input type="checkbox"/> R46	<input type="checkbox"/> R47	<input type="checkbox"/> R48	<input type="checkbox"/> R49	<input type="checkbox"/> R50	<input type="checkbox"/> R51

Laminado da borda para colagem (lado de pressão) **) / Gluing rim laminate (PS side) **)

<input type="checkbox"/> R04	<input type="checkbox"/> R05	<input type="checkbox"/> R06	<input type="checkbox"/> R07	<input type="checkbox"/> R08	<input type="checkbox"/> R09	<input type="checkbox"/> R10	<input type="checkbox"/> R11
<input type="checkbox"/> R12	<input type="checkbox"/> R13	<input type="checkbox"/> R14	<input type="checkbox"/> R15	<input type="checkbox"/> R16	<input type="checkbox"/> R17	<input type="checkbox"/> R18	<input type="checkbox"/> R19
<input type="checkbox"/> R20	<input type="checkbox"/> R21	<input type="checkbox"/> R22	<input type="checkbox"/> R23	<input type="checkbox"/> R24	<input type="checkbox"/> R25	<input type="checkbox"/> R26	<input type="checkbox"/> R27
<input type="checkbox"/> R28	<input type="checkbox"/> R29	<input type="checkbox"/> R30	<input type="checkbox"/> R31	<input type="checkbox"/> R32	<input type="checkbox"/> R33	<input type="checkbox"/> R34	<input type="checkbox"/> R35
<input type="checkbox"/> R36	<input type="checkbox"/> R37	<input type="checkbox"/> R38	<input type="checkbox"/> R39	<input type="checkbox"/> R40	<input type="checkbox"/> R41	<input type="checkbox"/> R42	<input type="checkbox"/> R43
<input type="checkbox"/> R44	<input type="checkbox"/> R45	<input type="checkbox"/> R46	<input type="checkbox"/> R47	<input type="checkbox"/> R48	<input type="checkbox"/> R49	<input type="checkbox"/> R50	<input type="checkbox"/> R51

Etapa de trabalho / Work step	Assinatura/Signature
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Controlo de qualidade / Quality control

 Não
OK OK

Travão adesivo do lado oposto do molde R4500 até R33000 (LS) <i>Mould opposite-side glue brake, R4500 to R33000 (SS side)</i>									<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> R04	<input type="checkbox"/> R05	<input type="checkbox"/> R06	<input type="checkbox"/> R07	<input type="checkbox"/> R08	<input type="checkbox"/> R09	<input type="checkbox"/> R10	<input type="checkbox"/> R11			
<input type="checkbox"/> R12	<input type="checkbox"/> R13	<input type="checkbox"/> R14	<input type="checkbox"/> R15	<input type="checkbox"/> R16	<input type="checkbox"/> R17	<input type="checkbox"/> R18	<input type="checkbox"/> R19			
<input type="checkbox"/> R20	<input type="checkbox"/> R21	<input type="checkbox"/> R22	<input type="checkbox"/> R23	<input type="checkbox"/> R24	<input type="checkbox"/> R25	<input type="checkbox"/> R26	<input type="checkbox"/> R27			
<input type="checkbox"/> R28	<input type="checkbox"/> R29	<input type="checkbox"/> R30	<input type="checkbox"/> R31	<input type="checkbox"/> R32	<input type="checkbox"/> R33					
Travão adesivo do lado oposto do molde R4500 até R33000 (LP) <i>Mould opposite-side glue brake, R4500 to R33000 (PS side)</i>									<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> R04	<input type="checkbox"/> R05	<input type="checkbox"/> R06	<input type="checkbox"/> R07	<input type="checkbox"/> R08	<input type="checkbox"/> R09	<input type="checkbox"/> R10	<input type="checkbox"/> R11			
<input type="checkbox"/> R12	<input type="checkbox"/> R13	<input type="checkbox"/> R14	<input type="checkbox"/> R15	<input type="checkbox"/> R16	<input type="checkbox"/> R17	<input type="checkbox"/> R18	<input type="checkbox"/> R19			
<input type="checkbox"/> R20	<input type="checkbox"/> R21	<input type="checkbox"/> R22	<input type="checkbox"/> R23	<input type="checkbox"/> R24	<input type="checkbox"/> R25	<input type="checkbox"/> R26	<input type="checkbox"/> R27			
<input type="checkbox"/> R28	<input type="checkbox"/> R29	<input type="checkbox"/> R30	<input type="checkbox"/> R31	<input type="checkbox"/> R32	<input type="checkbox"/> R33					
Saliência do laminado no lado do flange (distância entre o bordo e o início do material do núcleo) no arco do segmento 30 mm + 10 mm / - 0 mm <i>Flange-end laminate projection (distance from deburred edge to start of core material) on Segment bow, 30 mm +10 mm/-0 mm</i>									<input type="checkbox"/>	<input type="checkbox"/>
Camada do material de núcleo plana, sem desalinhamento <i>Position of core material is even, no offset</i>									<input type="checkbox"/>	<input type="checkbox"/>
Posição do encaixe do bypass correta (central R40000) <i>Position of bypass reinforcement insert correct (centred, R40000)</i>									<input type="checkbox"/>	<input type="checkbox"/>
Recorte de bordos de 120mm de largura total (150mm na área do travão adesivo) <i>Deburring of rim, total width 120 mm (150 mm in the area of the glue brake)</i>									<input type="checkbox"/>	<input type="checkbox"/>
Alma BA sem danos / LE web undamaged									<input type="checkbox"/>	<input type="checkbox"/>

*) completa e sem danos!

**) incluindo gargal para a alma sandwich

*) Complete and without defects!

**) Including the flute between rim and web sandwich

Alma BA de uma peça retida <input type="checkbox"/> <i>Single-part LE web barred</i>	Aprovado sob reserva <input type="checkbox"/> <i>Approved with reservations</i>	Aprovado / Approved <input type="checkbox"/>
Registos no SAP concluídos <input type="checkbox"/> <i>SAP entries made</i>	Data / Date:	Assinatura / Signature: