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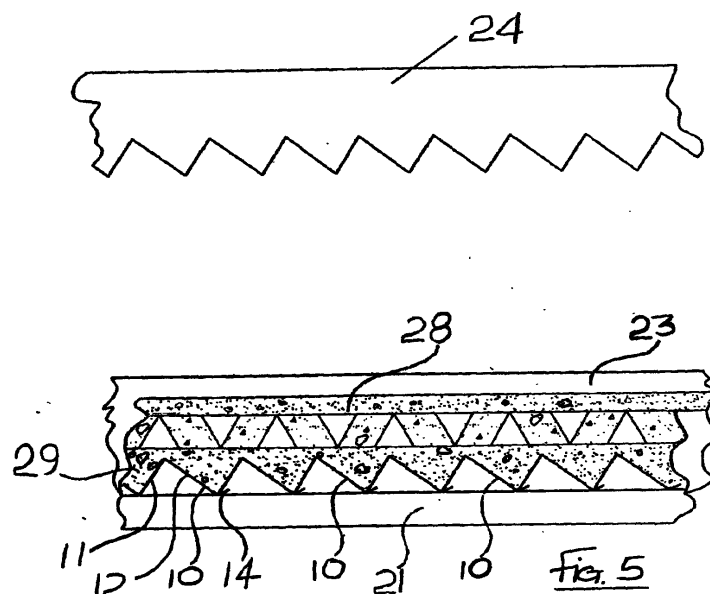
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(54) **Stairway manufacture**

(57) A set of L-shaped modular step forming elements (10) are arranged within a mould (20) on support rails (21) to define a stairway of steps having a desired riser and tread. Each element (10) comprises a steel sheet bent intermediate its ends into an L-shape having a riser panel (11) and a tread panel (12). Spaced-apart stringer panels (23,24) which engage the elements (10) define a required stairway width and end panels extending between the stringer panels (23,24) close off each

end of the mould (20) to define the length of the stairway. Steel reinforcement such as bars or a cage (28) is mounted on the step forming elements (10) and then concrete (29) is poured into the mould (20) covering the cage (28). A poker vibrator is inserted into the concrete (29) and vibrated to settle the concrete (29) and exclude air from the mould (20). A heating element (26) may be operated to accelerate the setting of the concrete (29) in the mould (20). After the concrete is set the stairway thus formed is removed from the mould.





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# EUROPEAN SEARCH REPORT

Application Number  
EP 99 65 0021

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A	---	7-9	
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The present search report has been drawn up for all claims			
Place of search		Date of completion of the search	Examiner
THE HAGUE		24 October 2000	Gourier, P
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	

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<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone  Y : particularly relevant if combined with another document of the same category  A : technological background  O : non-written disclosure  P : intermediate document</p> <p>T : theory or principle underlying the invention  E : earlier patent document, but published on, or after the filing date  D : document cited in the application  L : document cited for other reasons  &amp; : member of the same patent family, corresponding document</p>			

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**ANNEX TO THE EUROPEAN SEARCH REPORT  
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This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.  
The members are as contained in the European Patent Office EDP file on  
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