

## ABSTRACT

### DOUBLE-END SURFACE GRINDING METHOD AND DOUBLE-END SURFACE GRINDER

To be able to easily and securely align a grinding position of a thin sheet-like workpiece at a middle position between both static pressure pads, and to perform grinding with predetermined grinding precision from an initial product immediately after the setup.

When grinding both surfaces of the workpiece W by a pair of grinding wheels 3 and 4 while rotating a thin sheet-like workpiece W supported by static pressure by a pair of static pressure pads 1 and 2, an operation in which, after the workpiece W is pressed against one of the static pressure pads 1 and 2 at the static pressure supporting positions H1 and H2, the workpiece W is levitated by a predetermined amount from the one static pressure pad 1 or 2 by the grinding wheel 3 or 4 whose rotation is stopped while advancing the grinding wheel 3 or 4 on the one static pressure pad 1 or 2 side, and a position of the grinding wheel 3 or 4 when the workpiece W is levitated by the predetermined amount is tentatively determined as a grinding advancing end position F1 or F2 is carried out on each side, and thereafter, the workpiece W is supported by static pressure by the both static pressure pads 1 and 2.

FIG. 1