

(21) Application No 8036487

(22) Date of filing 13 Nov 1980

(30) Priority data

(31) 2948087

(32) 29 Nov 1979

(33) Fed. Rep. of Germany (DE)

(43) Application published

8 Jul 1981

(51) INT CL<sup>3</sup>

G01B 21/02

(52) Domestic classification

G1M A

(56) Documents cited

None

(58) Field of search

G1M

(71) Applicants

Hermann Berstorff

Maschinenbau GmbH, 3

Hannover Kleefeld, An der

Breiten Wiese 3/5,

Federal Republic of

Germany

(72) Inventors

Wilhelm Brand,

Dietmar Baasner

(74) Agents

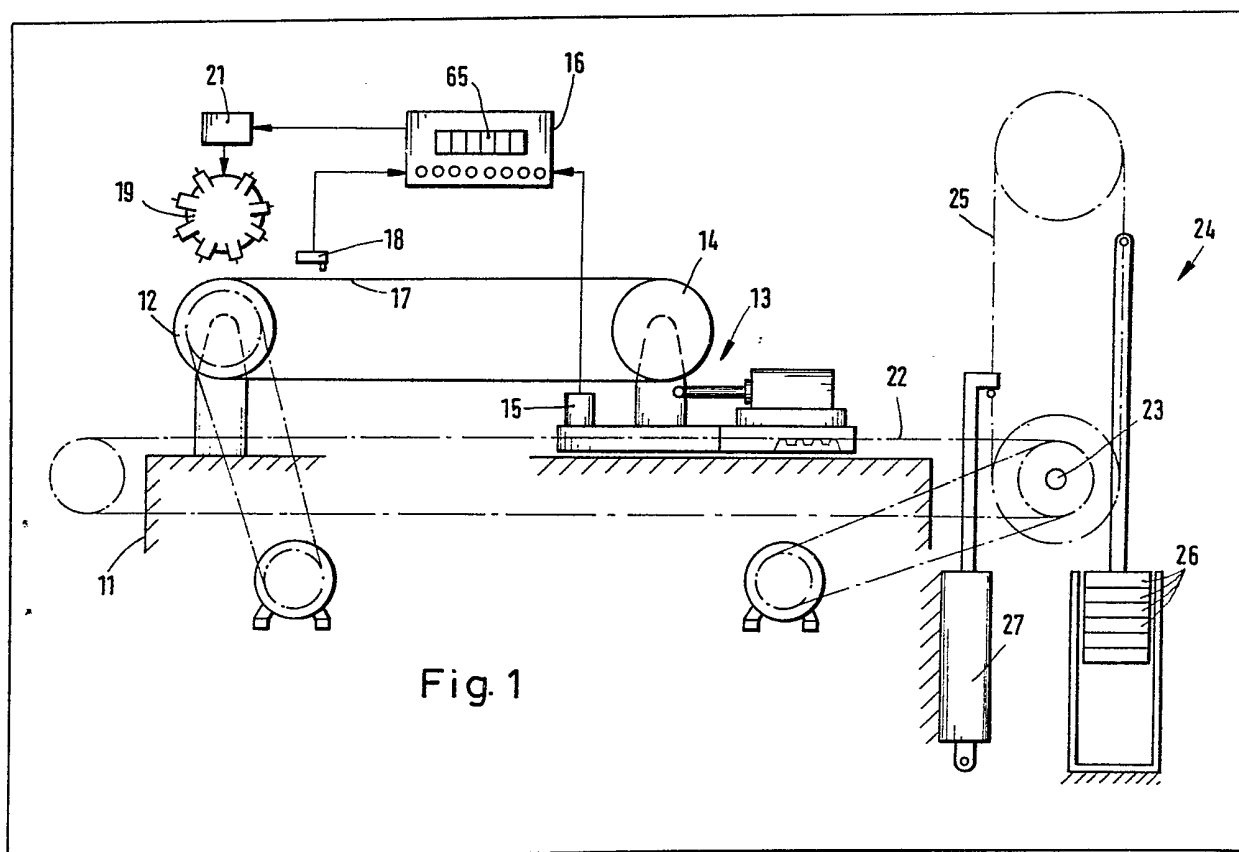
D. Young & Co., 10 Staple

Inn, London WC1V 7RD

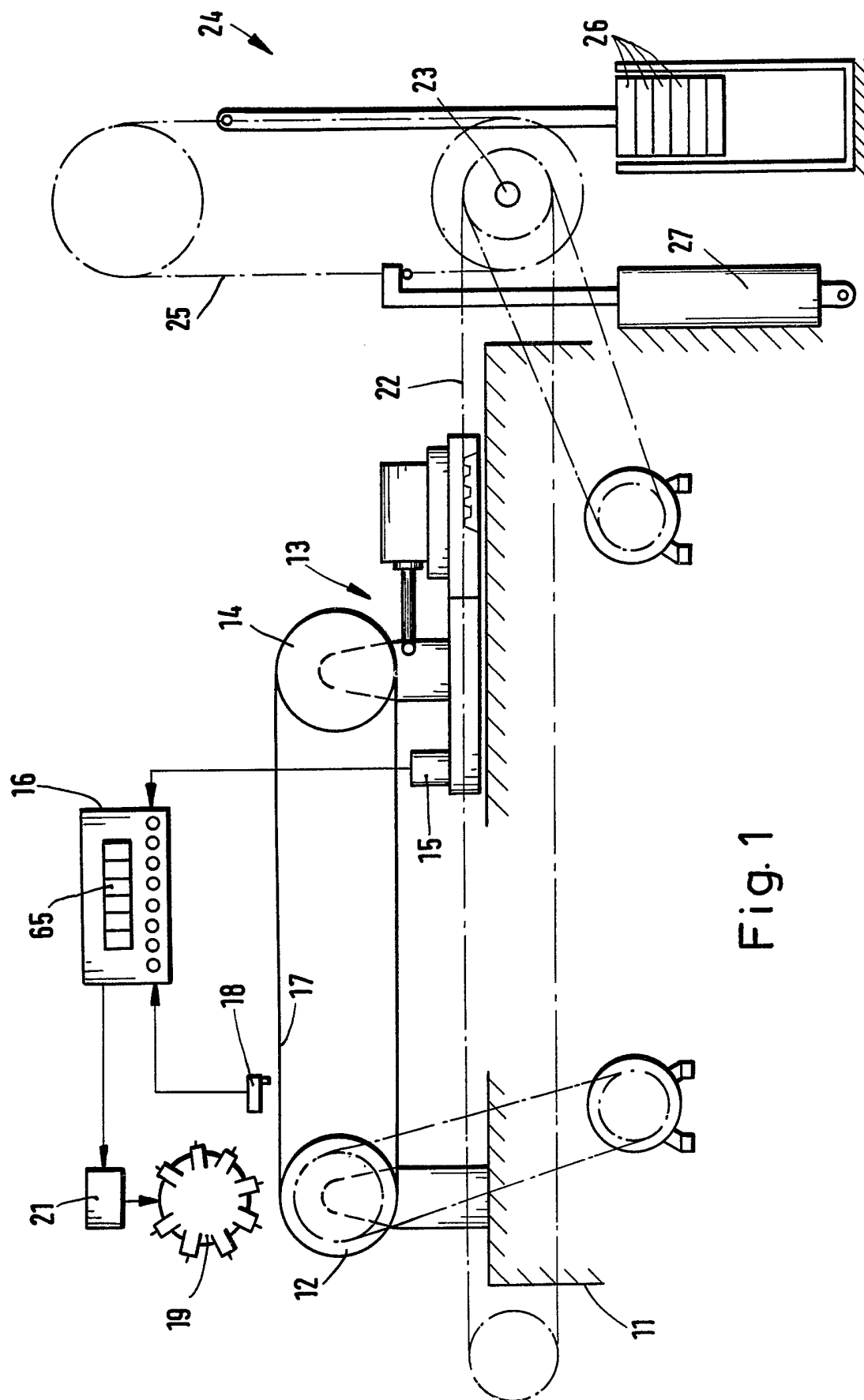
(54) Vee belt measuring apparatus

(57) Apparatus for measuring the length of vee belts, particularly so that vee belts of closely similar length can be identified and thereby used together in multi-belt drives, comprises a fixed drivably rotatable pulley (12), a further pulley (14) on a tensioning carriage (13), a belt (17) to

be measured being engaged on the pulleys (12, 14), a drag chain (22) to couple the carriage (13) to a travel drive or to a tensioning station (24) with tensioning weights (26), an absolute length measuring device (15) to supply an electronic control and arithmetic unit (16) and recording means (19) to mark the vee belt (17) with a symbol denoting a length tolerance part-range.



GB 2 066 472A



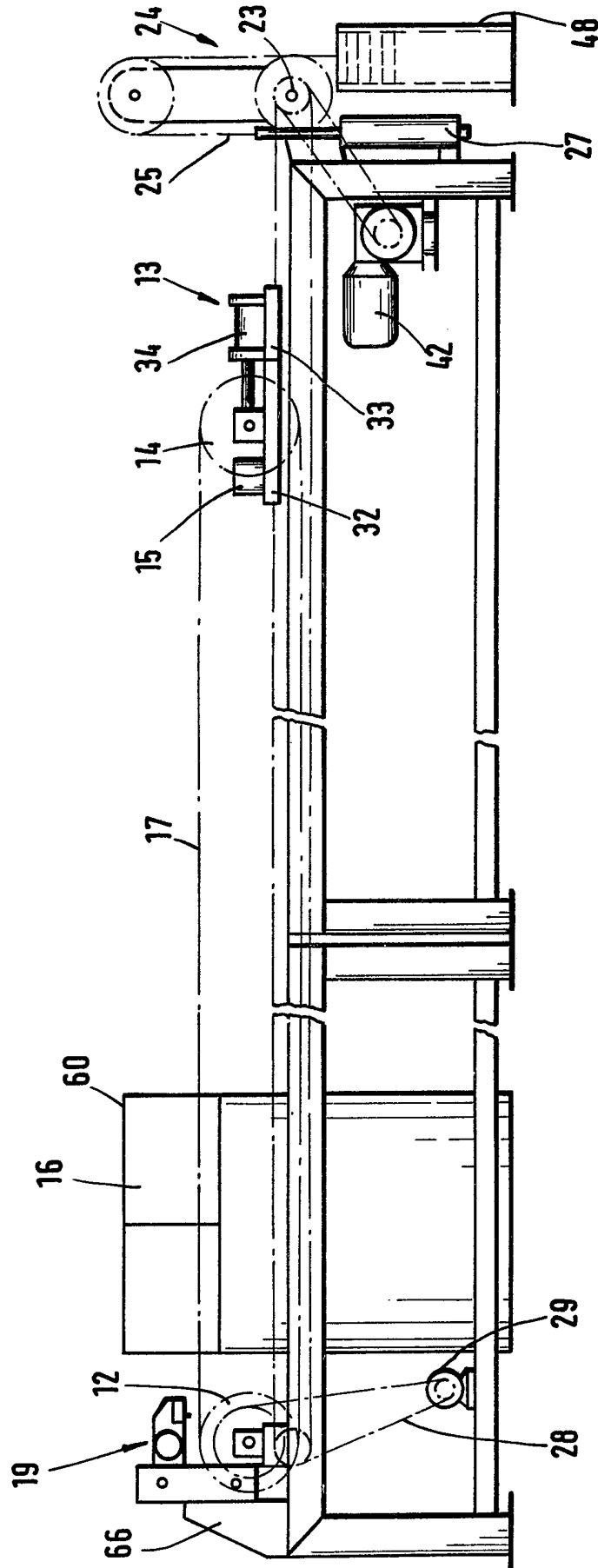


Fig. 3

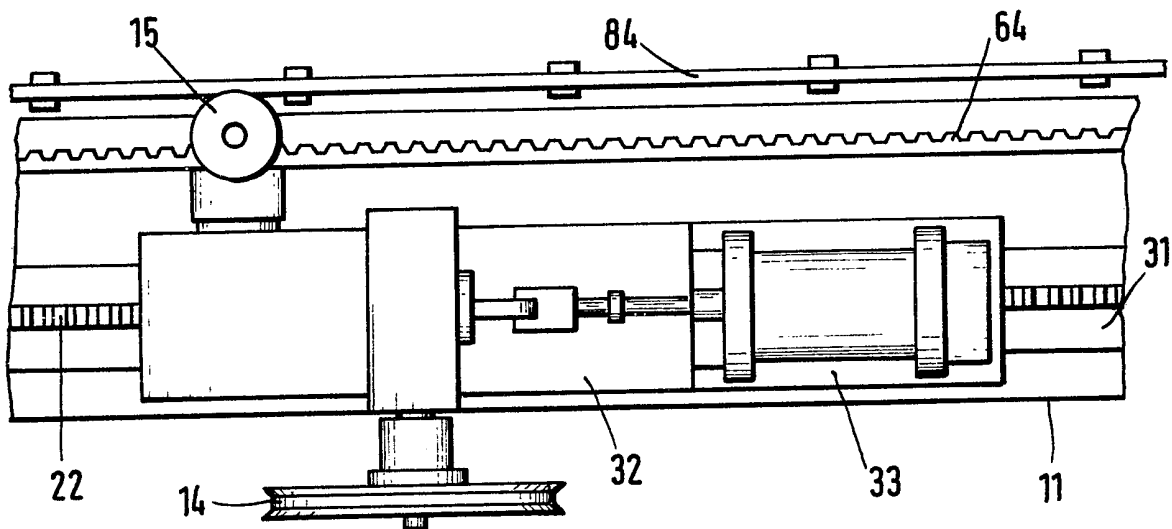
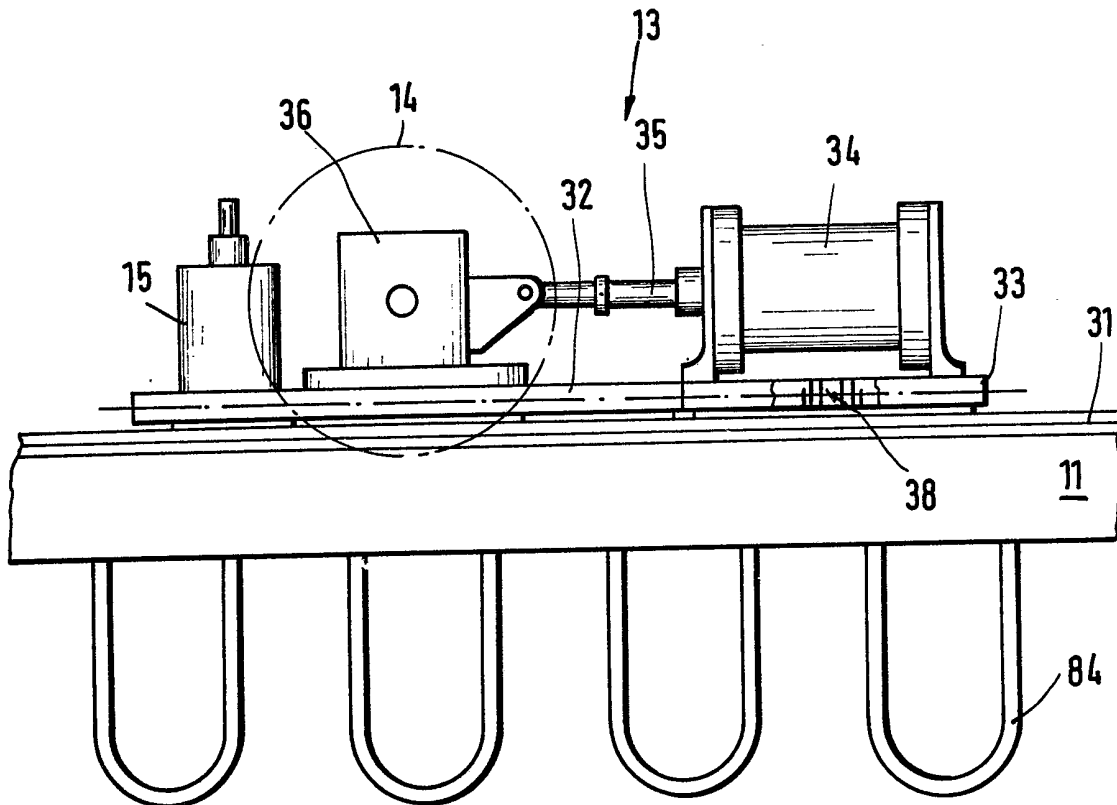
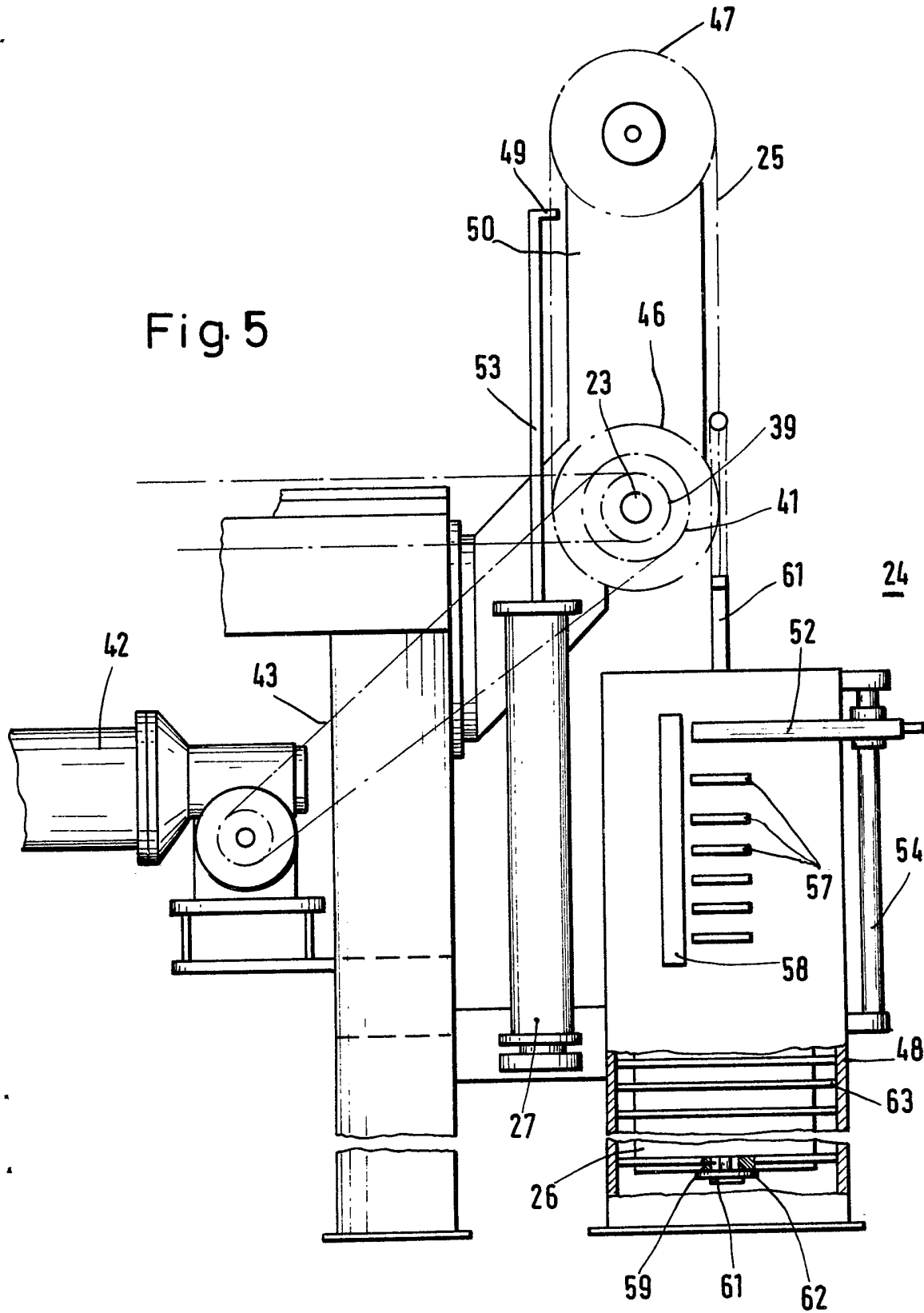
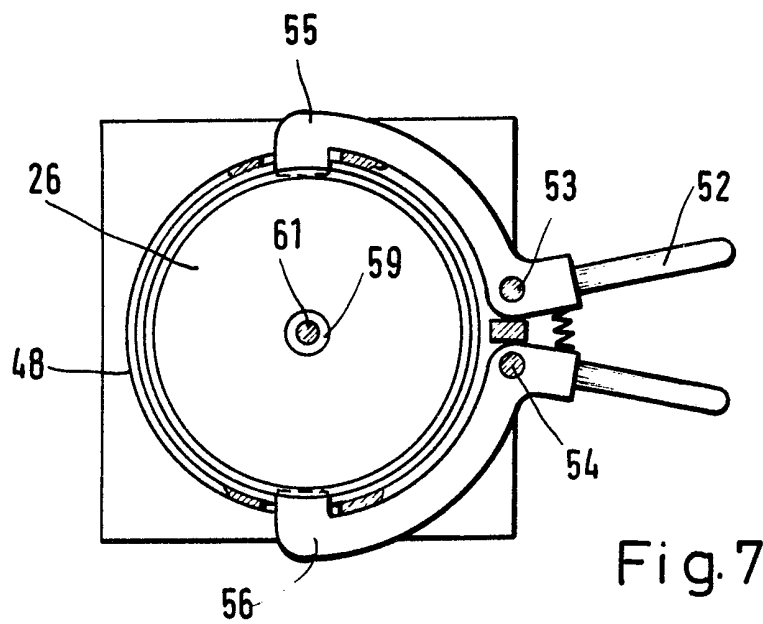
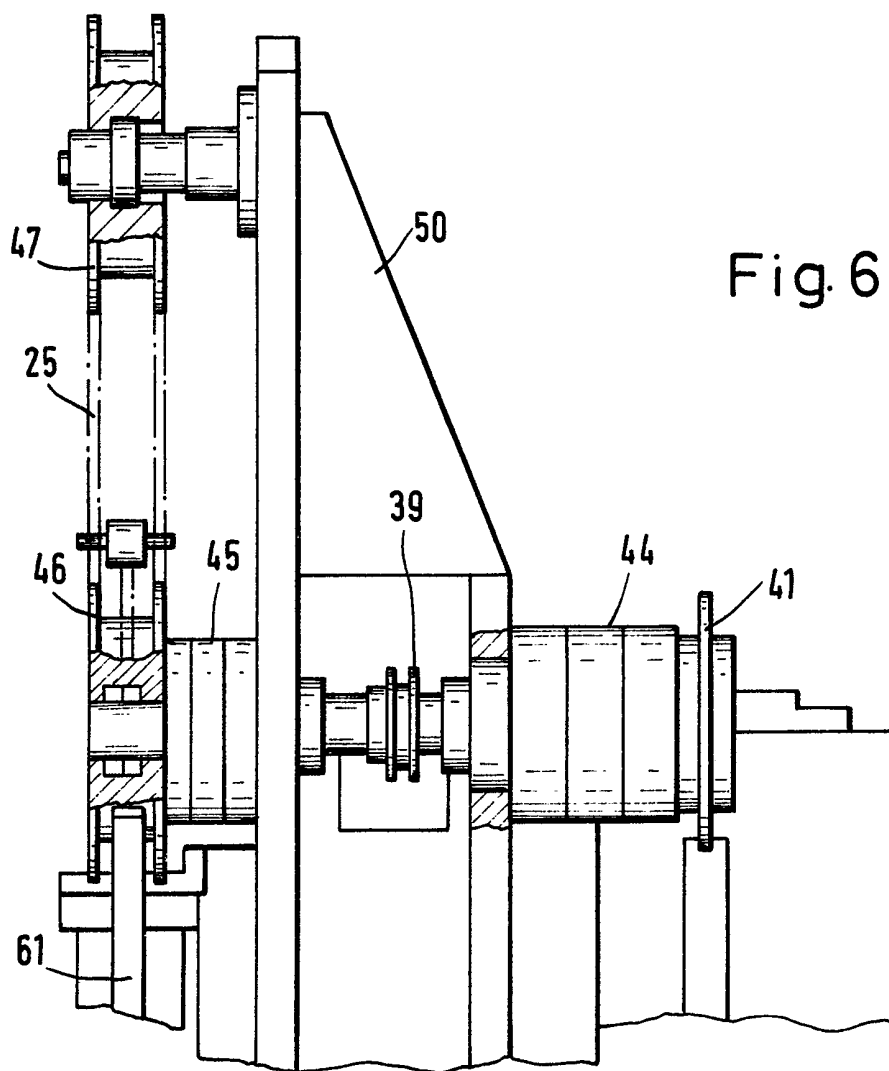


Fig. 4

Fig. 5



5/7



6/7

Fig. 8

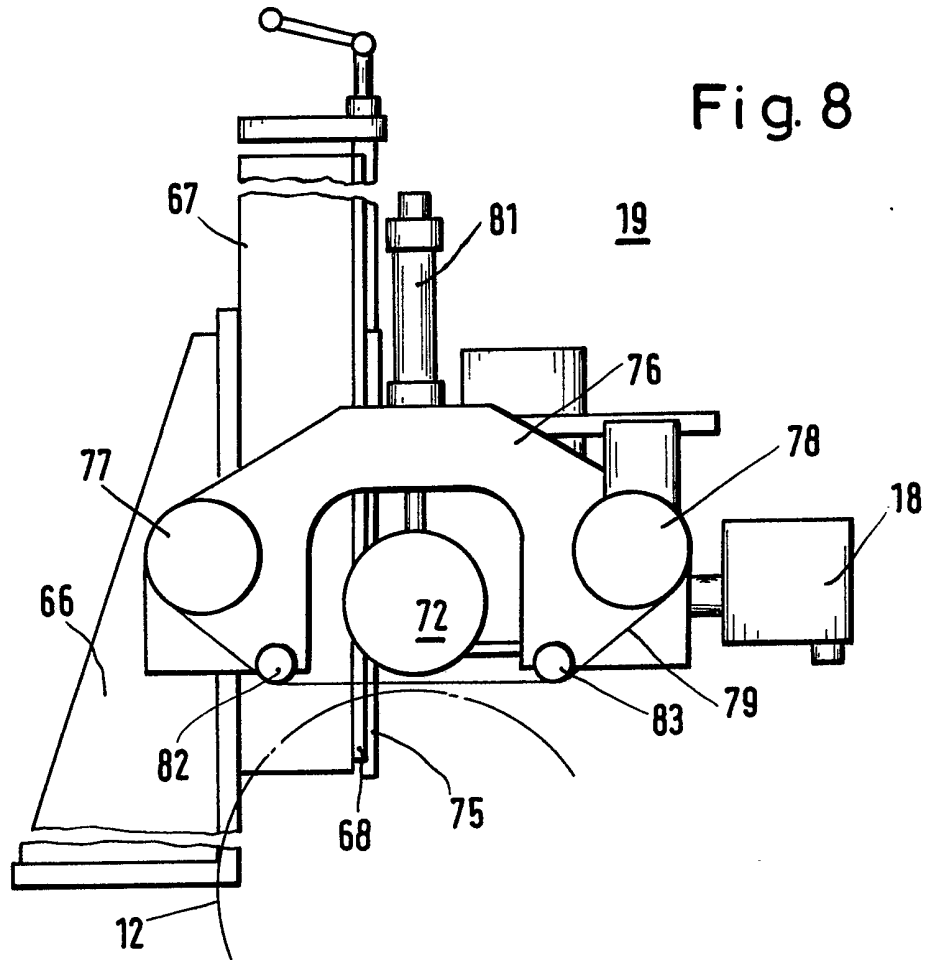


Fig. 9

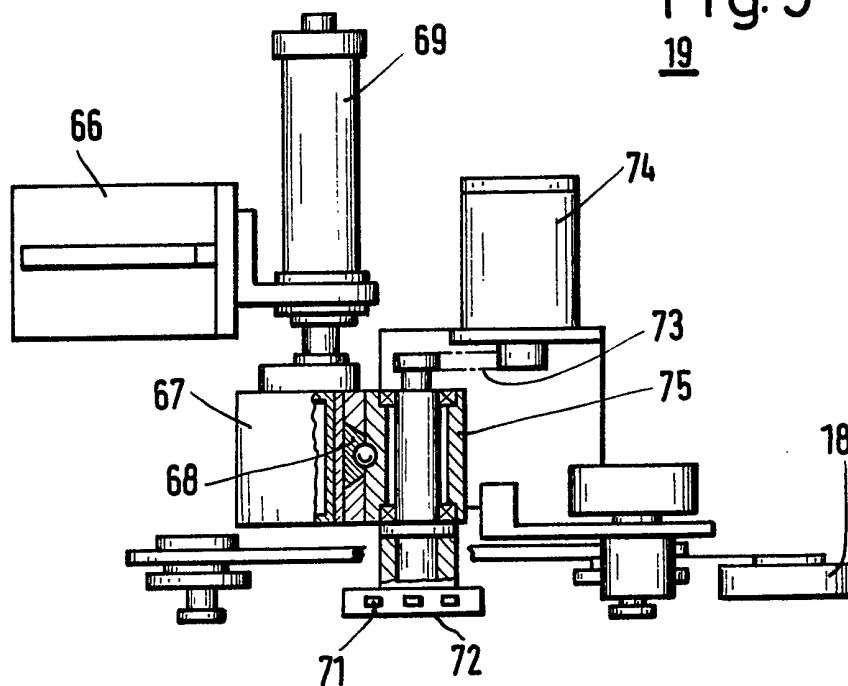
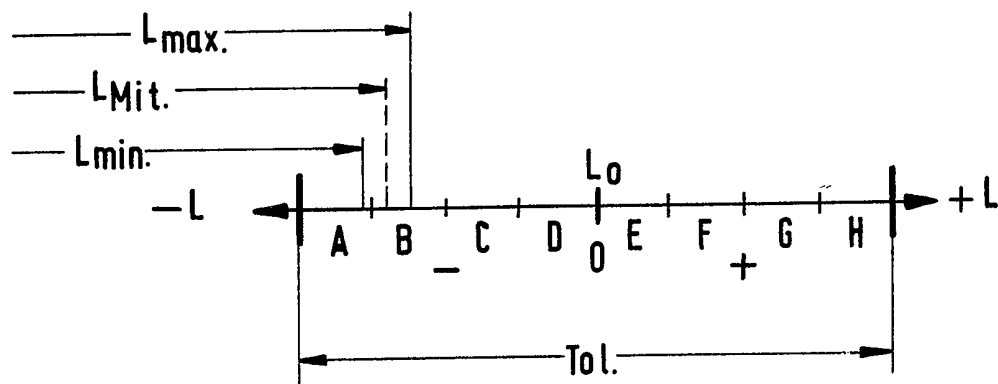


Fig.10





## SPECIFICATION

**Vee belt measuring apparatus**

The invention relates to apparatus for measuring the length of a vee belt.

5 In the manufacture of vee belts, differences in length are found, resulting from variations in the production process, although the nominal lengths are the same. These differences in length must come within a certain tolerance range. It has been  
10 found, however, that for multi-groove drives vee belts may have too great a difference in effective length, in one and the same set of parallel-running belts, although their effective lengths come within the predetermined tolerance range.

15 It has therefore already been proposed in German Patent Specification No 11 25 153 that, after vee belts have been vulcanised, those within the admissible tolerance should be divided into sets having the same average length as one  
20 another. This gives sets of vee belts for multi-groove drives which run quietly to a great degree. However, if one belt of a set of vee belts fails, the whole set has to be exchanged. Furthermore, with previously proposed measuring machines for this  
25 purpose, vee belts of the same effective length can only be divided into sets in a very laborious way.

According to the invention there is provided apparatus for measuring the length of a vee belt, comprising two vee belt measuring pulleys with a  
30 variable distance between their axes, one pulley being drivable for rotation and the other pulley being mounted on a tensioning carriage which can travel along a machine bed; a drag chain fixed to the tensioning carriage and couplable either to a  
35 travel drive or to a tensioning station provided with tensioning weights; an absolute length measuring device; an electronic control and arithmetic unit to receive an input from the absolute length measuring device, the control and  
40 arithmetic unit having an assessing circuit which compares the actual measured value of the length of the vee belt with stored values of part-ranges of the appropriate length tolerance; and a recording means to mark the vee belt being measured, when  
45 it has been measured and allocated to a tolerance part-range.

The vee belt measuring pulleys are moved towards one another by the travel drive acting on the drag chain of the tensioning carriage, so that  
50 the vee belts can be engaged on them. Data concerning the shape of the vee belt and its nominal length are fed into the control and arithmetic unit containing the assessing circuit. Thus the length tolerance corresponding to this  
55 nominal length of vee belt is calculated from a length tolerance formula in the memory and read back. The drag chain fixed to the tensioning carriage is coupled to the tensioning station, so that the tensioning weights become effective.  
60 After a few revolutions of the vee belt one revolution is assessed as the measuring run. The length determined from the vee belt is the mean value between the maximum and minimum lengths. The length measured is classified by the

65 control and arithmetic unit which assigns the actual length to a stored value of the possible tolerance part-ranges, and transmits a corresponding control pulse to a stepping motor of the recording means. The recording means marks  
70 the particular tolerance range on the vee belt. The tensioning carriage then moves back with the movable measuring pulley towards the stationary measuring pulley, so that the vee belt can be removed. A vee belt which comes within the  
75 allowable length tolerance is allocated by a simple process to a part-range of that tolerance. Belts which come outside the allowable length tolerance are recognised as rejects and not stamped.

80 Preferably the tensioning carriage substantially comprises two part carriages which can be locked together, a first of the two part carriages has a dual-action pressure medium cylinder, the piston rod of which is connected to the second part  
85 carriage; said first part carriage is joined to the drag chain; and the drag chain can be coupled either to the travel drive for moving the tensioning carriage or to the tensioning station.

The two part construction of the tensioning carriage simplifies the exchanging of vee belts of the same nominal length. The part carriage provided with the dual action pressure medium cylinder remains in position, once reached, while a  
90 number of vee belts of the same nominal length are being measured. The second part carriage, carrying the movable measuring pulley, is displaced by the piston rod of the pressure medium cylinder, to reduce the distance between the axes of the pulleys and at the beginning of the  
95 measuring process it is drawn up and locked onto the first part carriage again by the cylinder.  
100

For vee belts of different sizes the standards prescribe different tensioning weights for measuring the length. To simplify the adjustment  
105 and bringing into action of the various weights, the tensioning station preferably has an endless chain with disc-shaped tensioning weights hooked into it, and the weights are guided in a cylinder and can be brought into action in different  
110 combinations by means of an arrestable pair of gripping tongs, engaging through apertures in the cylinder. The gripping tongs, which can be arrested, pick up some tensioning weights and put them out of action, according to the weight  
115 specified.

Advantageously each tensioning weight has a central hole through which a supporting rod fixed to the endless chain is guided with clearance; the end of the rod is provided with a supporting disc  
120 on which the tensioning weights lie; and each of the weights has an extension for engagement by the tongs. The disc-shaped tensioning weights lie on the supporting disc and thereby exert a tensioning force on the tensioning carriage, by means of the supporting rod and the endless chain, when coupled to the drive shaft. The gripping tongs can take up the weight of any number of tensioning weights, so that only the remaining ones lie on the supporting disc.  
125

Alternative coupling of the travel drive or tensioning station to the drag chain of the carriage is advantageously provided by a construction in which a first sprocket, with the endless chain

5 looped round it, is seated on a common drive shaft with the travel drive; the first sprocket can be coupled to the drive shaft by a magneto coupling; and the travel drive can be coupled to the drive shaft by a further magneto coupling. Two magneto

10 couplings seated on the drive shaft connect the shaft either to the travel drive or to the tensioning station.

Preferably the tensioning station has a pulling member disposed on the machine frame and engaging in the endless chain. When a plurality of

15 vee belts of the same nominal length are being measured, the pulling member makes it possible to put the tensioning weights out of action during the process of exchanging the vee belts. Another measurement can then be taken immediately by removing the tensile force of the pulling member. Thus a measuring process with advantageous timing is possible. As a result of the

20 initial coupling of the tensioning station to the drive shaft of the carriage chain during engagement by the pulling member, the carriage can regain its once-assumed position after each measuring operation. This position is preferably within the minus-reject range.

Advantageously a rack is disposed on the machine frame parallel with the guide bed of the tensioning carriage, and a pinion of a digitally absolute rotation generator, disposed on the tensioning carriage, engages with the rack. The

35 use of a digitally absolute rotation generator has the advantage that a certain number value is allocated absolutely to each angular step of the pinion engaging in the rack. This specific number value, which represents a numerical value, can be read out by means of engraved sensing elements. The numerical value constitutes the measuring value, which is unchangeably present as a code pattern. This absolute measuring value is available for further processing without any waste of time,

45 and cannot be falsified as a measuring value by interruptions in operation and failure of mains electricity. Each longitudinal position of the tensioning carriage is defined, so that only a single initial calibration of the code pattern of the rotation generator is necessary.

Advantageously the recording means is in the form of a punching device and is located above said one pulley for vertical and horizontal displacement on the machine frame. The punching

55 means is vertically adjusted according to the diameter of the vee belt measuring pulley. After the measuring process the vee belt is stopped and the punching means moved downwards. The fact that the punching means is arranged above the stationary measuring pulley makes it possible to punch without a backing surface. The additional mark for the particular tolerance part-range is preferably impressed adjacent an existing mark showing the nominal length of the vee belt.

65 The punching means preferably includes a vertical

support carried by horizontal pressure medium cylinders mounted on the machine frame, a vertical displaceable guide beam is guided on the support; and a punching plate provided with symbols is mounted rotatably in the guide beam. Horizontal displacement of the punching means brings it into position or moves it away for removal of the vee belt. After the measuring process the vee belt is stopped and the guide beam moved

70 downwards, by means of a pressure medium cylinder which can also be controlled. The punching plate makes an impression of the symbol brought into position on the back of the vee belt.

A punching band can be located between the punching plate and the vee belt to be measured and marked; the band has a heat-fusible coating on the side facing towards the vee belt; and the punching plate can be heated. On downward movement of the punching plate the punching

80 band, provided with a heat-fusible coating, is pressed onto the back of the vee belt by the punching plate. The punching plate is heated, so that a mark corresponding to the symbol on the plate is fused out of the band and impressed on the back of the vee belt. This additional marking characterises the particular tolerance part-range within which the average actual length of the vee belt comes.

When a punching band is used it is advantageous for the punching means to include a step-by-step switch *per se* for advancing the punching band. The feed movement of the punching band is preferably initiated by upward movement of the punch means after a stamping

95 operation.

The apparatus preferably includes a photoelectric cell to sense an optical mark on the back of the vee belt, the output signals from the cell being fed to the control and arithmetic unit. Thus the cell detects the revolutions of the vee belt and stops the belt in the correct position relative to the punching means.

The invention is diagrammatically illustrated by way of example with reference to the accompanying drawings, in which:—

Figure 1 is a schematic representation of apparatus for measuring the length of a vee belt according to the invention;

Figure 2 is an elevation of the apparatus shown schematically in Figure 1;

Figure 3 is on a larger scale to Figure 2 and shows a two part tensioning carriage, which holds a movable vee belt measuring pulley and which has a distance-dependent rotation generator;

Figure 4 is a plan view corresponding to Figure 3;

Figure 5 shows tensioning means of the apparatus of Figures 1 to 4;

Figure 6 is a side elevation corresponding to Figure 5;

Figure 7 shows gripping tongs of the apparatus which bring different tensioning weights into action;

Figures 8 and 9 show punching means of the apparatus in side elevation and in plan view; and

Figure 10 is a graphic representation of an allowable length tolerance range, with a division into partial ranges.

Referring to Figure 1, a machine frame 11 carries a stationary mounted vee belt measuring pulley 12 and a further movable vee belt measuring pulley 14 which is displaceable by means of a two part tensioning carriage 13. A digitally absolute rotation generator 15 for length measurement is disposed on the carriage 13; values measured by it are coded and supplied to a control and arithmetic unit 16. A signal from a photoelectric cell 18, arranged above the vee belt 17 to be measured, is also supplied to the unit 16. A punching device 19, governed by a control apparatus 21, is disposed above the stationary pulley 12.

The tensioning carriage 13 can be moved by a drag chain 22 which may be driven by means of a shaft 23. The shaft 23 is rotated in a tensioning station 24 which has an endless chain 25. Tensioning weights 26 are suspended from the endless chain 25, and can be put out of action by a pneumatic cylinder 27 which is secured to the machine frame 11.

The individual units of the machine will now be explained in greater detail.

Referring now also to Figures 2 to 10, the vee belt measuring pulley 12 mounted stationary on the machine frame 11 can be driven by a DC geared motor 29 by means of a drive chain 28. The speed at which the pulley 12 revolves can be steplessly varied.

The movable vee belt measuring pulley 14 is mounted on the motor-driven tensioning carriage 13, which is located in a guide bed 31 on the machine frame 11. The carriage 13 comprises two part carriages, viz an inner carriage 32 and an outer carriage 33. The inner carriage 32 which is nearer the stationary pulley 12, carries the movable pulley 14 and a digitally absolute rotation generator 15, which records the change of length by means of the change of angle. The outer carriage 33 carries a dual-action pressure medium cylinder 34, the piston rod 35 of which is connected to a bearing block 36 of the movable pulley 14. A trailing cable 84 for the electrical and pneumatic supply is mounted laterally on the machine frame 11.

The tensioning carriage 13 which moves along the guide bed 31 of the machine frame 11 contains a longitudinal recess in its underside, with the drag chain 22 guided through it. The chain 22 is screwed to the outer carriage 33 by appropriate connecting means 38. The drag chain 22 engaging the outer carriage 33 can be driven by a DC geared motor 42 and a chain 43, by means of a sprocket 39 seated on the drive shaft 23 and engaging the drag chain 22 and a further drive sprocket 41 engaging the chain 43.

Two magneto couplings 44 and 45, seated on the drive shaft 23, cause the drive 42, 43 or the tensioning station 24 to act on the drag chain 22. The station 24 includes a sprocket 46 on the drive shaft 23, and a sprocket 47 located above the

sprocket 46 and rotatably mounted in a bearing arm 50, which is secured to the machine frame 11. The endless chain 25 moves around the sprocket 47 and has the tensioning weights 26 hooked onto it. These are in disc form and guided in a cylinder 48. The action of the tensioning weights 26 can be terminated by the pneumatic cylinder 27, which is secured to the machine frame 11. The cylinder 27 engages in the chain 25 by means of a catch 49 on its piston rod 51.

The cylinder 48 which guides the weights 26 has a pair of gripping tongs 52 (Figure 7) which can be adjusted in height on vertical rods 53 and 54 outside the cylinder 48, jaws 55 and 56 of the tongs engaging through apertures 57 in the wall of the cylinder. In this way the individual weights 26 can be brought into action as desired. A weight scale 58 mounted in the vicinity of the apertures 57 gives the operator the necessary information for the total weight which should be set so as to comply with standards.

The disc-shaped tensioning weights 26 each have a central hole 59 which has a supporting rod 61 extending through it. At the lower end of the group of weights 26 the rod 61 is joined to a supporting disc 62, to allow the group of weights 26 to be lifted. The disc-shaped weights 26 each have a circular extension 63, under which the jaws 35, 56 of the tongs can engage. The top of the rod 61 is joined to the endless chain 25.

On the inner carriage 32 the digitally absolute rotation generator 15, can record the change in length through a change in angle. A pinion, mounted on the generator 15 but not shown in the drawings, engages in a rack 64 located along the guide bed 31. The generator 15 of the carriage 13 transmits its particular distance-dependent measurement to the programmable, electronic control and arithmetic unit 16, which is accommodated in a switch box 60. The unit 16 has a display 65 of the actual measured length of the vee belt 17. The programmable part of the unit 16 enables a particular desired length of the vee belt to be set, the profile size to be set, the vee belt revolutions to be chosen and the particular standardised length tolerance to be computed on the basis of a length tolerance formula held in store. A programmed assessing circuit of the control and arithmetic unit 16 is used to check the actual length of the vee belt with predetermined portions A to H of the particular length tolerance range (Tol Figure 10) and transmits an output signal to the control apparatus 21 after measurement and evaluation. The control apparatus 21 correctly positions the appropriate symbol of the punch 19 over the stationary vee belt measuring disc 12 and moves the punch 19 down to stamp the back of the belt. All this can be readily done with modern electronic devices. The electronic component for carrying out the described functions are known *per se* and need not therefore be described in detail.

The punch 19 (Figures 8 and 9) is fixed to the machine frame 11 by a bearing bracket 66. The bracket 66 has a vertical support 67 with a dove-

tailed guide 68 (Figure 9) in which the punch 19 is guided for vertical adjustment. Movement of the punch 19 in a horizontal plane, transversely to the vee belt 17, can be effected by pressure medium cylinders 69 fixed to the bracket 66.

A heated punching plate 72 with a plurality of symbols 71 at its periphery is rotatably mounted in a displaceable, vertical guide beam 75 of the punch means 19. The positioning drive for setting whatever symbol 71 has to be punched is provided by a chain 73 driven by a DC stepping motor 74. The motor 74 is controlled by the control apparatus 21 shown in Figure 1. A yoke-shaped supporting beam 76 fixed to the guide beam 75 carries an unwinding reel 77 and a winding-up reel 78 for a punching band 79 which makes hot impressions. The band 79 is guided over spacing rollers 82 and 83 between the punching plate 72 and the measuring disc 12. A vertical pressure medium cylinder 81 carries out the punching process by pressing down the guide beam 75 carrying the punching plate 72.

The photoelectric cell 18 is fixed to the punch means 19. It senses an optical mark on the back of the vee belt 17 to be measured and thereby generates one output signal per vee belt revolution. This signal is fed to the control and arithmetic unit 16.

This mode of operation of the embodiment described above will now be explained.

When a number of vee belts of identical nominal length are being measured, the nominal length of the belts, the size of their section and a number of belt revolutions is fed into the control and arithmetic unit 16 at the beginning of the measuring operation. The vertical position of the punch means 19 is set to suit the diameter of the vee belt measuring pulley 12. The tensioning force stipulated by a standard is set by application of the gripping tongs 52 to leave appropriate weights 26 effective.

The drive for the two-part tensioning carriage 13 is actuated, and the carriage 13 moves into a position pre-selected and computed by the control and arithmetic unit 16. This initial position is within the minus reject range of the nominal length for the vee belt (Figure 10: -L). The pressure medium cylinder 34 of the outer carriage 33 is next actuated. This causes the inner carriage 32 to move towards the fixed vee belt measuring pulley 12 in order to reduce the axial spacing.

In the measuring process which now begins, the magneto coupling 45 for the tensioning station 24 is energised, after which the coupling 44 for the travel drive 42, 43 is disconnected.

The first vee belt 17 to be measured is placed on the two vee belt measuring pulleys 12 and 14. The dual-action pressure medium cylinder 34 of the carriage 13 is acted on so that the inner carriage 32 moves towards and is locked to the outer carriage 33. The punch means 19 is moved in a horizontal plane to a position over the back of the vee belt by the pressure medium cylinder 69.

The pneumatic cylinder 27, which has hitherto

put the tensioning weights out of action, is now extended, so that the weights 26 act on the drag chain 22 by means of the drive shaft 23. The DC geared motor 29 is actuated, so that the vee belt 17 moves round. Two revolutions of the belt 17 serve to insert it in the profile of the motor pulleys 12 and 14. The revolutions of the belt are picked up by the photoelectric cell 18 and transmitted to the control and arithmetic unit 16 through an output signal.

The third revolution of the vee belt is the measuring run. It is always the absolute length which is measured. From the maximum and minimum values measured the unit 16 forms a mean value, representing the actual length of the vee belt 17.

The allowable length tolerance is illustrated graphically in Figure 10. This length tolerance is divided into eight equal part-ranges A to H. In the measuring example shown here, the maximum length value  $L_{\max}$  is within the tolerance part-range B, while the minimum length value  $L_{\min}$  is within the part-range A. This mean value  $L_{\text{mit}}$  formed from these two length values comes within part-range B.

At the end of the third revolution of the vee belt the drive 28, 29 switches off with a time lag. An assessing circuit of the control and arithmetic unit 16 compares the actual value  $L_{\text{mit}}$  with the allowable length tolerance and allots it to one of the stored tolerance ranges, here part-range B. The unit 16 thereupon transmits a corresponding control pulse to the control appliance 21, which actuates the DC stepping motor 74 for the punching plate 72, so that the symbol on the punching plate 72 representing the recognised tolerance range B is brought into the punching position. The delayed deceleration of the vee belt 17 has taken place so that the marking of the part-range B is punched behind the usual vee belt stamp.

The guide beam 75 with the punch plate 72 is moved down by the cylinder 81, so that the plate 72 presses the punching band 79 onto the back of the vee belt. Since the plate 72 is heated and the band 79 carries a heat-fusible coating, an impression of the symbol on the plate 72 is made on the back of the vee belt. The punch means 19 then moves up again into the opposite position and horizontally away from the vee belt 17 into the starting position.

The removal process for the marked vee belt 17 is initiated by contraction of the pneumatic cylinder 27. By means of the catch 79 and the endless chain 25 the cylinder 27 pulls the weights 26, thus putting them out of action. The cylinder 34 of the carriage 13 is actuated, so that the inner carriage 32 is displaced so as to reduce the axial spacing. The marked vee belt 17 can be removed from the two measuring pulleys 12 and 14.

The new vee belt of the same nominal length is put on. The measuring process is initiated by contracting the cylinder 34 to move the carriage 32 carrying the measuring pulley 14, by locking, and by extending the pneumatic cylinder 27. Once

the punch means 19 has moved into the punching position and the vee belt revolving drive 28, 29 has started, the measuring process described above is repeated.

5 With the measuring apparatus described above a plurality of vee belts of the same nominal length can be measured easily and rapidly. The belts measure thereafter carry additional marking for the tolerance part-range, thus enabling multi-  
10 groove drive units with little difference in the effective length of the belts to be assembled. On failure of a vee belt from a particular multi-groove drive unit, made up of vee belts of the same tolerance part-ranges, all that need be done is to  
15 take out the faulty belt and exchange it for a belt carrying the mark for the same tolerance part-range.

If the actual belt is found to be within the minus reject range ( $-L$ ) or the plus reject range ( $+L$ ),  
20 then no punching of the belt is carried out. A vee belt will also be recognised as a reject and not punched if the minimum and maximum values measured during the last revolution are more than two adjacent tolerance part-ranges apart. This  
25 avoids having an inadmissible difference between the effective lengths of the vee belts of one and the same set in multi-groove drives.

#### CLAIMS

1. Apparatus for measuring the length of a vee  
30 belt, comprising two vee belt measuring pulleys with a variable distance between their axes, one pulley being drivable for rotation and the other pulley being mounted on a tensioning carriage which can travel along a machine bed; a drag  
35 chain fixed to the tensioning carriage and couplable either to a travel drive or to a tensioning station provided with tensioning weights; an absolute length measuring device; an electronic control and arithmetic unit to receive an input  
40 from the absolute length measuring device, the control and arithmetic unit having an assessing circuit which compares the actual measured value of the length of the vee belt with stored values of part-ranges of the appropriate length tolerance;  
45 and a recording means to mark the vee belt being measured, when it has been measured and allocated to a tolerance part-range.

2. Apparatus according to claim 1, in which the tensioning carriage substantially comprises two  
50 part carriages which can be locked together; a first of the two part carriages has a dual-action pressure medium cylinder, the piston rod of which is connected to the second part carriage; said first part carriage is joined to the drag chain; and the  
55 drag chain can be coupled either to the travel drive for moving the tensioning carriage or to the tensioning station.

3. Apparatus according to claim 1 or claim 2, in which the tensioning station has an endless chain

60 with disc-shaped tensioning weights hooked onto it, and the weights are guided in a cylinder and can be brought into action in different combinations by means of an arrestable pair of gripping tongs, engaging through apertures in the cylinder.

65 4. Apparatus according to claim 3, in which each tensioning weight has a central hole through which a supporting rod fixed to the endless chain is guided with clearance; the end of the rod is provided with a supporting disc on which the  
70 tensioning weights lie; and each of the weights has an extension for engagement by the tongs.

5. apparatus according to claim 3, in which a first sprocket, with the endless chain looped round it is seated on a common drive shaft with the travel  
75 drive; the first sprocket can be coupled to the drive shaft by a magneto coupling; and the travel drive can be coupled to the drive shaft by a further magneto coupling.

6. Apparatus according to any one of claims 3  
80 to 5, in which the tensioning station has a pulling member disposed on the machine frame and engaging in the endless chain.

7. Apparatus according to any one of claims 1  
to 6, in which a rack is disposed on the machine frame parallel with the guide bed of the tensioning carriage, and a pinion of a digitally absolute  
85 rotation generator, disposed on the tensioning carriage, engages with the rack.

8. Apparatus according to any of claims 1 to 7,  
90 in which the recording means is in the form of a punching device and is located above said one pulley for vertical and horizontal displacement on the machine frame.

9. Apparatus according to claim 8, in which the  
95 punching means includes a vertical support carried by horizontal pressure medium cylinders mounted on the machine frame, a vertically displaceable guide beam is guided on the support; and a punching plate provided with symbols is mounted rotatably in the guide beam.

10. Apparatus according to claim 9, in which a  
100 punching band is located between the punching plate and the vee belt to be measured and marked; the band has a heat-fusible coating on the side facing towards the vee belt; and the punching plate can be heated.

11. Apparatus according to claim 10, in which the punching means includes a step-by-step switch known *per se* for advancing the punching band.

12. Apparatus according to any one of claims 1  
to 11 including a photoelectric cell to sense an optical mark on the back of the vee belt, the output signals from the cell being fed to the control and arithmetic unit.

13. Apparatus for measuring the length of a vee belt substantially as hereinbefore described and illustrated with reference to the accompanying drawings.