Protocolo de produção   
DF-1751-20 CoberturaDoBA / LEcover   
   
ENERCON Partner   
D03008492/0.0-pt / WT   
1 de 2   
   
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1   
   
Data / Date \_\_\_\_\_\_\_\_\_\_   
2   
 Nº de material / Material No 1071929   
3   
 Cobertura do bordo de ataque Nº /   
Leading edge cover 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   
 Cobertura fabricada conforme DC /   
Leading edge cover manufactured in accordance with the DC   
 D02894339- \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
8   
 Nº de série do blank das fibras /   
Series No. of the non-woven fabric blank – no.   
   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
9   
 Etiqueta de identificação em R68000 colocada no centro /   
Component label on R68000 placed in the centre \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
10   
 Amostra para o teste de cinzas colocada no R72000 ao centro /   
Sample for ashing test placed on R72000 in the center   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
11   
 Sistema de vácuo completo e controle da vedação efetuado /   
Vacuum system complete and checks carried out on the sealing \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
12   
 Temperatura da resina /   
Temperature of the resin   
\_\_\_\_\_\_\_\_\_\_°C   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
13   
 Infusão / Infusion   
Início / Start   
\_\_\_\_\_\_\_h; Fim / End   
 \_\_\_\_\_\_\_h;   
 Quantidade de resina / Amount of resin \_\_\_\_\_\_\_l   
\_\_\_\_\_\_   
14   
 Processo de cura / Curing process   
Início / Start   
\_\_\_\_\_\_\_h; Fim / End   
 \_\_\_\_\_\_\_h \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
15   
 Bordas da cobertura do bordo de ataque rebarbadas /   
Leading edge cover 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 cobertura do bordo de ataque R67500 +/-20mm (verificado pela referencia marcada no molde) /   
Start of the leading egde glue cap R67500 +/-20mm (checked by reference imprint from the mould)   
\_\_\_\_\_\_   
   
   
20   
 Fim cobertura do bordo de ataque R87559 +/-20mm (verificado pela referencia marcada no molde) /   
End of the spar boom R87559 +/-20mm (checked by reference imprint from the mould) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
21   
 Laminado da bordo de ataque (impregnado, retilíneo, não ondulado, etc.) /   
Laminate of the leading edge glue cap (soaked, straight, not warped, etc.) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
R67   
R68   
R69   
R70   
R71   
R72   
R73   
R74   
R75   
R76   
R77   
R78   
R79   
R80   
R81   
R82   
R83   
R84   
R85   
R86   
R87   
   
22   
 Largura da coberta do bordo de ataque (radiano externo LS+LP) 0mm (até ao início), 60mm (até ao fim) - (+0/-  
5mm) /   
Width of the rims for gluing (outer radian measure SF+PF) 0mm (at beginning), 60mm (at the end) - (+0/-5mm)  
   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
R67:0/340   
R68:340   
R69:340   
R70:340   
R71:340   
R72:340   
R73:340   
R74:340   
R75:340   
R76:340   
R77:340   
R78:340   
R79:340   
R80:340   
R81:340   
R82:340   
R83:340   
R84:340   
R85:340   
R86:340   
R87:340/60   
   
23   
 Cobertura do bordo de ataque sem danos /   
Leading egde cover undamaged \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
24   
 Cobertura do bordo de ataque reprovada /   
Leading edge glue cap rejected   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
25   
 Aprovada sob reserva /   
Provisionally approved   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
26   
 Aprovada /   
Approved   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
27   
 Inspetor (assinatura e data) /   
Inspector (signature and date) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
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