What is claimed is:

1. A manufacturing method of glass substrate for magnetic disk, the method comprising the steps of

preparing a laminate that is formed with a plurality of sheet glass materials laminated, and

machining the laminate by revolving and moving a coring machine in the direction of lamination, the coring machine concentrically having an outer diameter blade of large diameter and an inner diameter blade of small diameter, while providing an outer machining surface which is the outer surface of the outer diameter blade of the coring machine with machining fluid, the outer diameter blade and the inner diameter blade contacting the sheet glass materials,

wherein a direction of the revolution of the coring machine and a flow direction of the machining fluid are arranged such that the machining fluid is well drawn into the outer machining surface, and

wherein the machining fluid is provided with a nozzle, and the flow direction of the machining fluid is substantially consistent with a revolving direction of the coring machine such that an angle between a lateral component of the vector directing from the nozzle to a point on the outer machining surface of the rotating outer diameter blade and a tangential velocity vector of said point ranges from 0 to 15 degrees, and said vector has a downward component.

2. The manufacturing method of glass substrate for magnetic disk according to claim 1, wherein said angle is 0 degrees.

3.The manufacturing method of glass substrate for magnetic disk according to claim 1 or 2, wherein the machining fluid is provided to the outer machining surface by use of a plurality of nozzles, the nozzles being positioned substantially evenly over the entire circumference of the outer diameter blade in said machining.

4. The manufacturing method of glass substrate for magnetic disk according to claim 1 or 2, wherein the machining fluid is provided to the outer machining surface by use of single or a plurality of nozzles, the nozzle or nozzles positioned toward the outer diameter blade and revolved concentrically with the outer diameter blade.

What is claimed is:

1. A manufacturing method of glass substrate for magnetic disk, the method comprising the steps of

preparing a laminate that is formed with a plurality of sheet glass materials laminated, and

machining the laminate by revolving and moving a coring machine in the direction of lamination, the coring machine concentrically having an outer diameter blade of large diameter and an inner diameter blade of small diameter, while providing an outer machining surface which is the outer surface of the outer diameter blade of the corning machine with machining fluid, the outer diameter blade and the inner diameter blade contacting the sheet glass materials,

wherein a direction of the revolution of the coring machine and a flow direction of the machining fluid are arranged such that the machining fluid is drawn into the outer machining surface, and

wherein the machining fluid is provided with a nozzle, and the flow direction of the machining fluid is a direction of a first vector directing from the nozzle to a first point on the outer machining surface of the rotating outer diameter blade, and

wherein the flow direction of the machining fluid is substantially consistent with a revolving direction of the coring machine such that an angle between a lateral component of the first vector and a tangential velocity vector of the first point ranges from 0 to 15 degrees, and

wherein said first vector has a downward component.

2. The manufacturing method of glass substrate for magnetic disk according to claim 1,

wherein said angle is 0 degree.

3. The manufacturing method of glass substrate for magnetic disk according to claim 1 or 2, wherein the machining fluid is provided to the outer machining surface by use of a plurality of nozzles, the nozzles being positioned substantially evenly over the entire circumference of the outer diameter blade in said machining.

4. The manufacturing method of glass substrate for magnetic disk according to claim 1 or 2, wherein the machining fluid is provided to the outer machining surface by use of single or a plurality of nozzles, the nozzle or nozzles positioned toward the outer diameter blade and revolved concentrically with the outer diameter blade.