

Material n.º / Material No: 195854

Data: _____

Blank R2 n.º:

R2 blank 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
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Rebarbação / Deburring

Rebarbação bordo de ataque / Deburring of leading edge	
Rebarbação bordo de fuga / Deburring of trailing edge	
Ajuste área de colagem ângulo de colagem pré-forma segmento 1 BA <i>Modification of gluing area on preform segment 1 LE glue cap</i>	
Ajuste área de colagem ângulo de colagem pré-forma segmento 1 BF <i>Modification of gluing area on preform segment 1 TE glue cap</i>	

Controlo de qualidade / Quality control

OK Não OK

Desvio do bordo de ataque entre a casca da pá LS e a casca da pá LP (máx. 2 mm) <i>Offset at the leading edge between rotor blade shell SS and rotor blade shell PS (max. 2 mm)</i>											<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> R01	<input type="checkbox"/> R03	<input type="checkbox"/> R05	<input type="checkbox"/> R07	<input type="checkbox"/> R09	<input type="checkbox"/> R11	<input type="checkbox"/> R13	<input type="checkbox"/> R15	<input type="checkbox"/> R17	<input type="checkbox"/> R19			
<input type="checkbox"/> R21	<input type="checkbox"/> R23	<input type="checkbox"/> R25	<input type="checkbox"/> R27	<input type="checkbox"/> R29	<input type="checkbox"/> R31	<input type="checkbox"/> R33	<input type="checkbox"/> R35	<input type="checkbox"/> R37	<input type="checkbox"/> R39			
<input type="checkbox"/> R41	<input type="checkbox"/> R43	<input type="checkbox"/> R45										
Junta de colagem bordo de ataque (4±2 mm) / <i>Leading-edge gluing joint (4±2 mm)</i>											<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> R01	<input type="checkbox"/> R03	<input type="checkbox"/> R05	<input type="checkbox"/> R07	<input type="checkbox"/> R09	<input type="checkbox"/> R11	<input type="checkbox"/> R13	<input type="checkbox"/> R15	<input type="checkbox"/> R17	<input type="checkbox"/> R19			
<input type="checkbox"/> R21	<input type="checkbox"/> R23	<input type="checkbox"/> R25	<input type="checkbox"/> R27	<input type="checkbox"/> R29	<input type="checkbox"/> R31	<input type="checkbox"/> R33	<input type="checkbox"/> R35	<input type="checkbox"/> R37	<input type="checkbox"/> R39			
<input type="checkbox"/> R41	<input type="checkbox"/> R43	<input type="checkbox"/> R45										
Colagem do ângulo de colagem BA com casca da pá LS (exterior) – injetar* <i>Gluing of LE glue cap with rotor blade shell SS (outside) – glue injection*</i>											<input type="checkbox"/>	<input type="checkbox"/>
<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									

DF-1153-26 Blank R2 - R2 blank Rev0.1.docx	Traduzido por (nome/data): TD/2020-06-17
Elaborado por (nome/data): A. Arndt/2019-11-05	Aprovado por (nome/data): J. Kannenberg/2020-06-17

Etapa de trabalho / Work step										Assinatura/Signature		
Controlo de qualidade / Quality control										OK	Não OK	
Colagem do ângulo de colagem BA com casca da pá LS (exterior) – rep. padrão** <i>Gluing of LE glue cap with rotor blade shell SS (outside) – standard repair**</i>											<input type="checkbox"/>	<input type="checkbox"/>
<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									
Desvio do bordo de fuga entre a casca da pá LS e a casca da pá LP (máx. 2 mm) <i>Offset at the trailing edge between rotor blade shell SS and rotor blade shell PS (max. 2 mm)</i>											<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> R01	<input type="checkbox"/> R03	<input type="checkbox"/> R05	<input type="checkbox"/> R07	<input type="checkbox"/> R09	<input type="checkbox"/> R11	<input type="checkbox"/> R13	<input type="checkbox"/> R15	<input type="checkbox"/> R17	<input type="checkbox"/> R19			
<input type="checkbox"/> R21	<input type="checkbox"/> R23	<input type="checkbox"/> R25	<input type="checkbox"/> R27	<input type="checkbox"/> R29	<input type="checkbox"/> R31	<input type="checkbox"/> R33	<input type="checkbox"/> R35	<input type="checkbox"/> R37	<input type="checkbox"/> R39			
<input type="checkbox"/> R40												
Junta de colagem bordo de fuga (4±2 mm) / TE gluing joint (4±2 mm)											<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> R01	<input type="checkbox"/> R03	<input type="checkbox"/> R05	<input type="checkbox"/> R07	<input type="checkbox"/> R09	<input type="checkbox"/> R11	<input type="checkbox"/> R13	<input type="checkbox"/> R15	<input type="checkbox"/> R17	<input type="checkbox"/> R19			
<input type="checkbox"/> R21	<input type="checkbox"/> R23	<input type="checkbox"/> R25	<input type="checkbox"/> R27	<input type="checkbox"/> R29	<input type="checkbox"/> R31	<input type="checkbox"/> R33						
Colagem do ângulo de colagem BF com casca da pá LS (exterior) – injetar* <i>Gluing of TE glue cap with rotor blade shell SS (outside) – glue injection*</i>											<input type="checkbox"/>	<input type="checkbox"/>
<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											
Colagem do ângulo de colagem BF com casca da pá LS (exterior) – rep. padrão** <i>Gluing of TE glue cap with rotor blade shell SS (outside) – standard repair**</i>											<input type="checkbox"/>	<input type="checkbox"/>
<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											
Colagem alma guia com casca do rotor LS (lado BA) – injetar* (exterior)*** <i>Gluing of hat web with rotor blade shell PS (LE-side) – glue injection* (outside)***</i>											<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> R51	<input type="checkbox"/> R52	<input type="checkbox"/> R53	<input type="checkbox"/> R54	<input type="checkbox"/> R55								
Colagem alma guia com casca do rotor LS (lado BA) – rep. padrão** (exterior)*** <i>Gluing of hat web with rotor blade shell PS (LE-side) – standard repair** (outside)***</i>											<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> R51	<input type="checkbox"/> R52	<input type="checkbox"/> R53	<input type="checkbox"/> R54	<input type="checkbox"/> R55								
Colagem alma seg. 5 com casca do rotor LS (lado BA) – injetar* (exterior)*** <i>Gluing of web seg. 5 with rotor blade shell PS (LE-side) – glue injection* (outside)***</i>											<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> R55	<input type="checkbox"/> R56											

Etapa de trabalho / Work step										Assinatura/Signature	
Controlo de qualidade / Quality control										OK	Não OK
Colagem alma seg. 5 com casca do rotor LS (lado BA) – rep. padrão** (exterior)*** <i>Gluing of web seg. 5 with rotor blade shell PS (LE-side) – standard repair** (outside)***</i>										<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> R55	<input type="checkbox"/> R56										
Colagem do bordo de fuga – injetar* / <i>Gluing on trailing edge – glue injection*</i>										<input type="checkbox"/>	<input type="checkbox"/>
<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							
Colagem do bordo de fuga – rep. padrão** / <i>Gluing on trailing edge – standard repair*</i>										<input type="checkbox"/>	<input type="checkbox"/>
<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							
Laminado externo casca da pá LS entre a longarina e o bordo de ataque <i>Outer laminate, rotor blade shell SS, between spar boom and 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					
Laminado externo casca da pá LS sobre a longarina <i>Outer laminate (rotor blade shell SS) on 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					
Laminado externo casca da pá LS entre a longarina e o bordo de fuga <i>Outer laminate (rotor blade shell SS) between spar boom and trailing 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					

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

OK	Não OK
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Laminado externo casca da pá LP entre a longarina e o bordo de ataque <i>Outer laminate (rotor blade shell PS) between spar boom and 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								
Laminado externo casca da pá LP sobre a longarina <i>Outer laminate (rotor blade shell PS) on 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								
Laminado externo casca da pá LP entre a longarina e o bordo de fuga <i>Outer laminate (rotor blade shell PS) between spar boom and trailing 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								
Espessura do bordo de fuga (medir e documentar a espessura a cada metro com um paquímetro!) <i>Trailing edge thickness (measure and record the thickness every metre using a calliper!)</i> Espessura nominal / Target thickness: R20086: 336,9 mm +/- 5 R23000: 188,9 mm +/- 5 R25396: 103,0 mm +/- 4 R29090: 33,6 mm +/- 4 R32754: 10,4 mm +3,6/-3,4 R36421: 5,9 mm +3,1/-2,9 R39942: 2,8 mm +2/-1,8 R40350: 2,7 mm +2/-1,7 R40351 – R57690: 3 mm +/-1											<input type="checkbox"/>	<input type="checkbox"/>		
<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													



ENERCON
Rotorblattproduktion

Documento de Fabricação /
Manufacturing record
E-115 EP3-RB-03

Revisão: 0.1

Página 5 de 5

Etapa de trabalho / Work step	Assinatura/Signature
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Controlo de qualidade / Quality control	OK	Não OK
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Colagem do arco da ponta da pá com a casca da pá LS <i>Gluing of tip bow with rotor blade shell SS</i>	<input type="checkbox"/>	<input type="checkbox"/>
Colagem arco da ponta da pá com casca da pá LP / <i>Gluing of tip bow with rotor blade shell PS</i>	<input type="checkbox"/>	<input type="checkbox"/>
Inspeção por luz área da raiz R1480 até R4500 <i>Fluoroscopy test for root area, R1480 to R4500</i>	<input type="checkbox"/>	<input type="checkbox"/>
LS/SS: _____ LP/PS: _____ BF/TE: _____ BA/LE: _____		
Blank R2 sem danos / <i>Blank R2 undamaged</i>	<input type="checkbox"/>	<input type="checkbox"/>

- * Injetar = furar e encher com cola PU os defeitos de tamanho médio que não estejam abertos até ao exterior, bem como enchimento de defeitos abertos até ao exterior com cola original.
- ** As reparações padrão incluem a exposição das superfícies não conectadas (normalmente lixando), torná-las ásperas e restaurá-las por laminação.
- *** Alma guia e alma seg. 5 são inspecionadas do exterior na área da cobertura do bordo de ataque de R55000 até R69000 após o corte!
- * *For the glue injection, closed, medium-sized defects are drilled open and filled with PU glue. Open defects are filled with the glue originally used*
- ** *Standard repairs include opening up the unconnected surfaces (usually through sanding), roughening them and recreating them through lamination.*
- *** *After deburring, the hat web and web seg. 5 are inspected from the outside on the LE side in the area of the leading-edge cover from R55000 to R69000!*

Blank R2 retido <input type="checkbox"/> <i>R2 blank barred</i>	Aprovado sob reserva <input type="checkbox"/> <i>Approved with reservations</i>	Aprovado / <i>Approved</i> <input type="checkbox"/>
Registos no SAP concluídos <input type="checkbox"/> <i>SAP entries made</i>	Data / <i>Date</i> :	Inspetor / <i>Inspector</i> :

DF-1153-26 Blank R2 - R2 blank Rev0.1.docx	Traduzido por (nome/data): TD/2020-06-17
Elaborado por (nome/data): A. Arndt/2019-11-05	Aprovado por (nome/data): J. Kannenberg/2020-06-17