Protocolo de produção   
DF-1751-91 DadosDeInfusão / InfusionData   
   
ENERCON Partner   
D03008506/0.0-pt / WT   
1 de 2   
   
© ENERCON GmbH. Todos os direitos reservados.   
1   
   
Data / Date \_\_\_\_\_\_\_\_\_\_\_\_   
2   
 Nº de material / Material No 1077199   
3   
 Dados do processo de infusão Nº /   
Process data of infusion - Component Nº \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
de / of   
longarina LS / spar boom SF   
longarina LP / spar boom PF   
   
casca LS / shell SF   
casca LP / shell PF   
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. / 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.   
5   
 Etapa de trabalho / Production step   
Assinatura / Signature   
6   
 Temperatura do ar exterior /   
Temperature of outside air   
\_\_\_\_\_\_\_\_\_\_°C \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
7   
 Humidade do ar exterior /   
Humidity of outside air   
\_\_\_\_\_\_\_\_\_\_% \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
8   
 Temperatura do ar interior /   
Temperature of inside air   
\_\_\_\_\_\_\_\_\_\_°C \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
9   
 Humidade do ar interior /   
Humidity of inside air   
\_\_\_\_\_\_\_\_\_\_% \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
10   
 Temperatura do molde (no painel de controlo) /   
Temperature of mould (displayed at control panel)   
\_\_\_\_\_\_\_\_\_\_°C   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
11   
 Temperatura da camada superior /   
Temperature of top layer   
flange \_\_\_\_\_\_\_\_\_\_°C   
centre \_\_\_\_\_\_\_\_\_\_°C   
tip \_\_\_\_\_\_\_\_\_\_°C \_\_\_\_\_\_\_\_\_\_\_   
12   
 Qualidade de desgasificação /   
Degassing quality   
\_\_\_\_\_\_\_\_\_\_mbar \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
13   
 Racio de mistura (ou pot Tg) /   
Mixing ratio (or pot Tg)   
\_\_\_\_\_\_\_\_\_\_100:x (°C) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
14   
 Temperatura da resina de infusão /   
Temperature of infusion resin   
\_\_\_\_\_\_\_\_\_\_°C \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
15   
 Teste de vacuo (Pressão perdida após 10min) /   
Vacuum test (pressure loss after 10min)   
\_\_\_\_\_\_\_\_\_\_mbar \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
16   
 Tempo do inicio da infusão /   
Time of beginning of infusion   
\_\_\_\_\_\_\_\_\_\_h \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
17   
 Pressão no inicio da infusão /   
Pressure at beginning of infusion   
\_\_\_\_\_\_\_\_\_\_ mbar   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
18   
 Tempo no fim da infusão /   
Time of end of infusion   
\_\_\_\_\_\_\_\_\_\_h \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
19   
 Pressão no fim da infusão /   
Pressure at end of infusion   
\_\_\_\_\_\_\_\_\_\_ mbar \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
20   
 Quantidade de resina /   
Resin quantity   
\_\_\_\_\_\_\_\_\_\_ltr, kg   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
21   
 Tempo pico da exotermia (na zona de espessura mais alta do laminado) /   
Time of exothermic peak (at highest lay-up thickness)   
\_\_\_\_\_\_\_\_\_\_°C \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
22   
 Tempo do inicio da cura /   
Time of beginning of curing   
\_\_\_\_\_\_\_\_\_\_h   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
23   
 Tempo do fim da cura /   
Time of end of curing   
\_\_\_\_\_\_\_\_\_\_h \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
24   
 Temperatura da cura /   
Temperatures of curing   
\_\_\_\_\_\_\_\_\_\_h \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
Released: 2024-04-03 10:04;Translation of D03008506/0.0-en

Protocolo de produção   
DF-1751-91 DadosDeInfusão / InfusionData   
   
ENERCON Partner   
D03008506/0.0-pt / WT   
2 de 2   
   
© ENERCON GmbH. Todos os direitos reservados.   
25   
 Etapa de trabalho / Production step   
Assinatura / Signature   
26   
 Tempo da desmoldagem /   
Time of demoulding   
\_\_\_\_\_\_\_\_\_\_h   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
27   
 Temperatura do componente na desmoldagem /   
Temperature of component at demoulding   
\_\_\_\_\_\_\_\_\_\_°C \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
28   
 Numero de lote do gelcoat (ou MDM) /   
Batch no. of inmould gelcoat (or no. used MDM)   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
29   
 Numero de lote da resina (ou MDM) /   
Batch no. of infusion resin (or no. used MDM)   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
30   
 Racio do conteudo de fibra /   
Fibre mass content   
\_\_\_\_\_\_\_\_\_\_% \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
31   
 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.   
   
Released: 2024-04-03 10:04;Translation of D03008506/0.0-en