

GRINDING METHOD

ABSTRACT

Disclosed herein is a grinding method including a pre-grinding step of grinding a plate-shaped workpiece to a thickness just before a finish thickness is reached using finish grinding unit, a thickness measuring step of measuring a thickness of the plate-shaped workpiece after the pre-grinding step, a calculation step of calculating, from the measured thickness of the plate-shaped workpiece, a variation amount of the distance between a holding face of the chuck table and a grinding face of a finish grindstone before and after inclination adjustment of the chuck table, and a height adjustment step of adjusting, on the basis of the variation amount, the inclination of the chuck table while adjusting the height of the finish grinding unit so that the relative moving speed between the finish grindstone and the plate-shaped workpiece in a state in which the grinding face contacts with an upper face of the plate-shaped workpiece becomes equal to zero.

(Figure 3D)