Protocolo de produção   
DF-1751-01 SegmentoPreForma1 / PreformSegment1   
   
ENERCON Partner   
D03008288/0.0-pt / WT   
1 de 2   
   
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1   
   
Data / Date\_\_\_\_\_\_\_\_\_\_\_\_   
2   
 Nº de material / Material No 1070660   
3   
 Pré-forma segmento 1 Nº /   
Preform segment 1 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   
 Aquecimento(s) do molde ligado(s) (molde de pré-cura) /   
Mould heating switched on (pre-curing mould)   
\_\_\_\_\_\_\_\_\_\_h \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
7   
 Etiqueta de identificação na lado oposto à superfície de colagem /   
Component label placed on opposite side to the gluing surface \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
8   
 Camadas da pré-forma segmento 1 aplicadas conforme DC /   
Preform segment 1 lay-up applied in accordance with the DC   
 D02883187- \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
9   
 Nº de série do blank das fibras /   
Series No. of the non-woven fabric blank – no.   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
10   
 Sistema de vácuo completo e controle da vedação efetuado /   
Vacuum system complete and checks carried out on the sealing   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
11   
 Temperatura da resina /   
Temperature of the resin   
\_\_\_\_\_\_\_\_\_\_°C   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
12   
 Infusão / Infusion   
Início / Start   
\_\_\_\_\_\_\_h; Fim / End   
 \_\_\_\_\_\_\_h;   
 Quantidade de resina / Amount of resin \_\_\_\_\_\_\_l   
\_\_\_\_\_\_   
13   
 Processo de cura / Curing process   
Início / Start   
\_\_\_\_\_\_\_h; Fim / End   
 \_\_\_\_\_\_\_h \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
14   
 Rebarbar as arestas do componente /   
Deburring of component edges \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
15   
 Mensagem de confirmação SAP enviada /   
SAP confirmation sent \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
16   
 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 log ends here.   
   
   
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2 de 2   
   
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17   
 Controle de qualidade / Quality assurance   
ok / nok   
18   
 Laminado da pré-forma segmento 1 (impregnado, retilíneo, não ondulado, etc.) - Inspeção com luz /   
Laminate of the preform segment 1 (soaked, straight, not warped, etc.) – Inspection with light \_\_\_\_\_\_\_\_\_\_   
   
   
19   
 Laminado alinhado no fim do flange, arestas do componentes rebarbadas /   
Laminate flush at flange end, component edges deburred \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
20   
 Comprimento do componente alvo 635 +/-10mm /   
Component length target 635 +/-10mm \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
21   
 Comprimento do chanfro no lado da TIP alvo 395 +/-10mm /   
Length of the chamfer on the TIP side target 395 +/-10mm   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
22   
 Espessura alvo da parede 63 +3/-0mm /   
Target wall thickness 63 +3/-0mm \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
23   
 Pré-forma segmento 1 sem danos /   
Preform segment 1 undamaged   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
24   
 Pré-forma segmento 1 reprovada /   
Preform segment 1 rejected   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
25   
 Aprovada sob reserva /   
Provisionally approved   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
26   
 Aprovada /   
Approved   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
27   
 Inspetor (assinatura e data) /   
Inspector (signature and date) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
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