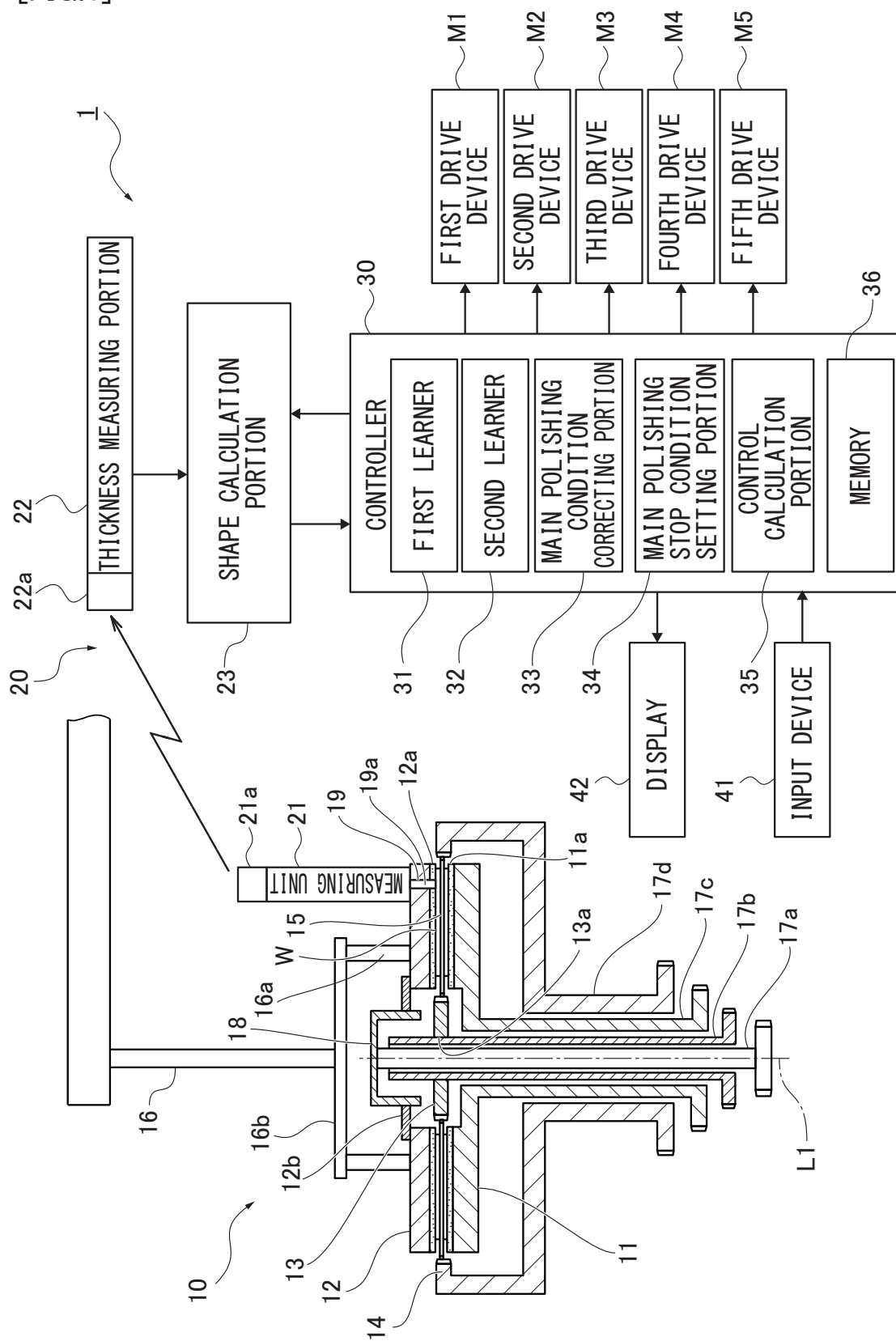
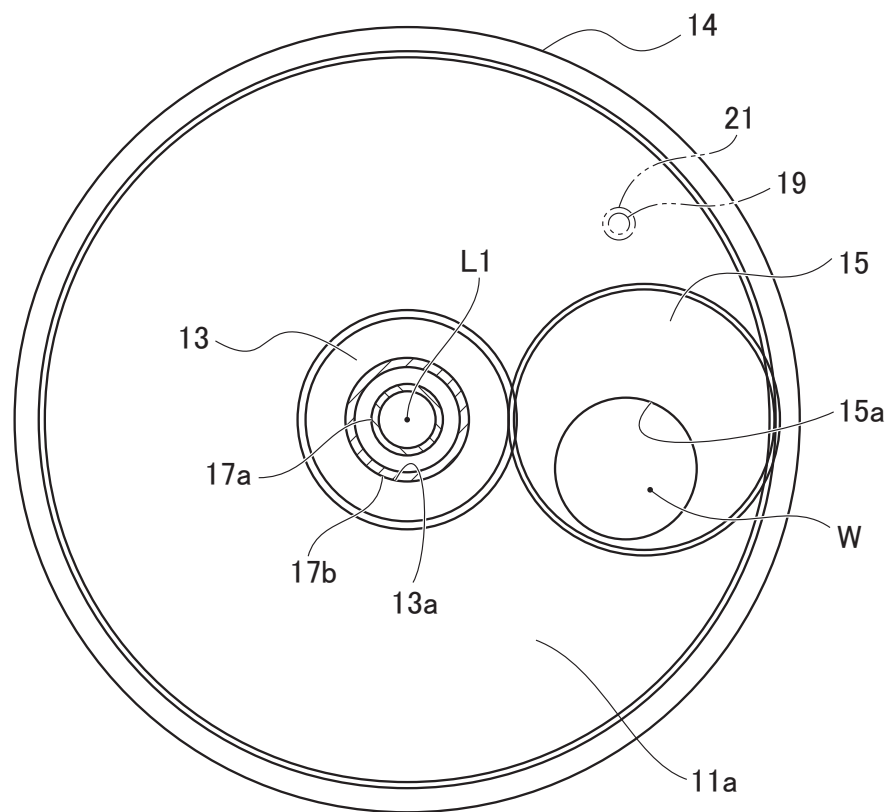


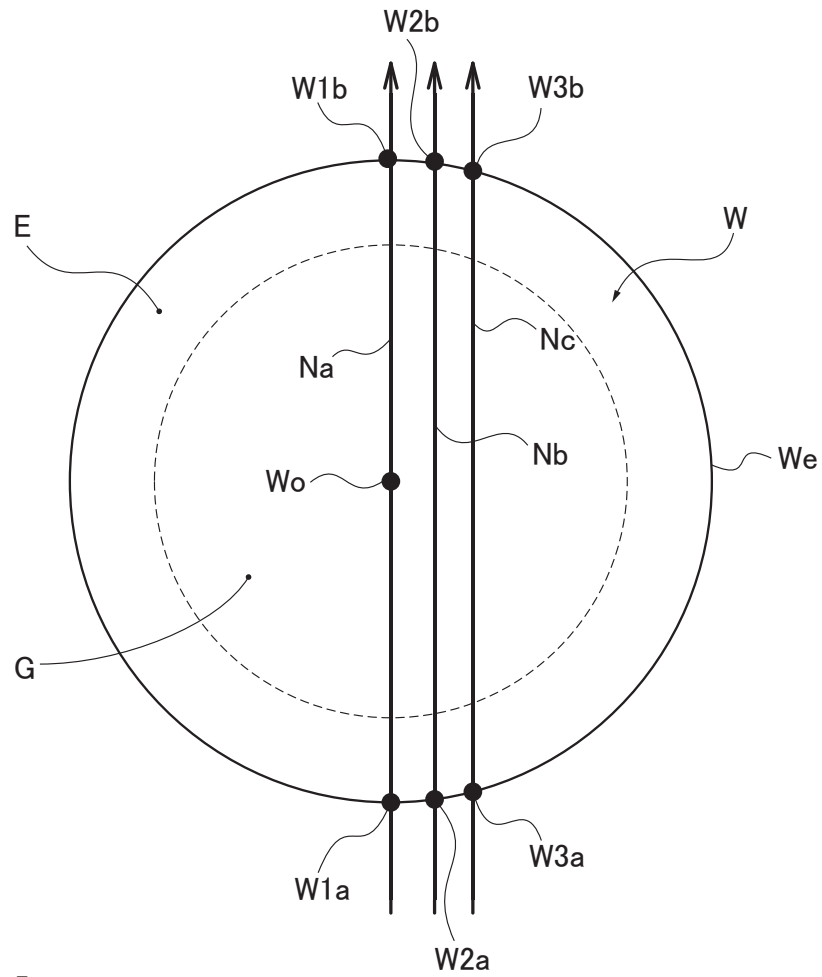
[FIG.1]



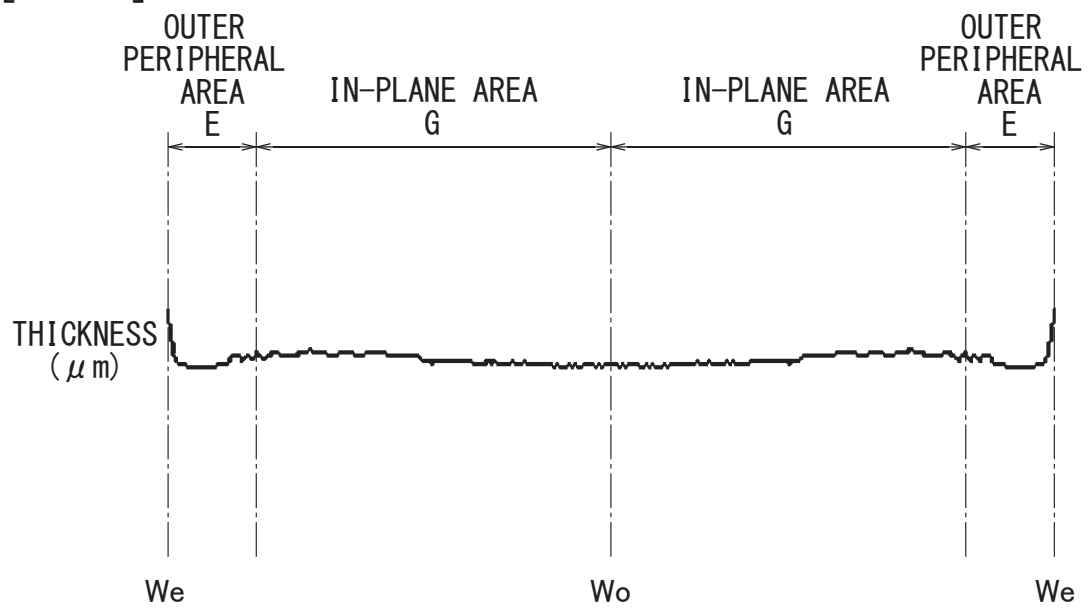
[FIG.2]



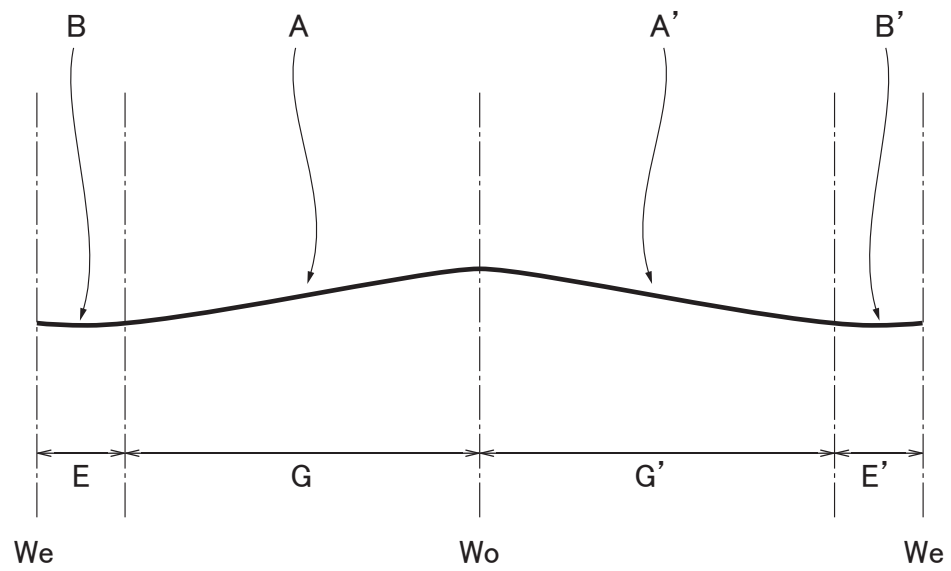
[FIG.3A]



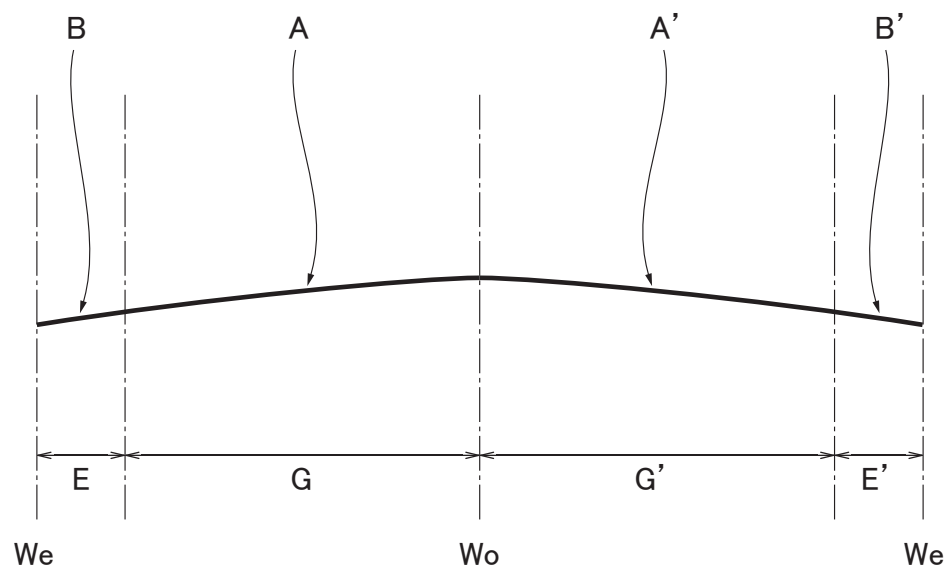
[FIG.3B]



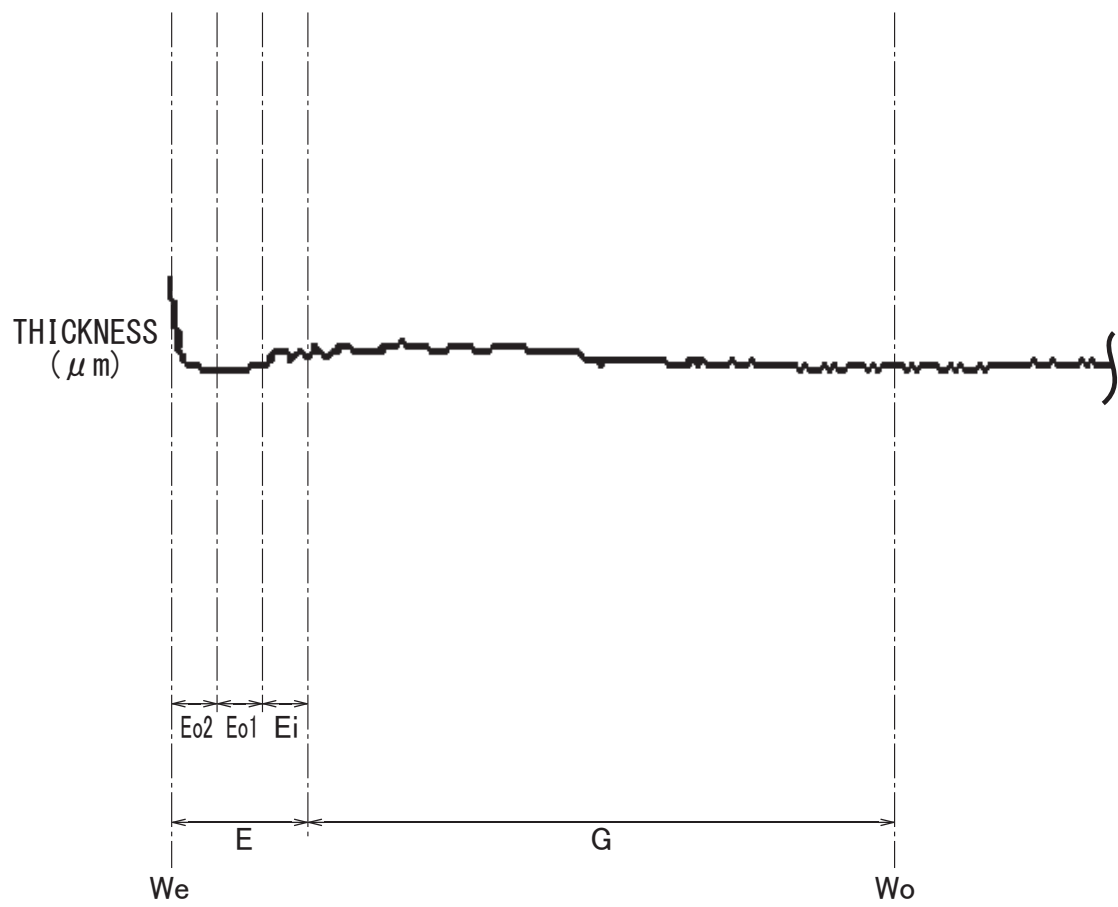
[FIG.4A]



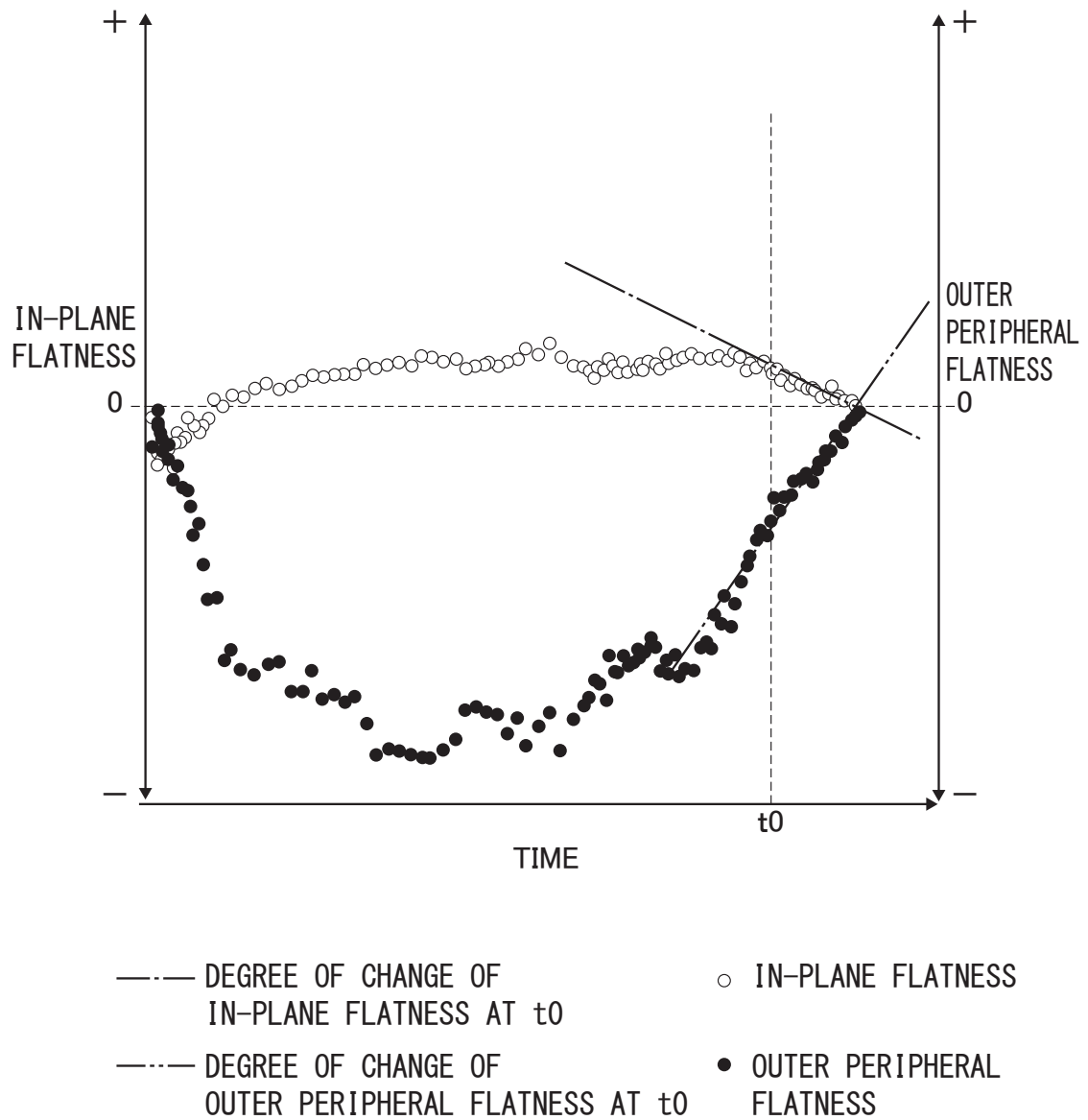
[FIG.4B]



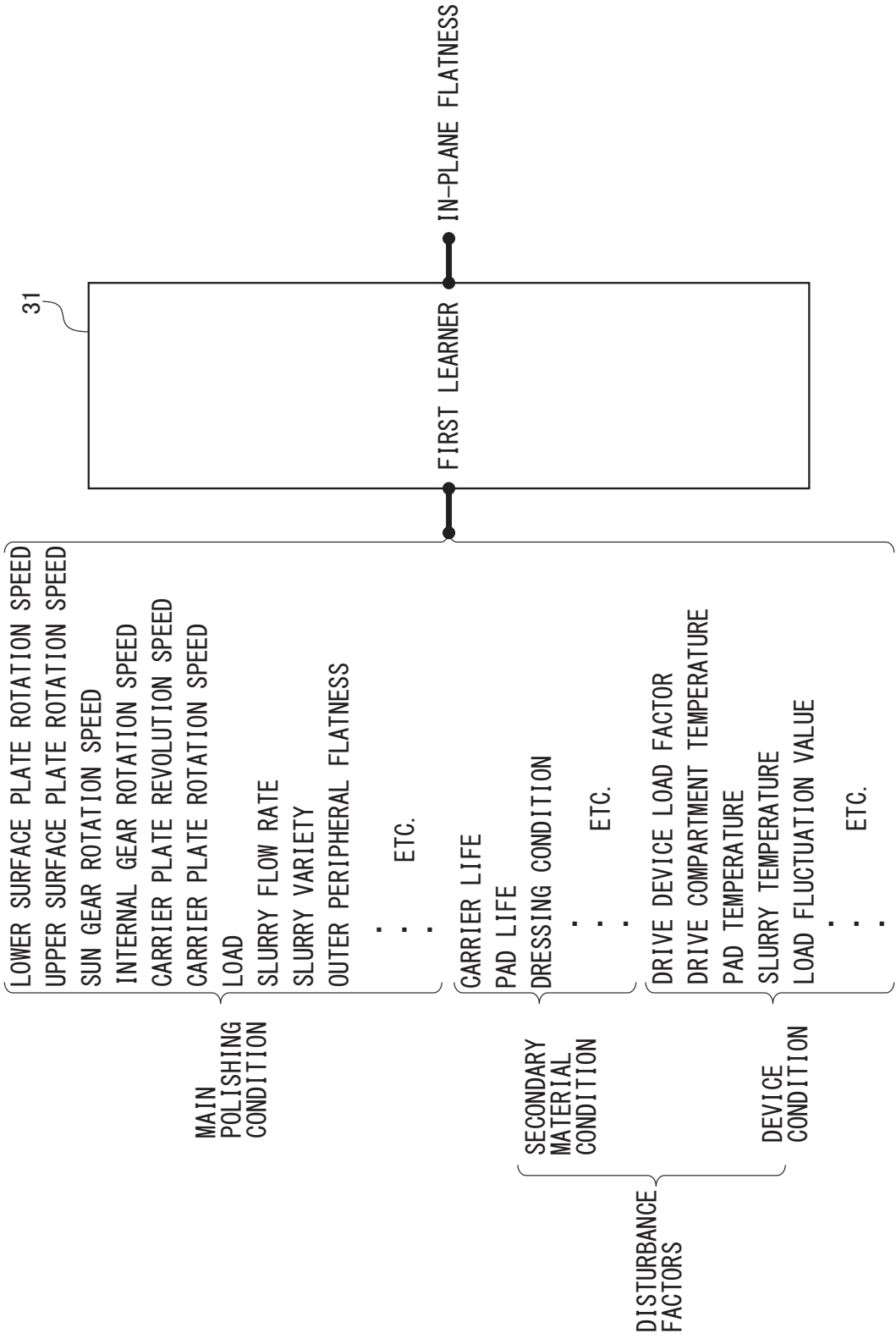
[FIG.5]



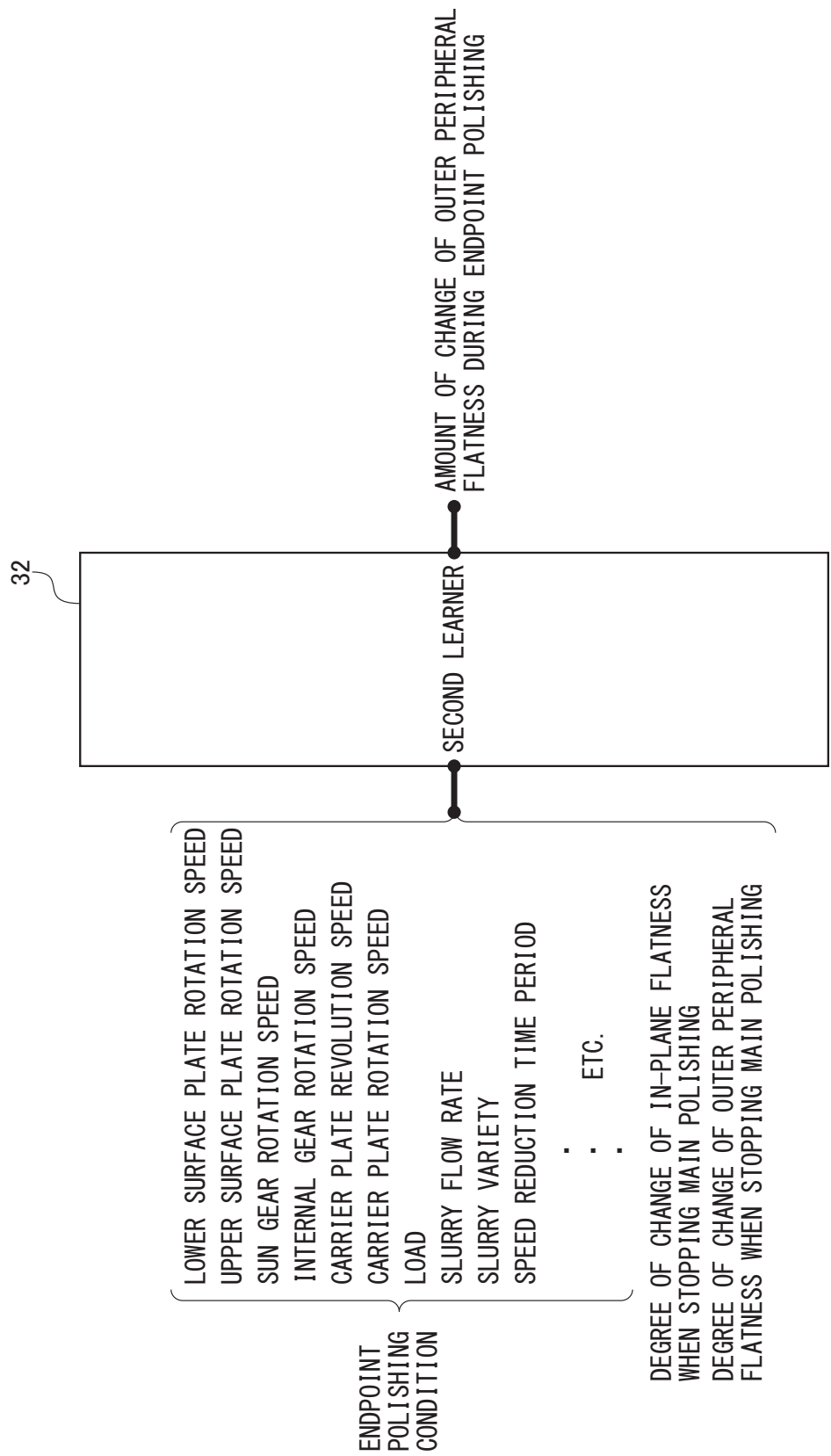
[FIG.6]



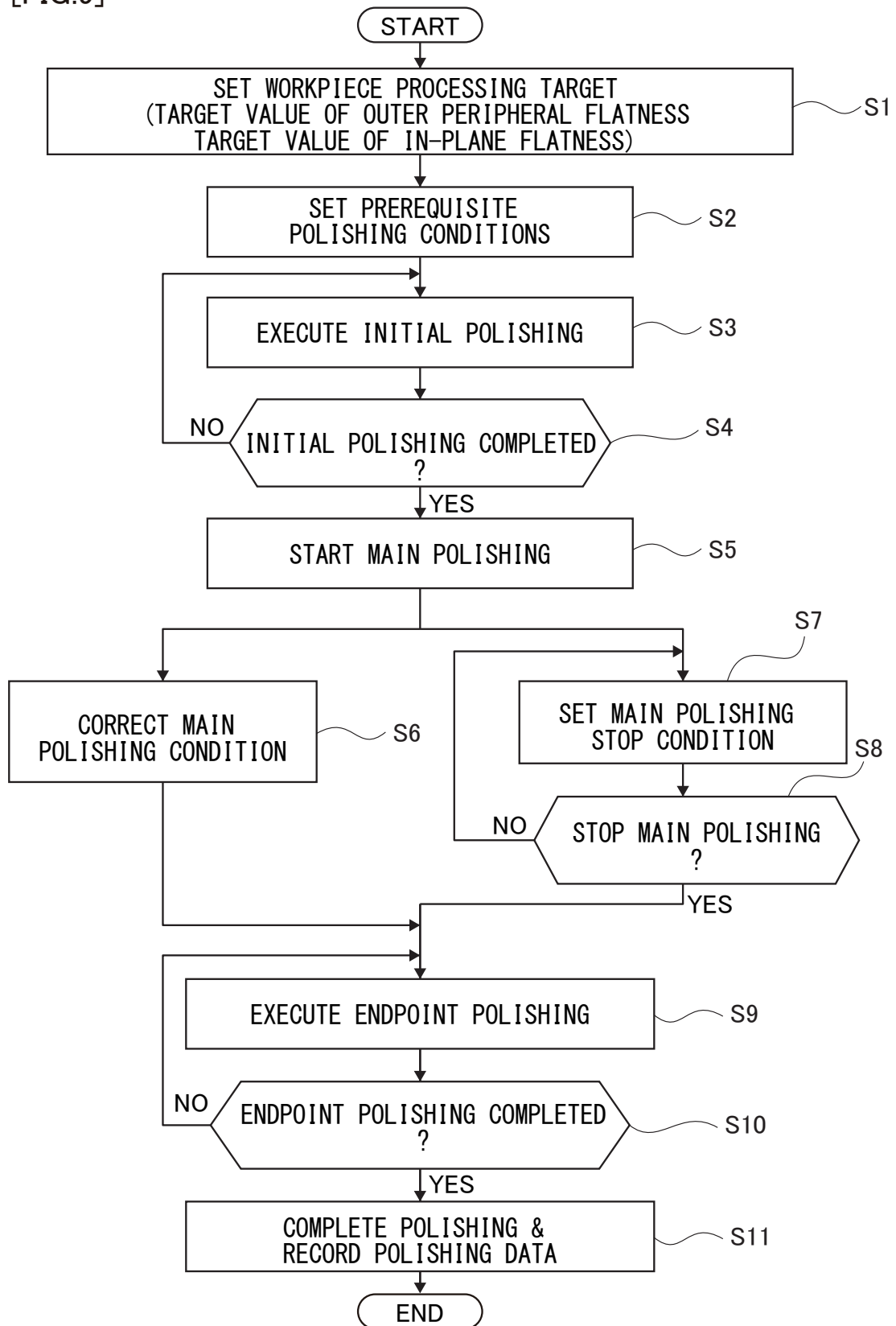
[FIG.7]



[FIG.8]



[FIG.9]



[FIG.10]

SHAPE CHANGE OF EXEMPLIFIED WORKPIECE
(DATA SET TO BE LEARNED BY FIRST LEARNER)

MAIN POLISHING CONDITION	OUTER PERIPHERAL FLATNESS (nm)	IN-PLANE FLATNESS (nm)
A	ZERO	+80
	-20	+90
	-50	+100
B	ZERO	ZERO
	-20	+10
	-50	+20
C	ZERO	-20
	-20	ZERO
	-50	+10

[FIG.11]

DATA SET TO BE LEARNED BY
LEARNER OF COMPARATIVE EXAMPLE

MAIN POLISHING CONDITION	IN-PLANE FLATNESS (nm)
A	+80
B	ZERO
C	-20

[FIG.12]

	ACTUAL IN-PLANE FLATNESS (nm)	ACTUAL OUTER PERIPHERAL FLATNESS (nm)
FIRST SAMPLE WORKPIECE	+34	-2
SECOND SAMPLE WORKPIECE	-4	-5
THIRD SAMPLE WORKPIECE	+40	-3
FOURTH SAMPLE WORKPIECE	+62	-3

TARGET VALUE OF OUTER PERIPHERAL FLATNESS = ZERO (nm)

[FIG.13]

	IN-PLANE FLATNESS TARGET VALUE (nm)	ACTUAL IN-PLANE FLATNESS (nm)	OUTER PERIPHERAL FLATNESS TARGET VALUE (nm)	ACTUAL OUTER PERIPHERAL FLATNESS (nm)
FIFTH SAMPLE WORKPIECE	0	-1	0	+3
SIXTH SAMPLE WORKPIECE	0	-4	-20	-20
SEVENTH SAMPLE WORKPIECE	-30	-30	0	+2
EIGHTH SAMPLE WORKPIECE	+30	+30	0	+3
NINTH SAMPLE WORKPIECE	0	-5	0	-4