Protocolo de produção   
DF-1751-25 LongBlankR2 / BlankR2   
   
ENERCON Partner   
D03008500/0.0-pt / WT   
1 de 4   
   
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1   
   
Data / Date \_\_\_\_\_\_\_\_\_\_\_\_   
2   
 Nº de material / Material No 1076809   
3   
 Blank R2 No.   
Blank R2 No. \_\_\_ \_\_\_\_\_\_ / MN-\_\_\_\_\_ \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
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   
 Rebarbação bordo de ataque /   
Deburring leading edge \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
7   
 Rebarbação bordo de fuga /   
Deburring trailing edge   
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8   
 Retrofitting do bordo da superfície de colagem do segmento 1 BA /   
Retrofitting of gluing surface rim of segment 1 on the LE   
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9   
 Retrofitting do bordo da superfície de colagem do segmento 1 no BF   
Retrofitting of gluing surface rim of segment 1 on the TE \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
10   
 Confirmação SAP enviada /   
SAP confirmation sent \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
11   
 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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12   
 Controle de qualidade / Quality assurance   
ok / nok   
13   
 Deslocamento do bordo de ataque entre a casca da pá do rotor (LS) e casca da pá do rotor (LP) (máx. 2 mm)/   
Offset of the leading edge between the rotor blade shell (SgS) and the rotor blade shell (PF) (max. 2 mm)   
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14   
 A gap de colagem do bordo de ataque (82 mm)/   
Gluing gap on the leading edge (82 mm) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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15   
 Colagem do ângulo de colagem do bordo de ataque à casca da pá do rotor (LS) (externo) – injeção de cola/   
Gluing of LE glue cap to the rotor blade shell (SF) (outer) – glue injection \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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16   
 Colagem do ângulo de colagem do bordo de ataque à casca da pá do rotor (LS) (externo) – standard rep./   
Gluing of LE glue cap to the rotor blade shell (SF) (outer) – standard rep. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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17   
 Deslocamento do bordo de fuga entre a casca da pá do rotor (LS) e casca da pá do rotor (LP) (máx. 2 mm)/   
Offset of the trailing edge between the rotor blade shell (SgS) and the rotor blade shell (PF) (max. 2 mm) \_   
   
   
   
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18   
 Colagem da gap no bordo de fuga (82 mm)/   
Gluing gap on the trailing edge (82 mm) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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19   
 Colagem do bordo de colagem do BF + extensão à casca da pá do rotor (LS) (externo) – injeção de cola/   
Gluing TE rim + extension with rotor blade shell (SF) (outer) – injection of glue \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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20   
 Controle de qualidade / Quality assurance   
ok / nok   
21   
 Colagem do ângulo de colagem BF + extensão com a casca da pá do rotor (LS)(externo) – standard rep./   
Gluing of TE glue cap + extension with the rotor blade shell (SF)(outer) – standard rep. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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 Colagem do bordo de fuga – injeção de cola/   
Gluing trailing edge – glue injection \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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 Colagem do bordo de fuga – standard rep./   
Gluing trailing edge – standard rep. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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24   
 Laminado externo (casca da pá do rotor LS) entre longarina e zona com risco de queda/   
Outer laminate (rotor blade shell SF) between the spar boom and leading edge \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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 Laminado externo (casca da pá do rotor LS) por cima da longarina/   
Outer laminate (rotor blade shell SF) over the spar boom \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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 Laminado externo (casca da pá do rotor LS) entre a longarina e o bordo de fuga/   
Outer laminate (rotor blade shell SF) between the spar boom and the trailing edge \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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27   
 Controle de qualidade / Quality assurance   
ok / nok   
28   
 Laminado externo (casca da pá do rotor LP) entre a longarina e o bordo de ataque/   
Outer laminate (rotor blade shell PF) between the spar boom and the leading edge \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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 Laminado externo (casca da pá do rotor LP) sobre a longarina/   
Outer laminate (rotor blade shell PF) over the spar boom \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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 Laminado externo (casca da pá do rotor LP) entre a longarina e bordo de fuga/   
Outer laminate (rotor blade shell PF) between the spar boom and the trailing edge \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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31   
 Espessura do bordo de fuga/   
Trailing edge thickness \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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R47\_\_\_\_   
R48\_\_\_\_   
R49\_\_\_\_   
R50\_\_\_\_   
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R79\_\_\_\_   
R80\_\_\_\_   
R81\_\_\_\_   
R82\_\_\_\_   
R83\_\_\_\_   
R84\_\_\_\_   
R85\_\_\_\_   
R86\_\_\_\_   
R87\_\_\_\_   
   
32   
 Colagem da ponta da pá à casca da pá do rotor (LS)/   
Gluing of the blade tip to the rotor blade shell (SF) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
33   
 Colagem da ponta da pá à casca da pá do rotor (LP)/   
Gluing of the blade tip to the rotor blade shell (PF) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
34   
 Inspeção com luz da área da raiz R\_\_\_\_\_ para R\_\_\_\_\_/   
Inspection with a light of root area R\_\_\_\_ to R\_\_\_\_   
LS/SF  
\_\_\_\_\_\_\_\_\_\_ LP/PF  
\_\_\_\_\_\_\_\_\_\_ BF/TE  
\_\_\_\_\_\_\_\_\_\_ BA/LE  
\_\_\_\_\_\_\_\_\_\_   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
35   
 Blank R2 undamaged   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
36   
 Blank R2rejected   
   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
37   
 Provisionally approved   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
38   
 Approved   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
39   
 Inspector (signature and date) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
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