Protocolo de produção   
DF-1751-28 MontagemM3 / InstallationM3   
   
ENERCON Partner   
D03008504/0.0-pt / WT   
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1   
   
Data / Date \_\_\_\_\_\_\_\_\_\_\_\_   
2   
 Nº de material / Material No. 1076797   
3   
 Blank M3 No. /   
Blank M3 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   
 Aprovação para instalação dos pernos /   
Approval for installation of the pins   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
7   
 Data de entrega/n.º de lote /   
Delivery date/Batch No. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
8   
 Pernos limpos e sem danos /   
Cross dowels clean and undamaged \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
9   
 Pernos fixados ao longo de toda a superfície de acordo com o sistema de numeração de acordo com DC /   
Cross dowels fixed in the entire surface in accordance with the numbering system in accordance with   
D02882629 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
10   
 Fita vedante posicionada à volta da pá e centralmente acima dos pernos transversais, sem dobras /   
Sealing tape positioned all around the blade and centrically above the cross dowels, without wrinkles \_\_\_\_\_\_\_\_   
11   
 Pernos limpos e sem danos /   
Pins clean and undamaged \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
12   
 Barras com material de selagem flexível aparafusadas ao batente /   
Pins with flexible damming material are screwed to the limit stop \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
13   
 Identificação externa (carimbo), torque de aperto do parafuso de 150 ±15Nm /   
Outer identification (stamp), torque of the screw fastening 150 ±15Nm   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
14   
 Fazer o furo de inspeção de acordo com o DC /   
Drill of the inspection hole according to D02880756 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
15   
 Inspeção do circulo de perfuração e inspeção do contorno interno e externo do flange da pá executada /   
Inspection of drilling circle and inspection of inner and outer contour of blade flange performed \_\_\_\_\_\_ CQ / QA   
16   
 Inspeção do círculo de pernos longitudinais com dispositivo de contraflange e documentada (fotos) /   
Inspection of the circle of longitudinal bolts with counter flange device and documented (photos) \_\_\_\_\_ CQ / QA   
17   
 Colagem do segmento 2 do anel de reforço na casca e reforço com 4x (G1+G1) de acordo com DC /   
Gluing of reinforcing ring segment 2 on shell and lamination with 4x (G1+G1) according to: D02885267 \_\_\_\_   
18   
 Nº de série do blank de fibra de reforço do segmento 2 /   
Series No. of the non-woven fabric blank of reinforcing the segment 2   
\_\_\_\_\_\_\_\_\_\_ \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
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19   
 Etapa de trabalho / Production step   
Assinatura / Signature   
20   
 Medição de resistȇncia na LP antes instalação do connecting bolts /   
Resistance measurements at PS before connecting bolts installation   
 Ponto de medição (de – até) /   
Point of measurement (from – to)   
Resistȇncia /   
Resistance [mΩ]   
Valor máximo /   
Maximum value [mΩ]   
 1PS   
2PS   
   
≤ 5   
 1PS   
3PS M   
   
≤ 5   
 1PS B   
11PS   
   
≤ 5   
 2PS B   
11PS   
   
≤ 5   
 3PS C   
4PS C   
   
≤ 500   
 3PS M   
4PS M   
   
≤ 160   
 6PS   
5PS   
   
≤ 5   
 6PS   
4PS M   
   
≤ 5   
   
Se aplicável / If applicable   
 6PS   
7PS   
   
   
 6PS   
8PS   
   
   
21   
 Medição de resistȇncia na LP depois de instalar connecting bolts e receptores /   
Resistance measurements at PS after installation of connecting bolts and receptors   
 1PS   
2PS   
   
   
 1PS   
3PS M   
   
   
 1PS   
11PS   
   
   
 1PS   
10PS   
   
   
 1PS   
9PS   
   
   
 9PS   
0PS   
   
   
 0PS   
4PS   
   
   
   
Se aplicável / If applicable   
 7PS   
Bolt 39;40   
   
   
 8PS   
Bolt 70;71   
   
   
22   
 Medição de resistȇncia na LS antes instalação do connecting bolts /   
Resistance measurements at SF before connecting bolts installation   
 Ponto de medição (de – até) /   
Point of measurement (from – to)   
Resistȇncia /   
Resistance [mΩ]   
Valor máximo /   
Maximum value [mΩ]   
 1SS   
2SS   
   
≤ 5   
 1SS   
3SS M   
   
≤ 5   
 1SS B   
11SS   
   
≤ 5   
 2SS B   
11SS   
   
≤ 5   
 3SS C   
4SS C   
   
≤ 500   
 3SS M   
4SS M   
   
≤ 160   
 6SS   
5SS   
   
≤ 5   
 6SS   
4SS M   
   
≤ 5   
   
Se aplicável / If applicable   
 6SS   
7SS   
   
   
 6SS   
8SS   
   
   
   
   
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 Etapa de trabalho / Production step   
Assinatura / Signature   
24   
 Medição de resistȇncia na LS depois de instalar connecting bolts e receptores /   
Resistance measurements at SF after installation of connecting bolts and receptors   
 1SS   
2SS   
   
   
 1SS   
3SS M   
   
   
 1SS   
11SS   
   
   
 1SS   
10SS   
   
   
 1SS   
9SS   
   
   
 9SS   
0SS   
   
   
 0SS   
4SS   
   
   
   
Se aplicável / If applicable   
 7SS   
Bolt 39;40   
   
   
 8SS   
Bolt 70;71   
   
   
25   
 Medição de resistência conforme /   
Resistance measurement according to D02947259 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
26   
 Furos realizados para os recetores do LS /   
Drill holes made for the SF receivers \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
27   
 Furos realizados para os recetores do LP /   
Drill holes made for the PF receivers \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
28   
 6x furo cego (Ø22 +0,3/-0 mm) para Sistema de controlo de carga perfurado com berbequim magnético;   
profundidade útil do furo: 27 +5/-0mm /   
6x blind hole (Ø22 +0,3/-0 mm) for Load Control system drilled with magnetic drill, usable depth   
of drill hole: 27 +5/-0mm \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
29   
 Preparação para a colagem das buchas de instalação do controlo de carga: Limpar os furos na pá,   
remover a areia do jato de areia, retirar o lubrificante ou óleo com isopropanol /   
Preparation for gluing LC mounting bushes: Clean the drill holes in the blade, sandblast bushes,   
fully degrease with isopropanol \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
30   
 N.º lote /   
Batch no.   
\_\_\_\_\_\_\_\_\_\_   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
31   
 Aprovação para colar nas buchas de montagem /   
Approval for gluing the mounting bushes   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
32   
 Enroscar buchas LC de montagem no molde e colar com 30 – 50 ml de SAF 30-5 /   
Bolt LC mounting bushes onto template and glue with 30 – 50 ml of SAF 30-5   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
33   
 N.º lote /   
Batch no.   
\_\_\_\_\_\_\_\_\_\_   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
34   
 Aguardar 10 minutos após colar /   
Waiting of 10 minutes after the gluing \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
35   
 Manga de rosca aquecida com ventilador de ar quente, durante 10 minutos a uma temperatura de 70°C /   
Screw-in sleeve`s heated with hot-air fan for 10 minutes at a temperature of 70°C   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
36   
 Modelo retirado das mangas de rosca após 10 minutos de tempo de arrefecimento /   
Template removed from screw-in sleeves after 10 minutes of cooling time \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
37   
 Desalinhamento entre a superfície da manga aparafusada, verificado, com máximo deslocamento ≤ 0,5mm /   
Misalignment between screw-in sleeve`s surface checked with maximum offset ≤ 0,5mm \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
38   
 Ângulo de fixação para chapa de proteção do Load Control colado /   
Mounting angle bracket for Load Control step guard glued \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
39   
 N.º lote /   
Batch no.   
\_\_\_\_\_\_\_\_\_\_   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
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40   
 Etapa de trabalho / Production step   
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41   
 Superfície de parafuso dos parafusos hexagonais e anilhas esféricas ligeiramente lubrificadas   
com Klüberpaste 46 MR 401 /   
Bolt surface of the hexagon bolts and spherical washers lightly greased   
with Klüberpaste 46 MR 401 lubricant \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
42   
 Marca vermelha de aperto e verificação funcional efetuada para os parafusos 20 do sistema de Load Control /   
Tightening mark and functional check carried out for bolts 20 of Load Control system \_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
43   
 Marca vermelha de aperto e verificação funcional efetuada para os parafusos 44 do sistema de Load Control /   
Tightening mark and functional check carried out for bolts 44 of Load Control system \_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
44   
 Marca vermelha de aperto e verificação funcional efetuada para os parafusos 68 do sistema de Load Control /   
Tightening mark and functional check carried out for bolts 68 of Load Control system \_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
45   
 Aprovação para encerrar a chapa de proteção do Load Control /   
Approval for closing Load Control step guard \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
46   
 Determinação do valor de ajuste (EW) conforme D /   
Determination of “setting value” (EW) (according to D0387399, D02448240)   
47   
 Valor BA pernos 71 /   
LE value Bolt 71\_\_\_\_\_\_\_\_° \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
48   
 Símbolo matemático / Mathematical sign   
positivo / positive   
negativo / negative \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
49   
 Valor BF pernos 35 /   
TE value Bolt 35\_\_\_\_\_\_\_\_° \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
50   
 Símbolo matemático / Mathematical sign   
positivo / positive   
negativo / negative \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
51   
 Valor EW calcualado /   
Calculated EW = (valor BA + valor BF)/2 =\_\_\_\_\_\_\_\_°   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
52   
 Símbolo matemático / Mathematical sign   
positivo / positive   
negativo / negative \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
53   
 Verifique a especificação do EW ao marcar o valor BA e valor BF na escala abaixo; em seguida,   
conte as marcas entre ambos. O EW está exatamente no centro. /   
Cross-check the EW determination by marking the LE value and the TE value on the scale below,   
then count the tick marks between them. The EW is exactly in the middle \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
54   
   
   
55   
 No caso de um EW calculado ≥ +0,4° ou ≤ -0,4°, a especificação do EW tem de ser repetida por um outro   
inspetor do CQ! /   
In case of calculated EW ≥ +0,4° or ≤ -0,4°, EW determination has to be repeated by another   
QA inspector! \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ CQ / QA   
56   
 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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57   
 Controle de qualidade / Quality assurance   
ok / nok   
58   
 Pernos de acordo com o sistema de numeração de acordo com MP /   
Pins in accordance with the numbering system In accordance with D02882629 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
59   
 Meias mangas colocadas totalmente no interior dos furos axiais a 3 +7/-2mm da superfície do flange /   
Half sleeves totally placed inside the axial holes at 3 +7/-2mm from the flange surface \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
60   
 Fita vedante posicionada à volta da pá e centrada acima dos pernos transversais, sem dobras /   
Sealing tape positioned all around the blade and centrical above the cross dowels, without wrinkles   
\_\_\_\_\_\_   
   
   
61   
 Barras aparafusadas com material de selagem elástica permanente /   
Bars screwed in using permanently flexible damming material \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
62   
 Entalhe das barras 71x 377,4 (+3/-2mm) /   
Recess of bars 71x 377,4 (+3/-2mm)   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
63   
 Diâmetro do furo de inspeção, alvo: Ø20 (+/-0,2mm) /   
Inspection hole diameter, target: Ø20 (+/-0,2mm) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
64   
 Furo de inspeção não coberto /   
Inspection drill hole not covered   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
65   
 Colagem do segmento 2 do anel de reforco na casca e reforco com 4x (G1+G1) de acordo com /   
Gluing of reinforcing ring segment 2 on shell and lamination with 4x (G1+G1) according to D02885267 \_\_\_   
   
   
66   
 Furos realizados para os recetores do LS /   
Drill holes made for the SF receivers \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
67   
 Furos realizados para os recetores do LP /   
Drill holes made for the PF receivers \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
68   
 Interior da pá do rotor limpo /   
Inside of rotor blade clean \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
69   
 Pá do rotor M3 sem danos /   
Rotor blade M3 undamaged   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
70   
 Pá do rotor M3 rejeitada /   
Rotor blade M3 rejected   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
71   
 Aprovada sob reserva /   
Provisionally approved   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
72   
 Aprovada /   
Approved   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
73   
 Inspetor (assinatura e data) /   
Inspector (signature and date) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
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