Claims

[Claim 1]

A composite yarn fabric, obtained by weaving using composite yarns as at least one of the warp or the weft, the composite yarns obtained by doubling and twisting inorganic multifilament yarns and thermoplastic resin yarns,

wherein the inorganic multifilament yarns have a mass in a range of 10 to 65 tex,

monofilaments constituting the inorganic multifilament yarns have a fiber diameter in a range of 6.6 to 9.5 μm,

a melt flow rate of a thermoplastic resin constituting the thermoplastic resin yarns is in a range of 34 to 100 g/10 minutes,

a ratio of a mass of the inorganic multifilament yarns to a total mass of the composite yarns is in a range of 40 to 90% by mass, and

the inorganic multifilament yarn is a bundle of only inorganic monofilaments.

[Claim 2]

The composite yarn fabric according to claim 1, wherein the inorganic multifilament yarns have a mass in a range of 33.7 to 65 tex.

[Claim 3]

The composite yarn fabric according to claim 1 or 2, wherein the inorganic multifilament yarns are glass fiber yarns.

[Claim 4]

The composite yarn fabric according to any one of claims 1 to 3, wherein the thermoplastic resin yarns are polyamide resin yarns.

[Claim 5]

A method for manufacturing a fiber-reinforced resin molded article according to any one of claims 1 to 4, comprising:

a molding step of heating and pressing one sheet of a composite yarn fabric or a stacked body in which a plurality of sheets of the composite yarn fabric is stacked, the composite yarn fabric being obtained by weaving using composite yarns as at least one of the warp or the weft, the composite yarns obtained by doubling and twisting inorganic multifilament yarns and thermoplastic resin yarns,

wherein the inorganic multifilament yarns have a mass in a range of 10 to 65 tex,

monofilaments constituting the inorganic multifilament yarns have a fiber diameter in a range of 6.6 to 9.5 μm,

a melt flow rate of a thermoplastic resin constituting the thermoplastic resin yarns is in a range of 34 to 100 g/10 minutes,

a ratio of a mass of the inorganic multifilament yarns to a total mass of the composite yarns is in a range of 40 to 90% by mass, and

the inorganic multifilament yarn is a bundle of only inorganic monofilaments.

[Claim 6]

The method for manufacturing a fiber-reinforced resin molded article according to claim 5, wherein the inorganic multifilament yarns have a mass in a range of 33.7 to 65 tex.

[Claim 7]

The method for manufacturing a fiber-reinforced resin molded article according to claims 5 or 6, wherein the inorganic multifilament yarns are glass fiber yarns.

[Claim 8]

The method for manufacturing a fiber-reinforced resin molded article according to any one of claims 5 to 7, wherein the thermoplastic resin yarns are polyamide resin yarns.