

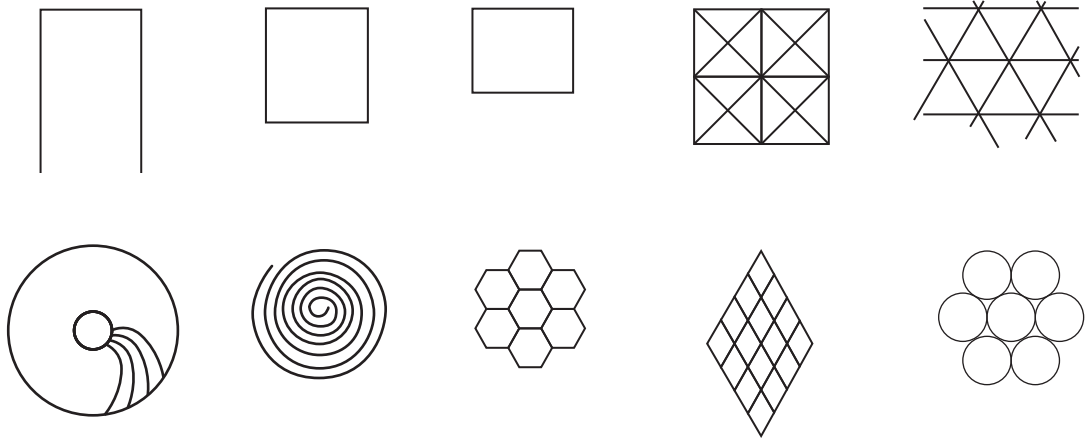


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ABOUT PITCH GROOVING

Grooving can be an added plus in pitch lap applications, delivering extra slurry with consistent dispersion, reducing heat buildup and providing an escape route for cut swarf. Swarf that remains on the lap while polishing results in scratches or sleeks which may be difficult to diagnose. Grooving can alleviate this problem.

GROOVE SHAPES COMMONLY FOUND ON PITCH LAPS



GROOVING PROCESS

- A series of crosshatch grooves are “sliced” onto the surface of the lap.
- Grooves can be deep, but should not exceed 50% of the thickness of the pitch on the lap.
- Width of grooves varies with application (material type, lap pressure, speed, slurry concentration, etc.), but usually do not exceed $\frac{1}{8}$ ” of an inch in width.
- Spacing is also gauged by application, but generally a minimum of 10% of the lap diameter is a good starting point, with a minimum measurement of $\frac{1}{2}$ ”.
- Tooling required to groove a lap can be a simple razor blade or hot knife, guided by light marks or straight edge.