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| 1 | | Data / Date _____ |
| 2 | Nº de material / Material No 1071970 | |
| 3 | Casca da pá do rotor (lado de sucção) Nº / <i>Rotor blade shell (suction face) No. _____/MN- _____</i> | |
| 4 | 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. / <i>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.</i> | |
| 5 | Etapa de trabalho / Production step | Assinatura / Signature |
| 6 | Material de Gelcoat usado / <i>Gelcoat material used</i> <input checked="" type="checkbox"/> _____ | |
| 7 | Lote n.º / <i>Batch No.:</i> A: <input checked="" type="checkbox"/> _____ B: <input checked="" type="checkbox"/> _____ | |
| 8 | Espessura da camada do solo / <i>Wet thickness (nominal: 250-300 µm)</i> | |
| 9 | Flange / <i>Flange:</i> <input checked="" type="checkbox"/> _____ µm | |
| 10 | Centro / <i>Centre:</i> <input checked="" type="checkbox"/> _____ µm | |
| 11 | Tip da pá / <i>Blade tip:</i> <input checked="" type="checkbox"/> _____ µm | |
| 12 | Segmento 1 da pré-forma inspecionado e corretamente instalado / <i>Segment 1 of the preform inspected and correctly installed no.:</i> <input checked="" type="checkbox"/> _____ | |
| 13 | TE-UD-LS da pré-forma inspecionado e corretamente instalado / <i>TE-UD part SS inspected and correctly installed no.:</i> <input checked="" type="checkbox"/> _____ | |
| 14 | Laminado externo completo e instalado de acordo com DC / <i>Outer laminate and lightning protection are complete and installed in accordance with</i> <input checked="" type="checkbox"/> D02895283- _____ | |
| 15 | N.º de série do blank de não-tecido (laminado externo) / <i>Series No. of the non-woven fabric blank (outer laminate) no.:</i> <input checked="" type="checkbox"/> _____ | |
| 16 | Segmento 2 da pré-forma inspecionado e corretamente instalado / <i>Segment 2 of the preform inspected and correctly installed no.:</i> <input checked="" type="checkbox"/> _____ | CQ/QA |
| 17 | Tipo e numero de Segmento 2 de pré-forma / Type and number of preform segment 2: No. de parte de enrolamento / <i>Winded part</i> (acc. D02894273) <input checked="" type="checkbox"/> _____ No. de blank de não tecido / <i>Layed-up part</i> (acc. D02826681) <input checked="" type="checkbox"/> _____ | CQ/QA |
| 18 | Reforços externos locais introduzidos de acordo com DC / <i>Local outer reinforcements inserted in accordance with</i> <input checked="" type="checkbox"/> D02900330- _____ | |
| 19 | Longarina (lado de sucção) corretamente posicionada e instalada (início R3000, fim R87250) / <i>Spar boom (suction face) positioned and installed correctly (start R3000, end R87250)</i> _____ | CQ/QA |
| 20 | Longarina (LS) / <i>Spar boom (SF) no.:</i> <input checked="" type="checkbox"/> _____ | CQ/QA |
| 21 | Data de entrega/n.º de lote do kit de espuma/kit de madeira de balsa / <i>Delivery date/Batch No. of the foam/balsa wood kit</i> <input checked="" type="checkbox"/> _____ / <input checked="" type="checkbox"/> _____ | |
| 22 | Realizadas 3 leituras da humidade da madeira de balsa (%) / <i>3 readings of the humidity of the balsa wood taken (%)</i> <input checked="" type="checkbox"/> _____ / <input checked="" type="checkbox"/> _____ / <input checked="" type="checkbox"/> _____ | CQ/QA |
| 23 | Material de núcleo instalado de acordo com o DC / <i>Core material installed in accordance with</i> <input checked="" type="checkbox"/> D02914583- _____ | |
| 24 | Áreas sem material de núcleo inspecionado / <i>Areas without core material inspected</i> _____ | |
| 25 | Reforços internos locais introduzidos de acordo com DC / <i>Local inner reinforcements inserted in accordance with</i> <input checked="" type="checkbox"/> D02904658- _____ | |

ENERCON Partner

| 26 | Etapa de trabalho / Production step | Assinatura / Signature |
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| 27 | Laminado interno introduzido de acordo com DC / Inner laminate inserted in accordance with <input checked="" type="checkbox"/> D02900921-_____ | |
| 28 | N.º de série do blank de não-tecido (laminado interno) / Series No. of the non-woven fabric blank (inner laminate): <input checked="" type="checkbox"/> _____ | |
| 29 | Etiqueta de Identificação instalada / Label of serial number installed _____ | |
| 30 | Sistema de vácuo completo e verificações efetuadas na selagem / Vacuum system complete and checks carried out on the sealing _____ | |
| 31 | Aprovação para processo de infusão / Approval for infusion _____ | CQ/QA |
| 32 | Aquecimento do molde ativado / Mould heating activated _____ | |
| 33 | Dados de processo preenchidos completamente, DF-175-91 DadosDeInfusão-InfusionData / Process data completely filled in the protocol DF-175-91 DadosDeInfusão-InfusionData _____ | |
| 34 | Confirmação SAP enviada / SAP confirmation sent _____ | |
| 35 | No caso do registo eletrónico de dados de controlo (lote de controlo SAP), este protocolo termina aqui. / In the case of electronic inspection data recording (SAP inspection lot), this log ends here. | |
| 36 | Controle de qualidade / Quality assurance | ok / nok |
| 37 | Material de núcleo (bordo de ataque) Início: R5000, fim: R64660 / Core material (leading edge) Start: R5000, End: R64660 _____ | <input type="checkbox"/> <input type="checkbox"/> |
| 38 | Diferenças na espessura do material de núcleo (bordo de ataque) R30000 (40 a 25,4), R35400 (25,4 a 19), R55400 (19 a 12,7) / Differences in the thickness of the core material (leading edge) R30000 (40 to 25,4), R35400 (25,4 to 19), R55400 (19 to 12,7) _____ | <input type="checkbox"/> <input type="checkbox"/> |
| 39 | Bordo sem material de núcleo no bordo de ataque / Rim without core material on the leading edge _____ | <input type="checkbox"/> <input type="checkbox"/> |
| | <input type="checkbox"/> R04:120 <input type="checkbox"/> R05:120 <input type="checkbox"/> R06:120 <input type="checkbox"/> R07:120 <input type="checkbox"/> R08:120 <input type="checkbox"/> R09:120 <input type="checkbox"/> R10:120 <input type="checkbox"/> R11:120 <input type="checkbox"/> R12:120 <input type="checkbox"/> R13:120 <input type="checkbox"/> R14:120 <input type="checkbox"/> R15:120 <input type="checkbox"/> R16:120 <input type="checkbox"/> R17:120 <input type="checkbox"/> R18:120 <input type="checkbox"/> R19:120 <input type="checkbox"/> R20:120 <input type="checkbox"/> R21:120 <input type="checkbox"/> R22:120 <input type="checkbox"/> R23:120 <input type="checkbox"/> R24:120 <input type="checkbox"/> R25:120 <input type="checkbox"/> R26:120 <input type="checkbox"/> R27:120 <input type="checkbox"/> R28:120 <input type="checkbox"/> R29:120 <input type="checkbox"/> R30:120 <input type="checkbox"/> R31:120 <input type="checkbox"/> R32:120 <input type="checkbox"/> R33:120 <input type="checkbox"/> R34:120 <input type="checkbox"/> R35:120 <input type="checkbox"/> R36:120 <input type="checkbox"/> R37:120 <input type="checkbox"/> R38:120 <input type="checkbox"/> R39:120 <input type="checkbox"/> R40:120 <input type="checkbox"/> R41:120 <input type="checkbox"/> R42:120 <input type="checkbox"/> R43:120 <input type="checkbox"/> R44:120 <input type="checkbox"/> R45:120 <input type="checkbox"/> R46:120 <input type="checkbox"/> R47:120 <input type="checkbox"/> R48:120 <input type="checkbox"/> R49:120 <input type="checkbox"/> R50:120 <input type="checkbox"/> R51:120 <input type="checkbox"/> R52:120 <input type="checkbox"/> R53:120 <input type="checkbox"/> R54:120 <input type="checkbox"/> R55:120 <input type="checkbox"/> R56:120 <input type="checkbox"/> R57:120 <input type="checkbox"/> R58:120 <input type="checkbox"/> R59:120 <input type="checkbox"/> R60:120 <input type="checkbox"/> R61:120 <input type="checkbox"/> R62:120 <input type="checkbox"/> R63:120 <input type="checkbox"/> R64:120 | |
| 40 | Posição dos segmentos de espuma entre a longarina e o bordo de ataque (reta, alinhada, sem arestas ou fendas) / Position of the foam segments between the spar boom and the leading edge (straight, flush, without edges or gaps) _____ | <input type="checkbox"/> <input type="checkbox"/> |
| 41 | Material de núcleo (bordo de fuga) início: R5700, fim: R84550 / Core material (trailing edge) Start: R5700, End: R84550 _____ | <input type="checkbox"/> <input type="checkbox"/> |
| 42 | Diferenças na espessura do material de núcleo (bordo de fuga) R20592 (38,1 a 50,8), R40508 (50,8 a 38,1), R66000 (38,1 a 38,1/40), R70400 (38,1/40 a 30), R75400 (30 a 20) / Differences in the thickness of the core material (trailing edge) R20592 (38,1 to 50,8), R40508 (50,8 to 38,1), R66000 (38,1 to 38,1/40), R70400 (38,1/40 to 30), R75400 (30 to 20) _____ | <input type="checkbox"/> <input type="checkbox"/> |

| 43 | Controle de qualidade / Quality assurance | ok / nok |
|----|--|---|
| 44 | Bordo sem material de núcleo no bordo de fuga / <i>Rim without core material on the trailing edge</i> _____ | <input type="checkbox"/> <input type="checkbox"/> |
| | <input type="checkbox"/> R05:210 <input type="checkbox"/> R06:210 <input type="checkbox"/> R07:135 <input type="checkbox"/> R08:135 <input type="checkbox"/> R09:135 <input type="checkbox"/> R10:135 <input type="checkbox"/> R11:135 <input type="checkbox"/> R12:135 <input type="checkbox"/> R13:135 <input type="checkbox"/> R14:135 <input type="checkbox"/> R15:135 <input type="checkbox"/> R16:135 <input type="checkbox"/> R17:135 <input type="checkbox"/> R18:135 <input type="checkbox"/> R19:135 <input type="checkbox"/> R20:135 <input type="checkbox"/> R21:135 <input type="checkbox"/> R22:135 <input type="checkbox"/> R23:135 <input type="checkbox"/> R24:135 <input type="checkbox"/> R25:135 <input type="checkbox"/> R26:000 <input type="checkbox"/> R27:000 <input type="checkbox"/> R28:000 <input type="checkbox"/> R29:000 <input type="checkbox"/> R30:000 <input type="checkbox"/> R31:000 <input type="checkbox"/> R32:000 <input type="checkbox"/> R33:000 <input type="checkbox"/> R34:000 <input type="checkbox"/> R35:000 <input type="checkbox"/> R36:000 <input type="checkbox"/> R37:000 <input type="checkbox"/> R38:000 <input type="checkbox"/> R39:000 <input type="checkbox"/> R40:125 <input type="checkbox"/> R41:125 <input type="checkbox"/> R42:140 <input type="checkbox"/> R43:140 <input type="checkbox"/> R44:140 <input type="checkbox"/> R45:140 <input type="checkbox"/> R46:140 <input type="checkbox"/> R47:140 <input type="checkbox"/> R48:140 <input type="checkbox"/> R49:140 <input type="checkbox"/> R50:140 <input type="checkbox"/> R51:140 <input type="checkbox"/> R52:140 <input type="checkbox"/> R53:140 <input type="checkbox"/> R54:140 <input type="checkbox"/> R55:140 <input type="checkbox"/> R56:140 <input type="checkbox"/> R57:140 <input type="checkbox"/> R58:140 <input type="checkbox"/> R59:140 <input type="checkbox"/> R60:180 <input type="checkbox"/> R61:180 <input type="checkbox"/> R62:180 <input type="checkbox"/> R63:180 <input type="checkbox"/> R64:180 <input type="checkbox"/> R65:180 <input type="checkbox"/> R66:180 <input type="checkbox"/> R67:180 <input type="checkbox"/> R68:180 <input type="checkbox"/> R69:180 <input type="checkbox"/> R70:180 <input type="checkbox"/> R71:180 <input type="checkbox"/> R72:180 <input type="checkbox"/> R73:180 <input type="checkbox"/> R74:147 <input type="checkbox"/> R75:113 <input type="checkbox"/> R76:100 <input type="checkbox"/> R77:100 <input type="checkbox"/> R78:100 <input type="checkbox"/> R79:100 <input type="checkbox"/> R80:100 <input type="checkbox"/> R81:100 <input type="checkbox"/> R82:100 <input type="checkbox"/> R83:100 <input type="checkbox"/> R84:100 | |
| 45 | Posição dos segmentos de espuma entre a longarina e o bordo de fuga (reta, alinhada, sem arestas ou fendas)./ <i>Position of the foam segments between the spar boom and the trailing edge (straight, flush, without edges or gaps)</i> _____ | <input type="checkbox"/> <input type="checkbox"/> |
| 46 | Execução do laminado interno entre a longarina e o bordo de ataque / <i>Execution of the inner laminate between the spar boom and the leading edge</i> _____ | <input type="checkbox"/> <input type="checkbox"/> |
| | <input type="checkbox"/> R01 <input type="checkbox"/> R02 <input type="checkbox"/> R03 <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 <input type="checkbox"/> R52 <input type="checkbox"/> R53 <input type="checkbox"/> R54 <input type="checkbox"/> R55 <input type="checkbox"/> R56 <input type="checkbox"/> R57 <input type="checkbox"/> R58 <input type="checkbox"/> R59 <input type="checkbox"/> R60 <input type="checkbox"/> R61 <input type="checkbox"/> R62 <input type="checkbox"/> R63 <input type="checkbox"/> R64 <input type="checkbox"/> R65 <input type="checkbox"/> R66 <input type="checkbox"/> R67 <input type="checkbox"/> R68 <input type="checkbox"/> R69 <input type="checkbox"/> R70 <input type="checkbox"/> R71 <input type="checkbox"/> R72 <input type="checkbox"/> R73 <input type="checkbox"/> R74 <input type="checkbox"/> R75 <input type="checkbox"/> R76 <input type="checkbox"/> R77 <input type="checkbox"/> R78 <input type="checkbox"/> R79 <input type="checkbox"/> R80 <input type="checkbox"/> R81 <input type="checkbox"/> R82 <input type="checkbox"/> R83 <input type="checkbox"/> R84 <input type="checkbox"/> R85 <input type="checkbox"/> R86 <input type="checkbox"/> R87 | |
| 47 | Execução do laminado interno sobre a longarina / <i>Execution of the inner laminate over the spar boom</i> _____ | <input type="checkbox"/> <input type="checkbox"/> |
| | <input type="checkbox"/> R01 <input type="checkbox"/> R02 <input type="checkbox"/> R03 <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 <input type="checkbox"/> R52 <input type="checkbox"/> R53 <input type="checkbox"/> R54 <input type="checkbox"/> R55 <input type="checkbox"/> R56 <input type="checkbox"/> R57 <input type="checkbox"/> R58 <input type="checkbox"/> R59 <input type="checkbox"/> R60 <input type="checkbox"/> R61 <input type="checkbox"/> R62 <input type="checkbox"/> R63 <input type="checkbox"/> R64 <input type="checkbox"/> R65 <input type="checkbox"/> R66 <input type="checkbox"/> R67 <input type="checkbox"/> R68 <input type="checkbox"/> R69 <input type="checkbox"/> R70 <input type="checkbox"/> R71 <input type="checkbox"/> R72 <input type="checkbox"/> R73 <input type="checkbox"/> R74 <input type="checkbox"/> R75 <input type="checkbox"/> R76 <input type="checkbox"/> R77 <input type="checkbox"/> R78 <input type="checkbox"/> R79 <input type="checkbox"/> R80 <input type="checkbox"/> R81 <input type="checkbox"/> R82 <input type="checkbox"/> R83 <input type="checkbox"/> R84 <input type="checkbox"/> R85 <input type="checkbox"/> R86 <input type="checkbox"/> R87 | |
| 48 | Casca da pá do rotor (LS) sem danos / <i>Rotor blade shell (SF) undamaged</i> _____ | <input type="checkbox"/> <input type="checkbox"/> |
| 49 | Casca da pá do rotor (LS) rejeitada / <i>Rotor blade shell (SF) rejected</i> <input type="checkbox"/> _____ | |
| 50 | Aprovada sob reserva / <i>Provisionally approved</i> <input type="checkbox"/> _____ | |
| 51 | Aprovada / <i>Approved</i> <input type="checkbox"/> _____ | |
| 52 | Inspetor (assinatura e data) / <i>Inspector (signature and date)</i> _____ | |