

ABSTRACT

The present invention provides a method for manufacturing a magnetic-disk substrate with which an edge surface of a disk-shaped substrate is finished to have a high quality and stable grinding processing can be performed. In the present invention, an edge surface of a disk-shaped substrate is subjected to grinding processing by bringing a grinding liquid into contact with an edge surface portion of the substrate, bringing a grindstone into contact with an outer circumferential side edge surface of the substrate, and moving the outer circumferential side edge surface and the grindstone relative to each other. The grindstone is formed into a tubular shape, a plurality of groove shapes arranged side by side are included on an inner circumference of the tubular shape, and the plurality of groove shapes include a groove for rough grinding processing and a groove for precision grinding processing. The grindstone has a means for suppressing a case in which grinding chips formed when grinding processing is performed with the groove for rough grinding processing move to the groove for precision grinding processing. Moreover, the outer circumferential side edge surface of the substrate is subjected to the grinding processing by sequentially bringing the outer circumferential side edge surface of the substrate into contact with the groove for rough grinding processing and the groove for precision grinding processing of the grindstone.

[Figure 4]