Method for the simultaneous double-side material-removing processing of at least three workpieces

Abstract

The invention relates to a method for the simultaneous double-side material-removing processing of at least three workpieces between a rotating upper working disk and a rotating lower working disk of a double-side processing apparatus, wherein the workpieces lie in freely movable fashion in a respective opening in a guide cage and are moved by the latter under pressure in a working gap formed between the two working disks, wherein, upon a preselected target thickness of the workpieces being attained, a deceleration process is initiated, during which the angular velocities $\omega_i(t)$ of all the drives i of the upper working disk, of the lower working disk and of the guide cage are reduced to a standstill of the two working disks and of the guide cage, wherein the angular velocities $\omega_i(t)$ of all the drives i are reduced in such a way that in this case the ratios of all the angular velocities $\omega_i(t)$ to one another as a function of the time t deviate by not more than 10% from the ratios at the instant at which the preselected target thickness is attained.

Fig. 2(B)