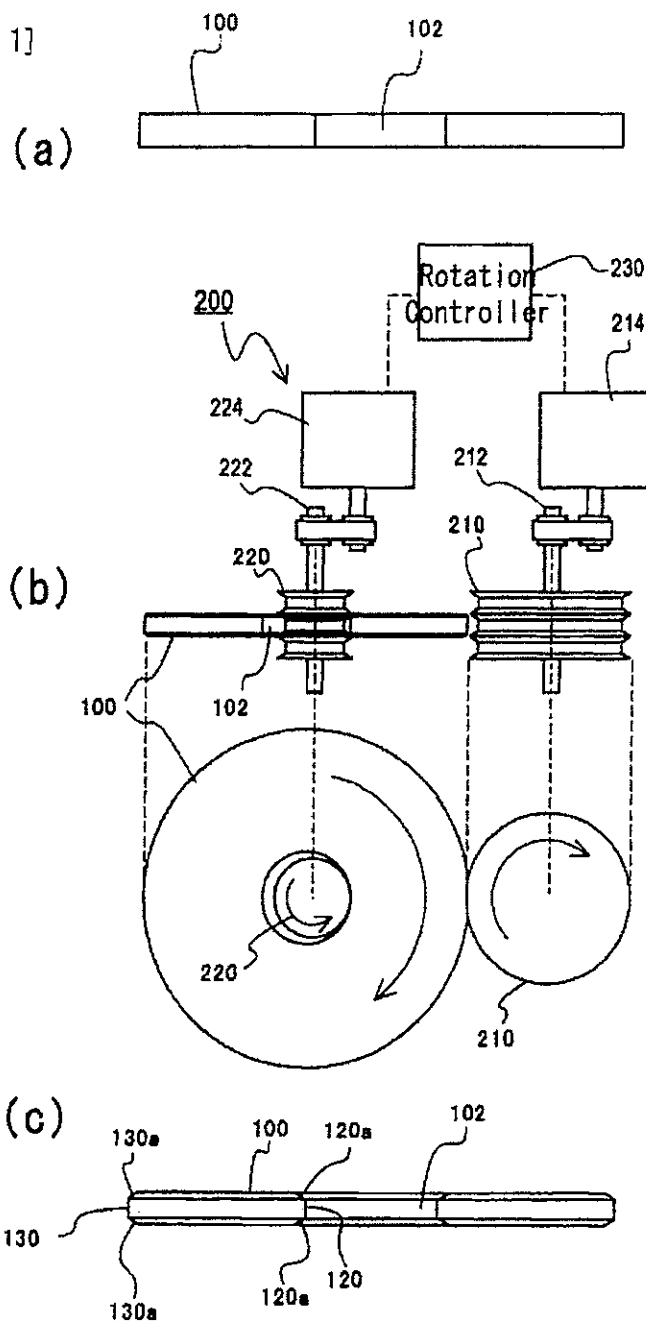
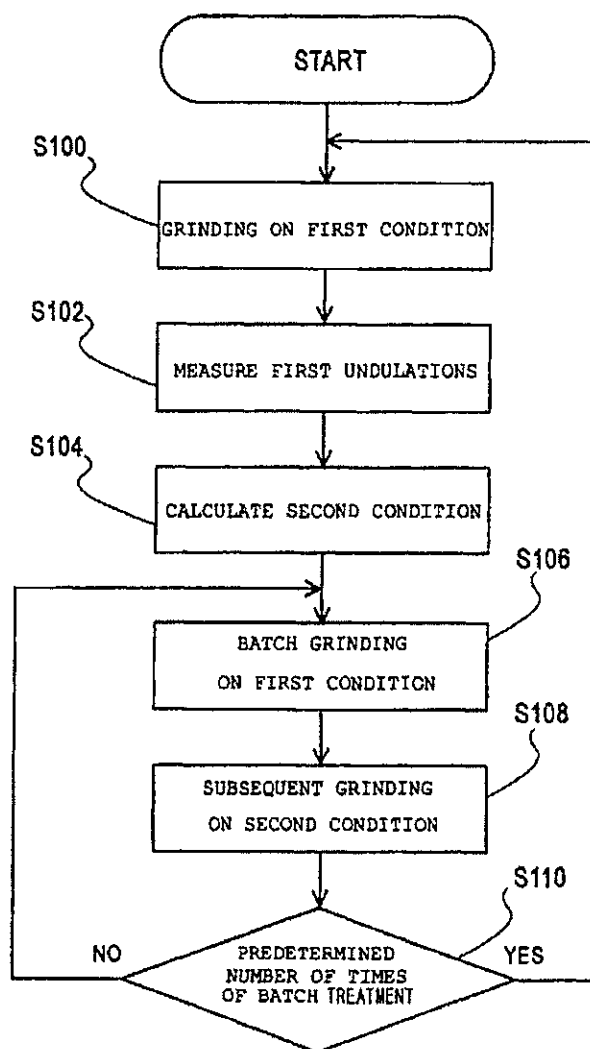


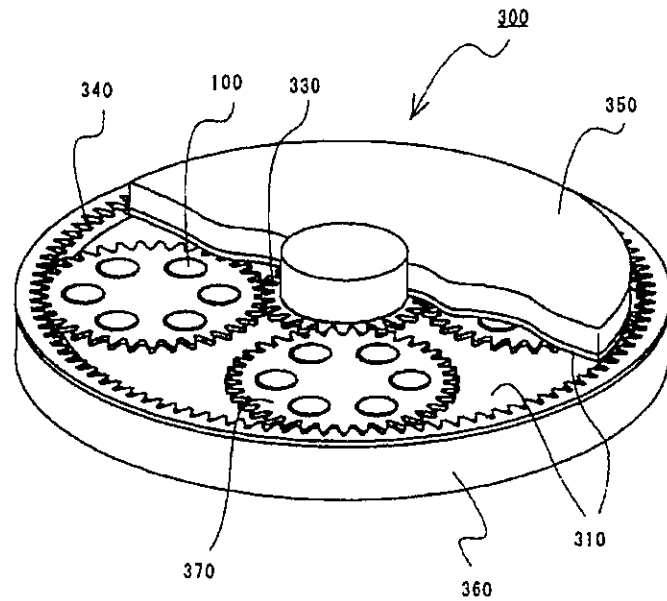
[Fig. 1]



[Fig. 2]



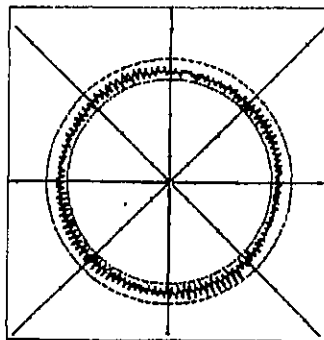
[Fig. 3]



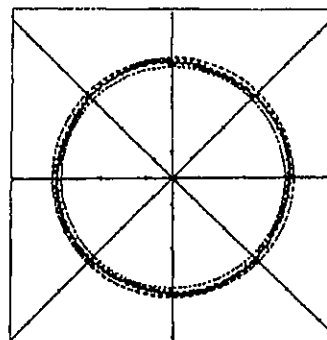
[Fig. 4]

(a) First Condition

(b) Second Condition



Rotational Frequency A of Grindstone	2412
Rotational Frequency B1 of Main Shaft	24
Number of First Undulations C	114



Rotational Frequency A of Grindstone	2412
Rotational Frequency B2 of Main Shaft	23.9
Number of Second Undulations	Numerous (Smooth)

(C) Calculation of Rotational Frequency B2 of Main Shaft on Second Condition

(Rotational Frequency B1 of Glass Substrate) / (Rotational Frequency B2 of Glass Substrate) × Number of Undulations

C=Rotational Frequency Ratio N2=2736/B2=Integer + 0.5 (Formula 5)

Rotational Frequency B2 of Main Shaft	Rotational Frequency Ratio N2 on Second Condition	Rounding-Off to First Decimal Place
23.6	115.9322	115.9
23.7	115.4430	115.4
23.8	114.9580	115.0
24.0	114.0000	114.0
24.2	113.0579	113.1
24.3	112.5926	112.6
24.4	112.1311	112.1

[Fig. 5]

(a)

Comparison of Time Required for Obtaining Roughness R_a = about $0.2 \mu\text{m}$

Working Example	First Condition + Second Condition	60 Seconds
Comparative Example	Only First Condition	120 Seconds

(b)

Comparison of Finishing in Same Processing Time

		Height of Undulations	Pitch of Undulations
Working Example	First Condition + Second Condition	$0.5 \mu\text{m}$	1.3 mm
Comparative Example	Only First Condition	$1 \mu\text{m}$	1.3 mm

[Fig. 6]

