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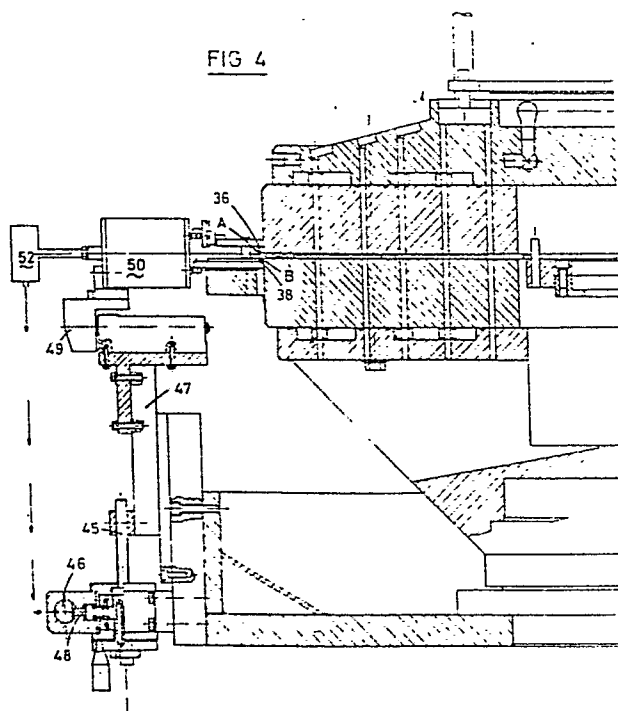
54 A two-plate lapping machine with comparator for continuously measuring the workpiece thickness.

57 In a lapping machine provided with two lapping plates (4,21) with satellites (10) rotated by a crown gear which is internal to the plate which satellites roll on outer ring gear along the periphery of the same plate, a comparator (50) is mounted provided with two points (36,38) between which, as between shears, in succession, a limb is taken of all the rotating satellites which all project from the lapping plate; at least a portion of a piece to be lapped being continued in said limb whereby the vertical thickness of said piece is measured.

Due to the suitable ratio being chosen between the number of teeth of the lapping plates and the number of the satellite teeth it is obtained that the measurement carried out on a workpiece for each satellite is continuously repeated.

A device (52) is also provided for restoring the alignment of the two points (36,38) of the comparator (50) when the lower plate is worn; a device (30) for facilitating the charging and the discharging of the satellites all filled of the workpieces being lapped is also provided.

FIG 4





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EUROPEAN SEARCH REPORT

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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.4)
A	PATENT ABSTRACTS OF JAPAN vol. 8, no. 258 (M340)(1695), 27th November 1984; & JP - A - 59 129 664 (FUJIKOSHI KIKAI KOGYO) 26-07-1984 ----	1	B 24 B 37/04
A	PATENT ABSTRACTS OF JAPAN vol. 1, no. 99 (M-77), 31st August 1977, page 2770; & JP - A - 52 39889 (TOSEI ENGINEERING SERVICE) 28-03-1977 ----	1	
A	US-A-3 097 458 (RICHMOND) * column 2, lines 2-30; column 3, lines 38-48; figure 2 * ----	1	
A	DE-A-3 213 252 (SHIN-ETSU et al.) * claim 1; pages 10,11; figure 1 * ----	1	
A	PATENT ABSTRACTS OF JAPAN vol. 9, no. 7 (M350)(1730), 12th January 1985; & JP - A - 59 156 665 (SUPIIDO FUA MU) 05-09-1984 ----	1	
A	US-A-3 304 662 (BOETTCHER) * claim 1; figures 1,2 * -----	1	
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			B 24 B 7/00 B 24 B 27/00 B 24 B 37/00 B 24 B 49/00
The present search report has been drawn up for all claims			
Place of search BERLIN		Date of completion of the search 31-03-1989	Examiner MARTIN A E W
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ----- & : member of the same patent family, corresponding document	