Protocolo de produção   
DF-1751-27 MontagemM2 / InstallationM2   
   
ENERCON Partner   
D03008503/0.0-pt / WT   
1 de 3   
   
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1   
   
Data / Date \_\_\_\_\_\_\_\_\_\_\_\_   
2   
 Nº de material / Material No. 1076809   
3   
 Blank M2 No /   
Blank M2 No \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
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   
 Maquinagem da ligação da pá exterior de acordo com o DC /   
Machining of the outer rotor blade connection in accordance with D02880756 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
7   
 Pré-seleção da série (E175 EP5-RB-01) executada no painel de controlos /   
Pre-selection of the series (E175 EP5-RB-01) is made on the control panel \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
8   
 Pá do rotor instalada, inspeção do posicionamento correto da pá no sentido longitudinal executada,   
ponto zero determinado /   
Rotor blade installed, inspection of correct positioning of the blade in the longitudinaldirection carried out,   
the zero point determined \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
9   
 Maquinagem da superfície do flange (fresagem) efetuada executed /   
Machining of the surface of the flange (milling) executed \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
10   
 Posicionamento da pa: ângulo de referȇncia dos moldes antes da perfuração 22,32 - 22,92° /   
Positioning of blade: mould reference angle before drilling 22,32 - 22,92° \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ/QA   
11   
 Inspeção da superfície do flange (sem deformação no laminado, formação de resina líquida, colagem   
defeituosa etc.) /   
Inspection of the surface of the flange (no laminate wrinkles, build-up of liquid resin, defective gluing etc.)   
OK   
 NOK  
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ/QA   
12   
 Planeza da superfície do flange verificada (insira dispositivo de medição) /   
Flatness of the flange surface checked (insert measuring device)   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ/QA   
13   
 Valores medidos / Measured values:   
 dentro/inner\_\_\_\_\_\_\_\_ meio/middle\_\_\_\_\_\_\_\_ fora/outer \_\_\_\_\_\_\_\_\_   
   
 planicidade calculada/calculated flatness \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ/QA   
14   
 Medição da centralização do flange / Measuring of flange centering   
BA/LE\_\_\_\_\_\_\_\_\_ meio/middle\_\_\_\_\_\_\_\_\_ (LP/PF)\_\_\_\_\_\_\_\_\_ (LS/SF)\_\_\_\_\_\_\_\_\_ BF/TE\_\_\_\_\_\_\_\_\_\_\_ CQ/QA   
15   
 Aprovação para perfuração   
Approval for drilling Data / Date:   
\_\_\_\_\_\_\_\_\_\_ \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ/QA   
16   
 Preparação da superfície do flange (terminada a preparação do flange, limpeza da superfície) /   
Flange surface preparation (flange preparation finished, surface cleaning) OK   
 NOK  
 \_\_\_\_\_\_\_\_\_ CQ/QA   
17   
 Furos radiais executados Ø96 mm (+0.2/-0.4) /   
Radial holes executed Ø96 mm (+0.2/-0.4) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
18   
 Furos longitudinais executados Ø45 mm (+/-0.3) /   
Longitudinal holes executed Ø45 mm (+/-0.3) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
19   
 Confirmação SAP enviada /   
SAP confirmation sent \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
20   
 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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D03008503/0.0-pt / WT   
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21   
 Controle de qualidade / Quality assurance   
ok / nok   
22   
 Planeza da superfície do flange (desvio máx. ≤0,3mm) /   
Flatness of the flange surface (max. excursion ≤0.3mm)   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
23   
 Execução dos furos radiais e longitudinais (sem bolhas de ar, ranhuras, etc.) /   
Execution of the radial and longitudinal drill holes (without air bubbles, grooves, etc.) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
B01   
B02   
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B06   
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B11   
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B63   
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B66   
B67   
B68   
B69   
B70   
B71   
   
24   
 Diâmetro nominal dos furos radiais: 96 mm (+0.2/-0.4) /   
Nominal diameter of the radial drill holes: 96mm (+0.2/-0.4) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
B01   
B02   
B03   
B04   
B05   
B06   
B07   
B08   
B09   
B10   
B11   
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B13   
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B69   
B70   
B71   
   
25   
 Distância nominal entre o flange e o início dos furos radiais: 122mm (+0.3/-0.3) /   
Nominal distance between the flange and the start of the radial drill holes: 122mm (+0.3/-0.3):   
dentro/internal: B04\_\_\_\_\_, B16\_\_\_\_\_, B27\_\_\_\_\_, B39\_\_\_\_\_, B51\_\_\_\_\_, B63\_\_\_\_\_   
fora/external: B04\_\_\_\_\_, B16\_\_\_\_\_, B27\_\_\_\_\_, B39\_\_\_\_\_, B51\_\_\_\_\_, B63\_\_\_\_\_ \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
26   
 Diâmetro nominal dos furos longitudinais: Ø 45 mm (+/-0,3) /   
Nominal diameter of the longitudinal drill holes: Ø 45mm (+/-0.3) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
B01   
B02   
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B68   
B69   
B70   
B71   
   
27   
 Espessura total do flange /   
Total flange thickness: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
B01: 151,1 (+20/0)   
B02: 151,1 (+20/0)   
B03: 151,1 (+15/0)   
B04: 151,1 (+15/0)   
B05: 151,1 (+15/0)   
B06: 151,1 (+15/0)   
B07: 151,1 (+15/0)   
B08: 151,1 (+15/0)   
B09: 151,1 (+15/0)   
B10: 151,1 (+15/0)   
B11: 151,1 (+15/0)   
B12: 151,1 (+15/0)   
B13: 151,1 (+15/0)   
B14: 151,1 (+15/0)   
B15: 151,1 (+15/0)   
B16: 151,1 (+15/0)   
B17: 151,1 (+15/0)   
B18: 151,1 (+15/0)   
B19: 151,1 (+15/0)   
B20: 151,1 (+15/0)   
B21: 151,1 (+15/0)   
B22: 151,1 (+15/0)   
B23: 151,1 (+15/0)   
B24: 151,1 (+15/0)   
B25: 151,1 (+15/0)   
B26: 151,1 (+15/0)   
B27: 151,1 (+15/0)   
B28: 151,1 (+15/0)   
B29: 151,1 (+15/0)   
B30: 151,1 (+15/0)   
B31: 151,1 (+15/0)   
B32: 151,1 (+20/0)   
B33: 151,1 (+20/0)   
B34: 151,1 (+20/0)   
B35: 151,1 (+20/0)   
B36: 151,1 (+20/0)   
B37: 151,1 (+20/0)   
B38: 151,1 (+15/0)   
B39: 151,1 (+15/0)   
B40: 151,1 (+15/0)   
B41: 151,1 (+15/0)   
B42: 151,1 (+15/0)   
B43: 151,1 (+15/0)   
B44: 151,1 (+15/0)   
B45: 151,1 (+15/0)   
B46: 151,1 (+15/0)   
B47: 151,1 (+15/0)   
B48: 151,1 (+15/0)   
B49: 151,1 (+15/0)   
B50: 151,1 (+15/0)   
B51: 151,1 (+15/0)   
B52: 151,1 (+15/0)   
B53: 151,1 (+15/0)   
B54: 151,1 (+15/0)   
B55: 151,1 (+15/0)   
B56: 151,1 (+15/0)   
B57: 151,1 (+15/0)   
B58: 151,1 (+15/0)   
B59: 151,1 (+15/0)   
B60: 151,1 (+15/0)   
B61: 151,1 (+15/0)   
B62: 151,1 (+15/0)   
B63: 151,1 (+15/0)   
B64: 151,1 (+15/0)   
B65: 151,1 (+15/0)   
B66: 151,1 (+15/0)   
B67: 151,1 (+15/0)   
B68: 151,1 (+20/0)   
B69: 151,1 (+20/0)   
B70: 151,1 (+20/0)   
B71: 151,1 (+20/0)   
   
   
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ENERCON Partner   
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28   
 Controle de qualidade / Quality assurance   
ok / nok   
29   
 Espessura do material entre o furo longitudinal e parede exterior da pá do rotor /   
Material thickness between longitudinal hole and exterior wall of rotor blade\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ \_\_\_\_\_\_   
   
   
   
B01: 52,5 (+5/-2,5)   
B02: 52,5 (+5/-2,5)   
B03: 52,5 (+5/-2,5)   
B04: 52,5 (+5/-2,5)   
B05: 52,5 (+5/-2,5)   
B06: 52,5 (+5/-2,5)   
B07: 52,5 (+5/-2,5)   
B08: 52,5 (+5/-2,5)   
B09: 52,5 (+5/-2,5)   
B10: 52,5 (+5/-2,5)   
B11: 52,5 (+5/-2,5)   
B12: 52,5 (+5/-2,5)   
B13: 52,5 (+5/-2,5)   
B14: 52,5 (+5/-2,5)   
B15: 52,5 (+5/-2,5)   
B16: 52,5 (+5/-2,5)   
B17: 52,5 (+5/-2,5)   
B18: 52,5 (+5/-2,5)   
B19: 52,5 (+5/-2,5)   
B20: 52,5 (+5/-2,5)   
B21: 52,5 (+5/-2,5)   
B22: 52,5 (+5/-2,5)   
B23: 52,5 (+5/-2,5)   
B24: 52,5 (+5/-2,5)   
B25: 52,5 (+5/-2,5)   
B26: 52,5 (+5/-2,5)   
B27: 52,5 (+5/-2,5)   
B28: 52,5 (+5/-2,5)   
B29: 52,5 (+5/-2,5)   
B30: 52,5 (+5/-2,5)   
B31: 52,5 (+5/-2,5)   
B32: 52,5 (+5/-2,5)   
B33: 52,5 (+5/-2,5)   
B34: 52,5 (+5/-2,5)   
B35: 52,5 (+5/-2,5)   
B36: 52,5 (+5/-2,5)   
B37: 52,5 (+5/-2,5)   
B38: 52,5 (+5/-2,5)   
B39: 52,5 (+5/-2,5)   
B40: 52,5 (+5/-2,5)   
B41: 52,5 (+5/-2,5)   
B42: 52,5 (+5/-2,5)   
B43: 52,5 (+5/-2,5)   
B44: 52,5 (+5/-2,5)   
B45: 52,5 (+5/-2,5)   
B46: 52,5 (+5/-2,5)   
B47: 52,5 (+5/-2,5)   
B48: 52,5 (+5/-2,5)   
B49: 52,5 (+5/-2,5)   
B50: 52,5 (+5/-2,5)   
B51: 52,5 (+5/-2,5)   
B52: 52,5 (+5/-2,5)   
B53: 52,5 (+5/-2,5)   
B54: 52,5 (+5/-2,5)   
B55: 52,5 (+5/-2,5)   
B56: 52,5 (+5/-2,5)   
B57: 52,5 (+5/-2,5)   
B58: 52,5 (+5/-2,5)   
B59: 52,5 (+5/-2,5)   
B60: 52,5 (+5/-2,5)   
B61: 52,5 (+5/-2,5)   
B62: 52,5 (+5/-2,5)   
B63: 52,5 (+5/-2,5)   
B64: 52,5 (+5/-2,5)   
B65: 52,5 (+5/-2,5)   
B66: 52,5 (+5/-2,5)   
B67: 52,5 (+5/-2,5)   
B68: 52,5 (+5/-2,5)   
B69: 52,5 (+5/-2,5)   
B70: 52,5 (+5/-2,5)   
B71: 52,5 (+5/-2,5)   
30   
 Espessura do material entre o furo longitudinal e parede interior da pá do rotor /   
Material thickness between longitudinal hole and interior wall of rotor blade \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
B01: 53,6 (+14,5/-4)   
B02: 53,6 (+14,5/-4)   
B03: 53,6 (+10/-3,5)   
B04: 53,6 (+10/-3,5)   
B05: 53,6 (+10/-3,5)   
B06: 53,6 (+10/-3,5)   
B07: 53,6 (+10/-3,5)   
B08: 53,6 (+10/-3,5)   
B09: 53,6 (+10/-3,5)   
B10: 53,6 (+10/-3,5)   
B11: 53,6 (+10/-3,5)   
B12: 53,6 (+10/-3,5)   
B13: 53,6 (+10/-3,5)   
B14: 53,6 (+10/-3,5)   
B15: 53,6 (+10/-3,5)   
B16: 53,6 (+10/-3,5)   
B17: 53,6 (+10/-3,5)   
B18: 53,6 (+10/-3,5)   
B19: 53,6 (+10/-3,5)   
B20: 53,6 (+10/-3,5)   
B21: 53,6 (+10/-3,5)   
B22: 53,6 (+10/-3,5)   
B23: 53,6 (+10/-3,5)   
B24: 53,6 (+10/-3,5)   
B25: 53,6 (+10/-3,5)   
B26: 53,6 (+10/-3,5)   
B27: 53,6 (+10/-3,5)   
B28: 53,6 (+10/-3,5)   
B29: 53,6 (+10/-3,5)   
B30: 53,6 (+10/-3,5)   
B31: 53,6 (+10/-3,5)   
B32: 53,6 (+14,5/-4)   
B33: 53,6 (+14,5/-4)   
B34: 53,6 (+14,5/-4)   
B35: 53,6 (+14,5/-4)   
B36: 53,6 (+14,5/-4)   
B37: 53,6 (+14,5/-4)   
B38: 53,6 (+10/-3,5)   
B39: 53,6 (+10/-3,5)   
B40: 53,6 (+10/-3,5)   
B41: 53,6 (+10/-3,5)   
B42: 53,6 (+10/-3,5)   
B43: 53,6 (+10/-3,5)   
B44: 53,6 (+10/-3,5)   
B45: 53,6 (+10/-3,5)   
B46: 53,6 (+10/-3,5)   
B47: 53,6 (+10/-3,5)   
B48: 53,6 (+10/-3,5)   
B49: 53,6 (+10/-3,5)   
B50: 53,6 (+10/-3,5)   
B51: 53,6 (+10/-3,5)   
B52: 53,6 (+10/-3,5)   
B53: 53,6 (+10/-3,5)   
B54: 53,6 (+10/-3,5)   
B55: 53,6 (+10/-3,5)   
B56: 53,6 (+10/-3,5)   
B57: 53,6 (+10/-3,5)   
B58: 53,6 (+10/-3,5)   
B59: 53,6 (+10/-3,5)   
B60: 53,6 (+10/-3,5)   
B61: 53,6 (+10/-3,5)   
B62: 53,6 (+10/-3,5)   
B63: 53,6 (+10/-3,5)   
B64: 53,6 (+10/-3,5)   
B65: 53,6 (+10/-3,5)   
B66: 53,6 (+10/-3,5)   
B67: 53,6 (+10/-3,5)   
B68: 53,6 (+14,5/-4)   
B69: 53,6 (+14,5/-4)   
B70: 53,6 (+14,5/-4)   
B71: 53,6 (+14,5/-4)   
31   
 Superfície do flange selada com resina e temperada /   
Flange surface sealed with resin and cured   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
32   
 Pá do rotor M2 sem danos /   
Rotor blade M2 undamaged   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
33   
 Pá do rotor M2 rejeitada /   
Rotor blade M2 rejected   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
34   
 Aprovada sob reserva /   
Provisionally approved   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
35   
 Aprovada /   
Approved   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
36   
 Inspetor (assinatura e data) /   
Inspector (signature and date) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
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