CLAIMS

1. A formed material manufacturing method of manufacturing a formed material having a tubular body and a flange, which is formed at an end portion of the body, by performing multistage drawing of a blank metal sheet, wherein

the multistage drawing includes:

preliminary drawing in which a preliminary body having a body preform is formed from the blank metal sheet; and

at least one compression drawing which is performed after the preliminary drawing by using a mold including a die having a press-in hole, a punch inserted into the body preform to press the body preform into the press-in hole, and pressurization means for applying a compressive force along a depth direction of the body preform to a circumferential wall of the body preform, and in which the body is formed by drawing the body preform while applying the compressive force to the circumferential wall of the body preform;

the pressurization means is a lifter pad having a pad portion which is disposed at the outer circumferential position of the punch so as to face the die and onto which a lower end of the circumferential wall of the body preform is placed, and a support portion which supports the pad portion from below and which is configured such that a support force that supports the pad portion can be adjusted;

at least one compression drawing is performed to be completed before the pad portion reaches bottom dead center; and

the support force acts as the compression force upon the circumferential wall of the body preform when the drawing of the body preform is performed.

2. The formed material manufacturing method according to claim 1, wherein where a value (N/mm^2) obtained by dividing the compressive force applied to the circumferential wall of the body preform by a cross-sectional area of a circumferential wall of the body preform is denoted by P and a ratio of the die shoulder radius (mm) to the thickness (mm) of the circumferential wall of the body preform before the compressive force is applied and the drawing is performed is denoted by x,

$163x^{-1.2} \leq P \leq 130x^{0.3}$ is satisfied.

3. The formed material manufacturing method according to claim 1 or 2, wherein

the body includes a top wall and a circumferential wall protruding from an outer edge of the top wall; and

the thickness of the circumferential wall of the body is equal to or greater than at least one of a maximum thickness of the top wall of the body and the thickness of the blank metal sheet.