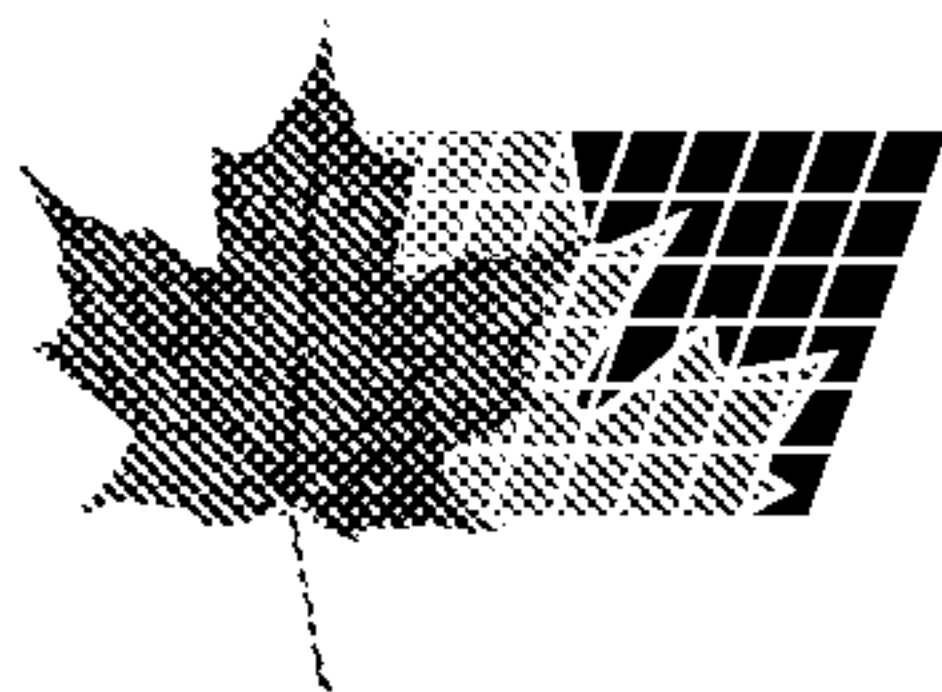
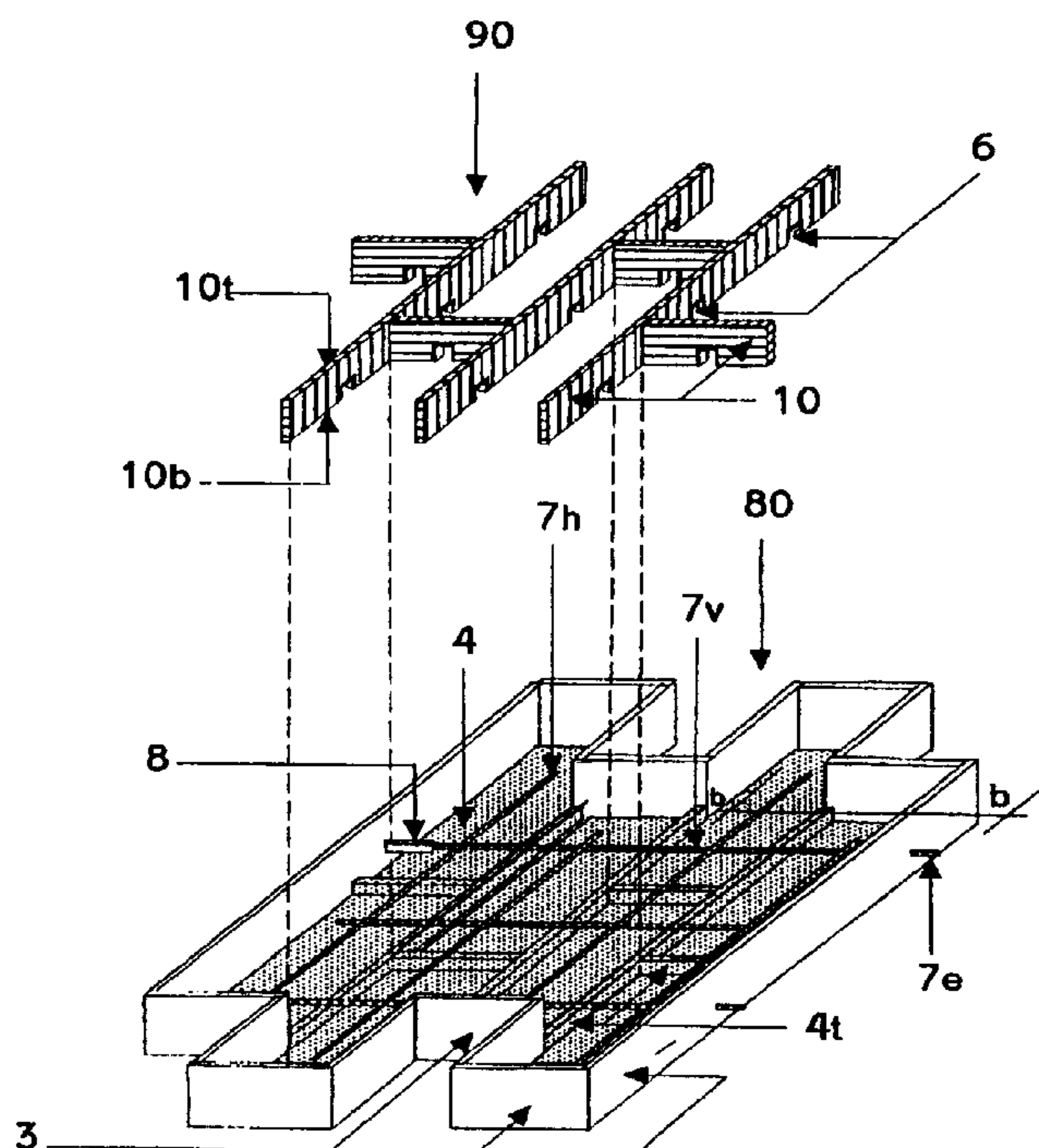




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(54) **PIERRES DECORATIVES ATTACHEES**
(54) **ATTACHED DECORATIVE STONES**



(57) Procédé permettant de produire un mur, un article en béton préfabriqué vertical ou horizontal, un trottoir ou une chaussée à l'aide d'au moins un article décoratif modulaire (100) comportant une pluralité de pierres séparées (1) constituées d'une matière durcie polymérisée (5) et une pluralité de tiges (7h et 7v) connectant les pierres (1) ensemble. Ledit article décoratif (100) est créé à l'aide d'au moins un moule (200) comportant (a) une structure externe (80) de moule dotée d'un fond horizontal (4) et de parois périphériques verticales (3) et (b) une forme interne (90) qui comporte une pluralité de poutres verticales (10) interconnectées dotées d'encoches (6). Les tiges (7h et 7v) sont placées à l'intérieur du moule (200) et après coulage, sont ancrées à l'intérieur de la matière durcie (5), ce qui les rend complètement solidaires de l'article décoratif (100).

(57) A method for producing a wall, vertical or horizontal precast concrete article, walkway and roadway of at least one modular decorative article (100) including a plurality of separate stones (1) of cured hardened material (5) and a plurality of rods (7h and 7v) connecting the stones (1) together. The decorative article (100) is created inside at least one mold (200) including (a) an exterior mold frame (80) that includes a horizontal bottom (4) and vertical perimeter walls (3) and (b) an interior form (90) that comprises a plurality of vertical interconnected beams (10) with grooves (6). The rods (7h and 7v) are placed inside the mold (200) which after casting are anchored inside the hardened material (5) and become an inseparable part of the decorative article (100).

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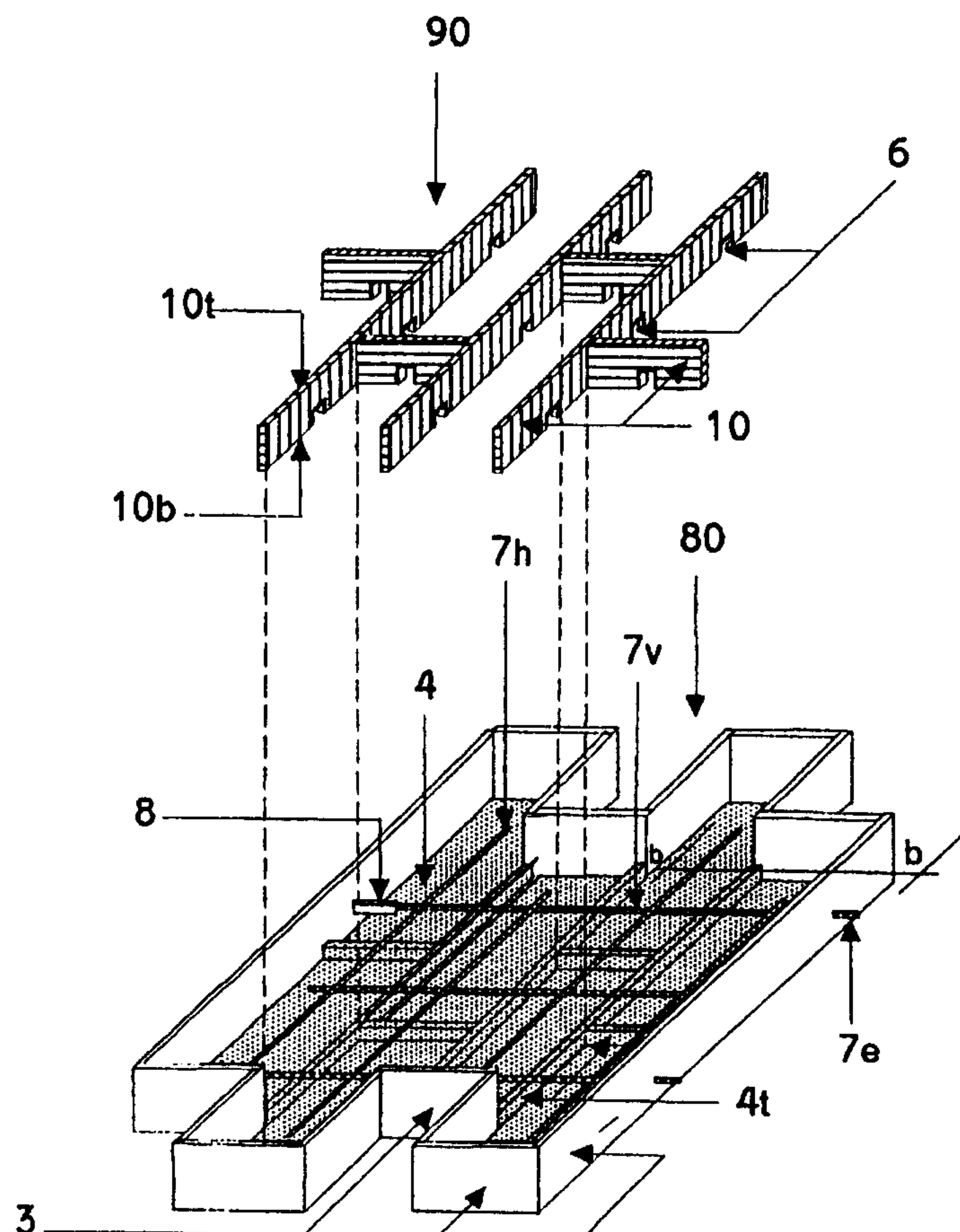
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(54) Title: ATTACHED DECORATIVE STONES

(57) Abstract

A method for producing a wall, vertical or horizontal precast concrete article, walkway and roadway of at least one modular decorative article (100) including a plurality of separate stones (1) of cured hardened material (5) and a plurality of rods (7h and 7v) connecting the stones (1) together. The decorative article (100) is created inside at least one mold (200) including (a) an exterior mold frame (80) that includes a horizontal bottom (4) and vertical perimeter walls (3) and (b) an interior form (90) that comprises a plurality of vertical interconnected beams (10) with grooves (6). The rods (7h and 7v) are placed inside the mold (200) which after casting are anchored inside the hardened material (5) and become an inseparable part of the decorative article (100).



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ATTACHED DECORATIVE STONES

SPEIFICATION

FIELD OF INVENTION

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The present invention relates to a method for producing a wall, vertical or horizontal precast concrete article, walkway and roadway which is faced with stones or bricks of water containing materials.

BACKGROUND OF INVENTION

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There are two main methods for producing a construction element which is faced with separate stones or bricks of water containing materials.

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According to the first method the individual stones are created and packed at the factory, and are shipped to the construction site. Each stone is attached separately to an existing construction element. According to the second method all the individual stones are attached to concrete forms. While casting, the said stones are attached together by the freshly poured concrete. The said methods are expensive since it is very time consuming and has to be done by skilled workers. As the individual stone is smaller and the design is more complicated the cost of the construction element is higher. Over the years some stones can pill off the exterior wall which can be dangerous.

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DISCLOSURE OF THE INVENTION

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I have found that the disadvantages, described above, may be overcome by producing a modular construction element which is faced with at least one construction article, here in after referred to as decorative article. The modular decorative article including a plurality of separate stones or bricks

5 which are connected together with a plurality of rods, wires or ropes here in
after referred to as rods while a space separate between all the adjacent
stones. The said stones and bricks here in after referred to as stones are made
of water containing materials such as concrete, gypsum, mortar, silicate or
any other material which can be transferred from liquid to a solid state, here
10 in after referred to as hardened material. The said stones can be produced in
various sizes, shapes and colors. The rods are made of rigid or flexible
material such as steel, aluminum, plastic or cotton and can be created in a
different cross section and bent to a desire geometrical shape.

The modular decorative article is produced in at least one mold
15 including(a) an exterior mold frame that comprises a horizontal bottom and
vertical perimeter walls and (b) an interior form that comprises a plurality of
vertical interconnected beams with grooves. The mold is created of rigid or
flexible material such as metal, wood ,plastic, rubber or polyurethane.
The said rods are mounted inside the said mold which after the pouring of the
20 hardened material and the curing process, become an inseparable part of the
modular decorative article.

The present invention introduce two main methods for producing the
modular decorative article.

According to the first method of production, the modular decorative article is
25 produced in a mold wherein exterior mold frame and the interior form are
created as at least two separate components. The exterior mold frame
comprises the said horizontal bottom which has even or uneven top surface
and the perimeter walls. In order to enable easier striping the perimeter walls
are usually created in at least two separate pieces which are erected and tied
30 together. The perimeter walls are erected around the said horizontal bottom

5 or on top of it. The interior form comprises a plurality of interconnected
beams which have a plurality of grooves at the bottom edge to accommodate
the said rods. The rods are mounted and tied inside the exterior mold frame in
a distance above the said horizontal bottom. Following the mounting of the
10 rods, the said interior form is positioned adjacent to the horizontal bottom
and to the said perimeter walls. The said vertical interconnected beams, the
perimeter walls and the horizontal bottom circumscribe together a plurality of
stone shaped openings. The hardened material is poured into the stone shaped
openings. Following the pouring of the hardened material and prior to the
hardening, the said form is lifted and removed. The modular decorative article
15 is created as the said rods are anchored inside the cured hardened material.

According to the first method of production it is possible pour the
hardened material inside the exterior mold frame prior to the placing of the
interior form. Following the pouring the said interior form is pushed inside
the hardened material and cut it to a plurality of stone shaped segments.

20 According to the second method of production the modular decorative
article is usually produced in at least two modular molds which are placed
adjacent each other. Each modular mold is usually created as one inseparable
component including the said horizontal bottom, perimeter walls and the said
vertical interconnected beams which circumscribe together a plurality of
25 stone shaped openings. The perimeter walls and the vertical interconnected
beams have a plurality of grooves at the top edge. In order to enable the
placing the said modular molds adjacent each other and to obtain equal
distance between all the adjacent stones it is necessary to create the said
vertical perimeter walls thinner than the interior vertical interconnected
30 beams. The present method is useful for producing a large modular

5 decorative article while using relatively small size modular molds. The said rods are mounted on top of the interior vertical interconnected beams inside the said grooves. The rods are stretched along the molds which after pouring and curing of the hardened material connect all the stones of the modular decorative article.

10 A detailed process for producing the decorative article and the construction elements according the present invention will be explain in the detailed description of the invention and in the claims.

DETAILED DESCRIPTION OF THE INVENTION

15 The present invention relates to methods for producing a wall, vertical or horizontal precast concrete article, walkway and roadway which are faced with a plurality of modular decorative articles. The modular decorative articles are positioned adjacent each other.

20 **FIG -1** illustrates a partial isometric view of a basic embodiment of the modular decorative article generally indicated as **100** . The decorative article **100** according to the present example comprises a plurality of separate stones **1** which are connected together with a plurality of rods **7h** and **7v** . The stones **1** which are made of cured hardened material can be produce in a desired thickness, geometrical shape and color.

25 The present invention introduce two main methods for producing the modular decorative article **100**.

According to the first method of production, the modular decorative article **100** is created in a mold generally indicated as **200**. **FIG - 3** is a view of a modular decorative article **100** which is created in a mold **200** as shows in an isometric views in **FIG - 2** and in **FIG - 4**. The mold **200** as illustrated

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5 in an isometric view in FIG - 2 including (a) an exterior mold frame, indicated as 80, comprising a horizontal bottom 4 and vertical perimeter walls 3 and (b) an interior form, indicated as 90, comprises a plurality of vertical interconnected beams 10. The interconnected beams 10 have a top edge 10t, a bottom edge 10b and a plurality of grooves 6 at the bottom

10 edge. The perimeter walls 3 according to the present example are created with holes 15. FIG -4 illustrates the mold 200 according FIG -3 which already erected and a plurality of the rods 7h and 7v. The interior form 90 is position inside the exterior mold frame 80 while the interconnected beams 10 are adjacent to the horizontal bottom 4 and to the perimeter walls 10

15 circumscribe together a plurality of stone shaped openings 2. The plurality of rods 7h and 7v are positioned inside the grooves 6 in a distanced above the horizontal bottom #4 and in a distance below the top edge 10t. 7e is part of longer rod 7v which is placed inside the hole 15 and extends the outer face of the perimeter wall 3. On the other side of the longer rod 7v is mounted a

20 receptacle 8 ,such as plastic pipe, for protruding the rod 7e of an adjacent decorative article 100. FIG - 5 is an enlarged cross sectional view along a - a which illustrates the stone shaped openings 2 and the relative positions of the horizontal bottom 4, the perimeter walls 3, the vertical beams 10 and the rods. The present example shows the perimeter walls 3 that are

25 positioned around the horizontal bottom 4 which has even top surface 4t. However, it is possible to position the perimeter walls 3 on top of the horizontal bottom 4 which has uneven top surface 4t as illustrated in FIG - 6. According to the present example the rods 7h and 7v are tied together and supported above the horizontal bottom 4 with the rods 7e inside the

30 holes 15. In order to enable the striping it is usually necessary to erect the

5 perimeter walls **3** of at least two separate components. The perimeter walls **3**
are connected together prior to the casting of the hardened material and are
striped separately from the decorative article **100** after the curing process.
FIG - 7 illustrates cross sectional view of mold **200** wherein the exterior
mold frame **80** is created as one inseparable component. In order to enable
10 the removal of the mold frame **80** the rods **7v** are not extending beyond the
perimeter walls and the rods are supported on top of spacers **16**.

The hardened material is cast into the stone shaped openings **2** up to the
top edge **10t** of the interconnected beams **10**. The rods **7h** and **7v** are
anchored inside the hardened material which after the curing process become
15 inseparable part of the decorative article **100**.

FIG - 8 and is an isometric view of different mold **200** which illustrates
the exterior mold frame **80**, the plurality of rods **7h** and **7v** which are
mounted inside the mold frame and the interior form **90** including a plurality
of vertical interconnected beams **10** with a plurality of grooves **6**
20 corresponding to the rods **7h** and **7v**. **FIG - 9** is a cross sectional view
along **b - b** in **FIG - 8**. The exterior mold frame according to the present
example including (a) the perimeter walls **3** and (b) horizontal bottom **4**
which has majority of even top surface and minority of uneven top surface **4t**.
The minority of the uneven surface **4t** comprises a plurality of interconnected
25 wall that extend upwardly beyond the said even top surface. The
interconnected walls **4t** corresponding to the plurality of the vertical
interconnected beams **10**.

The process for producing the modular decorative article according to the
first method of production is according to the following steps:

30 (a) preparing the hardened material **5**;

- 5 (b) erecting the exterior mold frame **80**;
(c) mounting the plurality of rods **7h** and **7v** inside the exterior mold frame **80** a tying the rods to the mold frame;
(d) positioning the interior form **90** inside the exterior mold frame **80** adjacent to the horizontal bottom **4** and to the perimeter walls
10 circumscribe together a plurality of stone shaped openings **2**.
(e) pouring the hardened material **5** into the stone shaped openings **2**;
(f) vibrating the hardened material **5**;
(g) lifting the interior form **90** and separating the form from the hardened material **5**;
15 (h) allowing the hardened material **5** to cure and the rods **7h** and **7v** are anchored inside the cured hardened material **5**, forming the modular decorative article **100**; and,
(i) separating and removing the exterior mold frame **80** from the decorative article **100**.
- 20 The process for producing the modular decorative article according to the first method of production is according to the following steps:
(a) preparing the hardened material **5**;
- FIG - 10** is an isometric view which illustrates a different way of production while using mold **200** which includes exterior mold frame **80** and
25 interior form **90**. The hardened material **5** is poured into the mold frame **80** prior to the position of the interior form **90**. The interior form **90** is pushed into the hardened material **5** and cutting it to a plurality of stone shaped segments.
- According to the second method of production the modular decorative
30 article **100** is created in at least one mold generally indicated as **300**.

5 **FIG - 11** is an isometric view of a mold **300** including (a) an exterior mold frame **80** comprises even or uneven horizontal bottom **4** and perimeter walls **3** and (b) an interior form **90** comprises plurality of vertical interconnected beams **10** which have a plurality of grooves **6** at the top edge. The interconnected beams **10** together with the perimeter walls **3** and the horizontal bottom **4** circumscribe a plurality of stone shaped openings **2**. **FIG - 11** further illustrates a plurality of the rods **7h** and **7v** which are mounted on top of the interconnected beams **10** inside the grooves **6**. The hardened material **5** is poured into the stone shaped openings **2**. During the curing process the plurality of rods are anchored inside the cured hardened material and become an inseparable part of the modular decorative article.

10 **FIG - 12** is an isometric view of a modular mold **300** including (a) an exterior mold frame **80** comprises even or uneven horizontal bottom **4** and perimeter walls **3** which have a plurality of grooves **6a** at the top edge and (b) an interior form **90** comprises plurality of vertical interconnected beams **10** which have a plurality of grooves **6** at the top edge. The interconnected beams **10** together with the perimeter walls **3** and the horizontal bottom **4** circumscribe a plurality of stone shaped openings **2**. **FIG - 13** and **FIG - 14** are partial cross sectional views of the modular mold **300** along **c - c** illustrating two different shapes of the perimeter walls **3** and the interconnected beams **10**. The modular mold **300** is usually created as one inseparable component. The modular mold **300** is useful for producing large modular decorative article while using a plurality of smaller size modular molds **300** which are positioned adjacent each other. In order to be able to attach two adjacent modular molds **300** it is necessary to create the thickness

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5 of the perimeter walls 3 less than half the thickness of the vertical interconnected beams 3.

FIG - 16 is an isometric view of two adjacent modular molds 300 according to **FIG - 12**. The rods 7h and 7v are positioned on top of the interconnected beams 10 inside the grooves 6. The rods 7h are placed
10 inside the both molds 300 which after the pouring and curing are anchored in the hardened material producing one inseparable decorative article 100.

FIG - 15 is an isometric view of modular decorative article 100 which is produced in the two adjacent modular molds 300 shown in **FIG - 16**.

The process for producing the modular decorative article according to the
15 second method of production is according to the following steps:

- (a) preparing the hardened material 5;
- (b) erecting at least one regular or modular mold 300;
- (c) mounting a plurality of rods 7h and 7v inside at least one mold 300;
- (d) pouring the hardened material 5 into the stone shaped openings 2;
- 20 (e) vibrating the hardened material 5;
- (f) allowing the hardened material 5 to cure and to anchor the rods 7h and 7v, forming the modular decorative article 100; and,
- (g) separating and removing the mold frame 300 from the decorative article 100.

25 **FIG - 17** is an isometric view that illustrates the hardened material inside the mold 200 or 300. The present example illustrates further additional metal elements 11 which are useful for attaching the modular decorative article 100 to a wall or for lifting the decorative article. The elements 11 are anchored inside the hardened material and connected to the rods.

5 **FIG - 18** is a partial isometric view of a mold according to the present invention that illustrates the hardened material inside the mold **200** or **300**. **FIG - 18** further shows form liner **12** which is positioned on top of the hardened material **5**. The form liner which has uneven bottom surface impart to the hardened material **5** uneven top surface. **FIG - 19** is an enlarged
10 cross sectional view along **d - d** which shows the relative position of the form liner **12**, the hardened material **5**, the rods **7h** and the mold.

The rods **7h** and **7v** are made of flexible or rigid material and the can bent horizontally whenever it is necessary. The rods are mounted inside the mold **200** or **300** as a separate pieces or the rods are connected together
15 and are mounted as an array of rods. **FIG - 20** illustrates part of decorative article **100** which is useful for facing an oval shaped wall. The stones **1** are connected with flexible rods **7h** and with rigid rods **7v**. The decorative article **100** can be bent to an oval shape as shown in **FIG - 21**.

FIG - 22, **FIG - 24**, **FIG - 25** and **FIG - 26** are an isometric views
20 which illustrate a production of vertical and horizontal decorative elements which are faced with a plurality of modular decorative articles **100**. The decorative article are produced are produced in small and large sizes. The small size decorative article **100** is created up to **0.75 sq.m** which can be lifted and placed by hand. The large decorative article **100** has to be handled
25 by suitable crane or any other machinery. While the small decorative articles **100** are usually created in the factory it is often more economical to produce the large decorative

FIG - 22 is an isometric partial view of vertical wall **30** which is covered with three modular decorative articles **100**. Each decorative article **100** is
30 supported on top of foundation **20** or on top of another decorative article

5 100 below, while the hangers 14 prevent a horizontal movement. FIG - 23
is an enlarged cross-sectional view along e - e. The view illustrates the
hangers 14 that are attached to the wall 30 which is sealed with a mortar
13. The view illustrates also the decorative article 100 which is hung with
the horizontal rod 7h on top of the hangers 14 adjacent to the mortar 13
10 and supported on top of the foundation 20.

 FIG - 24 is an isometric view of seven modular decorative articles 100
according to FIG - 17 and part of a stone 1a which are attached adjacent
each other to an exterior concrete form panel 21. The decorative articles 100
are supported on top of the foundation 20 and connected with nails or
15 special brackets to the panel 21. FIG - 24 further shows the interior
concrete form panel 22 which is erected in a horizontal distance from the
unexposed surface of the decorative articles 100u. The concrete is poured
into the concrete forms inside the space between the decorative articles 100
and the interior panel 22. Elements 11 which are part of the decorative
20 article 100 are anchored inside the concrete which after the curing process
attach the decorative articles 100 to the concrete. It is recommended to seal
the unexposed surface 100u with a mortar or with a layer of polyethylene.
The sealing prevent liquids that are normally discharged from the concrete to
penetrate through the space between the stones 1 and to damage the exposed
25 surface of the decorative article 100.

 FIG - 25 is a partial isometric view that illustrates a production process of
decorative precast concrete element which is faced with four modular
decorative articles 100 according to FIG - 17 and few stones 1a. The
decorative articles 100 are positioned horizontally adjacent each other and
30 the concrete forms 23 are erected around the perimeter. The concrete is

5 poured into the forms 23 on top of the decorative articles 100. The elements
11 are anchored inside the concrete and connect the decorative articles 100
to the concrete. In order to prevent the liquids that are normally discharged
from the concrete to damage the bottom decorative surface of the decorative
articles 100 it is recommended to seal the top surface prior to the pouring.

10 **FIG - 26** is a partial isometric view that illustrates a production process of
a wall which is faced with modular decorative articles 100. Each decorative
article 100 is supported on top of a foundation 20 or on top of another
decorative article 100 below and connected to two columns. The walls 30a
are built between the columns only after the connection of the decorative
15 articles is finished. **FIG - 27** is a cross sectional view along F - F showing
the position and the connection of the decorative article 100 prior to the
building of the wall 30a. The elements 11 which are anchored inside the
decorative article 100 are connected to elements 15 that are anchored inside
the columns 16.

20 While the invention has been described in conjunction with various
embodiments, the are illustrative only. Accordingly, many alternatives,
modifications will be apparent to persons skilled in the art in light of the
foregoing detailed description, and it is therefore intended to embrace such
alternatives and variations as to fall within the spirit and board scope of the
25 appended claims.

AMENDED CLAIMS

[received by the International Bureau on 25 May 1999 (25.05.99);
original claims 1-20 replaced by new claims 1-22 (6 pages)]

1. A method for producing a wall, vertical or horizontal precast concrete article, walkway and roadway of at least one modular decorative article including a plurality of separate stones of hardened material and a plurality of rods connecting the stones together comprising the following steps:
 - (a) preparing a hardened material;
 - (b) erecting or positioning an exterior mold frame including a horizontal bottom having even or uneven top surface and vertical perimeter walls;
 - (c) mounting a plurality of rods in the mold frame in distance above the horizontal bottom and tying the rods to the mold frame;
 - (d) erecting or positioning an interior form inside the interior mold frame including a plurality of vertical interconnected beams, circumscribe together with the mold frame a plurality of stone shaped openings, having a plurality of grooves at the bottom edge corresponding to a plurality of rods;
 - (e) pouring the hardened material into the plurality of the stone shaped openings;
 - (f) vibrating the hardened material;
 - (g) lifting the interior form and separating the form from the hardened material;
 - (h) allowing the hardened material to cure and to anchor the plurality of rods, forming the modular decorative article; and,
 - (i) separating the exterior mold frame from the decorative article.
2. The method of claim 1 wherein step (d) comprises pouring the hardened material into the exterior mold frame and step (e) comprises cutting the

hardened material with an interior form of rigid material, including a plurality of vertical interconnected beams having a plurality of grooves at a bottom edge corresponding to the plurality of rods, forming a plurality of stone shaped segments.

3. The method of claim 2 wherein step (e) comprises cutting the hardened material, at least twice, with at least one vertical beam of rigid material having a plurality of grooves at the bottom edge corresponding to a plurality of rods, forming a plurality of stone shaped segments.
4. The method of claim 1 wherein the horizontal bottom having uneven top surface including a plurality of interconnected walls corresponding to the vertical interconnected beams, extend upwardly beyond the top surface and the interior form is positioned inside the mold, so that each individual interconnected beam is adjacent to the top edge of the corresponding interconnected wall and the rods are located inside the grooves on top of the interconnected walls;
5. The method of claim 4 wherein the vertical interconnected beams are created without grooves, the interconnected walls having grooves at the top edge and the rods are mounted on top of the interconnected walls inside the grooves.
6. The method of claim 1 wherein a top edge of the vertical perimeter walls is erected higher than the top edge of the vertical interconnected beams and the hardened material is cast up to the top edge of the vertical perimeter walls forming the decorative article with an extra top layer of cured hardened material;
7. A method for producing a wall, precast concrete article, walkway and roadway of at least one modular decorative article including a plurality of

separate stones of hardened material and a plurality of rods connecting the stones together comprising the following steps:

- (a) erecting or positioning a mold including an exterior mold frame having a horizontal bottom and perimeter walls and an interior form comprising a plurality of vertical interconnected beams having grooves at the top edge, circumscribe together a plurality of stone shaped openings;
- (b) mounting a plurality of rods on top of the interconnected beams inside the grooves in a distance below the top edge;
- (c) preparing a hardened material;
- (d) pouring the hardened material into the plurality of the stone shaped openings;
- (e) vibrating the hardened material;
- (f) allowing the hardened material to cure and to anchor the plurality of rods forming the decorative article; and,
- (g) separating the mold from the decorative article.

8. The method of claim 1 further including the following steps:

erecting a wall having an exterior surface on top of a foundation;
sealing the exterior surface of the wall;
attaching at least one decorative article to the exterior surface of the wall with hooks and/or with mortar and supporting the at least one decorative article on top of the foundation or on top of another decorative article below..

9. The method of claim 7 and wherein the decorative article having exposed and unexposed surface and further comprising mounting a plurality of additional rigid rods in the mold, prior to pouring of the hardened material, so that the rods extend beyond the unexposed surface of the decorative

article for attaching the decorative article to a construction element.

- 10 . The method of claim 1 further comprises positioning on top the hardened material, prior to the curing of the hardened material, at least one horizontal top form liner having uneven bottom forming decorative article with an uneven top surface and separating the top form liner after the curing process.
- 11 . The method of claim 1 wherein at least two rods protrude at an edge of the decorative article, and further comprising providing receptacles for protruding portions of the rods for attaching the decorative article to an adjacent decorative article.
12. The method of claim 1 wherein at least two rods are connected together prior to the mounting of the plurality of the rods.
13. The method of claim 1 wherein the exterior mold frame including at least two separate components.
- 14 . The method of claim 7 wherein the mold is positioned as one inseparable component and the vertical perimeter walls having grooves at the top edge;
- 15 . The method of claim 14 wherein the vertical perimeter walls are thinner than the interior vertical interconnected beams.
- 16 . The method of claim 15 wherein step (a) further comprises positioning adjacent to the first mold at least one additional mold according to claim 15, step (b) comprises mounting a plurality of rods in at least two molds inside the grooves in a distance below the top edge of the molds and step (g) comprises the separation of at least two molds from the decorative article.
- 17 . The method of claim 7 further including the following steps:
 - erecting a wall having an exterior surface on top of a foundation;
 - sealing the exterior surface of the wall;
 - attaching at least one decorative article to the exterior surface of the wall

with hooks and/or with mortar and supporting the at least one decorative article on top of the foundation or on top of another decorative article below.

18 . The method of claim 9 further including the following steps:

erecting an exterior vertical concrete form panel having outside and inside face;

connecting at least one decorative article to the exterior vertical concrete form panel having the exposed surface of the decorative article adjacent to the inside faces of the vertical concrete panel and the additional rigid rods are extending horizontally the other way;

erecting an interior vertical concrete form panel in a horizontal distance from the decorative article;

pouring a concrete into the concrete forms and anchoring the additional rigid rods inside the concrete;

allowing the concrete to cure forming a wall being faced with at least one decorative; and,

removing the concrete forms.

19. The method of claim 9 further including the following steps:

erecting at least two concrete columns having steel reinforcement; and, attaching at least one decorative article to the concrete columns, having the unexposed surface of the decorative article adjacent to the columns, and connecting the additional rigid rods to the steel reinforcement of the columns.

20. The method of claim 19 further including the following steps:

sealing the unexposed face of at least one decorative article; and, building a concrete block or a wooden stud wall in between the columns.

21. The method of claim 1 wherein the modular decorative article including a plurality of separate stones of different shapes and the plurality of rods are made of rigid or flexible material.
22. The method of claim 7 wherein the modular decorative article including a plurality of separate stones of different shapes and the plurality of rods are made of rigid or flexible material.

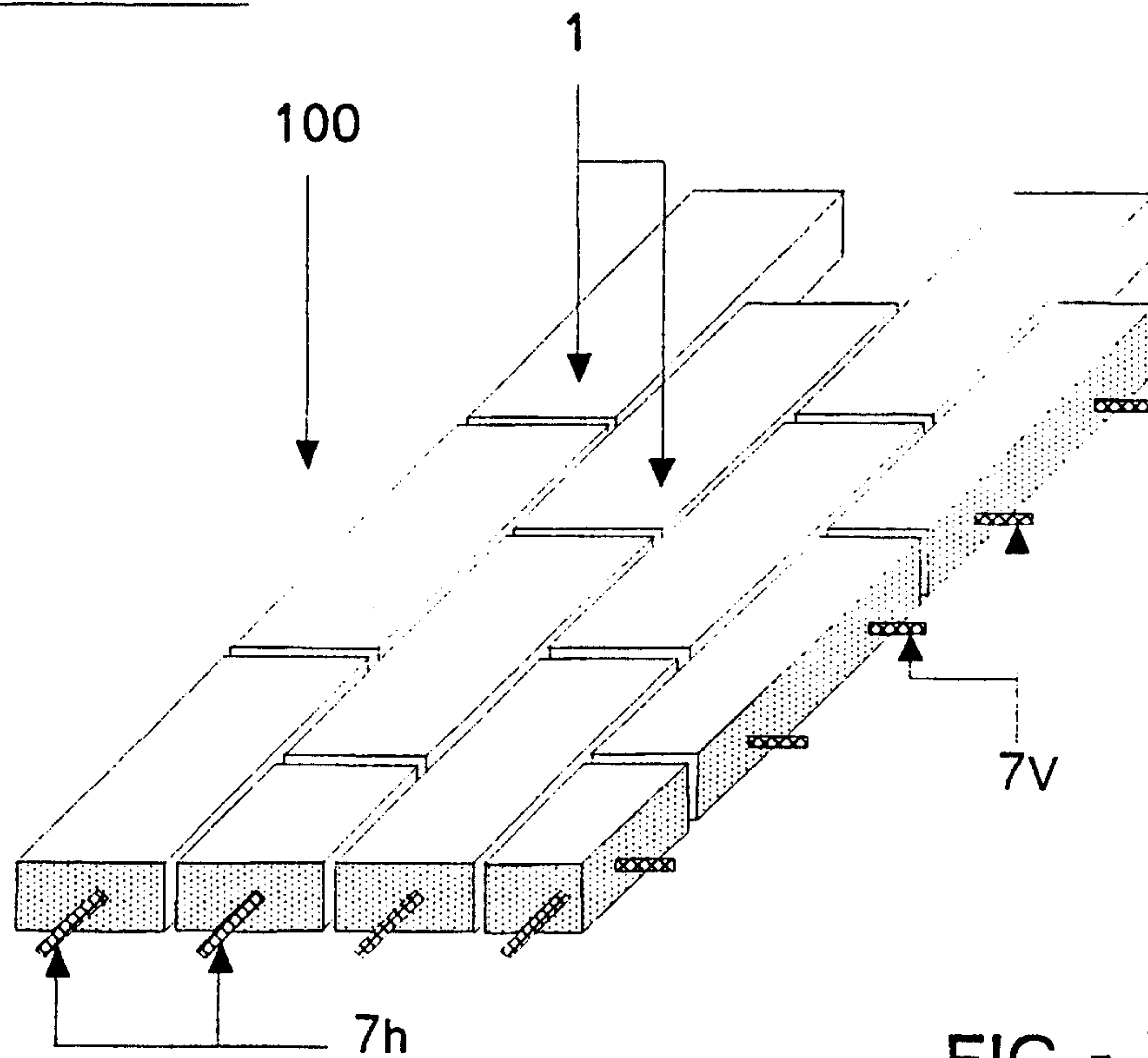
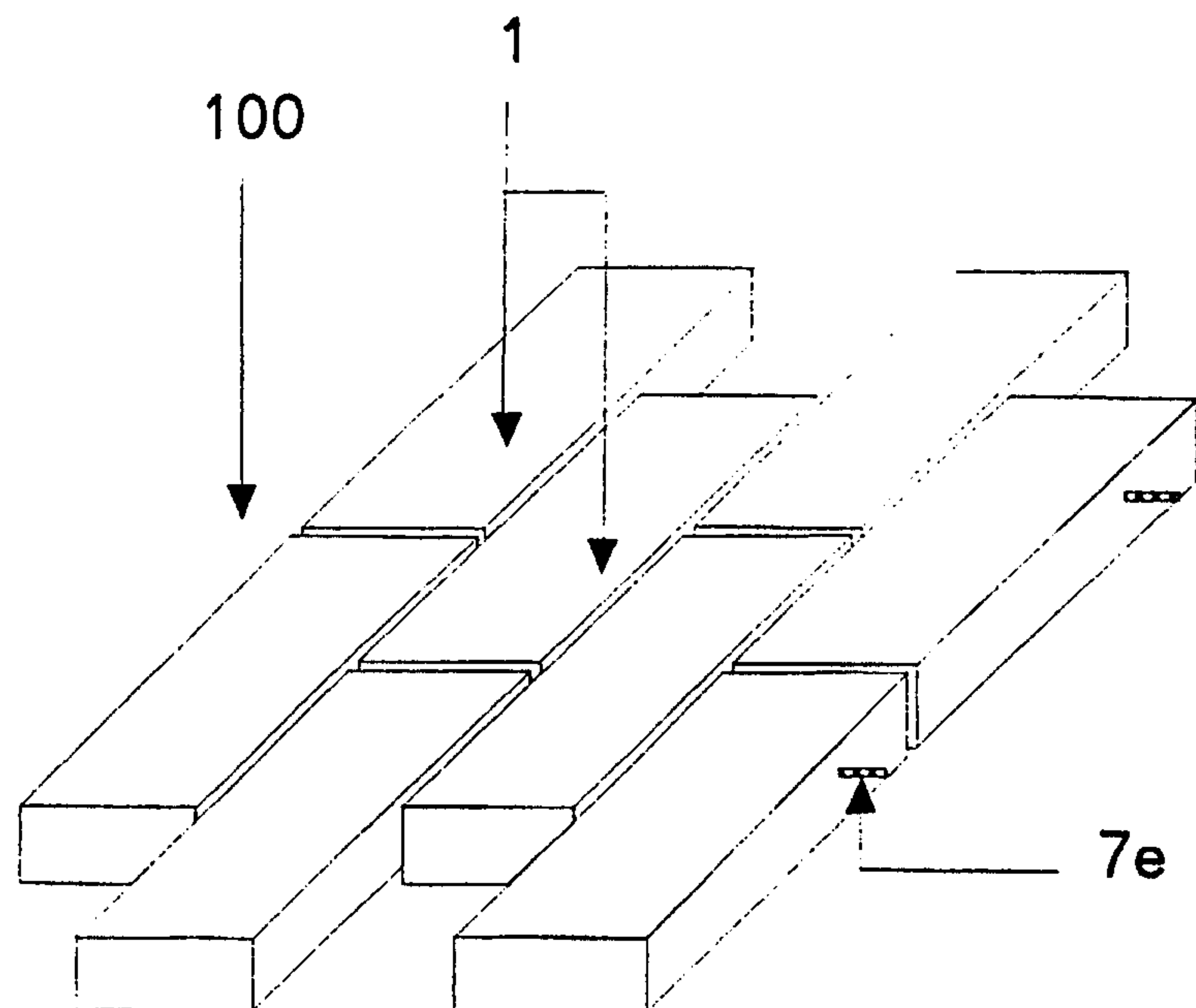
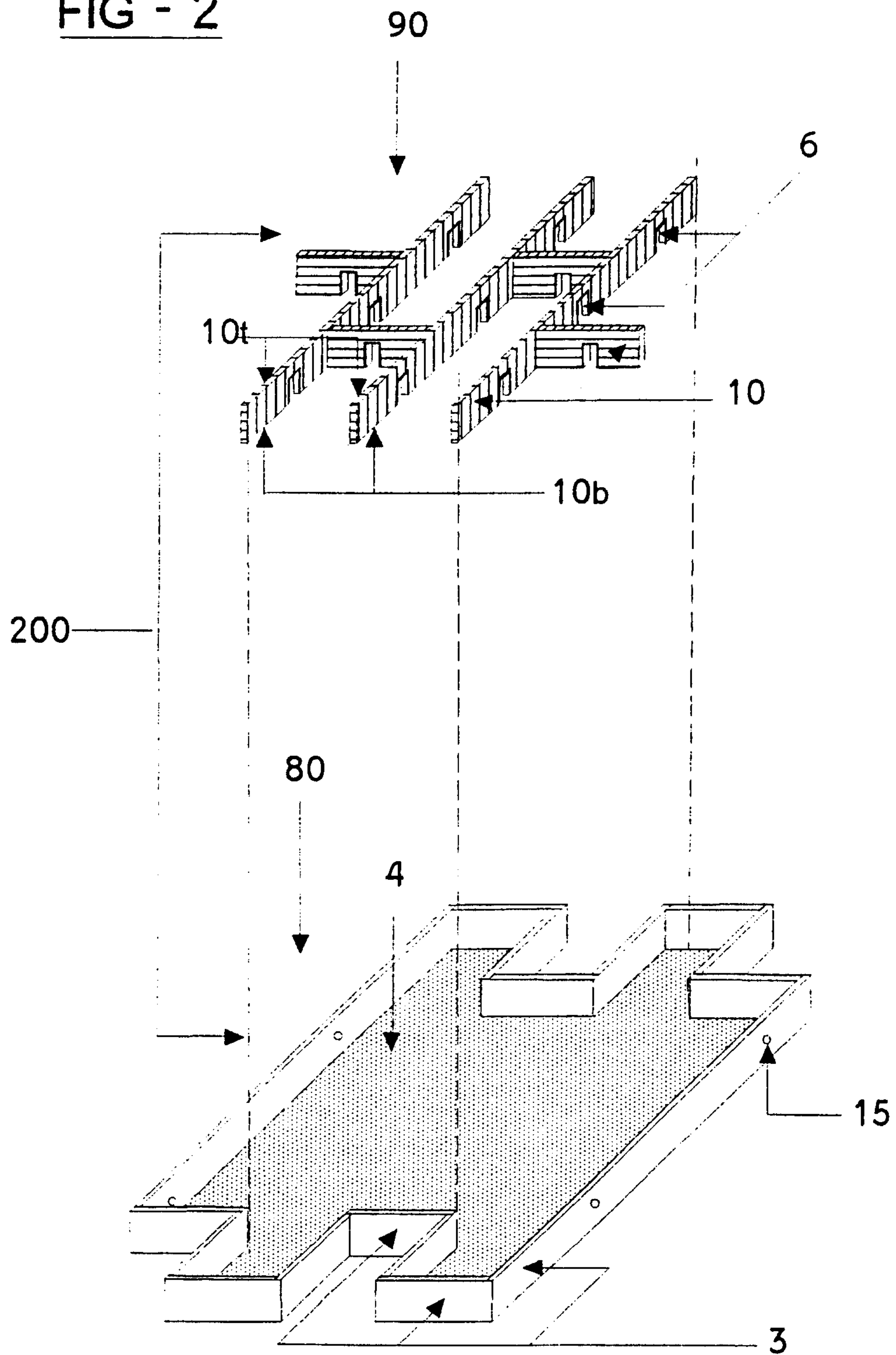
FIG - 1FIG - 3

FIG - 2



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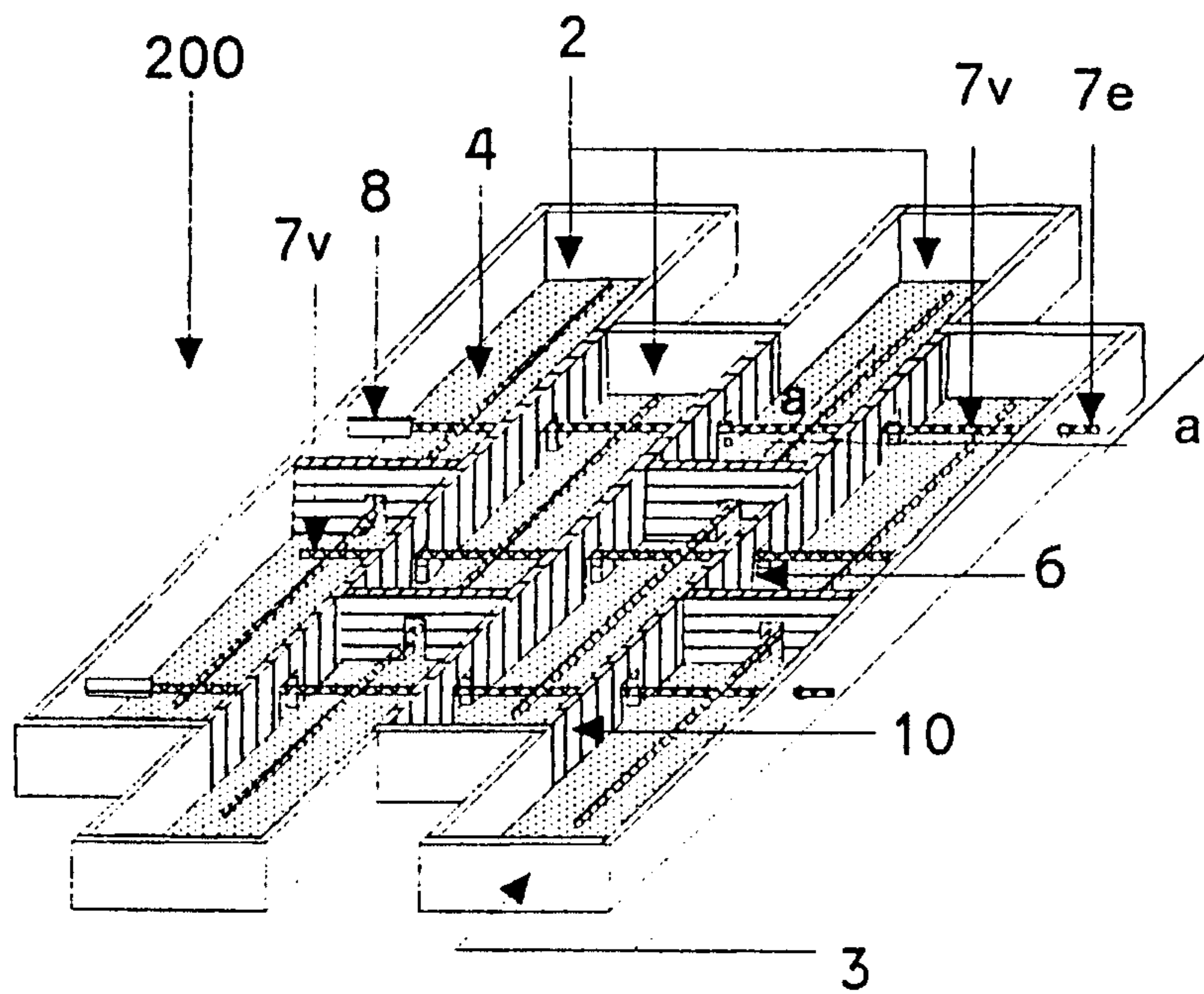
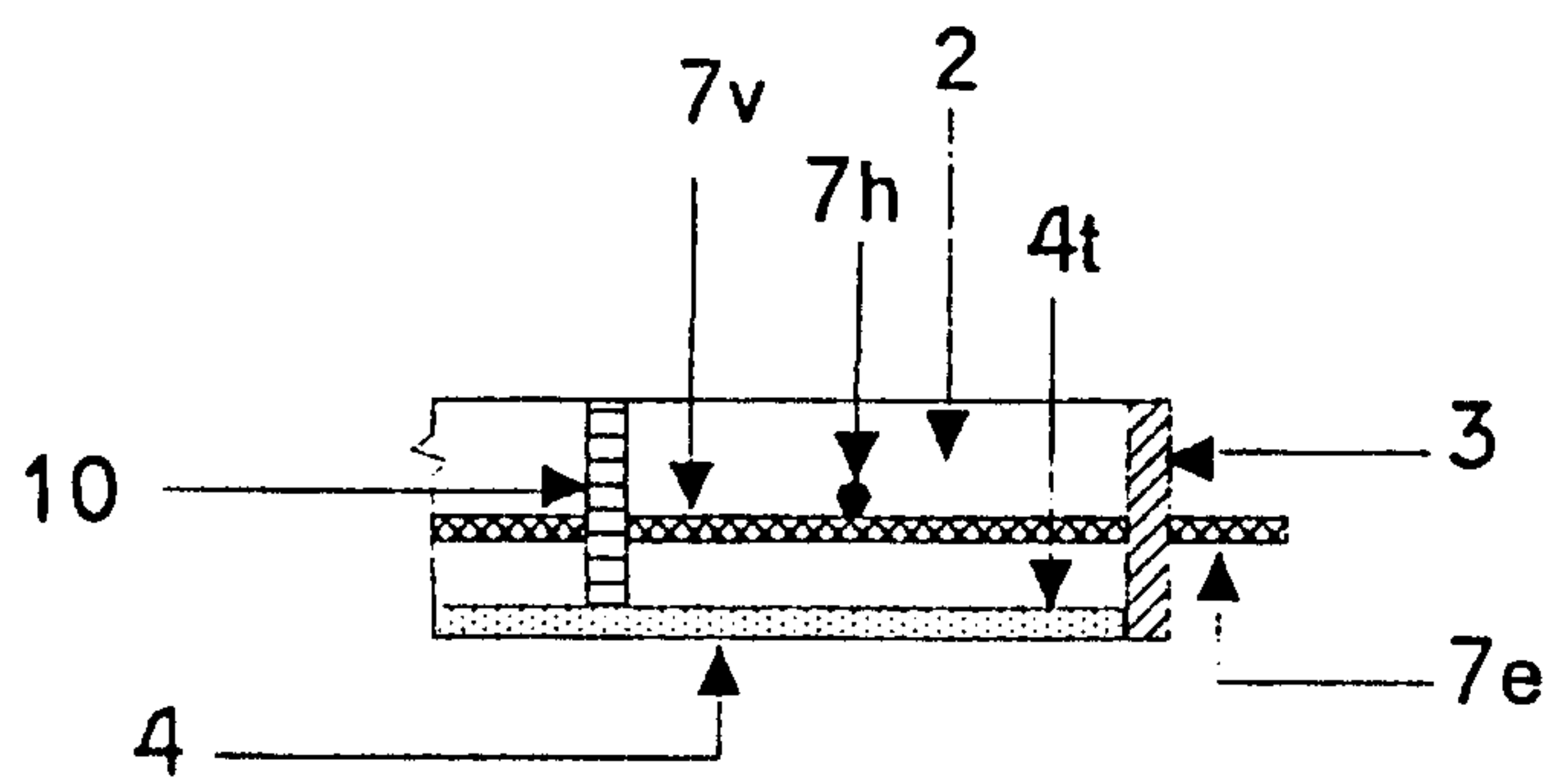
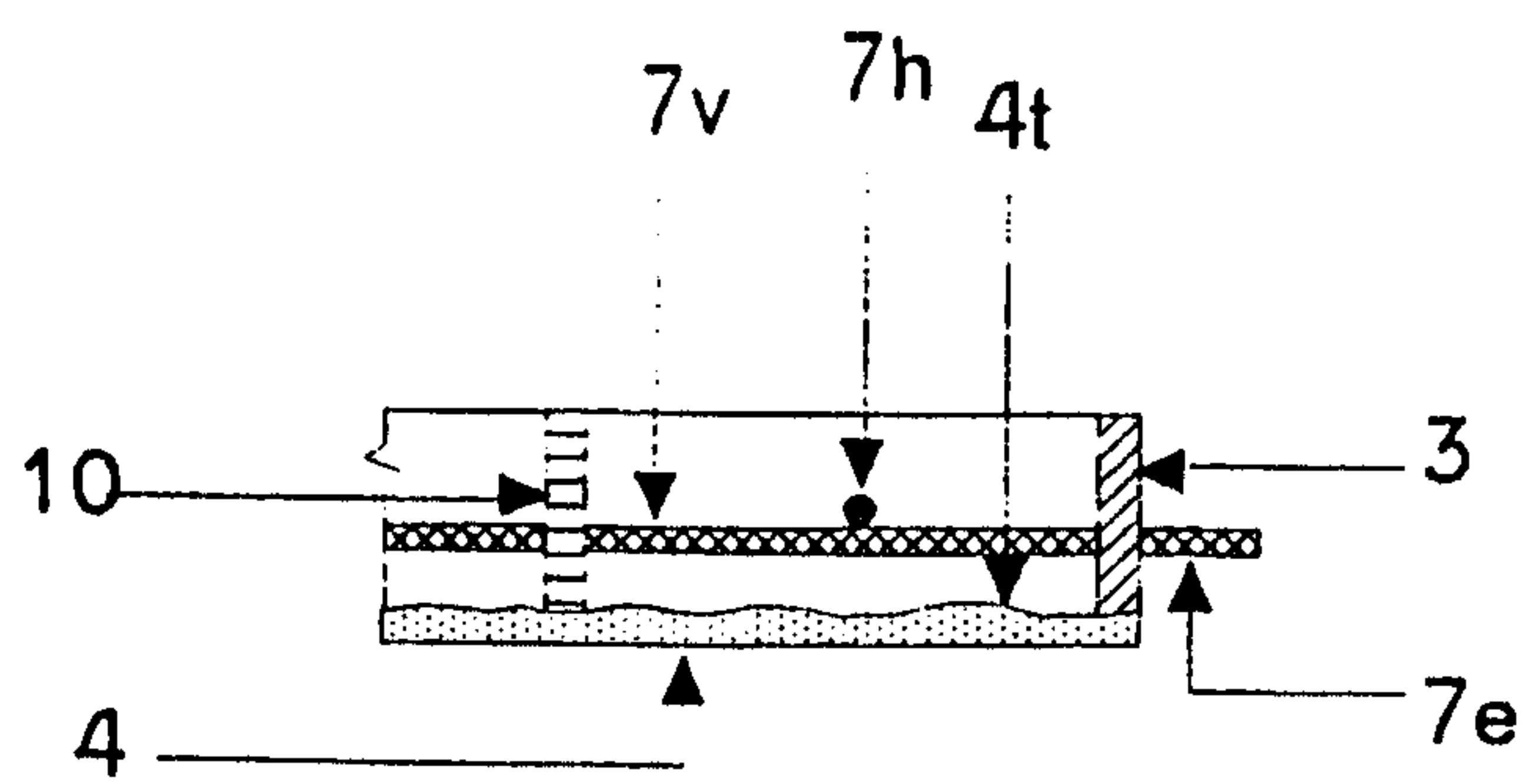
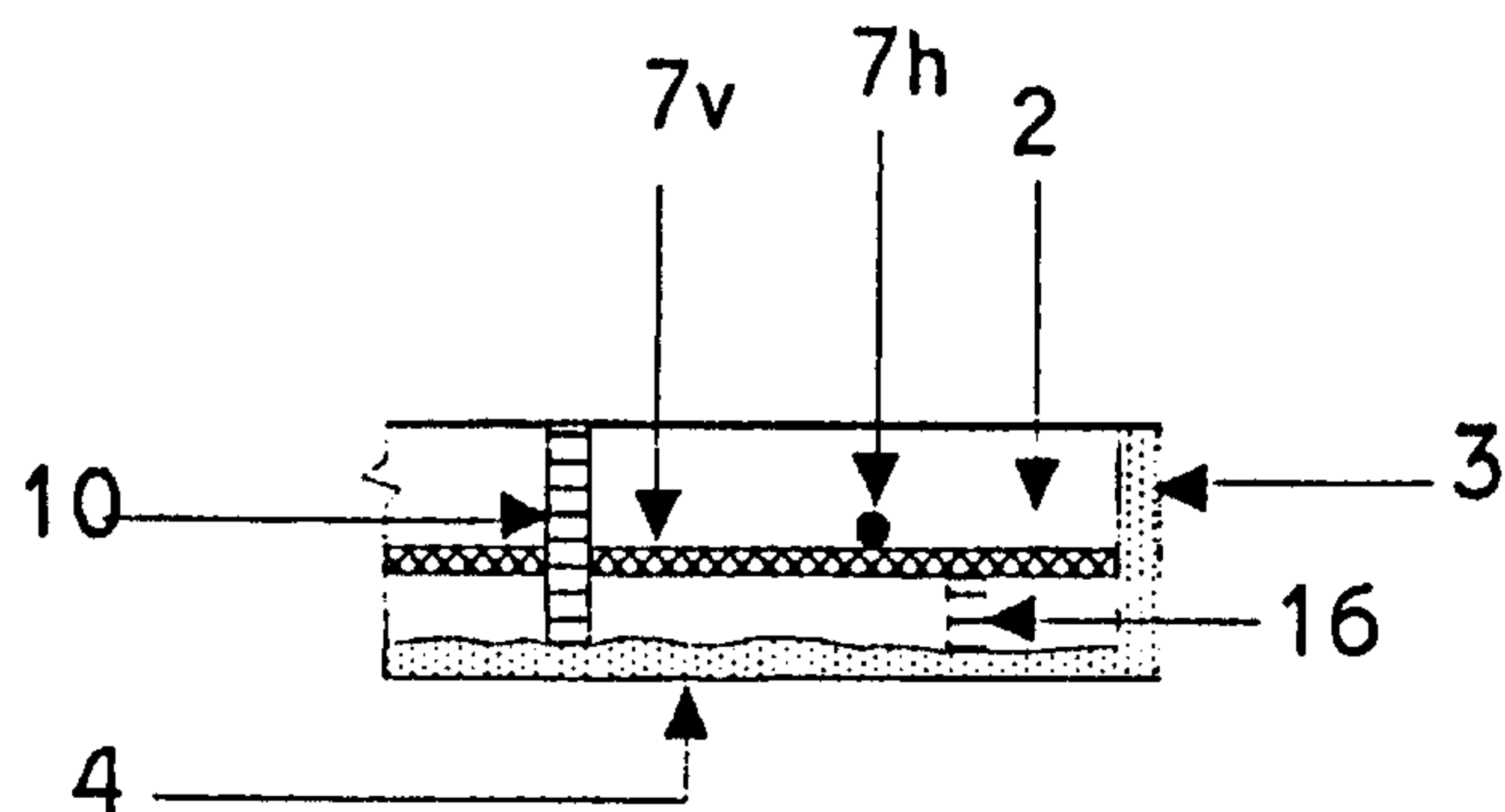
FIG - 4FIG - 5FIG - 6FIG - 7

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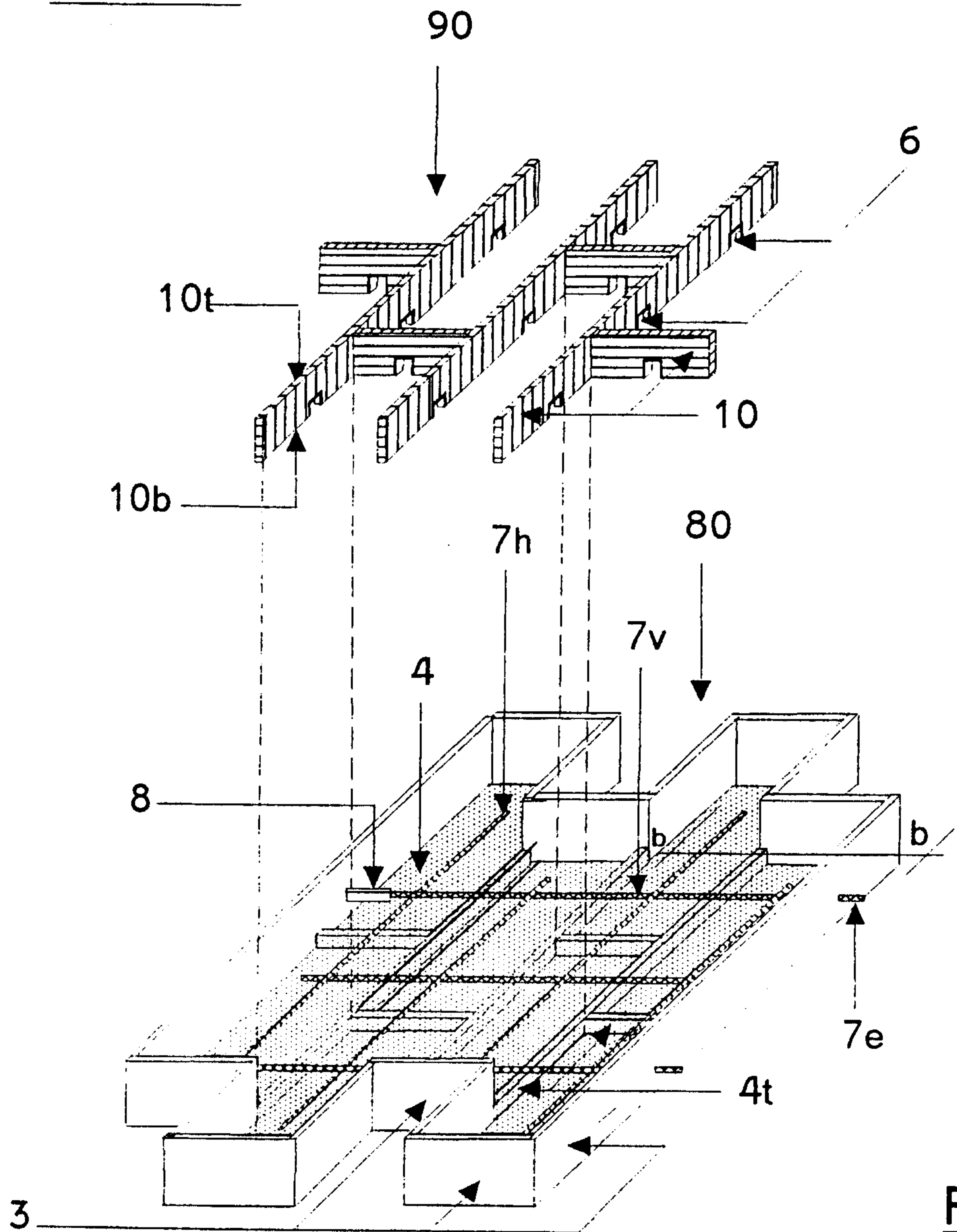
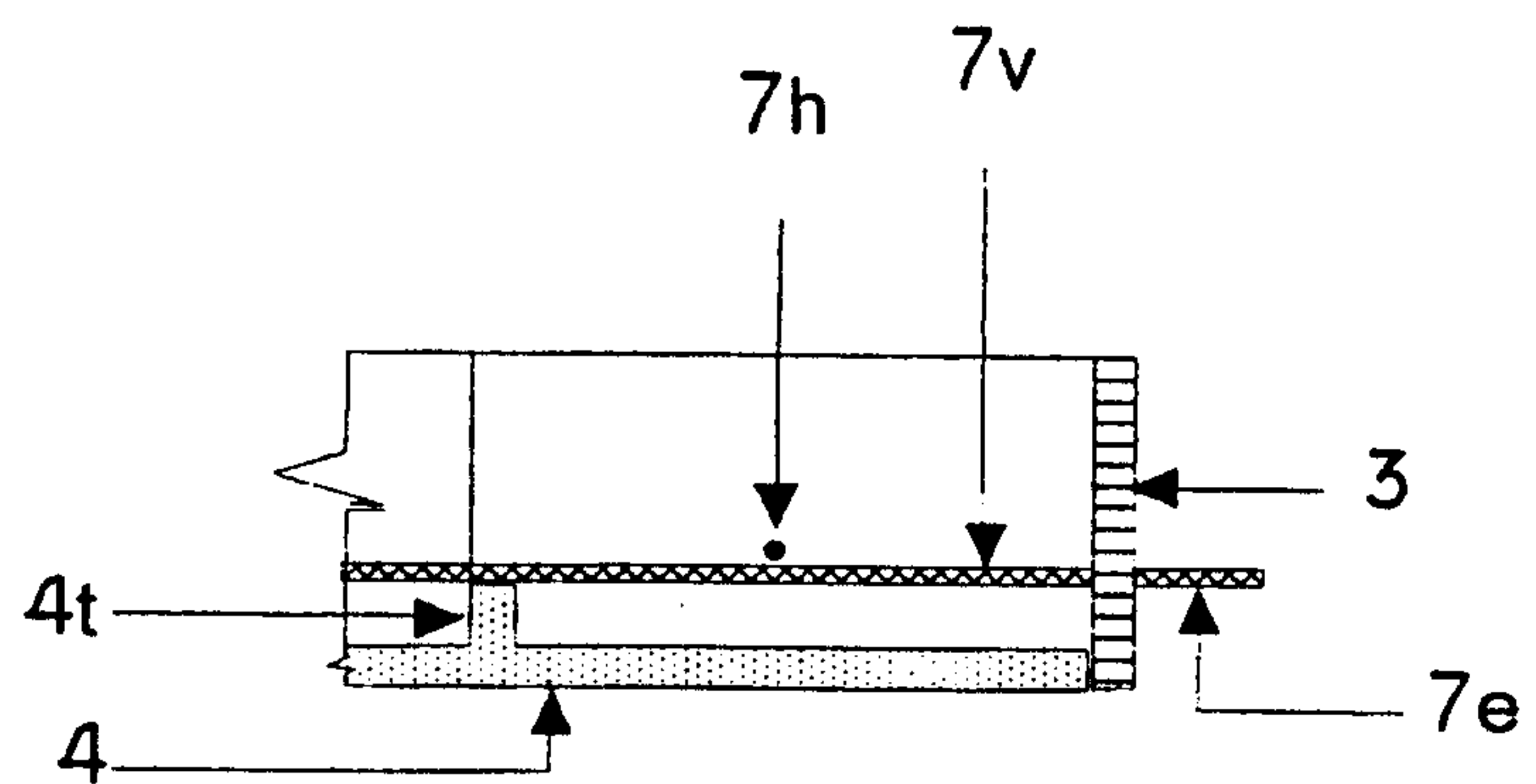
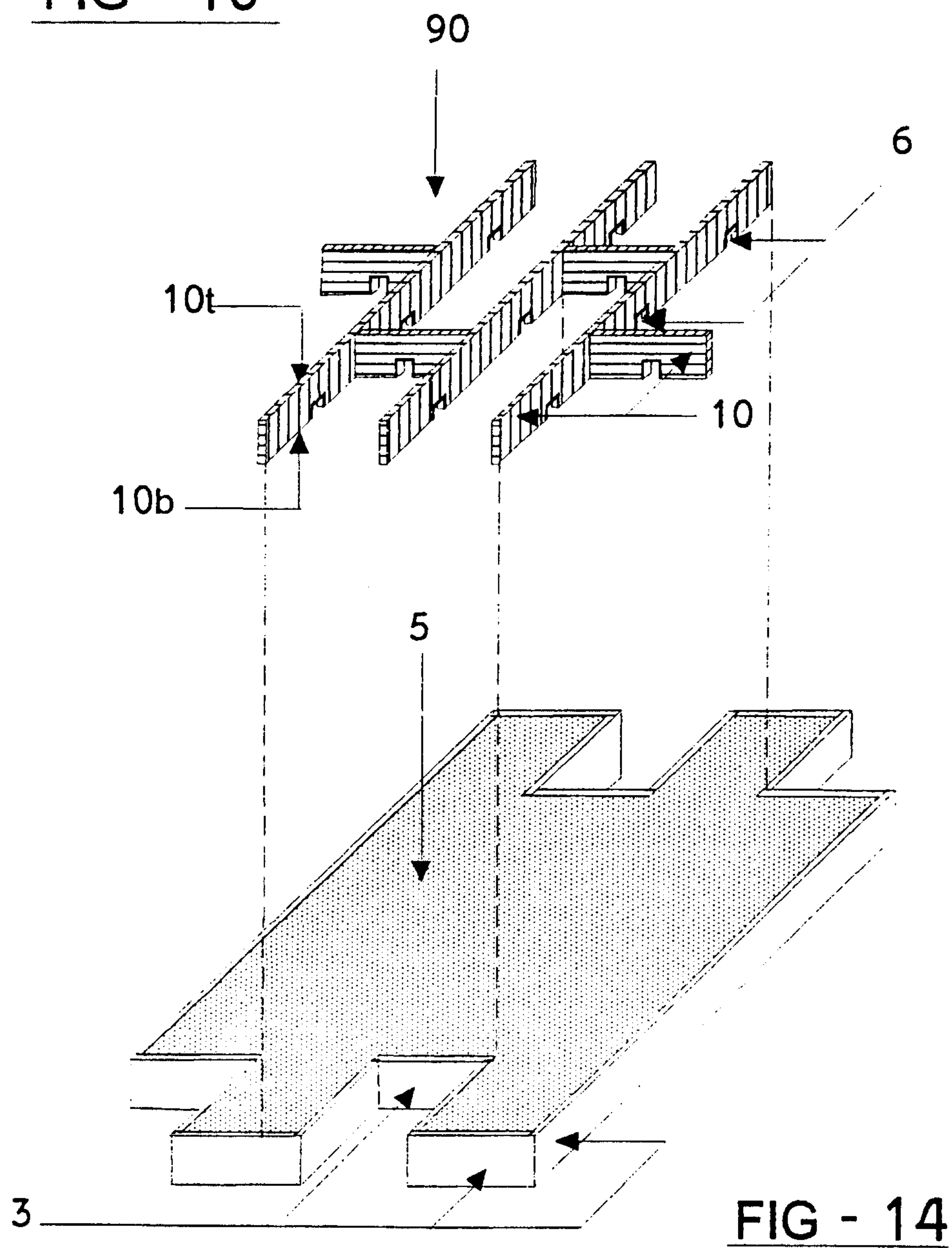
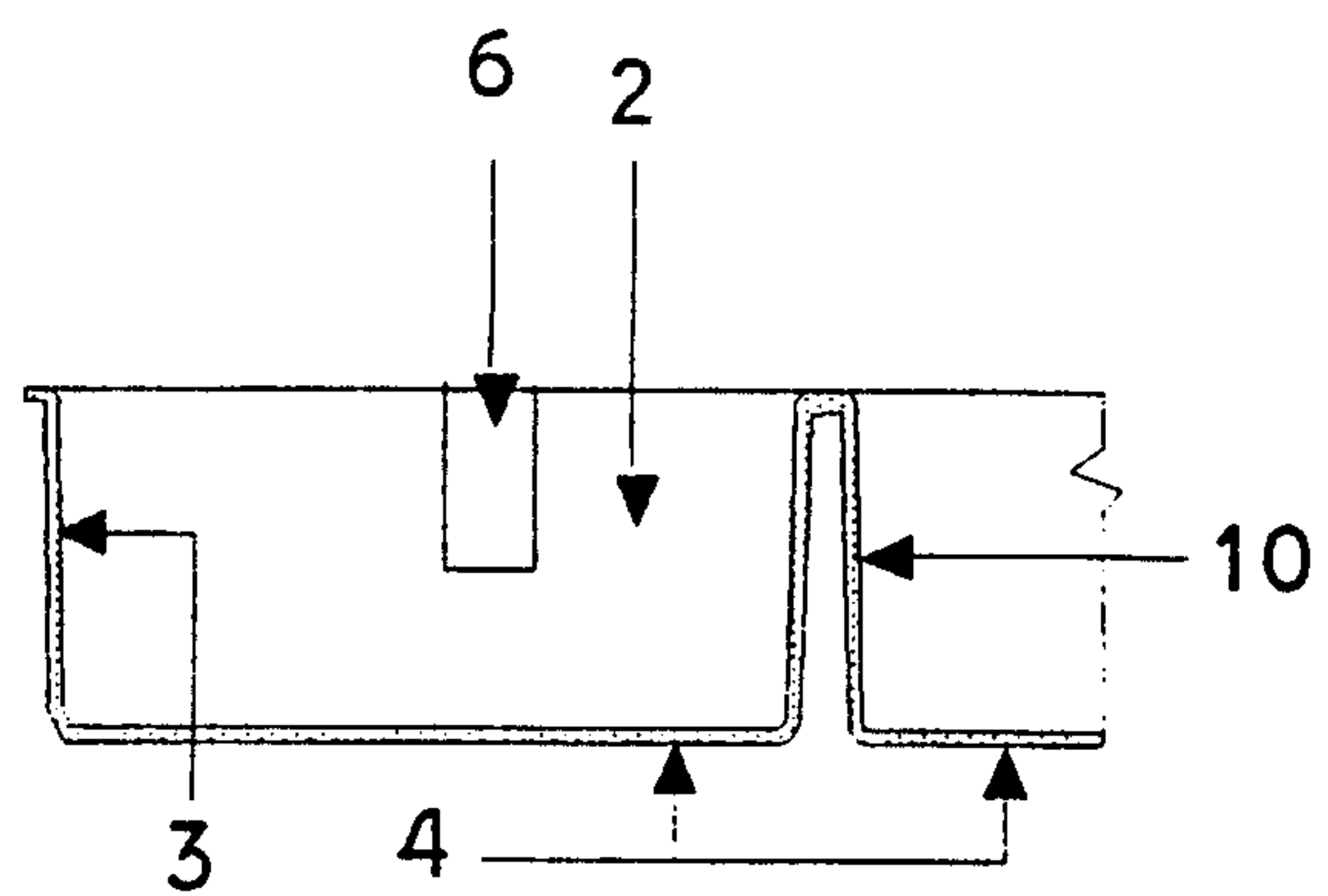


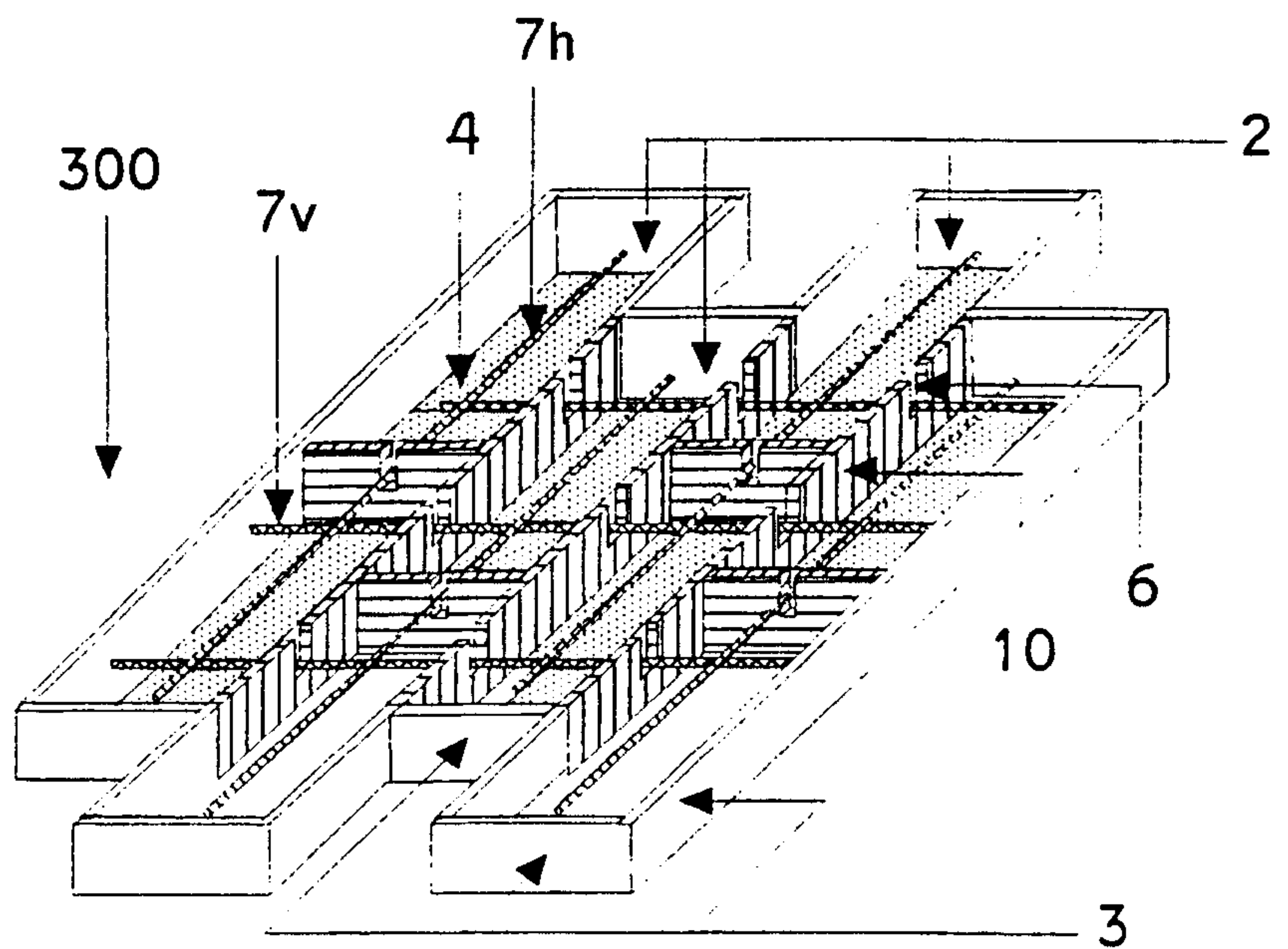
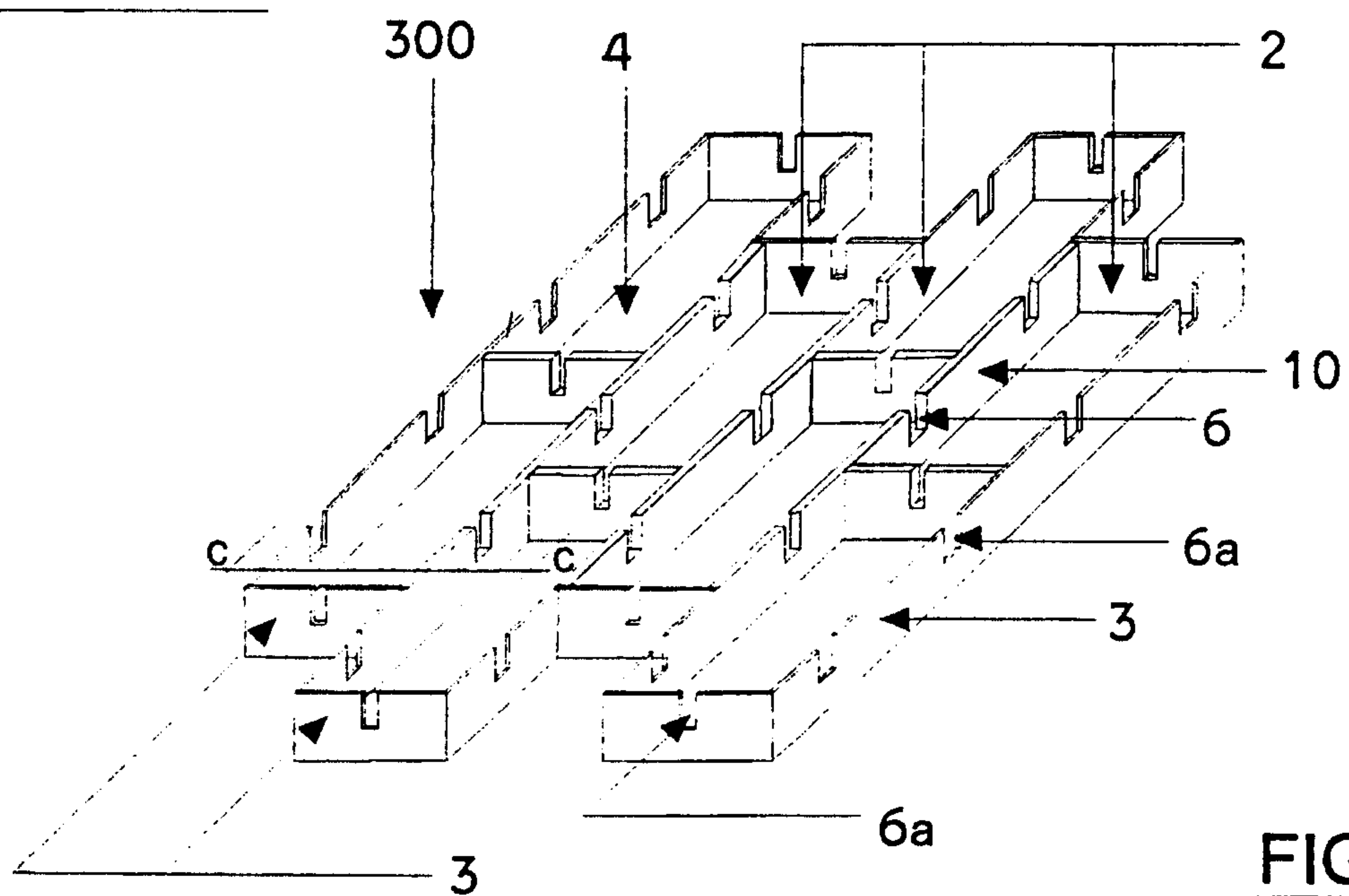
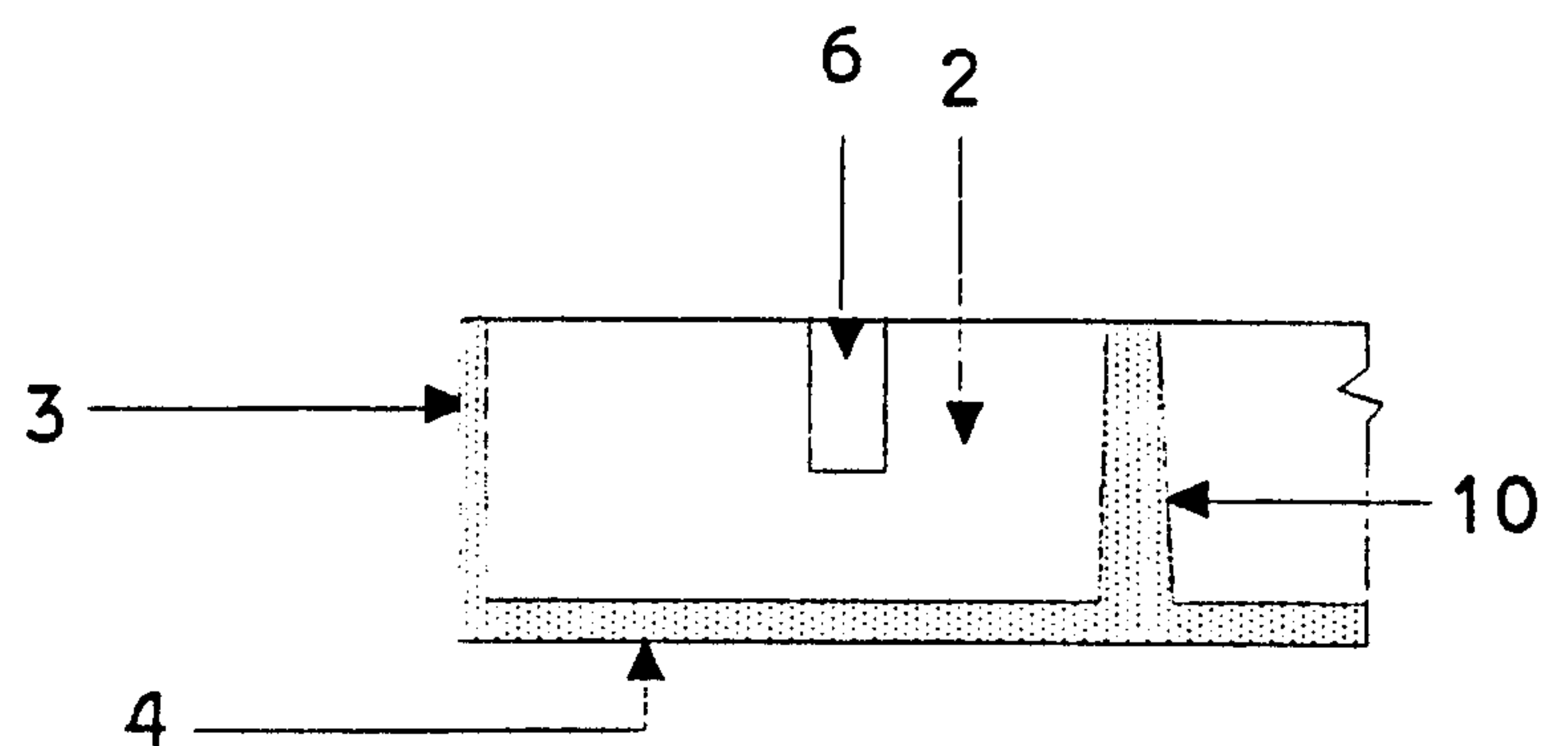
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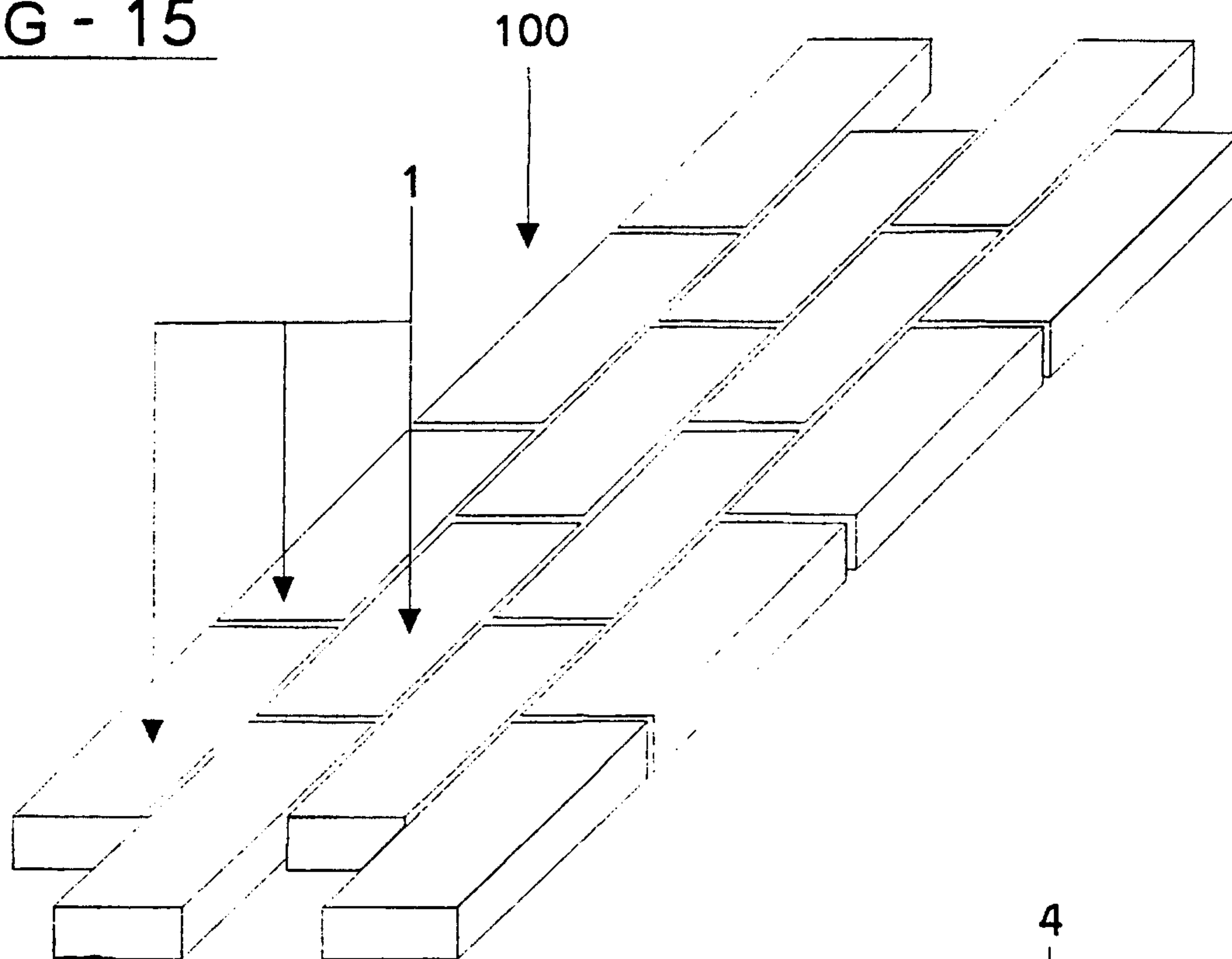
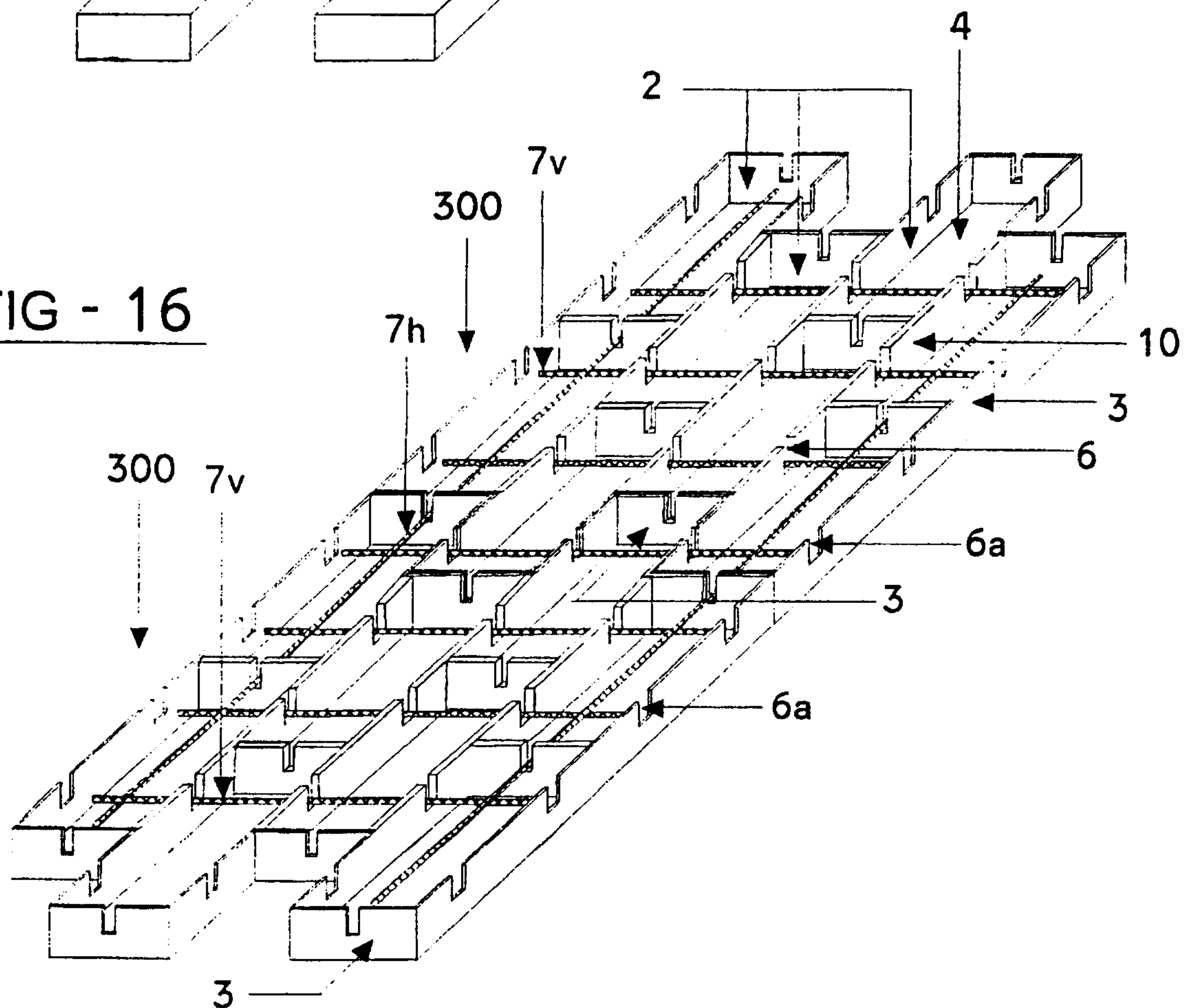
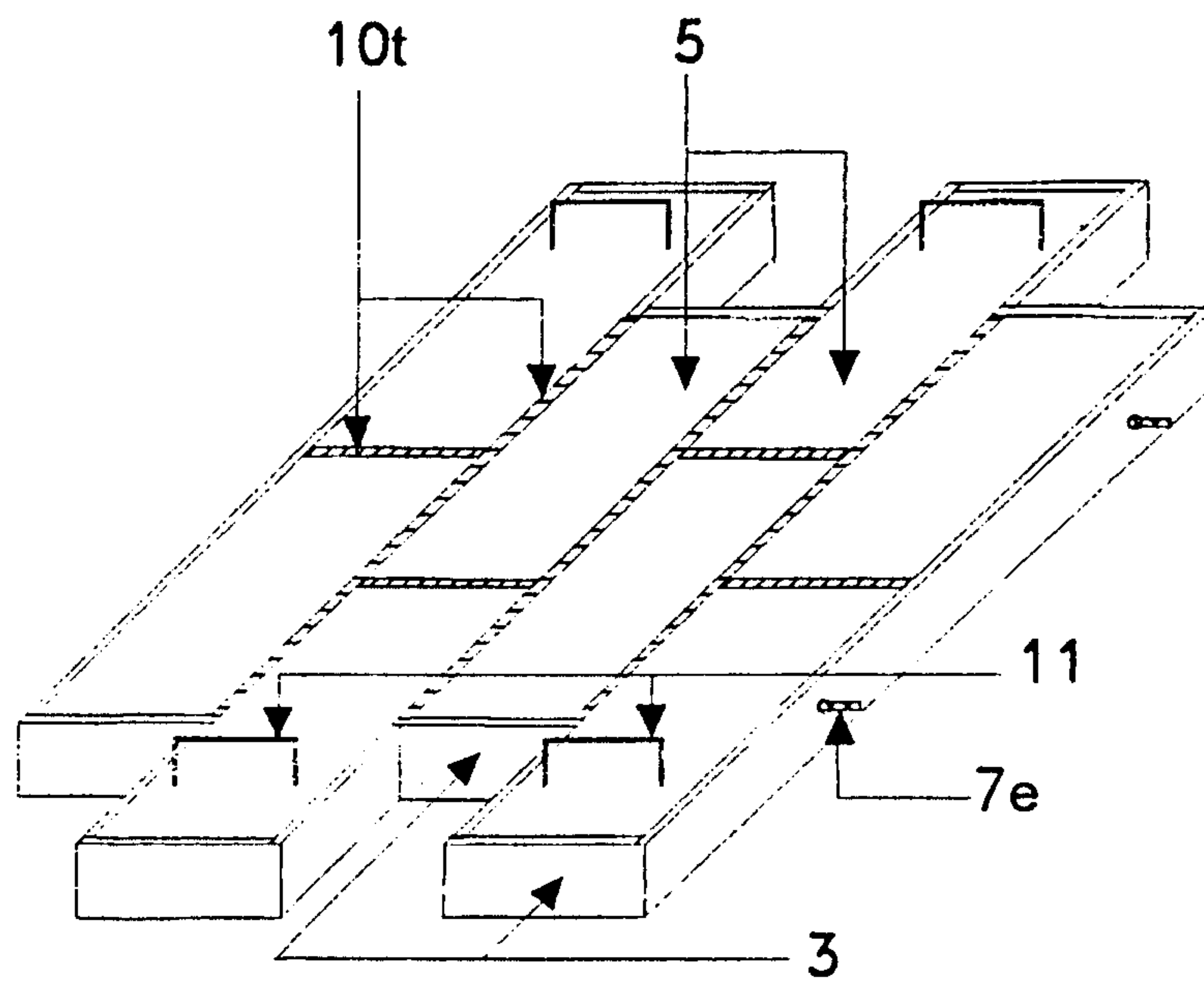
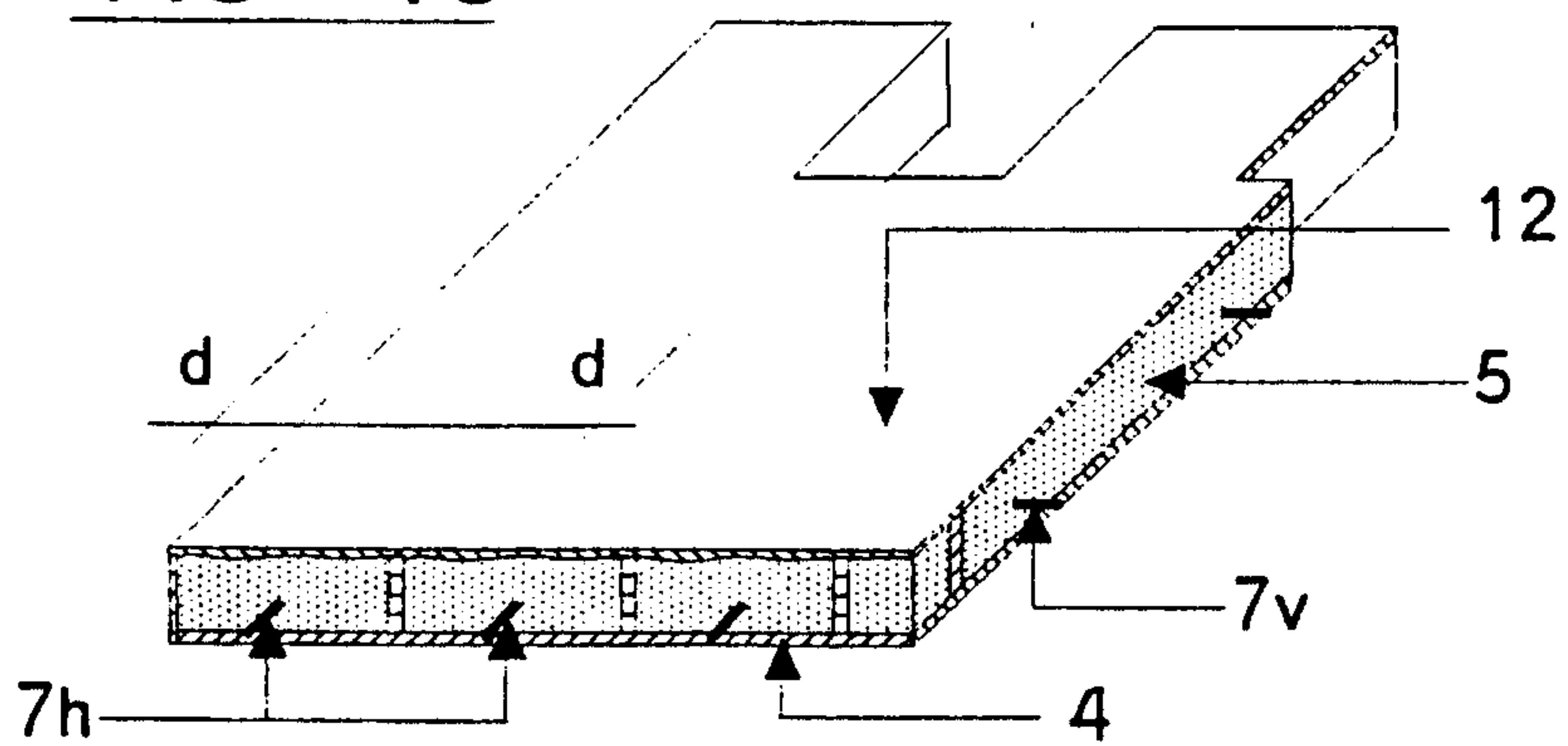
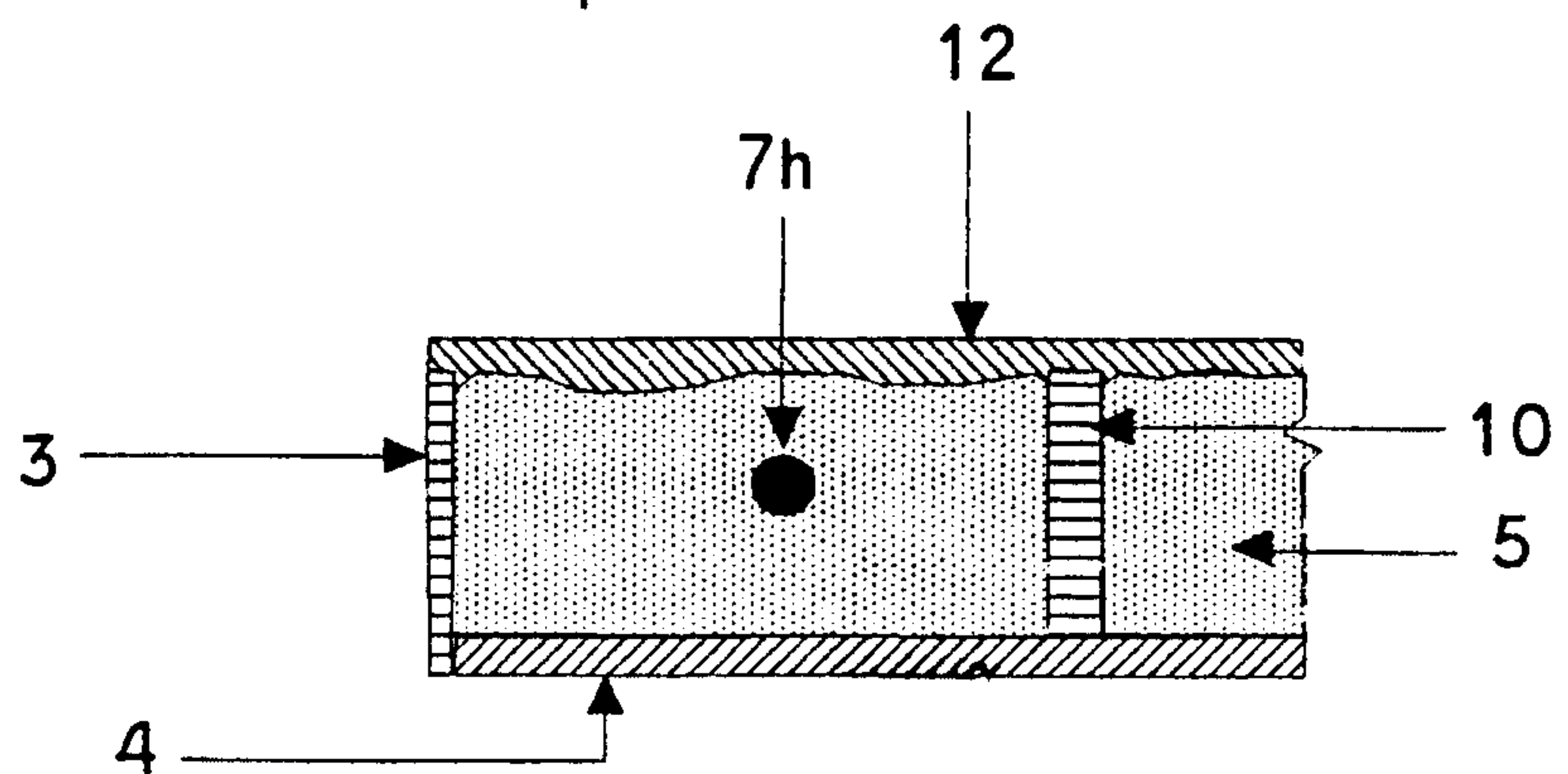
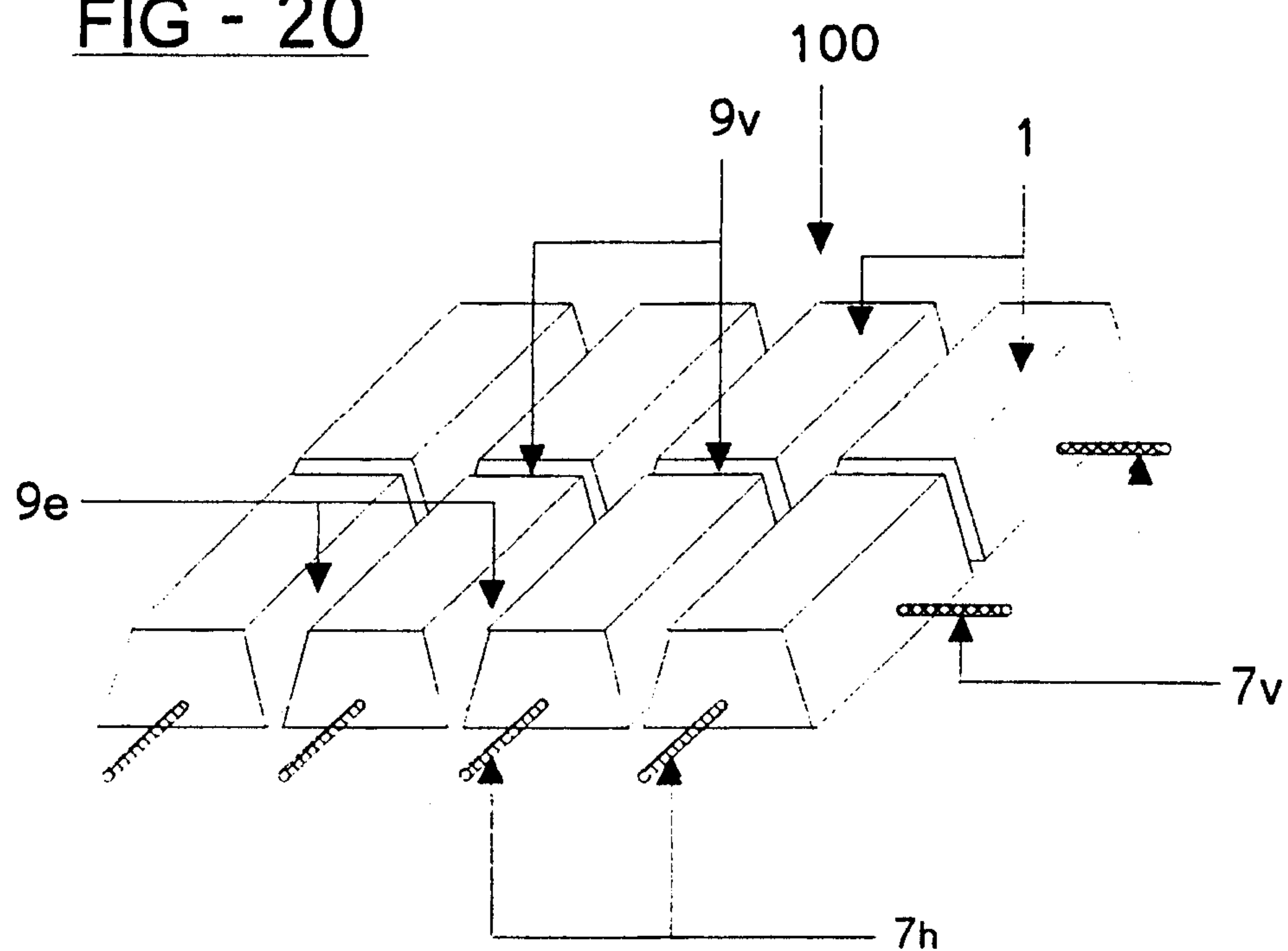
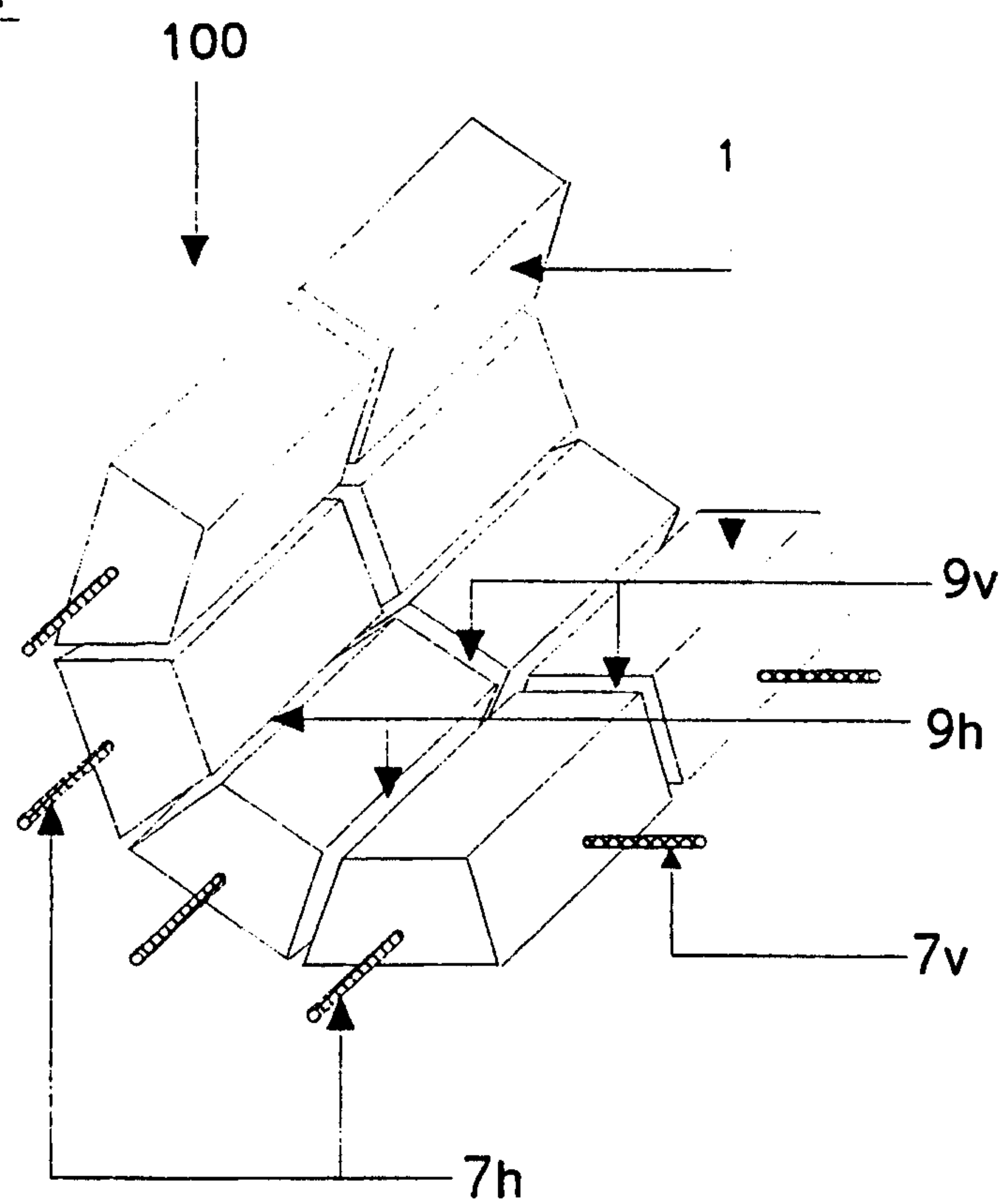
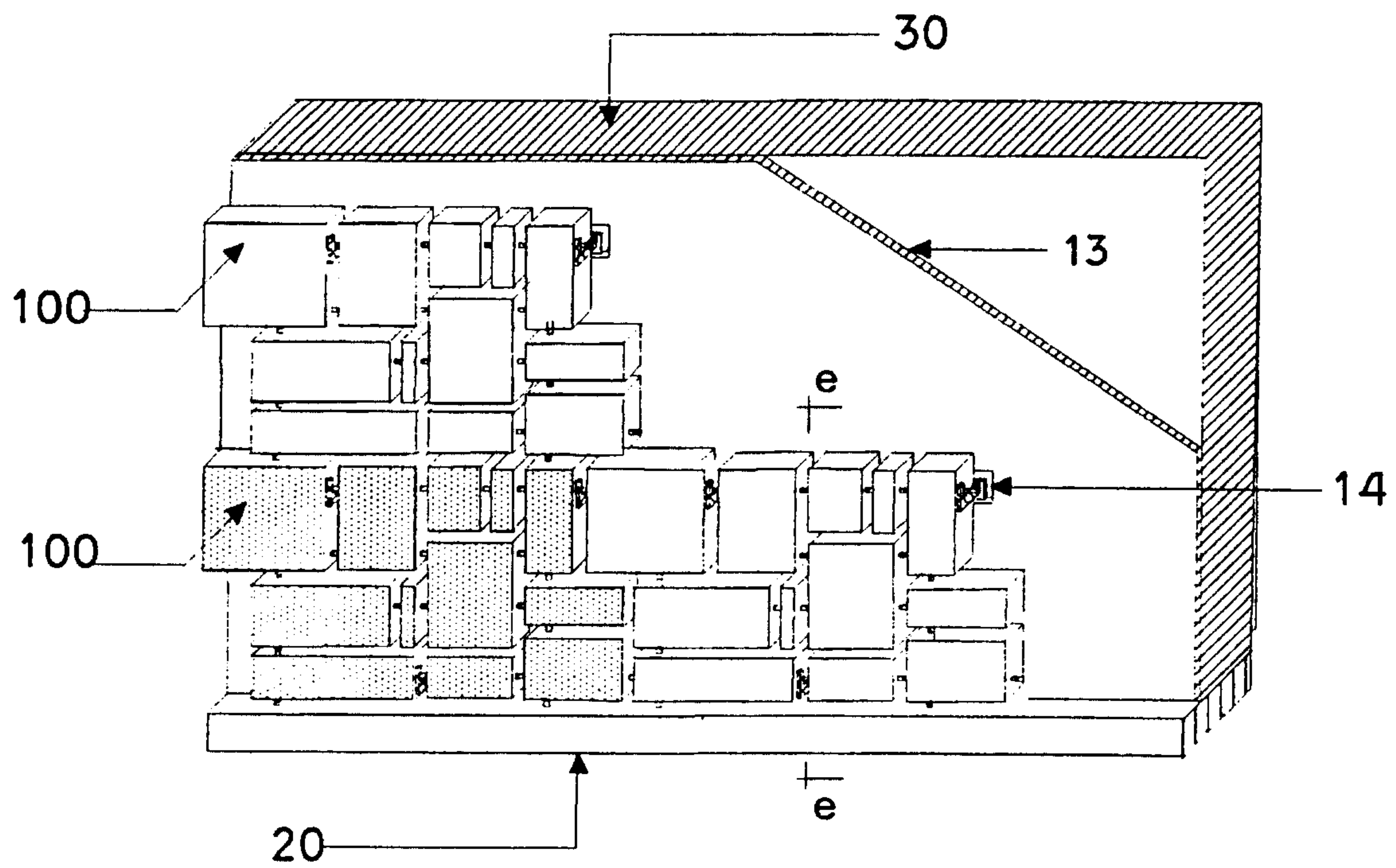
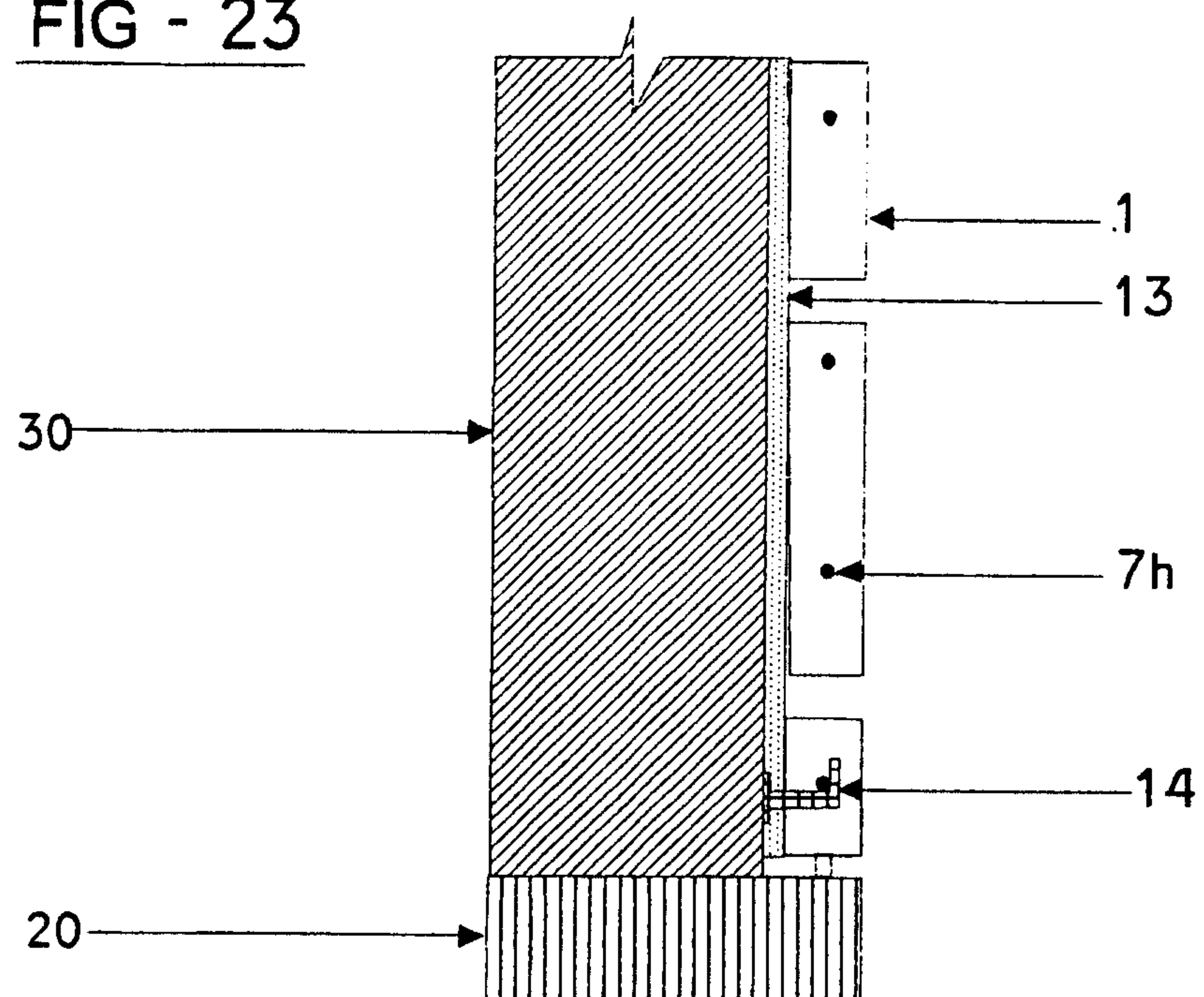
FIG - 15FIG - 16

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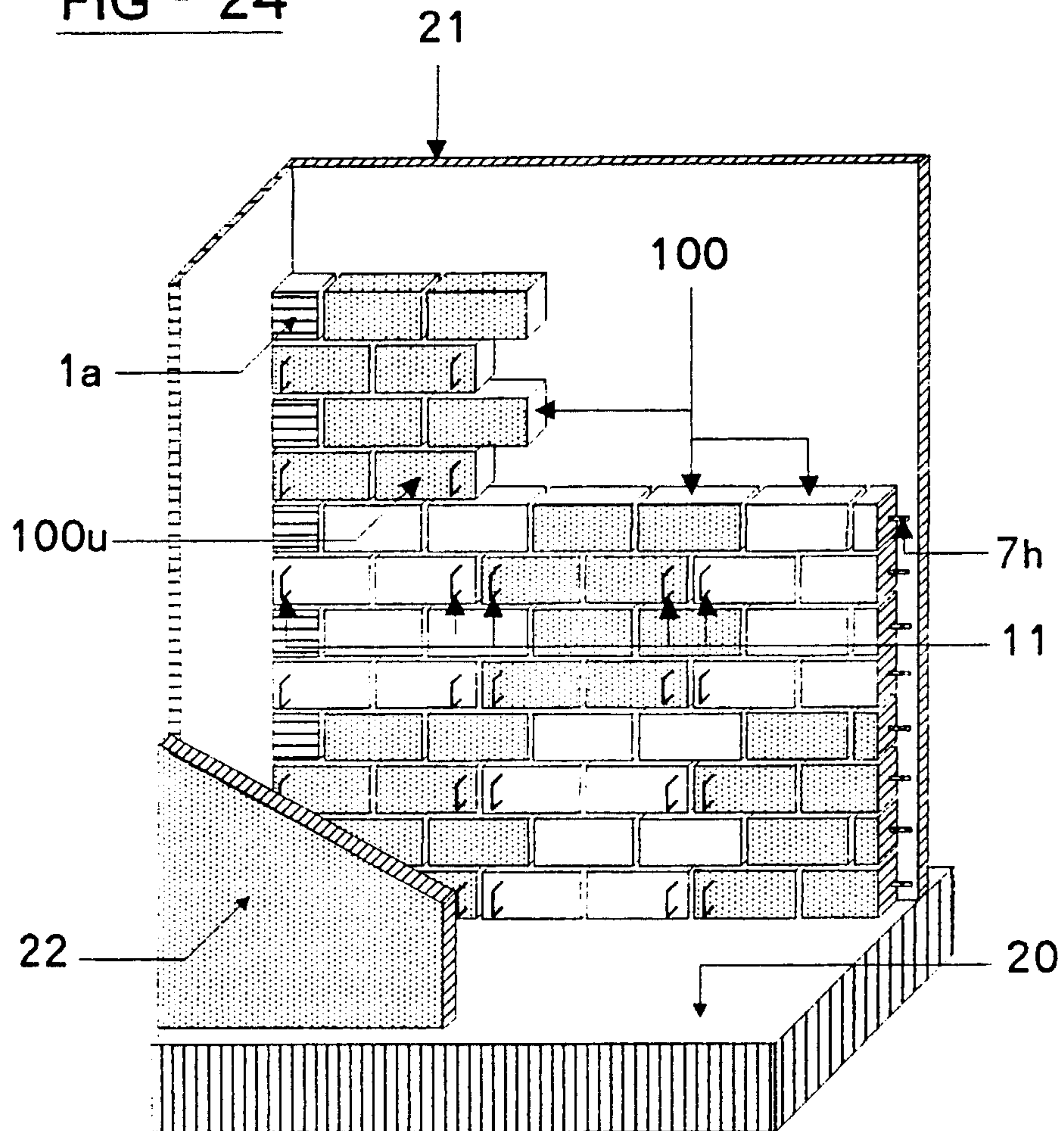
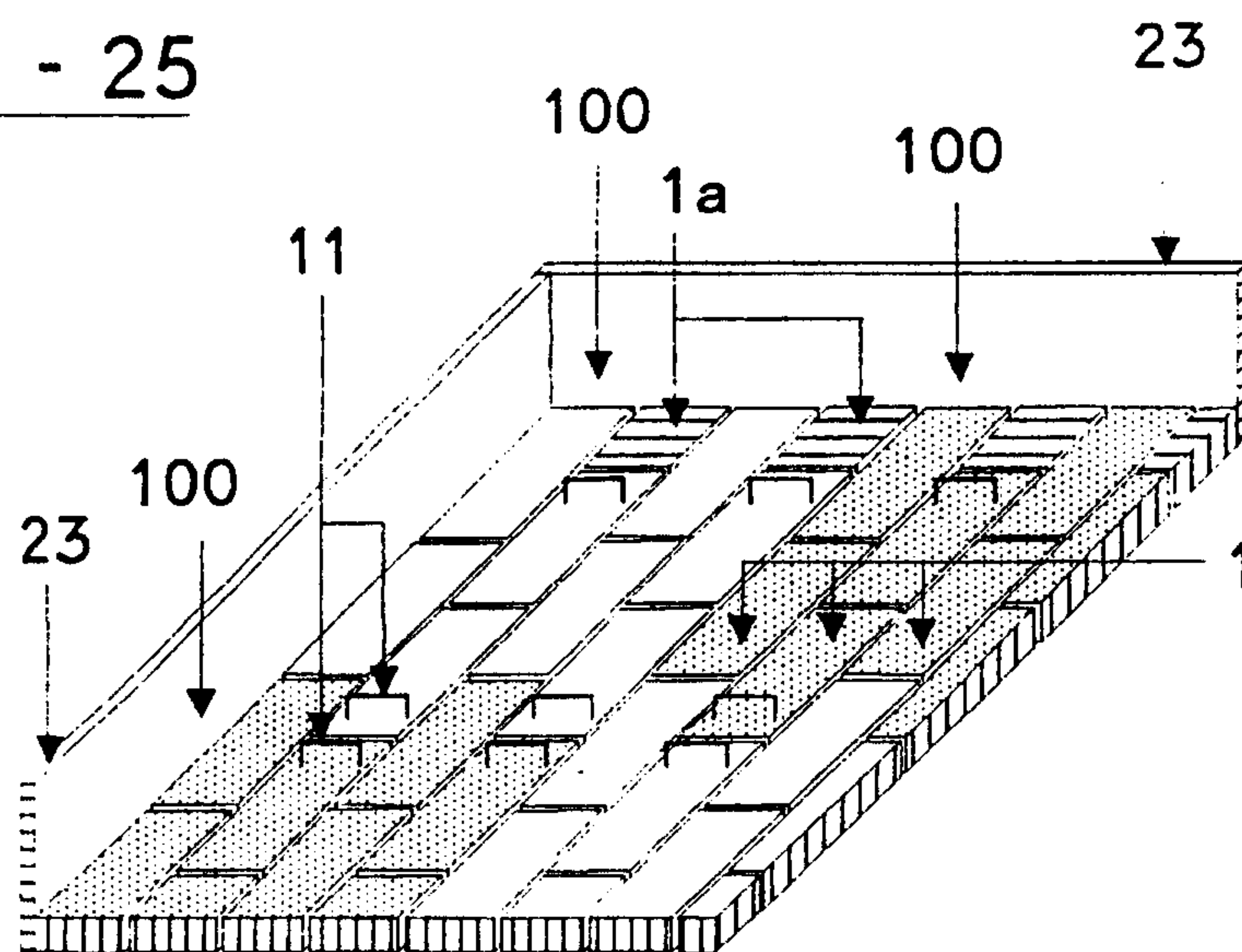
FIG - 24FIG - 25

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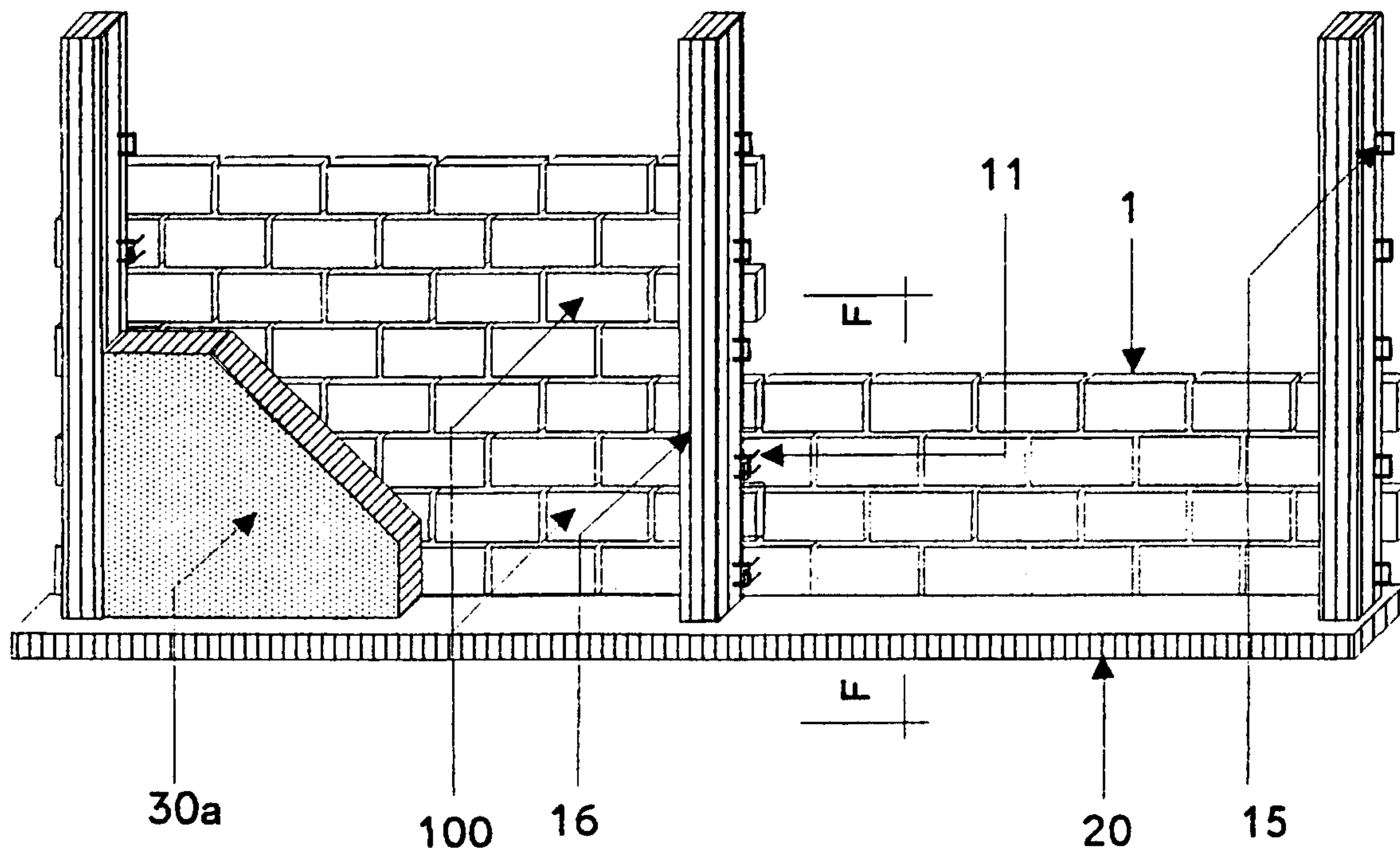


FIG - 27

