

IRONING MOLD AND FORMED MATERIAL MANUFACTURING METHOD

[ABSTRACT]

An ironing mold according to the present invention is provided with a punch, and a die which forms a pushing hole with respect to the punch. When the skewness R_{sk} of a surface treated metal plate is less than -0.6 and no less than -1.3 , then the curvature radius of a shoulder portion of the die and a clearance between a radius end and the punch are determined such that Y , which is expressed by $\{(t_{re} - c_{re})/t_{re}\} \times 100$, and X , which is expressed by r/t_{re} , satisfy $0 < Y \leq 18.7X - 6.1$, X satisfies $X \geq 0.6$ and r satisfies $r \leq 0.5h$.

Fig. 6