

Title (en)

Method and apparatus for the post-process check of the workpieces in a double-plate lapping machine.

Title (de)

Verfahren und Gerät zum Kontrollieren von Werkstücken auf einer zweiseitigen Läppmaschine nach deren Bearbeitung.

Title (fr)

Méthode et appareil pour le contrôle dans une machine à roder des deux côtés d'une pièce après son usinage.

Publication

EP 0481935 A2 19920422 (EN)

Application

EP 91830440 A 19911016

Priority

IT 4838990 A 19901019

Abstract (en)

A method and an apparatus for the post-process check of the workpieces machined by a double-plate lapping machine, in which the upper plate is associated to means controlling the lowering and the pressure applied on the workpieces, and the lower plate is provided with a probe able to detect the spacing from the upper plate and to feed a signal representing said spacing to an electronic meter, in which the corrected value F(K) obtained from the difference between the heights of the workpieces at the end of the first two machining cycle is set, said value being compared with the average of the values provided by a feeler pin detecting the thickness of four lapped workpieces located at diametrically opposed positions at the end of each machining cycle so as to provide a further correction signal considering the variable parameters from cycle to cycle, said correction signal being fed to the central data processing unit for the resetting thereof. <IMAGE>

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CPC (source: EP)

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Cited by

US6108091A; US6111634A; CN110757336A; JP2020015105A; US6146248A; EP0893203A3; KR19980087549A; US6621584B2; US6261155B1; US6254459B1; US7125313B2; WO9814306A1

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