



(12) **CORRECTED EUROPEAN PATENT APPLICATION**

(15) Correction information:
Corrected version no 1 (W1 A1)
Corrections, see
Bibliography INID code(s) 84

(51) Int Cl.:
B21D 22/06 (2006.01) **B21D 22/02 (2006.01)**
B30B 15/14 (2006.01) **B21D 24/10 (2006.01)**
B21D 24/02 (2006.01) **B21D 24/04 (2006.01)**

(48) Corrigendum issued on:
02.06.2010 Bulletin 2010/22

(43) Date of publication:
24.03.2010 Bulletin 2010/12

(21) Application number: **10150099.9**

(22) Date of filing: **12.04.2007**

(84) Designated Contracting States:
DE GB

(30) Priority: **14.04.2006 JP 2006112242**
14.04.2006 JP 2006112256

(62) Document number(s) of the earlier application(s) in accordance with Art. 76 EPC:
07106021.4 / 1 844 871

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Remarks:
This application was filed on 05-01-2010 as a divisional application to the application mentioned under INID code 62.

(54) **Press working method with a punch step and press working apparatus with a movable punch**

(57) In a press working apparatus (10), while a servo motor (24) is acting, an upper die (238) is made to come close to a lower die (252) while the plate (212) is being pinched by a first holder (240) and a second holder (254).

The pinch conducted by the first holder (240) and the second holder (254) on the plate (212) is released after press forming of the plate (212) was started in the press forming step and before both dies (238,252) reach a bottom dead center (x2) at which the dies (238,252) are made to come close to each other.

FIG. 14

