CLAIMS

1. A method for manufacturing a magnetic-disk glass substrate comprising a plurality of grinding processings for grinding a main surface of a glass substrate by interposing the glass substrate between an upper surface plate and a lower surface plate, each having a grinding surface provided with a fixed abrasive particle grindstone containing an assembled abrasive particle in which a plurality of grinding abrasive particles are bonded via a glass bonding material; and dressing processing performed between a plurality of the grinding processings, wherein

the dressing processing is performed on respective surfaces of the fixed abrasive particle grindstone on the upper surface plate side and the fixed abrasive particle grindstone on the lower surface plate side, thereby adjusting a percentage of the assembled abrasive particles to which sludge is not adhered on the upper and the lower surface plates such that a difference in processing speed between the upper and lower surface plates decreases after the dressing processing than that before the dressing processing.

2. A method for manufacturing a magnetic-disk glass substrate comprising a plurality of grinding processings for grinding a main surface of a glass substrate by interposing the glass substrate between an upper surface plate and a lower surface plate, each having a grinding surface provided with a fixed abrasive particle grindstone containing an assembled abrasive particle in which a plurality of grinding abrasive particles are bonded via a glass bonding material; and dressing processing performed between a plurality of the grinding processings, wherein

the dressing processing is performed under different conditions on respective surfaces of the fixed abrasive particle grindstone on the upper surface plate side and the fixed abrasive particle grindstone on the lower surface

plate side such that a percentage of the assembled abrasive particles to which sludge is not adhered is greater for the lower surface plate.

3. The method for manufacturing a magnetic-disk glass substrate according to claim 1 or 2, wherein a time and/or frequency of the dressing processing is made different between the fixed abrasive particle grindstone on the lower surface plate side and the fixed abrasive particle grindstone on the upper surface plate side.

4. The method for manufacturing a magnetic-disk glass substrate according to any of claims 1 to 3, wherein the dressing processing is performed using a grindstone.

5. The method for manufacturing a magnetic-disk glass substrate according to any of claims 1 to 4, wherein a plurality of the grinding abrasive particles include diamond particles.

6. The method for manufacturing a magnetic-disk glass substrate according to any of claims 1 to 5, wherein the grinding processing is performed on the glass substrate in a state in which the main surface is a mirror-finished surface.

7. The method for manufacturing a magnetic-disk glass substrate according to any one of claims 1 to 6, wherein a percentage of the assembled abrasive particles to which sludge is not adhered is higher by 5% or more in the lower surface plate than that in the upper surface plate.

8. A method for manufacturing a glass substrate as a base of a magnetic-disk glass substrate, comprising a plurality of grinding processings for grinding a main surface of a glass substrate by interposing the glass substrate between an upper surface plate and a lower surface plate, each having a grinding surface provided with a fixed abrasive particle grindstone containing an assembled abrasive particle in which a plurality of grinding abrasive particles are bonded via a glass bonding material; and dressing processing performed

between a plurality of the grinding processings, wherein

the dressing processing is performed on respective surfaces of the fixed abrasive particle grindstone on the upper surface plate side and the fixed abrasive particle grindstone on the lower surface plate side, thereby adjusting a percentage of the assembled abrasive particles to which sludge is not adhered on the upper and the lower surface plates such that a difference in processing speed between the upper and lower surface plates decreases after the dressing processing than that before the dressing processing.

9. A method for manufacturing a glass substrate as a base of a magnetic-disk glass substrate comprising a plurality of grinding processings for grinding a main surface of a glass substrate by interposing the glass substrate between an upper surface plate and a lower surface plate, each having a grinding surface provided with a fixed abrasive particle grindstone containing an assembled abrasive particle in which a plurality of grinding abrasive particles are bonded via a glass bonding material; and dressing processing performed between a plurality of the grinding processings, wherein

dressing processing is performed under different conditions on respective surfaces of the fixed abrasive particle grindstone on the upper surface plate side and the fixed abrasive particle grindstone on the lower surface plate side such that a percentage of the assembled abrasive particles to which sludge is not adhered is greater for the lower surface plate.

10. The method for manufacturing a glass substrate as a base of a magnetic-disk glass substrate according to claim 8 or 9, wherein the grinding processing is performed on the glass substrate in a state in which the main surface is a mirror-finished surface.

11. The method for manufacturing a glass substrate as a base of a magnetic-disk glass substrate according to any one of claims 8 to 10, wherein a percentage of the assembled abrasive particles to which sludge is not adhered is

greater by 5% or more in the lower surface plate than that in the upper surface plate.

12. A method for manufacturing a magnetic-disk glass substrate, wherein polishing processing is at least performed on the main surface of the glass substrate as a base of a magnetic-disk glass substrate that is manufactured by the method of manufacturing a glass substrate as a base of a magnetic-disk glass substrate according to any one of claims 8 to 11.

13. A method for manufacturing a magnetic disk, wherein at least forming a magnetic recording layer is formed on a magnetic-disk glass substrate manufactured using the method for manufacturing a magnetic-disk glass substrate according to any of claims 1 to 7 and 12.