Protocolo de produção   
DF-1751-10 LongarinaLP / SparboomPF   
   
ENERCON Partner   
D03008455/0.0-pt / WT   
1 de 2   
   
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1   
   
Data / Date \_\_\_\_\_\_\_\_\_\_   
2   
 Nº de material / Material No 1071389   
3   
 Longarina (lado da pressão) Nº /   
Spar boom (pressure face) 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   
 Temperatura de compensação das fibras de carbono asseguradas de acordo com a instrução eOI-03 /   
Temperature compensation of the CFRP non-woven fabric ensured according to eOI-03 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
8   
 Longarina fabricada conforme DC /   
Spar boom manufactured in accordance with the DC   
 D02901774- \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
9   
 Nº de série do blank das fibras /   
Series No. of the non-woven fabric blank – no.   
   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
10   
 Placas de material de núcleo aplicadas conforme DC /   
Core material plates applied in accordance with the DC \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
11   
 Data da entrega/Nº do lote do kit de material de núcleo /   
Delivery date/Batch No. of the core material kit   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_/ \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
12   
 Etiqueta de identificação em R68000 colocada no centro /   
Component lable on R68000 placed in the centre \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
13   
 Amostras para o teste de cinzas colocada no R21000 e R63000 ao centro /   
Sample for determination of fiber mass content placed on R21000 and R63000 in the center \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
14   
 Dados de processo preenchidos completamente, DF-175-91 DadosDeInfusão-InfusionData /   
Process data completely filled in the protocol MR-175-91 DadosDeInfusão-InfusionData\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
15   
 Bordas da longarina rebarbadas /   
Spar boom rims deburred \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
16   
 Mensagem de confirmação SAP enviada /   
SAP confirmation sent \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
17   
 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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18   
 Controle de qualidade / Quality assurance   
ok / nok   
19   
 Início da longarina R3000 +/-20mm (verificado pela referencia marcada no molde) /   
Start of the spar boom R3000 +/-20mm (checked by reference imprint from the mould)   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
20   
 Fim da longarina R87250 +/-20mm (verificado pela referencia marcada no molde) /   
End of the spar boom R87250 +/-20mm (checked by reference imprint from the mould) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
21   
 Material de núcleo colocado corretamente (Início LE-R5000, TE-R5700 – Fim LE-R66760, TE-R82500) – (+/-  
20mm) /   
Core material correctly placed (Start LE-R5000, TE-R5700 – End LE-R66760, TE-R82500) – (+/-20mm) \_\_   
   
   
22   
 Laminado interno da longarina (impregnado, não ondulado) /   
Inner laminate of the spar boom (soaked, free of waves, spar boom thickness equal   
or higher than foam edge \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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23   
 Laminado externo da longarina (impregnado, retilíneo, não ondulado, etc.) /   
Outer laminate of the spar boom (soaked, straight, not warped, etc.) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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24   
 Inspeção ultrasom efetuada (Sem rugas or defeitos de infusão) /   
Ultrasonic checking for infusion defects and fibre wrinkles \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
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25   
 Longarina (LP) sem danos /   
Spar boom (PF) undamaged \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
26   
 Longarina (LP) reprovada /   
Spar boom (PF) rejected   
   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
27   
 Aprovada sob reserva /   
Provisionally approved   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
28   
 Aprovada /   
Approved   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
29   
 Inspetor (assinatura e data) /   
Inspector (signature and date) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
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