ABSTRACT

METHOD FOR MANUFACTURING MAGNETIC-DISK GLASSSUBSTRATE, METHOD FOR MANUFACTURING MAGNETIC DISK, AND GRINDSTONE

In edge surface grinding processing performed on a disk-shaped glass substrate, a pair of chamfered surfaces of the glass substrate are simultaneously ground with a rotation axis of the grindstone inclined with respect to an axis orthogonal to the main surface of the substrate. The grindstone is a groove-shaped grindstone having a pair of chamfered surface grinding areas for grinding the chamfered surfaces of the glass substrate. In this case, the pair of chamfered surface grinding areas include a chamfered surface grinding area (A) that comes into contact with the chamfered surface of the glass substrate on a front side in a rotation direction of the grindstone, with reference to a contact point between the glass substrate and the grindstone that is located on a straight line connecting the center of the glass substrate and a rotation axis of the grindstone, and a chamfered surface grinding area (B) that comes into contact with the chamfered surface of the glass substrate on a rear side in a rotation direction of the grindstone. The opening angle of the chamfered surface grinding area (A) is smaller than the opening angle of the chamfered surface grinding area (B).

[FIG. 3]