Protocolo de produção   
DF-1751-92 DadosDeColagem / GluingData   
   
ENERCON Partner   
D03008507/0.0-pt / WT   
1 de 2   
   
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1   
   
Data / Date \_\_\_\_\_\_\_\_\_\_\_\_   
2   
 Dados do processo de colagem /   
Process data of gluing - Component Nº \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
de / of   
casca S2 / shell S2   
long blank / blade blank   
3   
 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.   
4   
 Etapa de trabalho / Production step   
Assinatura / Signature   
5   
 Temperatura do ar exterior /   
Temperature of outside air   
\_\_\_\_\_\_\_\_\_\_°C \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
6   
 Humidade do ar exterior /   
Humidity outside air   
\_\_\_\_\_\_\_\_\_\_%   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
7   
 Dados seguintes a ser medidos perto do componente /   
Next values to be measured next to the workplace   
8   
 Temperatura do ar interior /   
Temperature of inside air   
\_\_\_\_\_\_\_\_\_\_°C \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
9   
 Humidade do ar interior /   
Humidity of inside air   
\_\_\_\_\_\_\_\_\_\_% \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
10   
 Temperatura do ponto de orvalho interior /   
Temperature of dew point inside   
\_\_\_\_\_\_\_\_\_\_°C   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
11   
 Temperatura da Casca LP (no BA) /   
Temperature of shell-SF (at LE)   
flange \_\_\_\_\_\_\_\_\_\_°C   
centre \_\_\_\_\_\_\_\_\_\_°C   
tip \_\_\_\_\_\_\_\_\_\_°C \_\_\_   
12   
 Temperatura da Casca LP (no Meio) /   
Temperature of shell-SF (middle)   
flange \_\_\_\_\_\_\_\_\_\_°C   
centre \_\_\_\_\_\_\_\_\_\_°C   
tip \_\_\_\_\_\_\_\_\_\_°C \_\_\_   
13   
 Temperatura da Casca LP (no BF) /   
Temperature of shell-SF (at TE)   
flange \_\_\_\_\_\_\_\_\_\_°C   
centre \_\_\_\_\_\_\_\_\_\_°C   
tip \_\_\_\_\_\_\_\_\_\_°C \_\_\_   
14   
 Temperatura da alma BA /   
Temperature of web-LE   
flange \_\_\_\_\_\_\_\_\_\_°C   
centre \_\_\_\_\_\_\_\_\_\_°C   
tip \_\_\_\_\_\_\_\_\_\_°C \_\_\_   
15   
 Temperatura da alma BF /   
Temperature of web-TE   
flange \_\_\_\_\_\_\_\_\_\_°C   
centre \_\_\_\_\_\_\_\_\_\_°C   
tip \_\_\_\_\_\_\_\_\_\_°C \_\_\_   
16   
 Temparatura da Tip /   
Temperature of tip   
\_\_\_\_\_\_\_\_\_\_°C   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
17   
 Temperatura da Casca LP (no BA) /   
Temperature of shell-PF (at LE)   
flange \_\_\_\_\_\_\_\_\_\_°C   
centre \_\_\_\_\_\_\_\_\_\_°C   
tip \_\_\_\_\_\_\_\_\_\_°C \_\_\_   
18   
 Temperatura da Casca LP (no Meio) /   
Temperature of shell-PF (at SP)   
flange \_\_\_\_\_\_\_\_\_\_°C   
centre \_\_\_\_\_\_\_\_\_\_°C   
tip \_\_\_\_\_\_\_\_\_\_°C \_\_\_   
19   
 Temperatura da Casca LP (no BF) /   
Temperature of shell-PF (at TE)   
flange \_\_\_\_\_\_\_\_\_\_°C   
centre \_\_\_\_\_\_\_\_\_\_°C   
tip \_\_\_\_\_\_\_\_\_\_°C \_\_\_   
20   
 Inicio da remoção do nylon da casca LS /   
Beginning of peel ply removal of shell-SF   
 \_\_\_\_\_\_\_\_\_\_h / time \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
21   
 Inicio da remoção do nylon da casca LP /   
Beginning of peel ply removal of shell-PF   
 \_\_\_\_\_\_\_\_\_\_h / time \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
22   
 Inicio da remoção do nylon das almas /   
Beginning of peel ply removal of webs   
 \_\_\_\_\_\_\_\_\_\_h / time \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
23   
 Inicio da remoção do nylon do Bordo de ataque /   
Beginning of peel ply removal of glue cap-LE   
 \_\_\_\_\_\_\_\_\_\_h / time \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
24   
 Inicio da remoção do nylon do Bordo de fuga /   
Beginning of peel ply removal of glue cap-TE   
 \_\_\_\_\_\_\_\_\_\_h / time \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
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25   
 Etapa de trabalho / Production step   
Assinatura / Signature   
26   
 Temperatura do mix /   
Temperature of skim coat material   
\_\_\_\_\_\_\_\_\_\_°C \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
27   
 Temperatura do Material de colagem /   
Temperature of gluing paste material   
MDM1\_\_\_\_\_°C   
MDM2\_\_\_\_\_°C   
MDM3\_\_\_\_\_°C   
MDM4\_\_\_\_\_°C   
28   
 Numero de lote do material de colagem /   
Batch no. of gluing paste material   
MDM1\_\_\_\_\_\_\_   
MDM2\_\_\_\_\_\_\_   
MDM3\_\_\_\_\_\_   
MDM4\_\_\_\_\_\_   
29   
 Pasta aplicada nas cascas /   
Applicated paste at shells   
TypG+35G\_\_   
TypG+36G\_\_   
TypG+37G\_\_   
TypG+38G\_\_   
\_\_\_\_\_\_\_\_\_\_   
30   
 Pasta aplicada nas almas /   
Applicated paste at webs   
TypG+35G\_\_   
TypG+36G\_\_   
TypG+37G\_\_   
TypG+38G\_\_   
\_\_\_\_\_\_\_\_\_\_   
31   
 Pasta aplicada na Tip /   
Applicated paste at tip   
TypG+35G\_\_   
TypG+36G\_\_   
TypG+37G\_\_   
TypG+38G\_\_   
\_\_\_\_\_\_\_\_\_\_   
32   
 Tempo de aplicação do mix /   
Time of skim coating   
beginning \_\_\_\_\_\_\_\_\_\_h   
end \_\_\_\_\_\_\_\_\_\_h   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
33   
 Tempo de aplicação da pasta /   
Time of paste application   
beginning \_\_\_\_\_\_\_\_\_\_h   
end \_\_\_\_\_\_\_\_\_\_h   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
34   
 Tempo apos quebra da pasta /   
Time of paste brushing   
beginning \_\_\_\_\_\_\_\_\_\_h   
end \_\_\_\_\_\_\_\_\_\_h \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
35   
 Tempo de fecho do molde /   
Time of mould closing   
beginning \_\_\_\_\_\_\_\_\_\_h   
end \_\_\_\_\_\_\_\_\_\_h \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
36   
 Tempo de fecho dos clamps /   
Time of clamping completed   
beginning \_\_\_\_\_\_\_\_\_\_h   
end \_\_\_\_\_\_\_\_\_\_h \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
37   
 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 protocol ends here.   
   
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