[Claims]

[Claim 1]

A formed material manufacturing method of manufacturing a formed material having a tubular body and a flange, which is formed at an end of the body, by performing at least three forming processes on a base metal sheet, wherein

the at least three forming processes include at least one drawing-out process, at least one drawing process performed after the drawing-out process, and at least one coining process performed after the drawing process,

the drawing-out process is performed using a mold that includes a punch and a die having a pushing hole,

a width of a rear end side of the punch is set to be wider than a width of a tip end side thereof so that a clearance between the die and the punch, when the punch is pushed into the pushing hole in the die, is narrower on the rear end side than on the tip end side,

an ironing process is performed on a region corresponding to the flange of the base metal sheet by pushing the base metal sheet together with the punch into the pushing hole in the drawing-out process, and

in the coining process, the flange formed in the drawing process is inserted between a pushing mold and a receiving mold, wherein the flange is compressed and reduced in

thickness and a flat portion extending in circumferential direction of the flange is formed.

[Claim 2]

The formed material manufacturing method according to claim 1, wherein

an ironing ratio of the ironing process is 50% or less.

[Claim 3]

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

the coining process is performed on a part where the ironing process has been performed in the drawing-out process, which is a flange region necessary for a product.