Abstract

Method for providing a respective flat working layer on each of the two working disks of a double-side processing apparatus

The invention relates to a method for providing a respective flat working layer (32, 39) on each of the two working disks (13, 26) of a double-side processing apparatus comprising a ring-shaped upper working disk (13), a ring-shaped lower working disk (26) and a rolling apparatus (20, 21), wherein the two working disks (13, 26) and also the rolling apparatus (20, 21) are mounted in a manner rotatable about the axis of symmetry (28) of the double-side processing apparatus, and wherein the method comprises the following steps in the stated order:

(a) applying a lower intermediate layer (29) on the surface of the lower working disk (26) and an upper intermediate layer (16) on the surface of the upper working disk (13);

(b) simultaneously leveling both intermediate layers (16, 29) by means of at least three trimming apparatuses, each comprising a trimming disk (34), at least one trimming body (35, 36) containing an abrasive substance, and an outer toothing (37), wherein the trimming apparatuses are moved by means of the rolling apparatus (20, 21) and the outer toothing (37) under pressure and with addition of a cooling lubricant, which contains no substances with abrasive action, on cycloidal paths over the intermediate layers (16, 29) and thus bring about a material removal from the intermediate layers (16, 29); and

(c) applying a lower working layer (32) of uniform thickness to the lower intermediate layer (29) and an upper working layer (39) of uniform thickness to the upper intermediate layer (16).

Fig. 7A - 7D