

ABSTRACT

The present invention provides a method for manufacturing a magnetic-disk glass substrate that can manufacture a high-quality glass substrate having a favorable flatness after grinding. In the method for manufacturing a magnetic-disk glass substrate according to the present invention, a lubricant and a pair of upper and lower surface plates having a grinding surface provided with fixed abrasive particles including diamond particles are used and both main surfaces of the glass substrate are sandwiched between and ground with the pair of upper and lower surface plates while supplying the lubricant between the grinding surfaces and the glass substrate. The glass substrate is made using a sheet of plate glass manufactured by a float method, and has a surface portion containing tin in a large amount on one main surface side. The grinding processing is performed such that the upper surface plate side and the lower surface plate side are different in a processing speed, and the main surface of the glass substrate having the surface portion containing tin in a large amount is set on the surface plate side with the lower processing speed and ground.