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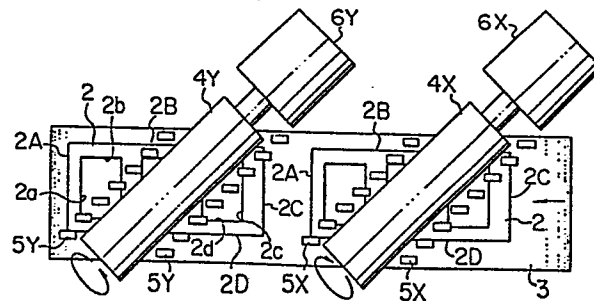
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⑤④ **Burring chamfering method.**

⑤⑦ A method of burring and chamfering a workpiece (2) employs an apparatus including: a workpiece carrying belt conveyor (3); one or a plurality of elastic grinding wheels (4) obliquely disposed over the belt conveyor (3), the grinding wheels (4) being arranged in parallel to each other in the same direction; and split-type press rollers (5X, 5Y) disposed along both sides of each of the grinding wheels (4). The method comprises the steps of: passing the workpiece (2) under a first grinding wheel (4X) which has a grinding surface rotating in the direction opposite to the moving direction of the workpiece (2) thereby to effect burring and chamfering; and passing the workpiece (2) under a second grinding wheel (4Y) which is disposed in parallel to the first grinding wheel (4X) and has a grinding surface rotating in the same direction as the moving direction thereby to effect burring and chamfering. The grinding wheels (4X, 4Y) may be rotated while having an angle of about 45 degrees with respect to the moving direction. The moving direction of the belt conveyor (3) may be changed every time a predetermined time elapses. Moreover, the grinding wheels (4X, 4Y) may be vibrated in an axial direction of the grinding wheels.





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)
Y	FR-A-2 374 137 (MITSUBISHI) * Page 8, line 16 - page 13, line 10; claims 1,2; figures 9,10 *	1	B 24 B 9/00
A	---	2,3	
Y	US-A-3 435 566 (ENSERINK) * Column 2, lines 53-64; figures 3,5 *	1	
A	--- GB-A-2 106 020 (AVCO) * Page 3, lines 8-30; figure 5 *	5	
A	--- GB-A-1 461 570 (HAWKER-SIDDELEY) -----		
The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			B 24 B
Place of search THE HAGUE		Date of completion of the search 28-11-1984	Examiner ESCHBACH D.P.M.
<p>CATEGORY OF CITED DOCUMENTS</p> <p>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</p> <p>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</p>			

