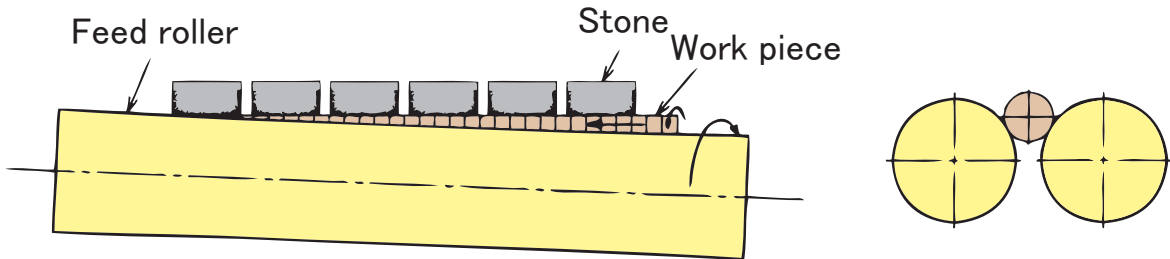



Improvement of roundness on centerless machining

As far as centerless stone lapping process performed by rigid abrasive grains is concerned, as shown in Fig. 2 and Fig. 3, it is characterized by topping effect that tends to cut from peaked areas in the cross section of a work piece, and is possible to improve roundness of a work piece largely. On the other hand in case of the oval shape shown in Fig. 1, its effect is not much obtainable, and thus roundness is not expected to improve.



Oval 
 This area is cut well, and an oval shape becomes more degenerated.

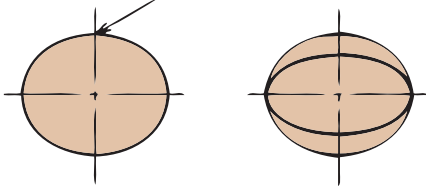
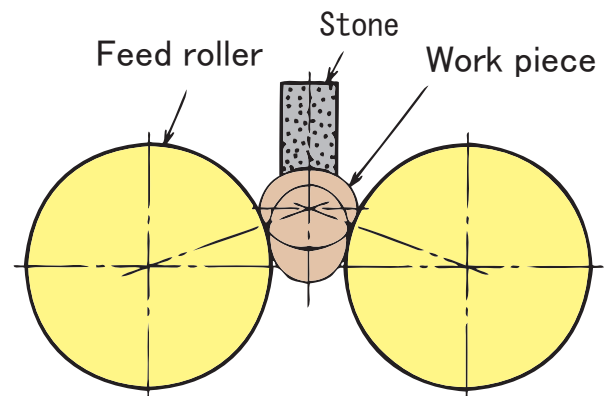



Fig. 1



Triangle 
 This area is cut well, and a shape becomes more rounded.

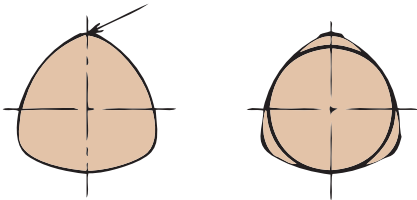
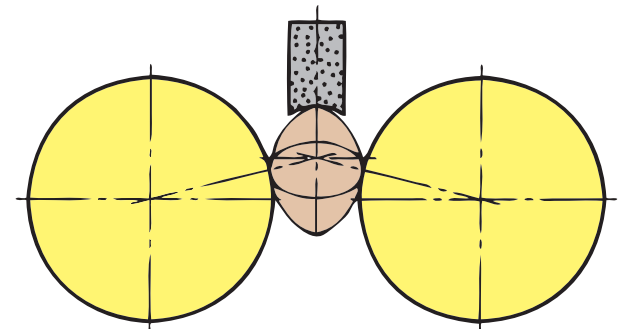



Fig. 2



Square 
 This area is cut well, and a shape becomes more rounded.

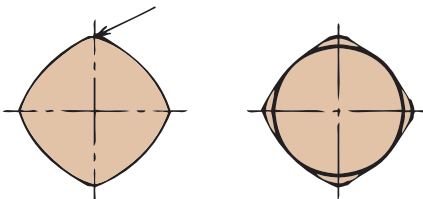


Fig. 3

