Protocolo de produção   
DF-1751-11 TE\_UD\_LS / TEreinforceInsertSF   
   
ENERCON Partner   
D03008456/0.0-pt / WT   
1 de 2   
   
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1   
   
Data / Date \_\_\_\_\_\_\_\_\_\_   
2   
 Nº de material / Material No 1072100   
3   
 Trailing edge reinforcement insert SF (TE-UD) Nº /   
Trailing edge reinforcement insert SF 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   
 Reinforcement insert (TE-UD) conforme DC /   
Reinforcement insert manufactured in accordance with the DC   
 D02900460-   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
8   
 Nº de série do blank das fibras /   
Series No. of the non-woven fabric blank – no.   
   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
9   
 Etiqueta de identificação em R5000 colocada no centro /   
Component lable on R5000 placed in the centre \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
10   
 Amostra para o teste de cinzas colocada no R7600 ao centro /   
Sample for ashing test placed on R7600 in the center   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
11   
 Sistema de vácuo completo e controle da vedação efetuado /   
Vacuum system complete and checks carried out on the sealing \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
12   
 Verificação pelo chefe de equipe quanto a construção sem defeitos antes da infusão do componente   
Construction checked by the foreman to make sure it's free of defects before infusion of the componente \_\_\_\_\_   
13   
 Temperatura da resina /   
Temperature of the resin   
\_\_\_\_\_\_\_\_\_\_°C   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
14   
 Infusão / Infusion   
Início / Start   
\_\_\_\_\_\_\_h; Fim / End   
 \_\_\_\_\_\_\_h;   
 Quantidade de resina / Amount of resin \_\_\_\_\_\_\_l   
\_\_\_\_\_\_   
15   
 Processo de cura / Curing process   
Início / Start   
\_\_\_\_\_\_\_h; Fim / End   
 \_\_\_\_\_\_\_h \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
16   
 Reinforcement insert (TE-UD) rebarbadas /   
Reinforcement insert rims deburred   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
17   
 Mensagem de confirmação SAP enviada /   
SAP confirmation sent \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
18   
 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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19   
 Controle de qualidade / Quality assurance   
ok / nok   
20   
 Início da reinforcement insert (TE-UD) R2900 +/-20mm (verificado pela referencia marcada no molde) /   
Start of the reinforcement insert R2900 +/-20mm (checked by reference imprint from the mould) \_\_\_\_\_\_\_\_   
   
   
21   
 Início da material de nucleo R6500 +/-20mm /   
Start of the foam inlay R6500 +/-20mm \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
22   
 Fim da reinforcement insert (TE-UD) R33300 +/-20mm (verificado pela referencia marcada no molde) /   
End of the reinforcement insert R33300 +/-20mm (checked by reference imprint from the mould) \_\_\_\_\_\_\_\_   
   
   
23   
 Fim da material de nucleo R26000 +/-20mm /   
End of the foam inlay R26000 +/-20mm   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
24   
 Laminado da reinforcement insert (TE-UD) (impregnado, retilíneo, não ondulado, etc.) /   
Laminate of the reinforcement insert (soaked, straight, not warped, etc.) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
   
R03   
R04   
R05   
R06   
R07   
R08   
R09   
R10   
R11   
R12   
R13   
R14   
R15   
R16   
R17   
R18   
R19   
R20   
R21   
R22   
R23   
R24   
R25   
R26   
R27   
R28   
R29   
R30   
R31   
R32   
R33   
   
25   
 Bordo de ataque do componente corretamente rebarbado (verificado pela referencia marcada no molde) /   
LE-sided edge of component correctly deburred (checked by reference imprint from the mould) \_\_\_\_\_\_\_\_\_   
   
   
26   
 Reinforcement insert (TE-UD) sem danos /   
Reinforcement insert undamaged \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
   
27   
 Reinforcement insert (TE-UD) reprovada /   
Reinforcement insert rejected   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
28   
 Aprovada sob reserva /   
Provisionally approved   
 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
29   
 Aprovada /   
Approved   
\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
30   
 Inspetor (assinatura e data) /   
Inspector (signature and date) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_   
   
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