

[ABSTRACT]

WORKPIECE CARRYING-IN-AND-OUT METHOD IN DOUBLE-END SURFACE
GRINDING AND DOUBLE-END SURFACE GRINDER

[Object] To be able to prevent a workpiece in a carrier from dropping off at the time of carrying in and out the workpiece, which makes it possible to prevent beforehand damage to the workpiece.

[Solution Means] In double-end surface grinding for grinding both surfaces of the workpiece W by a pair of grinding wheels while rotating a thin sheet-like workpiece W which is held by static pressure by a pair of static pressure pads 1 and 2, by a carrier 7, at the time of sucking the workpiece W by carrying-in-and-out means 8 and 9, to carry the workpiece W into and out from the carrier 7 between the both static pressure pads 1 and 2, after the workpiece W is sandwiched by the carrying-in-and-out means 8 and 9 and the right static pressure pad 2, in that state, the workpiece W in the carrier 7 is sucked by the right static pressure pad 2 at an advanced holding position X1.

[Selected Drawing] FIG. 1