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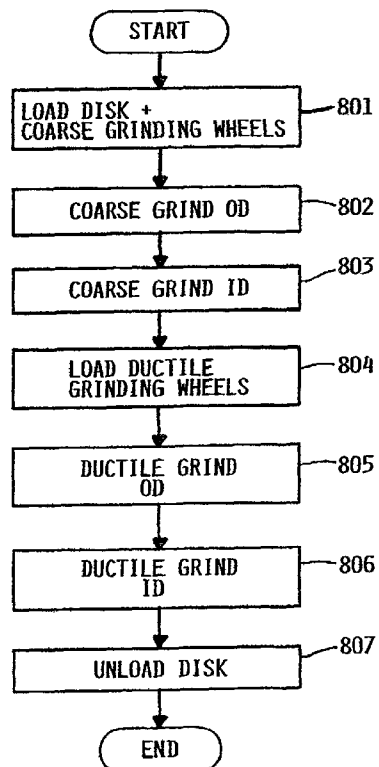
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(54) Title: EDGE FINISHING PROCESS FOR GLASS OR CERAMIC DISKS USED IN DISK DRIVE DATA STORAGE DEVICES



(57) Abstract: The circumferential edges of glass or ceramic disks used in disk drive data storage devices are preferably finished by ductile grinding to produce an essentially fracture-free surface, which is not chemically strengthened. Preferably, the material is glass, and both the inner and outer edges of the disk are finished. Edge finishing is preferably achieved in a two-stage process, involving a coarse grind and a ductile grind, using air bearing spindles rotated at high speed for grinding wheels and workpiece. Preferably, the grinding wheels are shaped to provide a radius at the juncture of the circumferential edges and flat disk surfaces.



WO 03/024664 A2



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