

Material n.º: 195854

Data / Date:

**R1 blank n.º:****R1 blank n.º****/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.*

<b>Etapa de trabalho / Work step</b>	<b>Assinatura/Signature</b>
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**Inspeção das partes individuais / Inspection of individual parts**

Componentes verificados antes da instalação / <i>All components checked before installation</i>	Casca da pá do rotor (LS) N.º: _____ / <i>Rotor blade shell (SS)</i>	
	Casca da pá do rotor (LP) N.º: _____ / <i>Rotor blade shell (PS)</i>	

**Colagem / Gluing**

Preparações / <i>Preparations:</i>  - Peel ply removido completamente das superfícies de colagem / <i>Peel ply fully removed from all gluing surfaces</i>  - Todas as superfícies de colagem cuidadosamente pré-roladas / <i>All gluing surfaces carefully pre-rolled</i>  - Atenção prestada à limpeza (sem acesso às superfícies de colagem preparadas, sem pó de lixamento, etc.) / <i>Attention paid to cleanliness (no access to prepared gluing surfaces, no grinding dust, etc.)</i>	
Todas as superfícies de colagem encontram-se revestidas de modo suficiente com resina de colagem para garantir a colagem <u>sem furos vazios</u> em todas as áreas da superfície; verificada toda a aplicação de resina de colagem / <i>All gluing surfaces sufficiently coated with gluing resin to guarantee gluing <u>without holes</u> on all surface areas; complete application of gluing resin checked</i>	
Aplicação de resina de colagem inspecionada antes de vedar as cascas da pá do rotor / <i>Application of gluing resin inspected before sealing rotor blade shells</i>	Colaboradores do CQ / QA employees
Todos os elementos de tensionamento corretamente selados / <i>All mould tensioning elements correctly sealed</i>	
Retificação dos defeitos / <i>Rectification of defects:</i>  - Excesso, fugas e derramamento de resina de colagem removida de todas as áreas acessíveis / <i>Excess, leaking and spilled gluing resin removed from all accessible areas</i>  - Todas as colagens acessíveis verificadas e (se necessário) melhoradas através da aplicação de resina de colagem  adicional à junta de colagem (a colagem tem de estar isenta de defeitos!) / <i>All accessible gluing checked and (if necessary) improved by applying additional gluing resin to gluing joints (gluing must be free of voids!)</i>	

DF-1153-25 Blank R1 - R1 blank Rev3.docx	Verificado por (nome/data): Mónica Sousa/2023-09-11
Compilado por (nome/data): Thayc Marinho/2023-07-18	Aprovado por (nome/data): Volker Burkandt/2023-09-11

Etapa de trabalho / Work step	Assinatura/Signature
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**Cura**

Início da cura: _____ horas / <i>Start of curing o'clock</i>	
Fim da cura: _____ horas / <i>End of curing o'clock</i>	
Aprovação para abertura do molde / <i>Approval for opening of the mould</i>	Valor TG: _____ °C / <i>TG value °C</i> CQ / QA

☐ Sim / Yes ☐ Não / No **TEste de tensão cruzada – “Dolly Test” / Cross-Tension Test – “Dolly Test”**

Todas as dollys coladas e preparadas para efetuar o teste / <i>All dollys glued and prepared to perform the test</i>	
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**SAP / SAP**

Confirmação SAP concluída / <i>SAP confirmation completed</i>	
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**Controlo de qualidade / Quality control**

**OK /**  
**OK** **Não OK**  
**/ NOK**

Inspeção por câmara (inspeção interior) até ao raio / <i>Camera inspection (interior inspection) up to radius</i>  Bordo de ataque / <i>Leading edge:</i> R _____ int. almas / <i>int. webs</i> R _____ Bordo de fuga / <i>Trailing edge:</i> R _____										<input type="checkbox"/>	<input type="checkbox"/>
Gap sem material de núcleo entre tampa BA e LS (5mm +5/-25) / <i>Gap without core material between LE cap and SF (5mm +5/-25)</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								
Colagem do ângulo de colagem BA com casca da pá do rotor LS (interior) - injeção de cola* / <i>Gluing of glue cap LE with rotor blade shell SF (inside) – 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								
Colagem do ângulo de colagem BA com a casca da pá do rotor LS (interior) – reparação standard** / <i>Gluing of glue cap LE with rotor blade shell SF (inside) – 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								

Gap sem material de núcleo entre tampa BA e LP(5mm +5/-25) / <i>Gap without core material between LE cap and PF (5mm +5/-25)</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									
Colagem do ângulo de colagem BA com casca da pá do rotor LP(interior) - injeção de cola* / <i>Gluing of glue cap LE with rotor blade shell PF (inside) – 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			
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<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									
Colagem do ângulo de colagem BA com a casca da pá do rotor LP interior) – reparação standard** / <i>Gluing of glue cap LE with rotor blade shell PF (inside) – 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									

Etapa de trabalho / Work step										Assinatura/Signature	
Controlo de qualidade / Quality control										OK / OK	Não OK / NOK
Colagem da alma do BA com a casca da pá do rotor LP (lado do BA- e BF) – injeção de cola* / <i>Gluing of LE web with rotor blade shell PF (LE- and TE-side) – glue injection*</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		
<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				
Colagem da alma do BA com a casca da pá do rotor LP (lado do BA e do BF) – reparação standard** / <i>Gluing of LE web with rotor blade shell PF (LE and TE-side) – standard repair**</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		
<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				
Colagem da alma BF com a casca da pá do rotor LP (lado do BA- e BF) – injeção de cola* / <i>Gluing of TE web with rotor blade shell PF (LE- and TE-side) – glue injection*</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		
<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				
Colagem da alma do BF com a casca da pá do rotor LP (lado BA e BF) – reparação standard** / <i>Gluing of TE web with rotor blade shell PF (LE and TE-side) – standard repair**</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		
<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				
Colagem da alma flatback com a casca da pá do rotor LP (lado BA- e BF) – injeção de cola* / <i>Gluing of flatback web with rotor blade shell PF (LE- and TE-side) – glue injection*</i>										<input type="checkbox"/>	<input type="checkbox"/>
<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						

Etapa de trabalho / Work step										Assinatura/Signature	
Controlo de qualidade / Quality control										OK / OK	Não OK / NOK
Colagem da alma flatback à casca da pá do rotor LP (lado BA e BF) – reparação standard** / <i>Gluing of flatback web with rotor blade shell PF (LE and TE-side) – standard repair**</i>										<input type="checkbox"/>	<input type="checkbox"/>
<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						
Gap sem material de núcleo entre tampa BF e LS (5mm +5/-25) / <i>Gap without core material between TE cap and SF (5mm +5/-25)</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										
Colagem do ângulo de colagem BF com a casca da pá do rotor LS (interior) - injeção de cola* / <i>Gluing of glue cap TE with rotor blade shell SF (inside) – 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											
Colagem do ângulo de colagem BF com a casca da pá do rotor LS (interior) - reparação standard* / <i>Gluing of glue cap TE with rotor blade shell SF (inside) – 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											
Gap sem material de núcleo entre tampa BF e LP (5mm +5/-25) / <i>Gap without core material between TE cap and PF (5mm +5/-25)</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										
Colagem do ângulo de colagem BF com a casca da pá do rotor LP (interior) - injeção de cola* / <i>Gluing of glue cap TE with rotor blade shell PF (inside) – 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											

Etapa de trabalho / Work step										Assinatura/Signature	
<b>Controlo de qualidade / Quality control</b>										<b>OK / OK</b>	<b>Não OK / NOK</b>
Colagem do ângulo de colagem BF com a casca da pá do rotor LP (interior) - reparação standard* / <i>Gluing of glue cap TE with rotor blade shell PF (inside) – 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											
<b>Opcional para a variante 2 anel de reforço:</b> Laminado de cobertura do segmento 1 colado no LP de acordo com D02254116/x. / <i>Optional for variant 2 reinforcing ring: Reinforcement laminate of Segment 1 glued in the PF according to D02254116/x.</i>										<input type="checkbox"/>	<input type="checkbox"/>
<b>Opcional para a variante 2 anel de reforço</b> Segmento 1 pos. R2450 +/- 20mm colado no LP / <i>Optional for variant 2 reinforcing ring: Segment 1 pos. R2450 +/- 20mm glued in PF</i>										<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> Sim / Yes <input type="checkbox"/> Não / No <b>Teste de tensão cruzada – “Dolly Test” / Cross-Tension Test – “Dolly Test”</b>											
Todos os testes primários foram realizados com o valor individual acima do limite e a média geral acima do limite. / <i>All primary tests performed with the individual value above the threshold and the overall average above the threshold</i>										<input type="checkbox"/>	<input type="checkbox"/>
Todas as imagens e resultados dos testes de tensão cruzada foram registados adequadamente / <i>All images and tests results from cross-tension test registered properly</i>										CQ / QA	
R1 blank sem defeito / R1 blank undamaged										<input type="checkbox"/>	<input type="checkbox"/>

A aceitação interior cobre essencialmente a área até um raio de 30,000 para o bordo de ataque, até um raio de 24,000 para o bordo de fuga, até um raio de 33,000 entre alma FB e alma BF, e até um raio de 6,000 entre almas! As áreas do componente para além disto, permanecem desmarcadas a menos que seja utilizado equipamento de teste específico. /

*The interior acceptance essentially covers the area up to a radius of 30,000 for the leading edge, up to a radius of 24,000 for the trailing edge, up to a radius of 33,000 between the FB web and TE web, and up to a radius of 6,000 between the webs! Component areas beyond this remain unchecked unless specific testing equipment is used.*

Ao verificar a colagem da alma, prestar atenção aos pontos ocultos, bem como aos “zero gaps” entre bordo de colagem da alma; no caso de “zero gaps”, o segmento da alma tem de ser inspecionado relativamente a danos através de compressão! /

*When checking web gluing, attention must also be paid to voids as well as ‘zero gaps’ between web gluing rims and shell laminate; in the case of ‘zero gaps’, the web segment must be inspected for damage by means of compression*

\* Para a injeção de cola, defeitos de tamanho médio, fechados são perfurados e abertos e preenchidos com cola PU. Os defeitos abertos são preenchidos com cola de PU ou com a cola originalmente utilizada. /

*\*For the glue injection, closed, medium-sized defects are drilled open and filled with PU glue. Open defects are filled with PU glue or the glue originally used*

\*\* reparações standard incluem abrir as superfícies não conectadas (normalmente através de lixagem), tornar áspero e recriar através dos laminados. /

*\*\* Standard repairs include opening up the unconnected surfaces (usually through sanding), roughening them and recreating them through lamination.*

R1 blank retido <input type="checkbox"/> <i>R1 blank barred</i>	Aprovada com reservas <input type="checkbox"/> <i>Approved with reservations</i>	Aprovada / Approved <input type="checkbox"/>
Efetuada as entradas SAP <input type="checkbox"/> <i>SAP entries made</i>	Data / Date:	Inspetor / Inspector:

DF-1153-25 Blank R1 - R1 blank Rev3.docx	Verificado por (nome/data): Mónica Sousa/2023-09-11
Compilado por (nome/data): Thayc Marinho/2023-07-18	Aprovado por (nome/data): Volker Burkandt/2023-09-11