

Method for Multiple Cutoff Machining of Rare Earth Sintered Magnet

ABSTRACT

5 A rare earth magnet block is cutoff machined into pieces by rotating cutoff abrasive blades. Improvements are made by setting the blades on one side of the magnet block, rotating the blades, starting machining operation to form cutting grooves in the magnet block from one side, interrupting the machining operation, moving the blades to the other side of the magnet block, and restarting the machining operation to form cutting grooves in
10 the magnet block from the other side, until the cutting grooves formed from the one and other sides merge with each other.

Fig. 2